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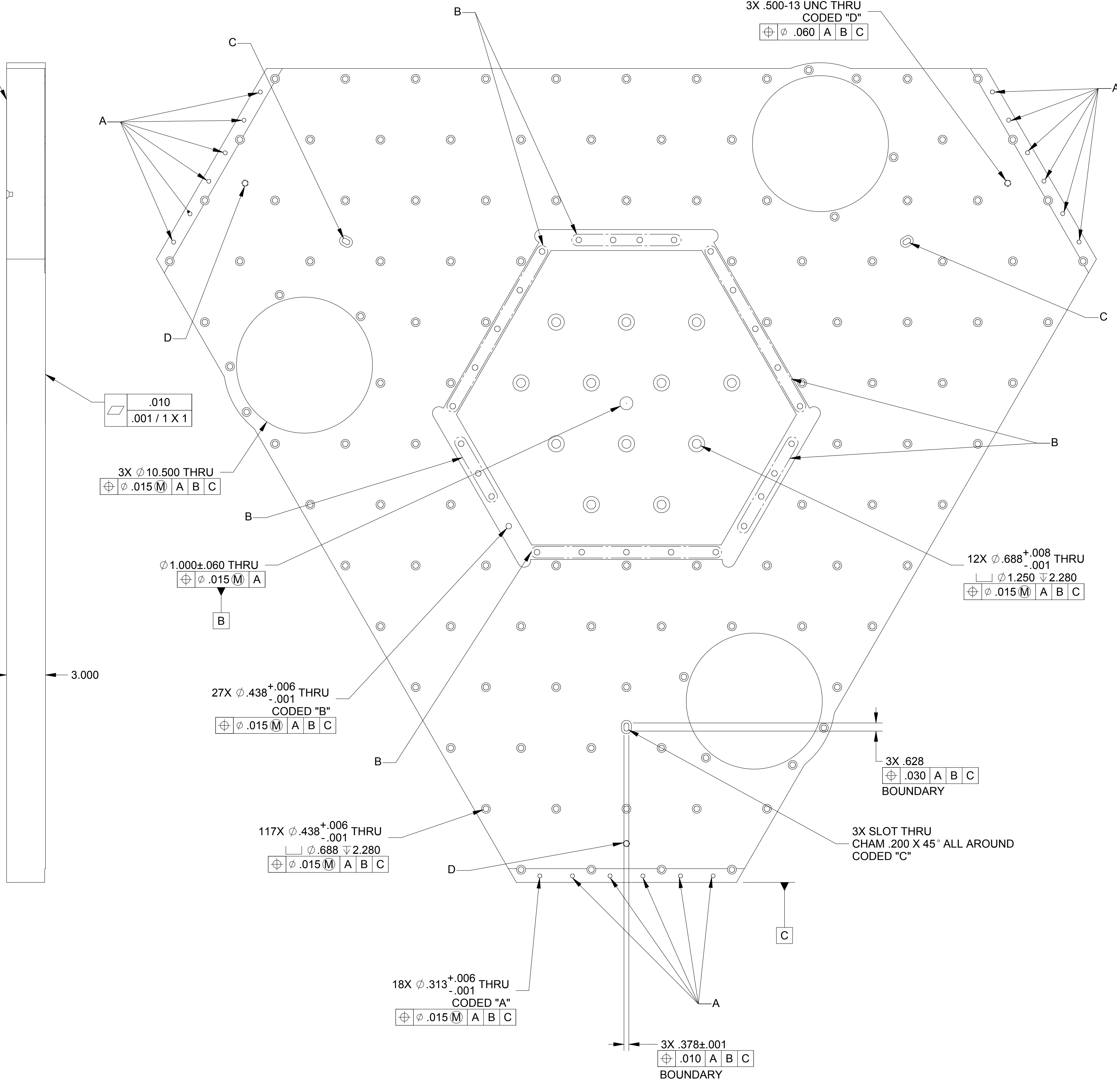
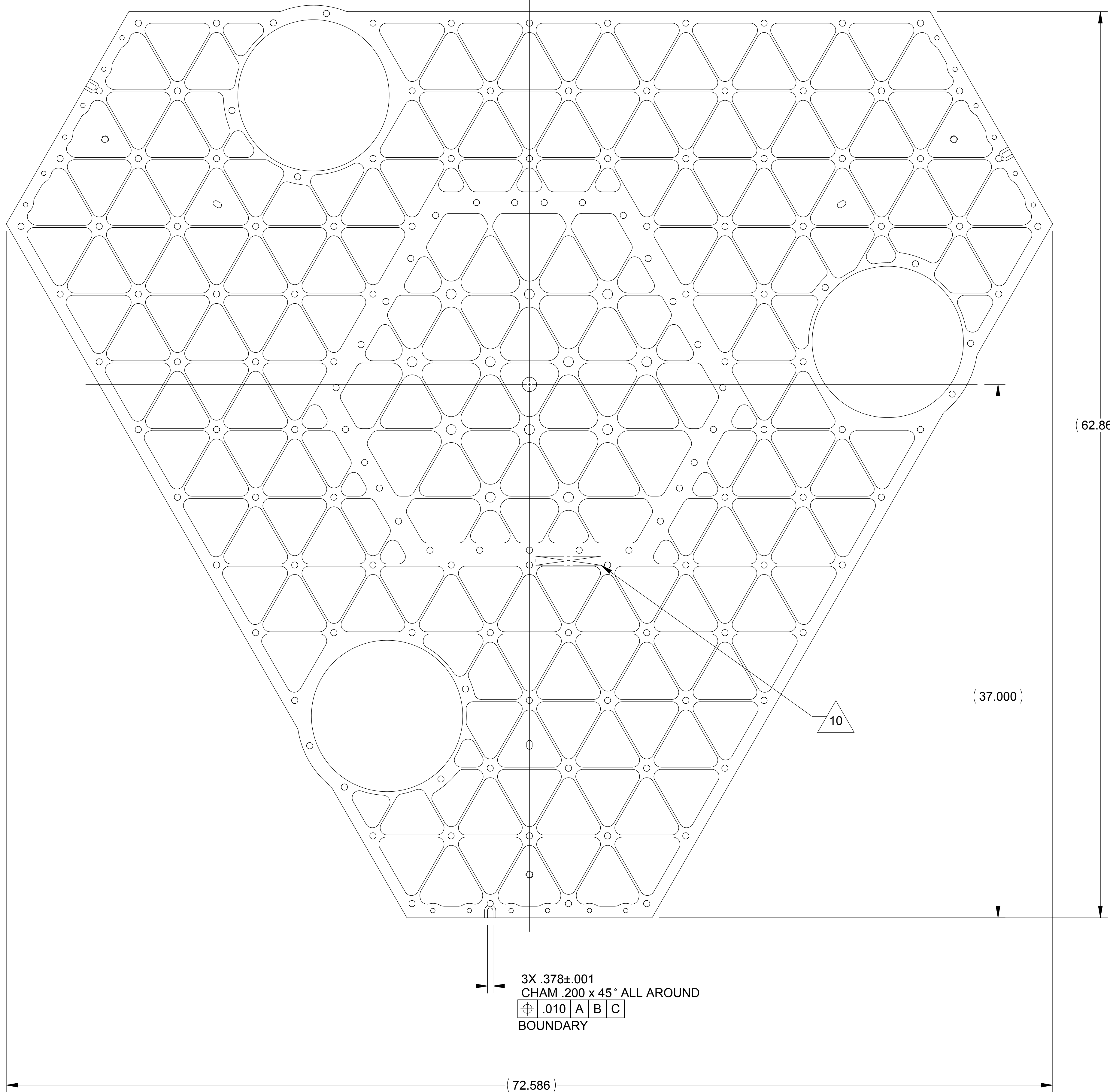
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LTR		ZONE		REVISIONS										DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A				INITIAL RELEASE																				



