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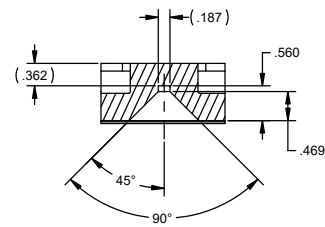
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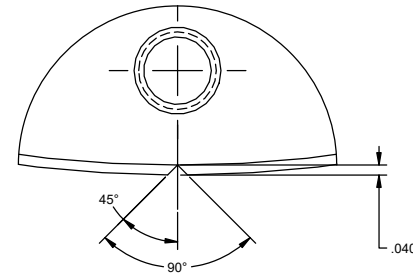
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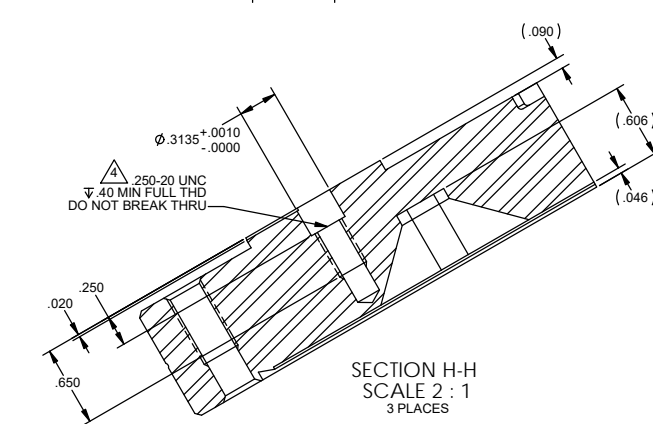
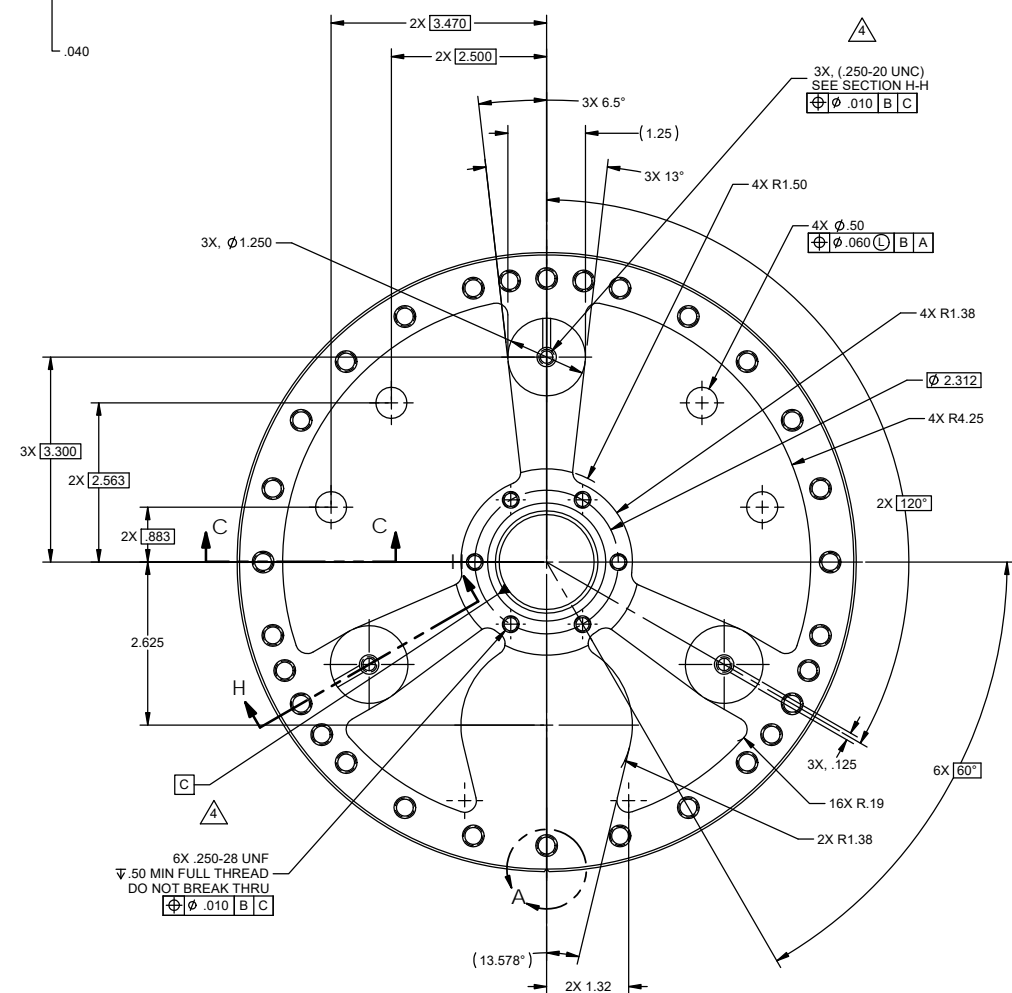
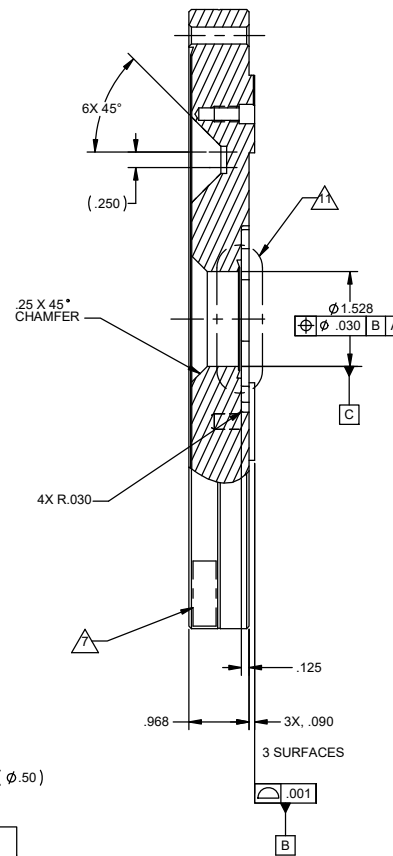
