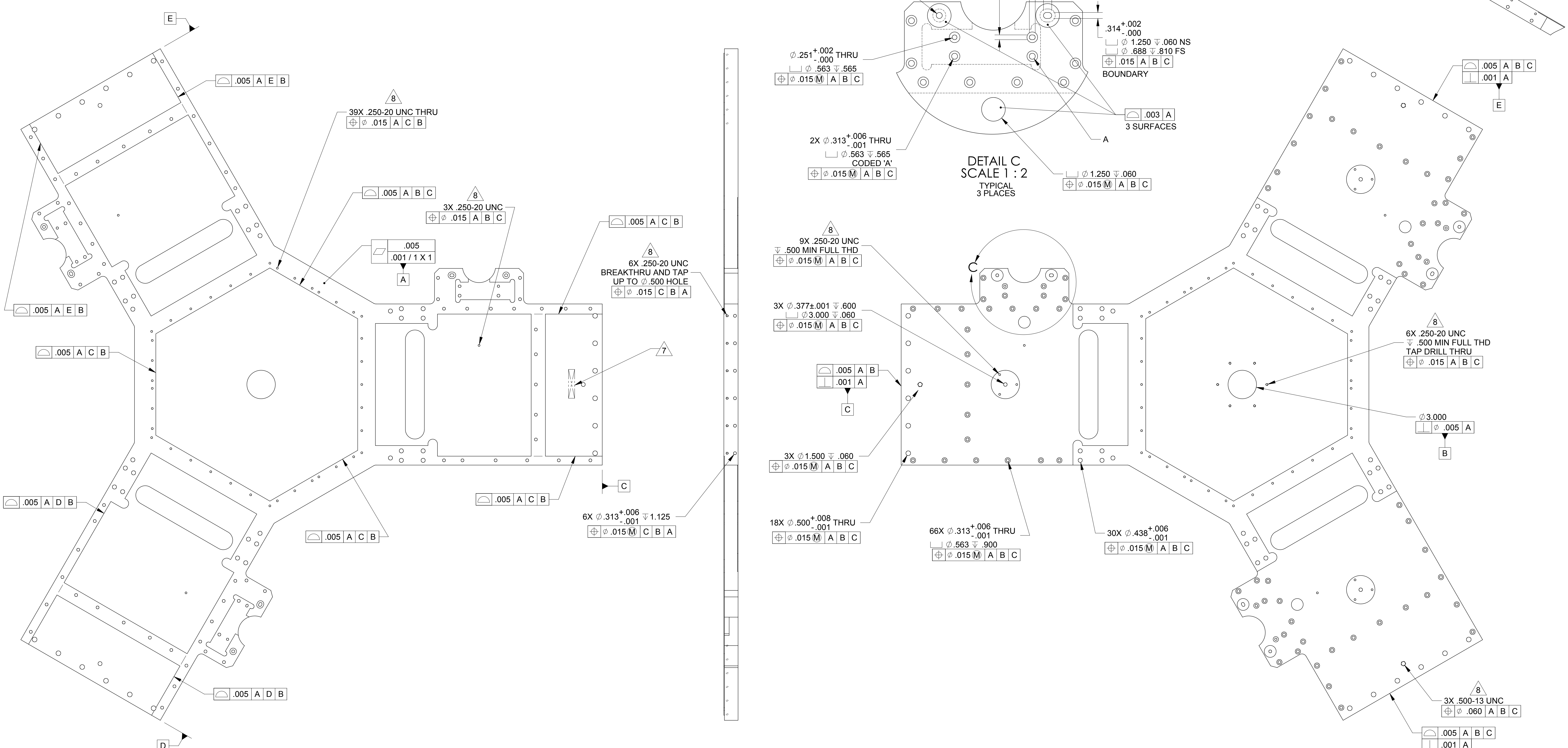
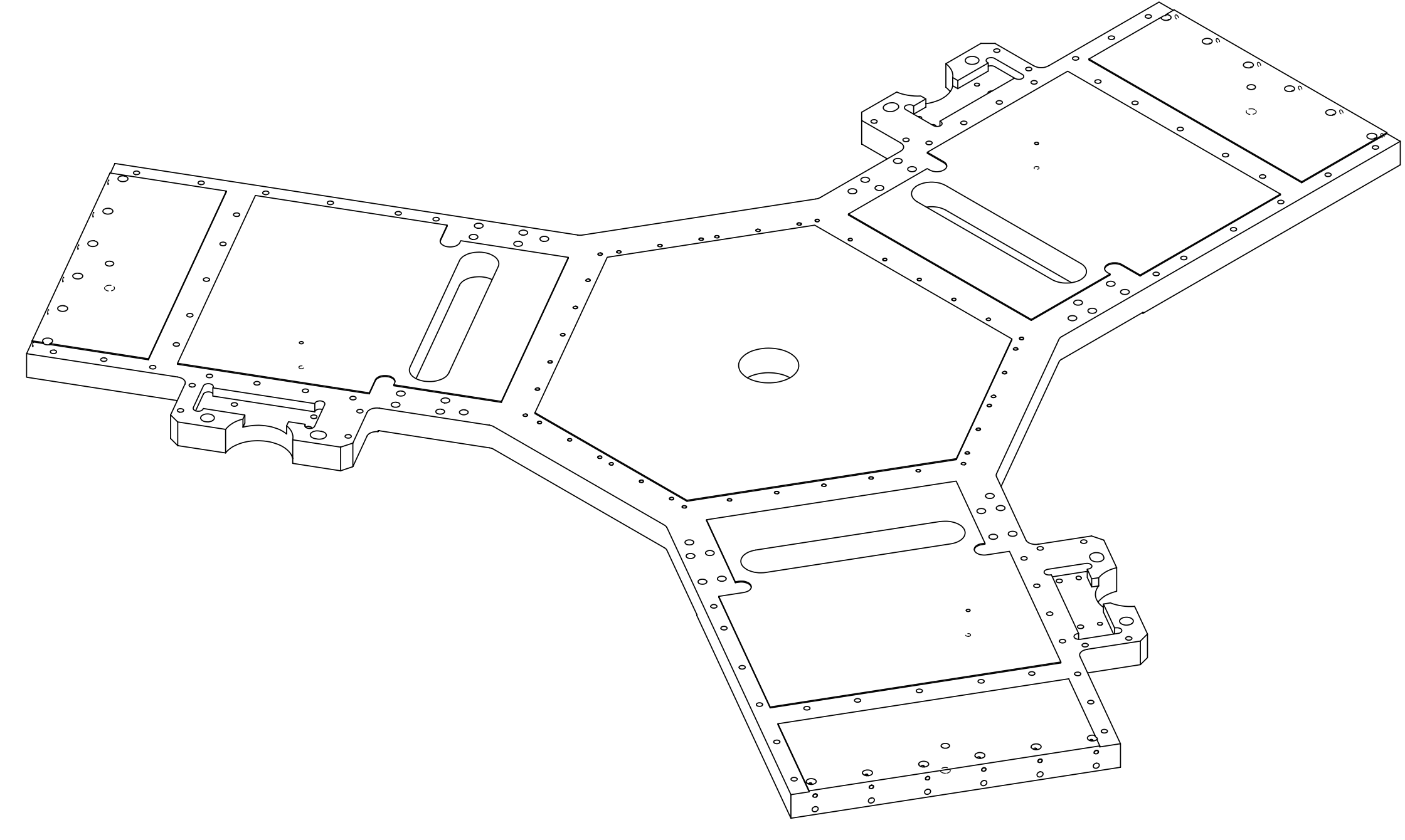