NOTES: UNLESS OTHERWISE SPECIFIED.

- THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE, THE MODEL DATABASE WILL TAKE PRECEDENCE.
- PART SHALL BE CHECKED USING THE MODEL DATABASE.
- SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUM(S). A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
- REMOVE ALL BURRS AND SHARP EDGES .005-.015.
- MACHINE FILLET RADII .003-.015.
7. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION. THIS DOES NOT APPLY TO THREADED INSERT HOLES.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-0.00.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
10. MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.13 INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006886, TYPE I, CLASSES 4, 5, OR 6. SERIAL NUMBERS START AT 001 FOR FIRST PART AND PROCEED CONSECUTIVELY. PARTS TOO SMALL TO MARK SHALL BE IDENTIFIED IN ACCORDANCE WITH 20006886, TYPE II.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 293.0 LBS.

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

QTY		REGD	ITEM NO	REF DES	CAGE NO	20007849-1	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
PARTS LIST											
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES		DECIMALS		ANGLES		MACHINE FINISH	
		XX ±.03		XXX ±.010		1/2"		125		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994	
20007845		1388		AL ALY 6061-T651		PER AMS-QQ-A-250/11		DWN KEVIN J SPINK		06/30/04	
NEXT ASSEMBLY		PROJECT CODE		MATERIAL		MATERIAL		PROJ ENGR		STRS	
				AL ALY 6061-T651		PER AMS-QQ-A-250/11		CHK		MATL	
APPLICATION				MATERIAL		MATERIAL		PROJ		QA	
				AL ALY 6061-T651		PER AMS-QQ-A-250/11		ME		QA	
				AL ALY 6061-T651		PER AMS-QQ-A-250/11		SIZE		CAGE CODE	
				AL ALY 6061-T651		PER AMS-QQ-A-250/11		E		1KNU9	
				AL ALY 6061-T651		PER AMS-QQ-A-250/11		SCALE		1:4	
				AL ALY 6061-T651		PER AMS-QQ-A-250/11		UNCLASSIFIED		SHEET 1 OF 2	