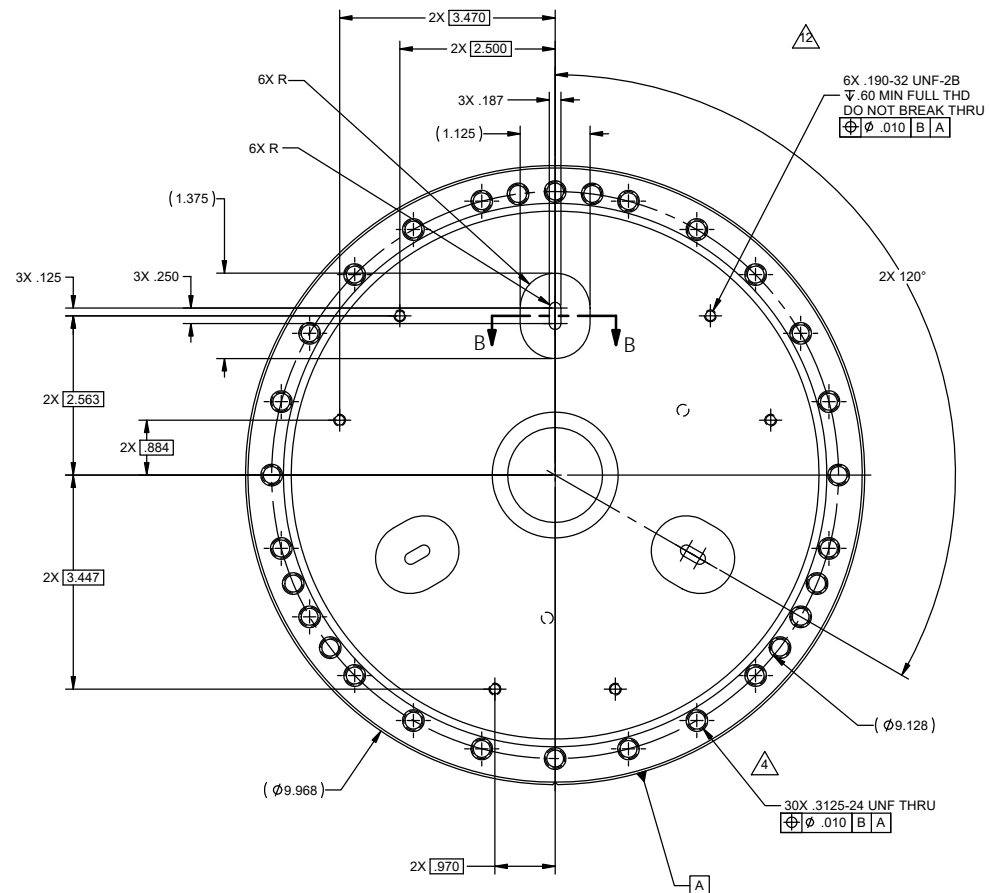
REV	DATE	DESCRIPTION	APP'D	CHK'D	ENGR	DRWG	MATL	THRM	ME	PRJCT	QA	RELEASE DATE
A		INITIAL RELEASE										
B		ADD 6 PERM .3125-24 HOLES, ADD THRD MTG. HOLE, MTG. BOSSES, AND TAPS TO TYPE #1, HPD ECO 1065										6/21/2007
C		MULTIPLE MINOR CHANGES HPD ECO 1067										
V3		CHG NOTES										



