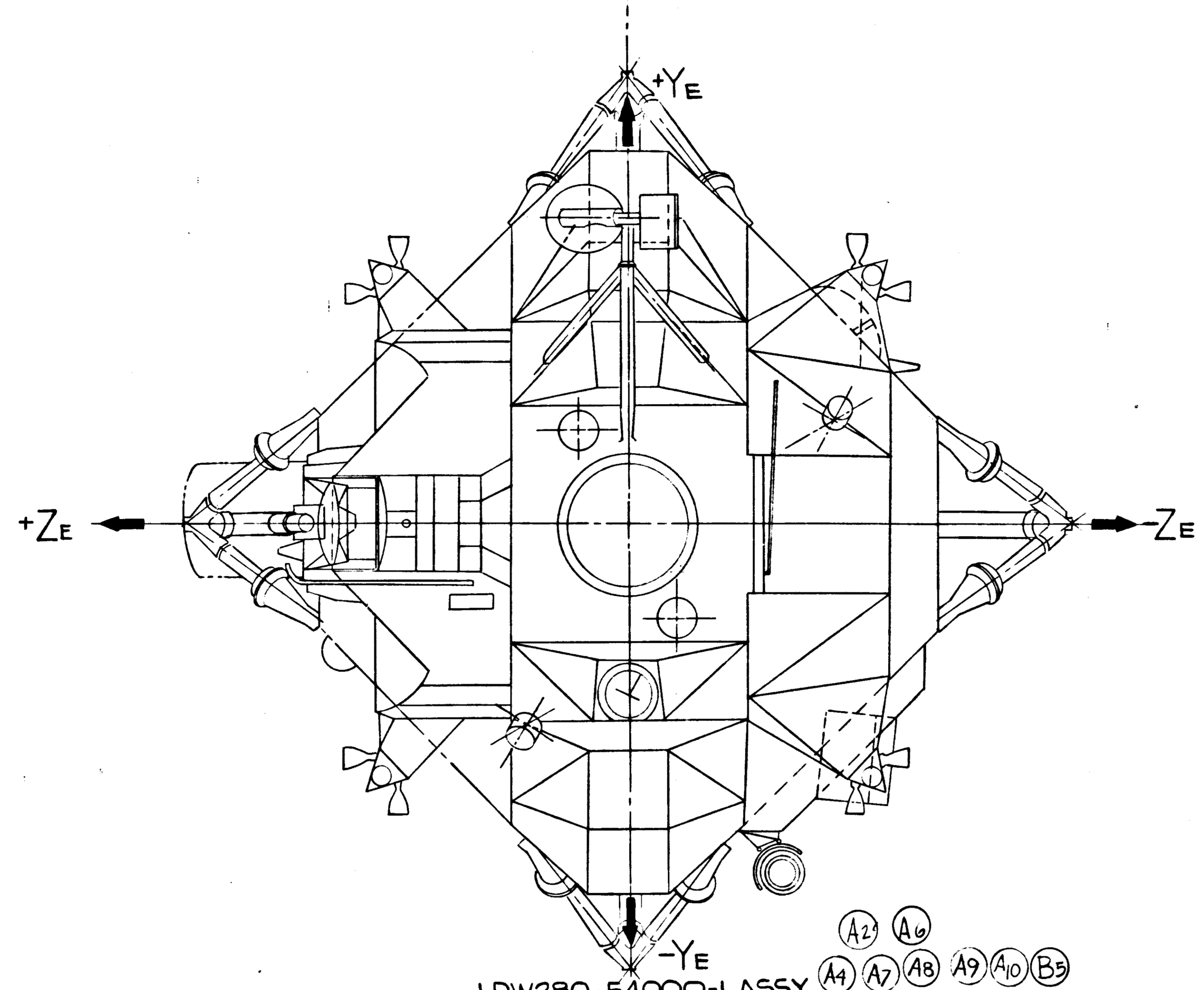


4 3 2

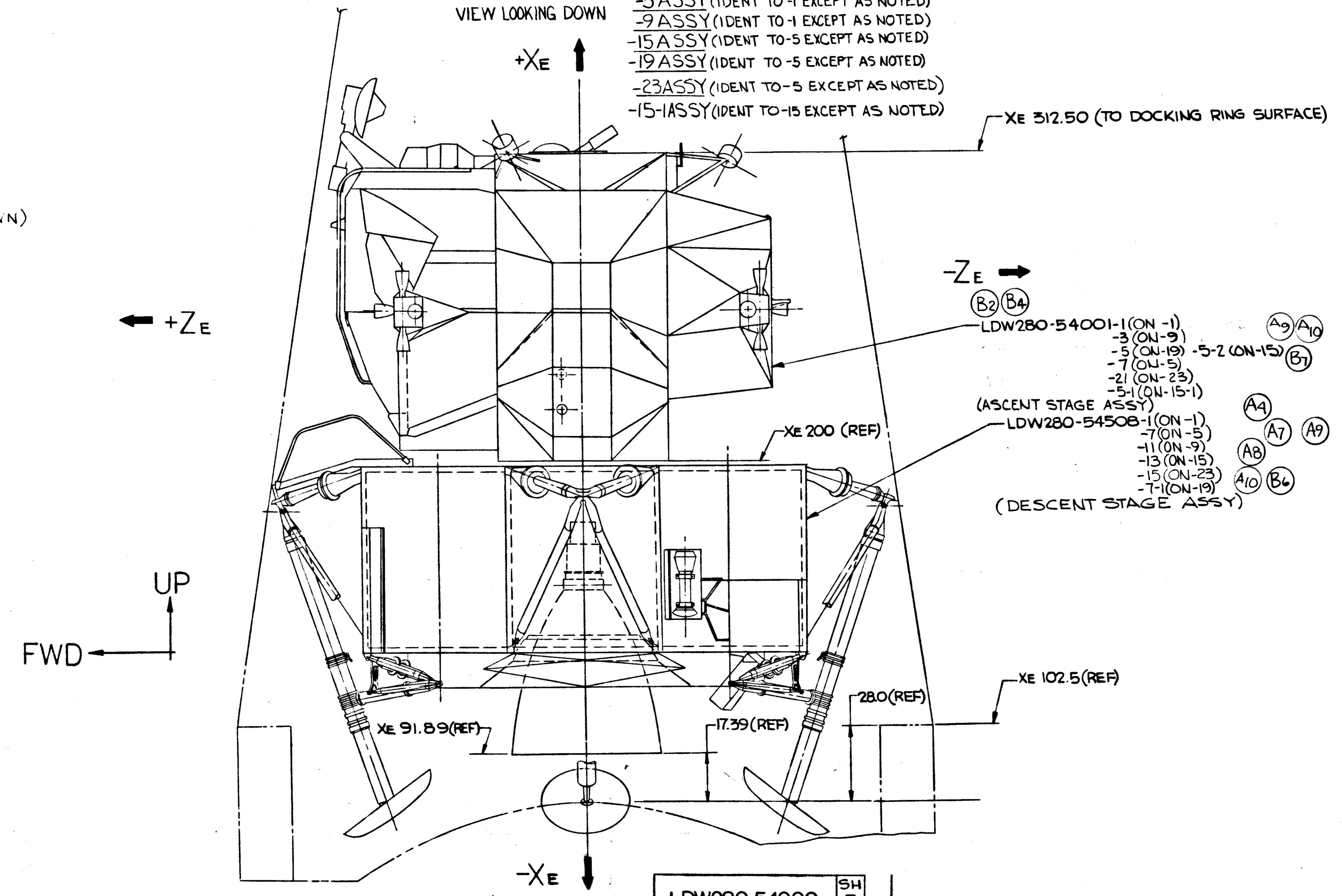


LDW280-54000-1 ASSY
 VIEW LOOKING DOWN
 +XE ↑
 -5 ASSY (IDENT TO -1 EXCEPT AS NOTED)
 -9 ASSY (IDENT TO -1 EXCEPT AS NOTED)
 -15 ASSY (IDENT TO -5 EXCEPT AS NOTED)
 -19 ASSY (IDENT TO -5 EXCEPT AS NOTED)
 -23 ASSY (IDENT TO -5 EXCEPT AS NOTED)
 -15-1 ASSY (IDENT TO -15 EXCEPT AS NOTED)

SPACECRAFT LM ADAPTER (SLA) (REF)

LDW280-54000-1 (ON -1)
 -13 (ON -9)
 -17 (ON -15)
 -21 (ON -19)
 -25 (ON -23)
 -27 (ON -23)
 -29 (ON -15-1)
 (LOCATE APPROX IN AREA AS SHOWN)
 SEE NOTE 1 & 2

(B1)
 LDW320-54400-1 (ON -1)
 -3
 (EXPLOSIVE DEVICES INSTL)