LTR		REVISIONS									
ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A	INITIAL RELEASE	RB	RF	KS	RF	RK	DCW	DCW	SV	GDL	10-06-04
B	MOVED 250-20 UNC HOLE (3 PL) DUE TO REDESIGN OF GS-13 HOLD-DOWN CLAMP	RF									



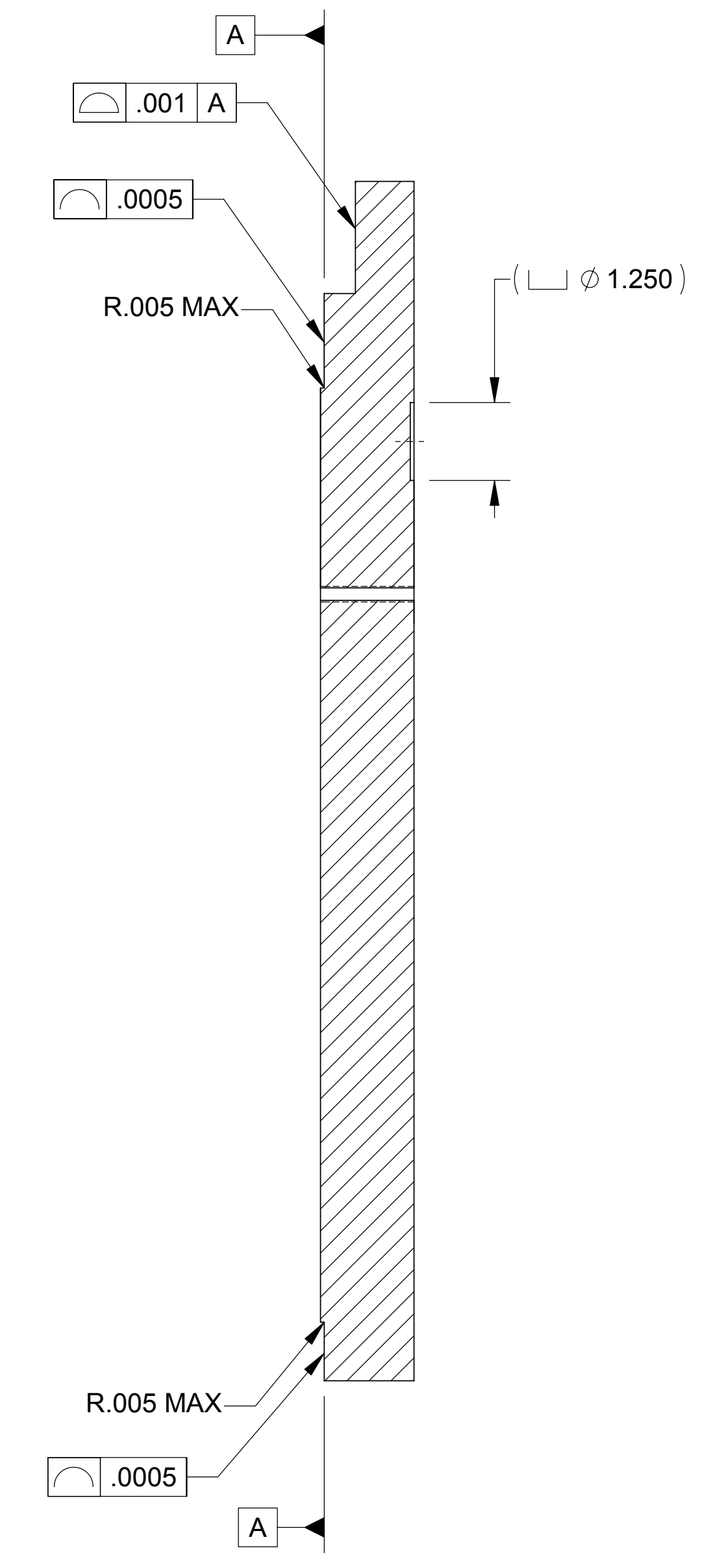
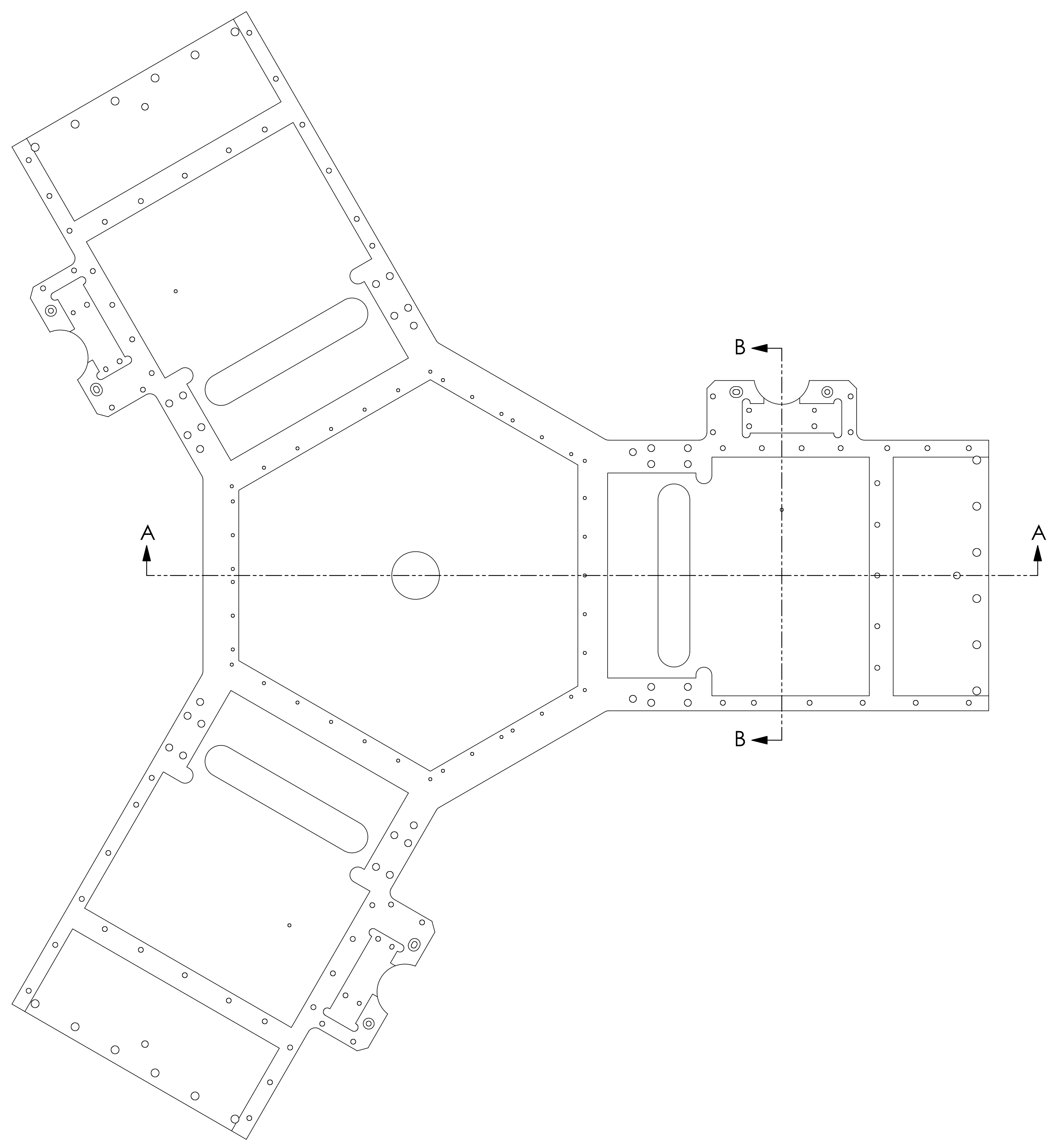
- NOTES: UNLESS OTHERWISE SPECIFIED
- THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE THE MODEL DATABASE WILL TAKE PRECEDENCE.
  - PART SHALL BE CHECKED USING THE MODEL DATABASE.
  - SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC 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.
  - MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.13-INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006686, 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 20006686, TYPE II.
  - 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/-.000.
  - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
  - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 253.9 LBS.