SECTION B-B
TYPICAL 3 PLACES



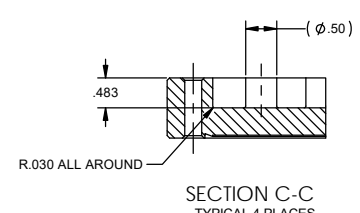
DETAIL A
SCALE 4:1



SECTION H-H
SCALE 2:1
3 PLACES

NOTES: UNLESS OTHERWISE SPECIFIED.

- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364 AND E0900048.
- REMOVE ALL BURRS AND SHARP EDGES .005-.015.
- MACHINE FILLET RADII .003-.015.
- THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE (VIBRATORY ACCEPTABLE) THE FOLLOWING INFORMATION AS SHOWN BELOW: LIGO PIN-REVISION-TYPE, FOLLOWED ON THE NEXT LINE BY "SIN-" AND A THREE DIGIT SERIAL NUMBER, STARTING AT 100, AND PROCEEDING CONSECUTIVELY. USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER. D047813-C-1 SIN-100 (EXAMPLE)
- FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO TO NOR-CAL PRODUCTS PART NUMBER 1000-000NT.
- REFERENCE MATING PART DRAWING 20007812.
- PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- CONFIGURATION OF KNIFE EDGE, GASKET RELIEF AREAS, AND THEIR RELATIONSHIP TO THE SURROUNDING BOLT PATTERN AND MATING FLANGE AREA SHALL CONFORM TO A 2.75 CF FLANGE SUCH AS A 275-150N.
- NOTE 4 DOES NOT APPLY.
- EXTERNAL SURFACE OF POD IS EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF WELD RESIDUE, SCALE, DIRT, AND INK.
- TACK WELD CAN BE USED IF NEEDED FOR SETUP, VOLUME MUST VENT TO THE INSIDE.
- ELECTROPOLISH AFTER WELDING PER BEST COMMERCIAL PRACTICE. MASK CF FLANGE GASKET SURFACE.