(B2) (B4)
 LDW280-54001-1 (ON -1)
 -3 (ON -9)
 -5 (ON -19)
 -7 (ON -5)
 -21 (ON -23)
 -51 (ON -15-1)
 (ASCENT STAGE ASSY)
 LDW280-54508-1 (ON -1)
 -7 (ON -5)
 -11 (ON -9)
 -13 (ON -15)
 -15 (ON -23)
 -71 (ON -19)
 (DESCENT STAGE ASSY)

LDW280-54000 SH 3

4 3 2

MANUFACTURING OPERATIONS	
UNLESS OTHERWISE SPECIFIED NOTES CHECKED ✓ APPLY TO THIS DWG.	
AND ALL OTHER MARKINGS IN REGION MARKED [] USE BOTH SIDES IF NECESSARY.	PART NUMBER
FILLET AND INSIDE CORNER RADIUS TOLERANCES: .018 TO .030 ± .005, .030 TO .250 ± .015, OVER .250 ± .030	
DEPTH SHOWN FOR TAPPED HOLES IS FULL THICKNESS. 2-3 IMP THDS. BEYOND PERMISSIBLE.	
EXTERNAL THREAD LENGTH SHOWN INCLUDES 2 IMPERFECT THREADS MAX.	
DO NOT CADMIUM PLATE & PAINT HOLES OR SURFACES MARKED WITH DOUBLE ASTERISK.	
MISMATCH STEP OF ± .005 PERMISSIBLE DUE TO CHANGE OF CUTTERS AT INSIDE INTERSECTING SURFACES.	
DIAMETERS MARKED MUST BE CONCENTRIC WITH FULL INDICATOR READING	
HOLES MUST BE KEPT FREE OF CHROME PLATING SOLUTION.	
ALL DIMENSIONS SHOWN TO BE MET AFTER CADMIUM PLATING. THICKNESS OF PLATE .003 MIN. TO .005 MAX. MIN. THICKNESS TO BE .002 ON THREADED AREAS. NO ALLOWANCE FOR PLATING IN HOLES.	
SURFACE ROUGHNESS INCLUDING REAMED HOLES PER MIL-STD-10	
300 ✓ FOR ALL DRILLED HOLES	
REMOVE ALL BURRS. BREAK ALL EDGES .015-.031	
INSPECTION INFORMATION MINIMUM PERMISSIBLE AVERAGE EDGE DISTANCE MARKED IS	
SYMBOL ✓ DENOTES SURFACE TO BE MACHINED	
UNLESS OTHERWISE SPECIFIED TOLERANCE ON FLANGES IS ± 1/32	
LENGTHS OF AN, HAS & HS AL ALY RIVETS SHORTER THAN 1 INCH ARE NOT SPECIFIED.	
TOLERANCE ON LOFTED DELINEATIONS IS	

- NOTES:
- BOND LDW280-54000-11, -13, -17, -21, -25, -27, TO +Z 27.0 BULKHEAD WITH RTV731 AS PER LS-14-22601.
 - NAME PLATE PROTECTION IN ACCORDANCE WITH GNI11AC.
 - THIS DWG IS AFFECTED BY LFM 107 WHICH MAY BE USED ON LM-4 (34) & LM-5 (35). SEE LFM 107 FOR EFFECTIVITY.
 - THE ASCENT & DESCENT BLANKETS SHOWN ON THIS DRAWING THAT MAKE CONTACT WITH EACH OTHER ARE TO BE HELD IN PLACE AS INDICATED & UNDER NO CIRCUMSTANCES WILL A BLANKET ON THE DESCENT STAGE BE TAPED TO A BLANKET ON THE ASCENT STAGE.
 - THE (2) 2" DIA HOLES LOCATED AT (-Z 27.00 +Y 65.00 & -Z 27.00, -Y 65.00) IN THE EXTERNAL F.I.T.H. SHIELD BLANKET AND THE (2) 2" DIA HOLES AT (+Y 23.406 & +Z 65.906, -Y 23.406 & +Z 65.906) IN THE LDW280-54173 CABIN BLANKET ARE TO BE HELD IN PLACE AS SHOWN BEFORE THE MATING OF THE ASCENT WITH THE DESCENT STAGES.

02/02 NAS 9-1100

GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK			
SIZE	CODE IDENT NO	LDW280-54000	B
LM			
MODEL OR END ITEM	SCALE	1/20	SHEET 3.00

20 IN. FT.
 5 IN. FT.
 PRINTING INFO ONLY
 FULL SIZE SHEET AREA (OR X 75%)
 1/2 SIZE SHEET AREA (1/4 OF FULL)
 DWG SIZE N X 70
 LDW280-54000 B
 LDW280-54000 B
 LDW280-54000 B
 2 FR