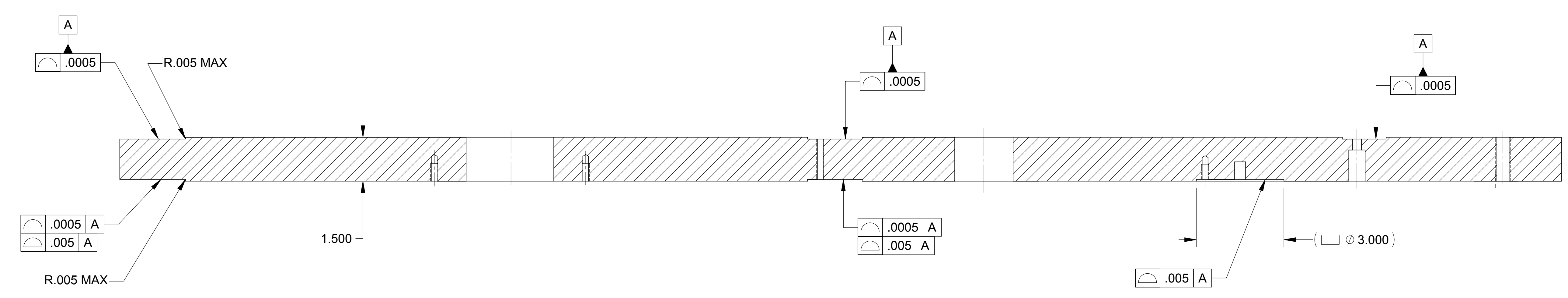
20007850-1		PARTS LIST																									
QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE																		
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		THIS DRAWING IS PRELIMINARY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS HERE.		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994		MATERIAL		<table border="1"> <tr> <td>DWN</td> <td>R.D.BILLING</td> <td>09/30/04</td> </tr> <tr> <td>PROJ ENGR</td> <td>STRS</td> <td></td> </tr> <tr> <td>CHK</td> <td>MATL</td> <td></td> </tr> <tr> <td>CONFIG</td> <td>PROJ</td> <td></td> </tr> <tr> <td>ME</td> <td>QA</td> <td></td> </tr> </table>			DWN	R.D.BILLING	09/30/04	PROJ ENGR	STRS		CHK	MATL		CONFIG	PROJ		ME	QA	
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ME	QA																										
20007845	1388	AL ALLOY 6061-T651 PER AMS-QQ-A-250/11		ALLIANCE SPACESHIELDS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103		BASEPLATE, STAGE 2 LIGO-047850-A		20007850		REV B																	
NEXT ASSEMBLY		APPLICATION		SCALE 1:4		UNCLASSIFIED		SHEET 1 OF 2		REV 704																	

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

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



SECTION B-B  
SCALE 1 : 2  
TYPICAL  
3 PLACES  
ROTATED 120° APART



SECTION A-A  
SCALE 1 : 2  
TYPICAL  
3 PLACES  
ROTATED 120° APART

THIS DOCUMENT MAY CONTAIN ITAR CONTROLLED INFORMATION  
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	20007850	REV B
SCALE 1:4	UNCLASSIFIED	SHEET 2 OF 2	REV 3/03