SECTION C-C
TYPICAL 4 PLACES

-1 SHOWN
-2 SHEET 2

LIGO D047813

THIS DOCUMENT MAY CONTAIN (ITAR CONTROLLED INFORMATION AND/OR COMMERCE CONTROLLED INFORMATION EXPORT RESTRICTIONS MAY APPLY)

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
				20007813-1	BASE PLATE, HORIZONTAL			
				20007813-2	BASE PLATE, VERTICAL			

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		THIS DRAWING IS PRELIMINARY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS HERE.		PARTS LIST	
		DECIMALS	ANGLES	asi		ALLIANCE SPACESYSTEMS, INC.	
		.XX ± .03	.XXX ± .010 ± 1/2°	06/28/04		1250 Lincoln Ave., Suite 100	
		MACHINE FINISH	125	PROJENOR		Pasadena, CA 91103	
		DO NOT SCALE DRAWING	INTERPRET DWG PER ASME Y14.5M	MATERIAL		BASEPLATE, GS-13	
				304 SS		HORIZONTAL & VERTICAL	
				DECARBURIZATION PER ASTM 240		LIGO-D047813	
				APPLICATION		20007813	
						REV V3	
						SCALE 1:1	
						UNCLASSIFIED	
						SHEET 1 OF 2	

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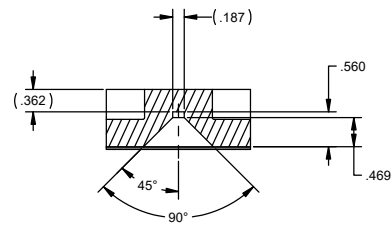
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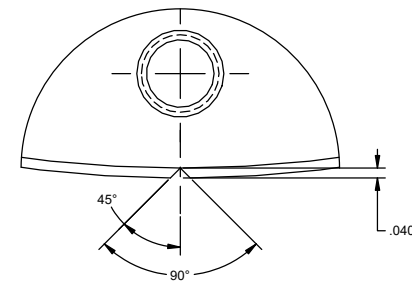
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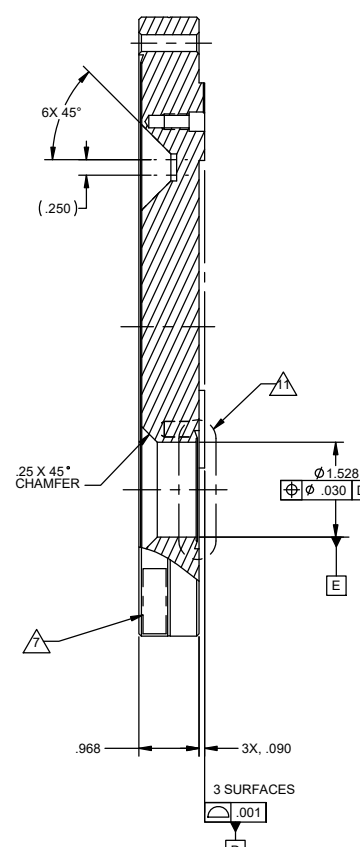
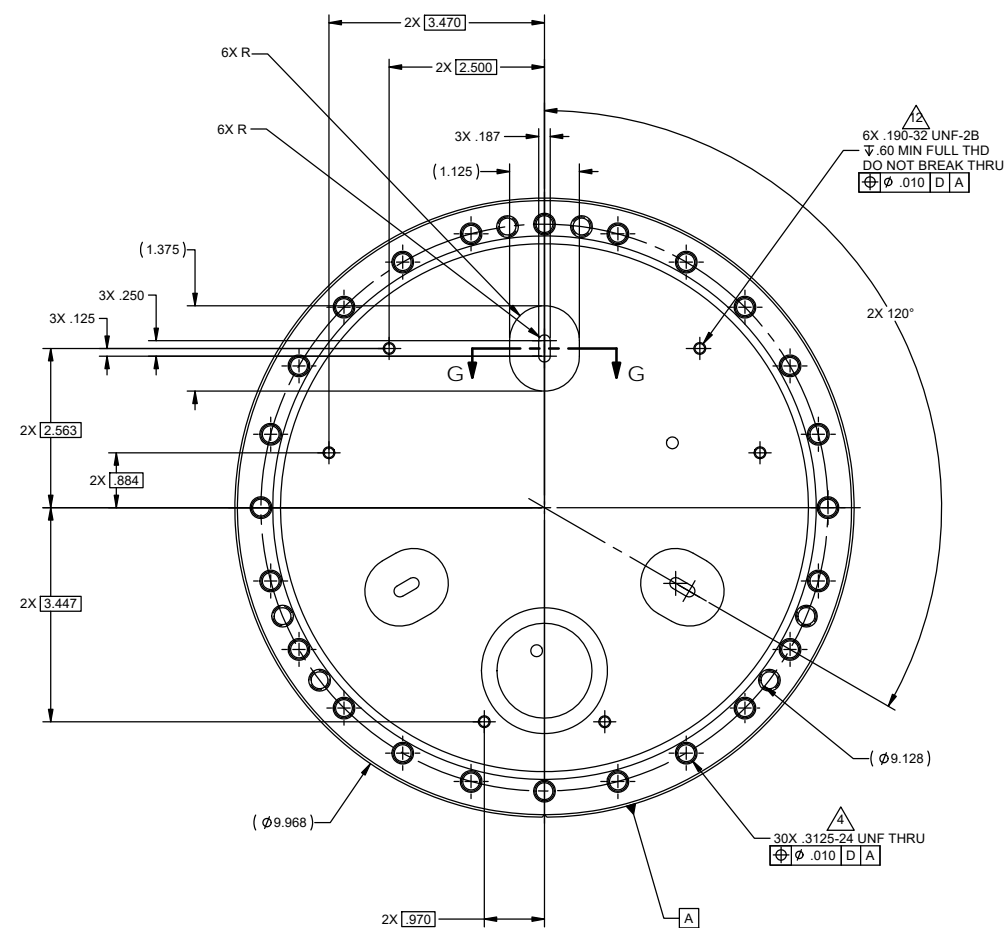
THIS DRAWING IS PRELIMINARY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS HERE.