RELEASED 10/5/2004

asi ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103

KEEL PLATE - LOWER STAGE 2 LIGO D047849-A

20007849

REV A

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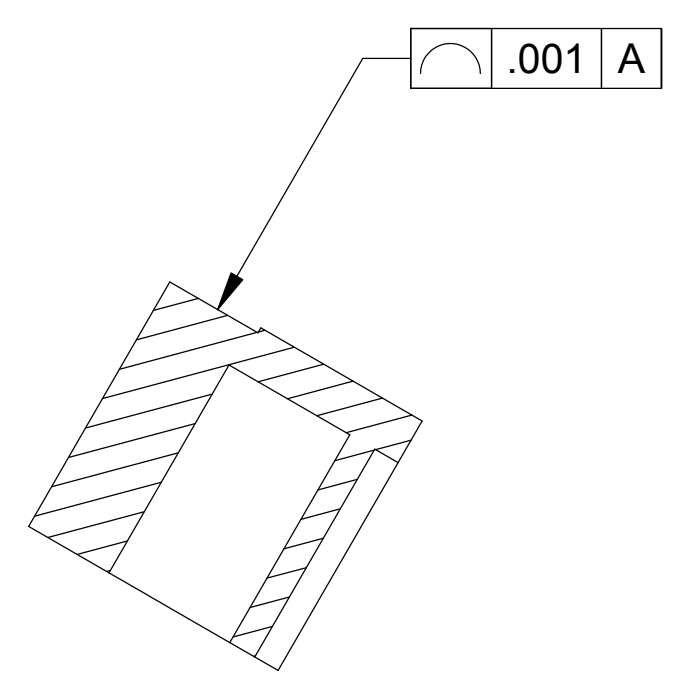
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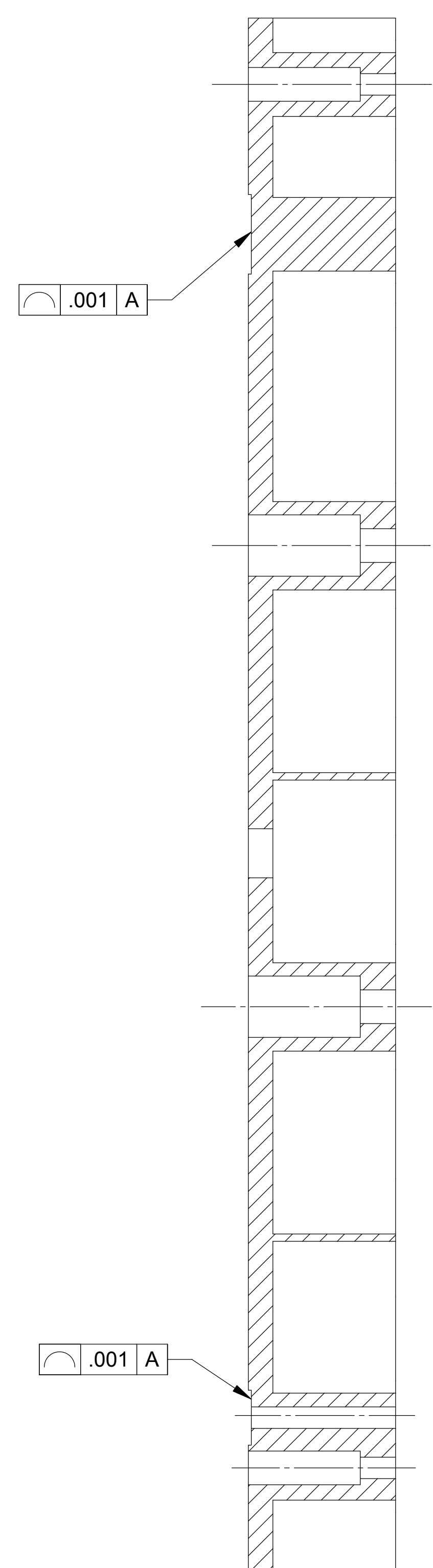
