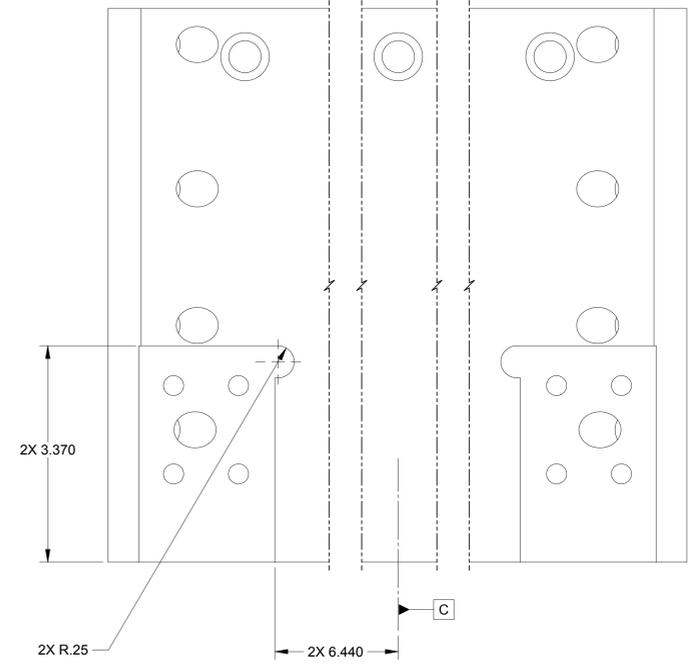
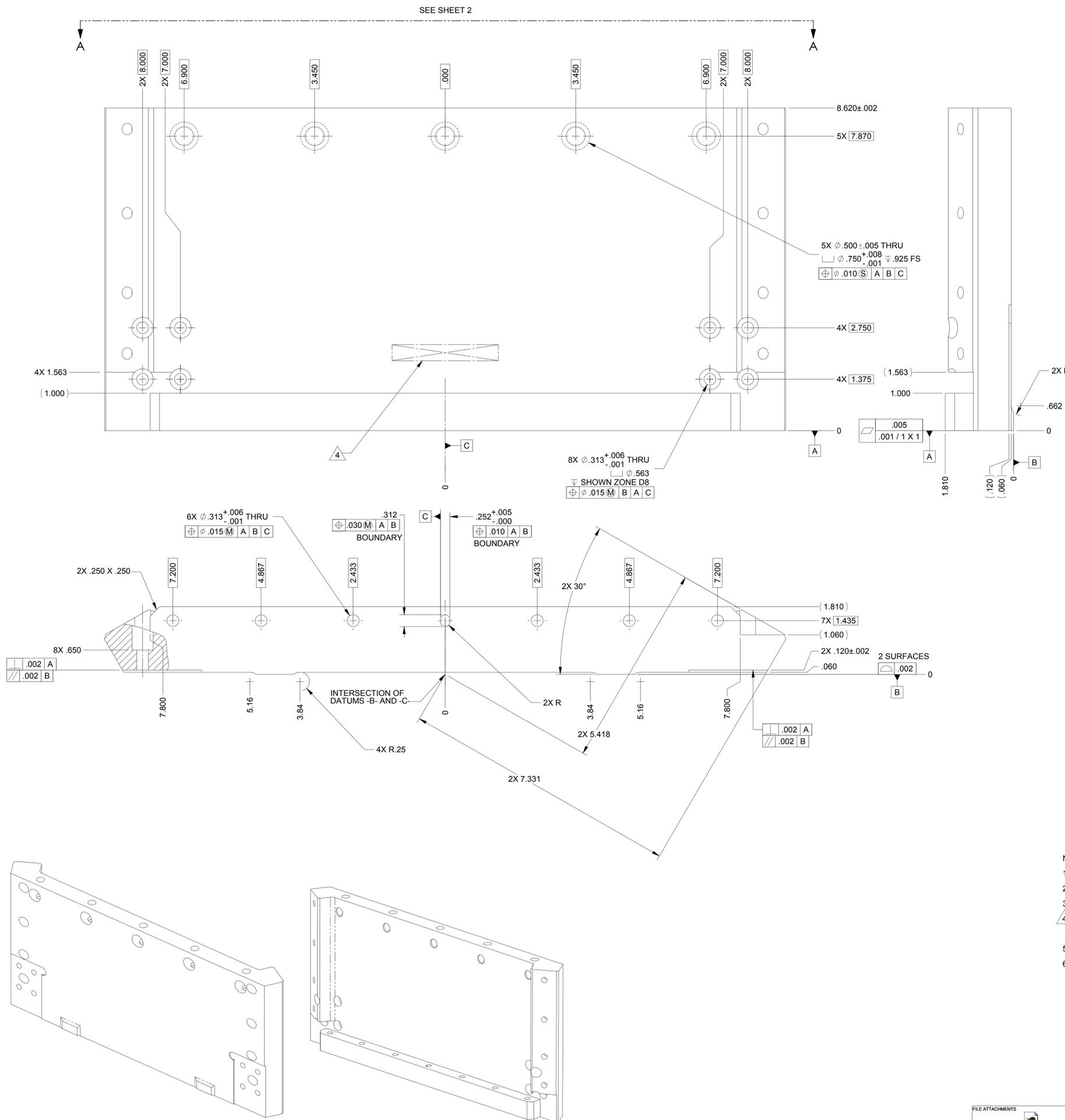