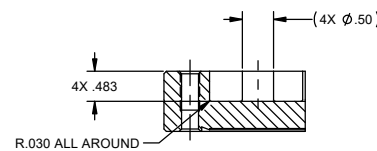
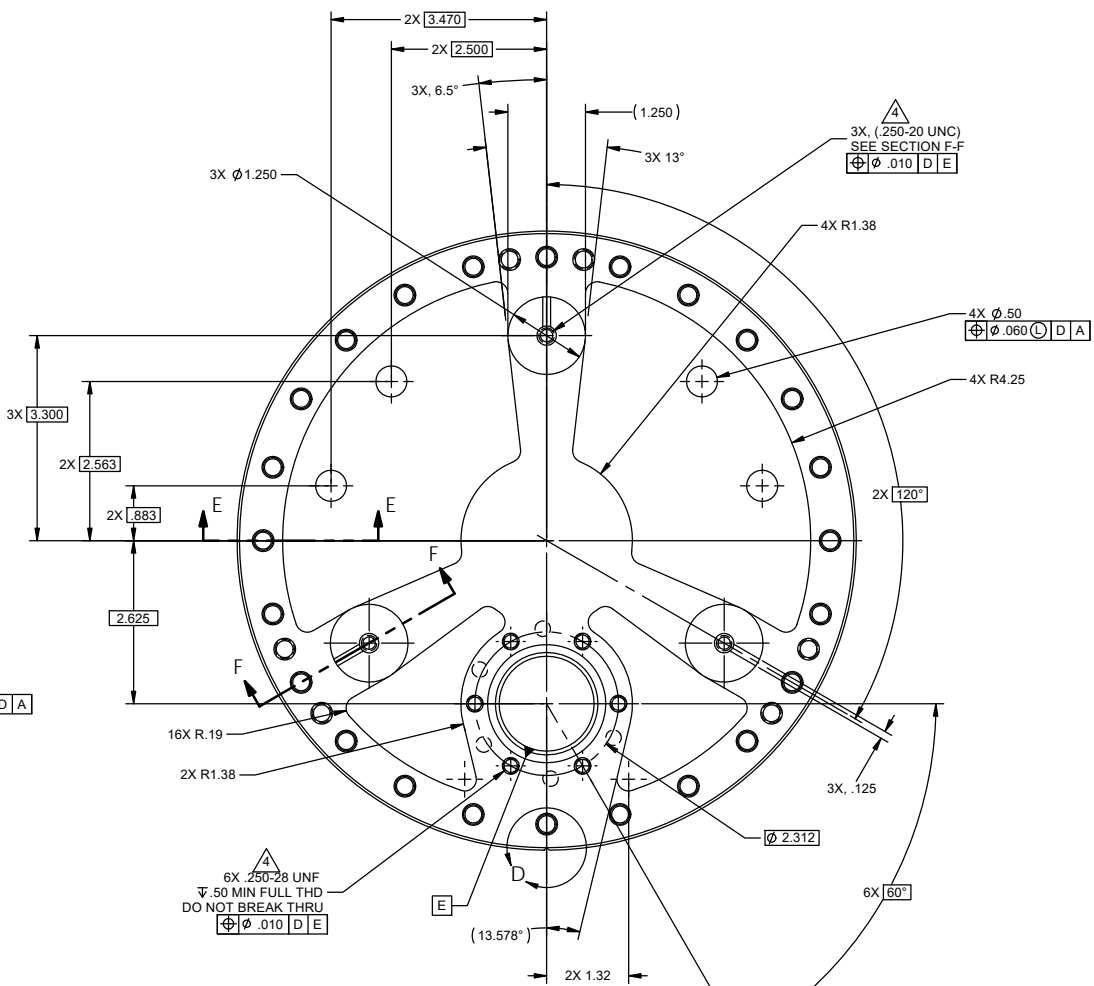
SECTION G-G
TYPICAL 3 PLACES