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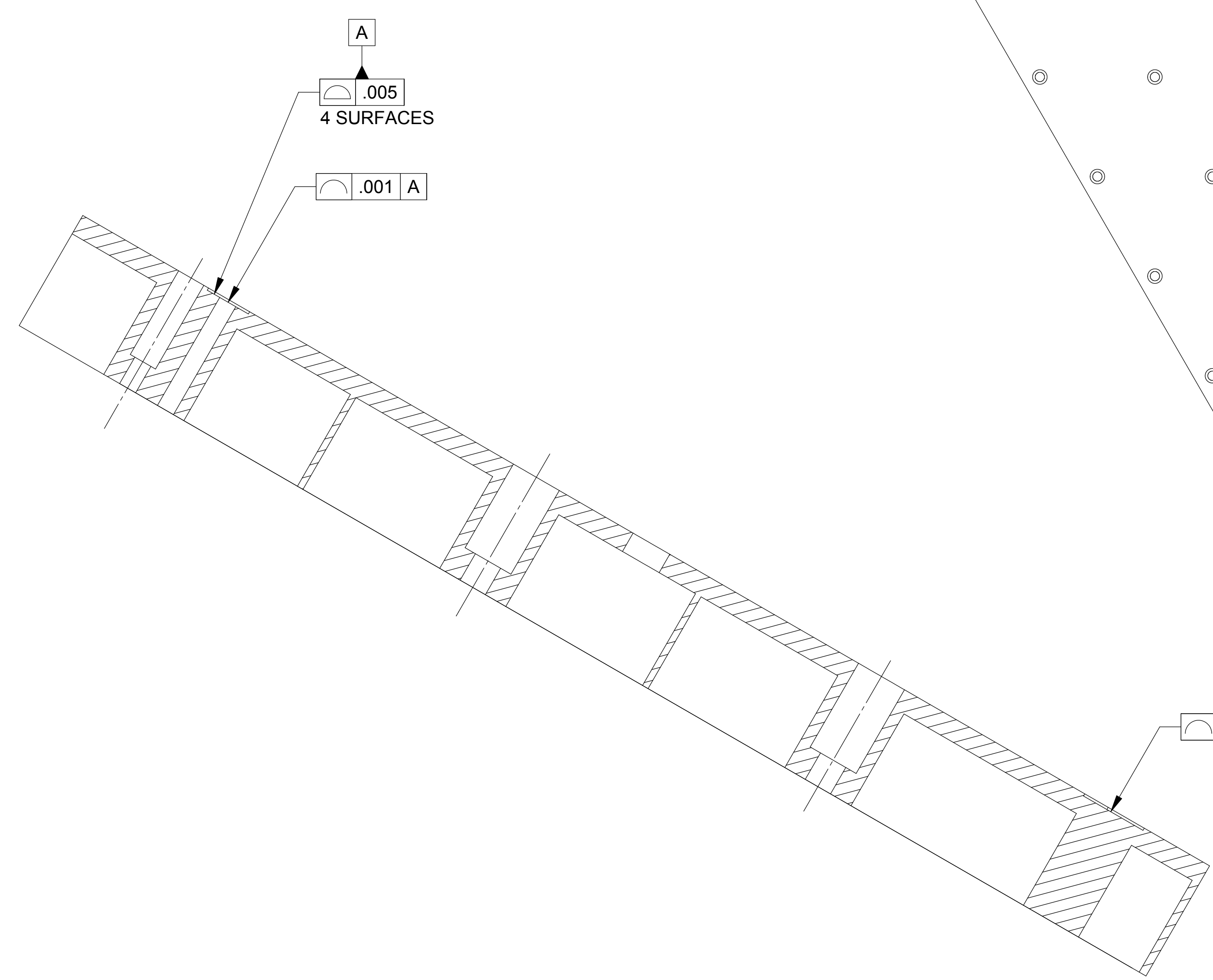
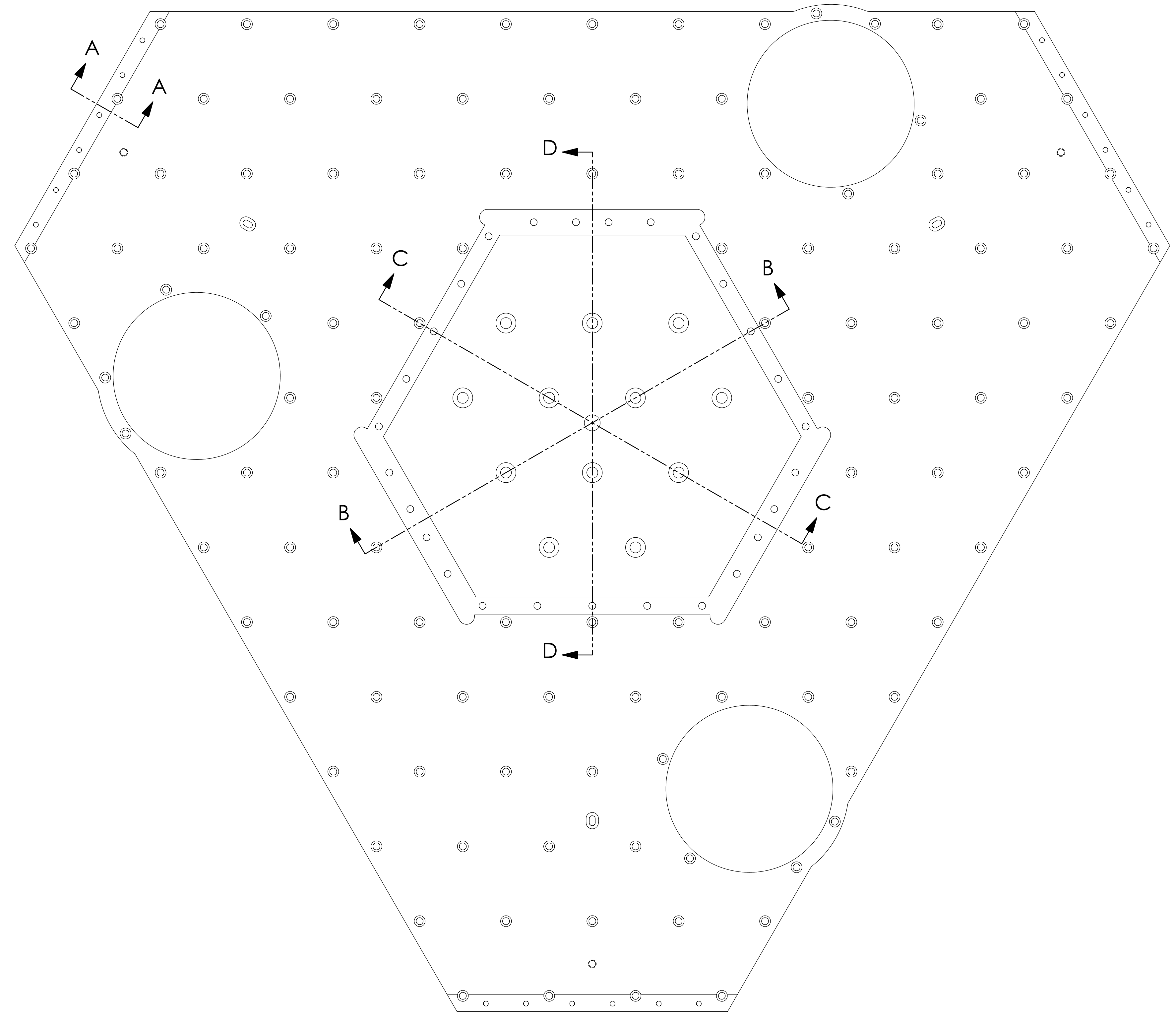
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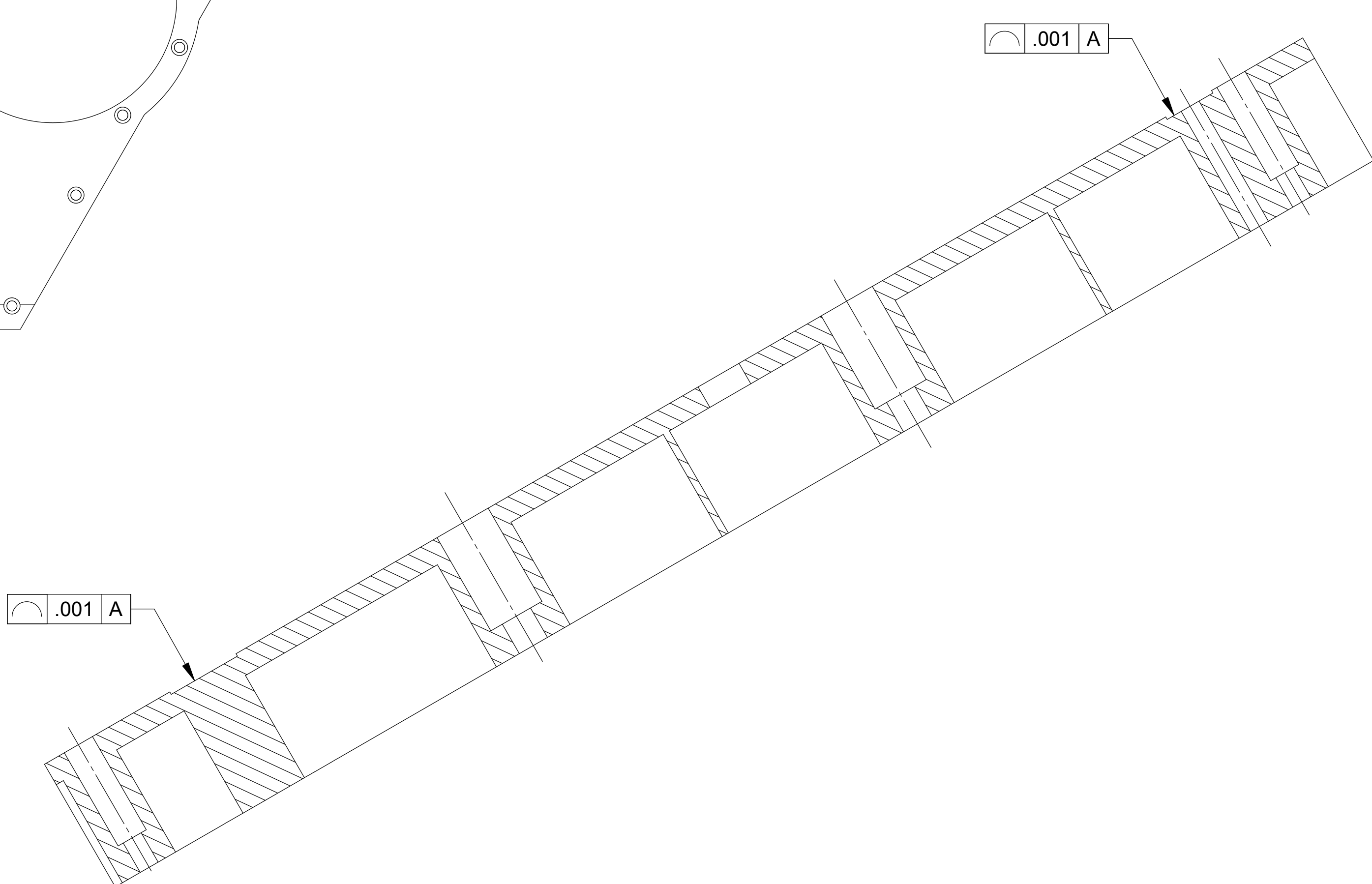
SECTION A-A
SCALE 1 : 2
TYPICAL
3 PL



SECTION D-D
SCALE 1 : 2



SECTION C-C
SCALE 1 : 2



SECTION B-B
SCALE 1 : 2

NOTES: SEE SHEET ONE

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AND/OR COMMERCE CONTROLLED INFORMATION
EXPORT RESTRICTIONS MAY APPLY

asi ALLIANCE SPACESYSTEMS, INC.
1250 Lincoln Ave., Suite 100
Pasadena, CA 91103

SIZE E	CAGE CODE 1KNU9	REV A
SCALE 1:4		UNCLASSIFIED
SHEET 2 OF 2		REV 303

8 7 6 5 4 3 2 1