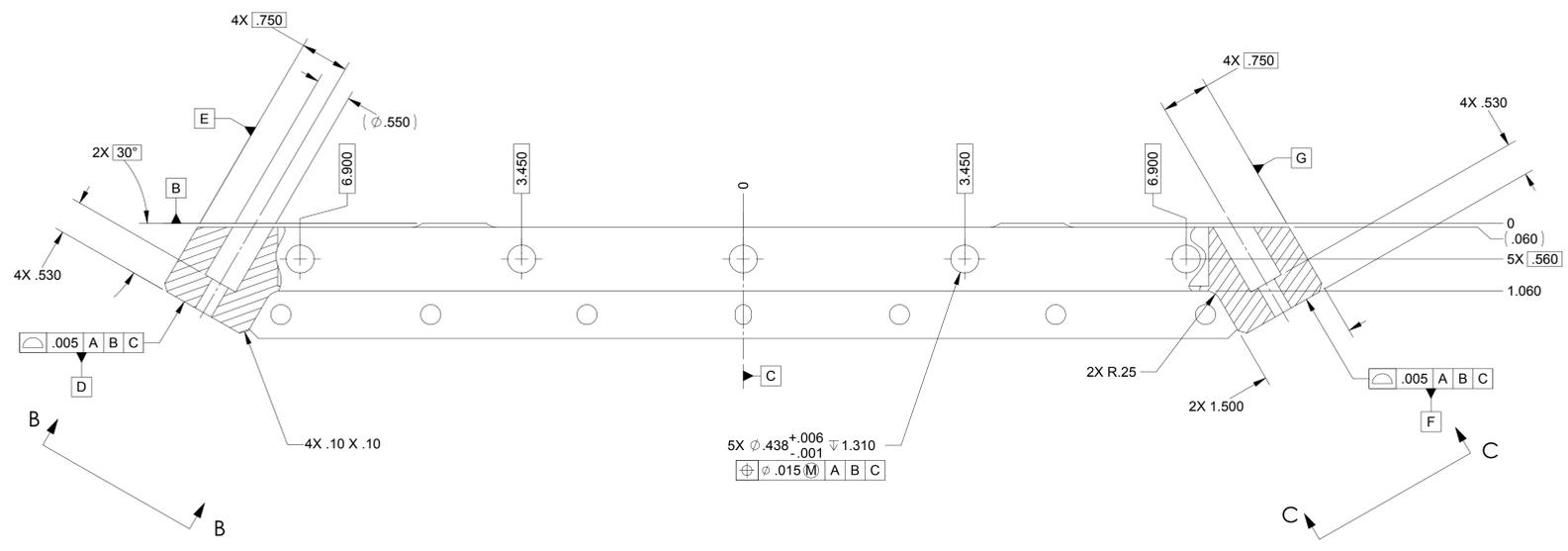
LTR		ZONE		REVISIONS									
				DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A				INITIAL RELEASE									



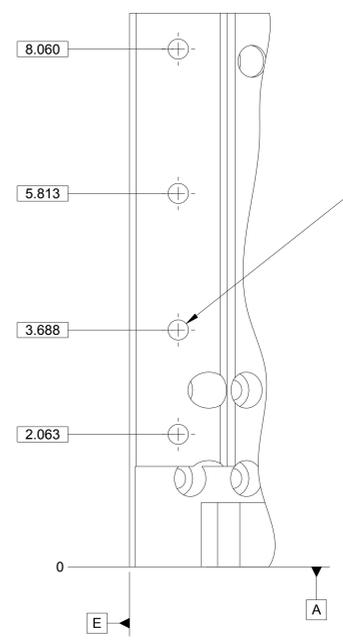
- NOTES: UNLESS OTHERWISE SPECIFIED.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
  - REMOVE ALL BURRS AND SHARP EDGES .005-.015.
  - MACHINE FILLET RADII .003-.015.
  - MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.13-INCH HIGH CHARACTER 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.
  - 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 AFTER FINAL MACHINING IS: 16.2

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

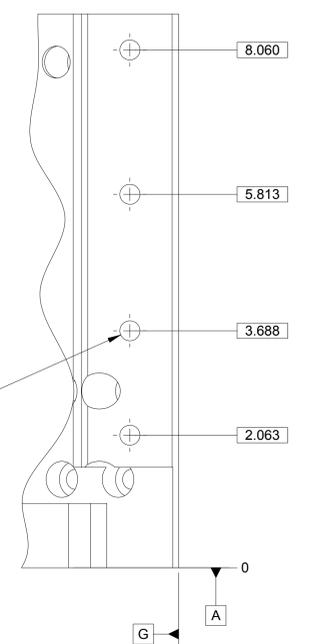
20007856-1									
QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
PARTS LIST									
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES		ANGLES		MACHINE FINISH	
		XX ± .03		XXX ± .010		± 1/2°		125	
		DO NOT SCALE DRAWING		INTERPRET DWGS PER ASME Y14.5M, 1994		MATERIAL		AL ALY 6061-T651 AMS-QQ-A-250/11	
20007871		1388		20007856.X_1		DWN KEVIN J SPINK		06/30/04	
NEXT ASSEMBLY		PROJECT CODE		APPLICATION		PROJ ENGR		STRS	
						DWN		06/30/04	
						MATERIAL			
						CONFIG		PROJ	
						ME		QA	
						SIZE		E	
						CAGE CODE		1KNU9	
						SCALE		1:2	
						UNCLASSIFIED		SHEET 1 OF 2	
						ALLIANCE SPACESYSTEMS, INC.		1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
						ANGLED HEX WALL, KEEL		STAGE 2	
						LIGO-D047856-A		20007856	
						REV		A	



VIEW A-A



VIEW B-B



VIEW C-C