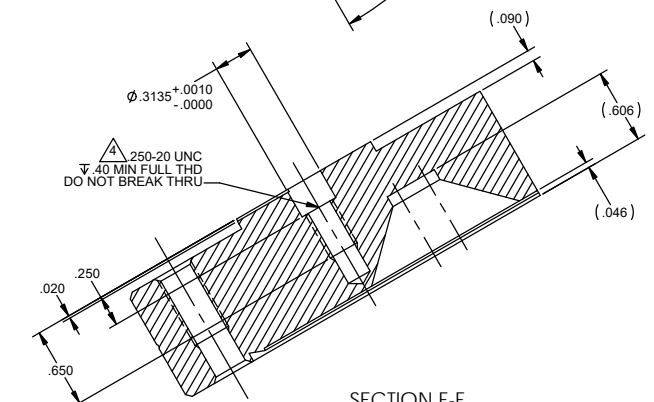
DETAIL D
SCALE 4 : 1



**-2 SHOWN
-1 SHEET 1**



SECTION E-E
TYPICAL 4 PLACES



SECTION F-F
SCALE 2 : 1
3 PLACES

NOTES: SEE SHEET ONE

THIS DOCUMENT MAY CONTAIN ITAR CONTROLLED INFORMATION AND/OR COMMERCE CONTROLLED INFORMATION EXPORT RESTRICTIONS MAY APPLY

LIGO D047813

		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
SIZE E	CAGE CODE 1KNU9	20007813	REV V3
SCALE 1:1	UNCLASSIFIED	SHEET 2 OF 2	REV 3/03