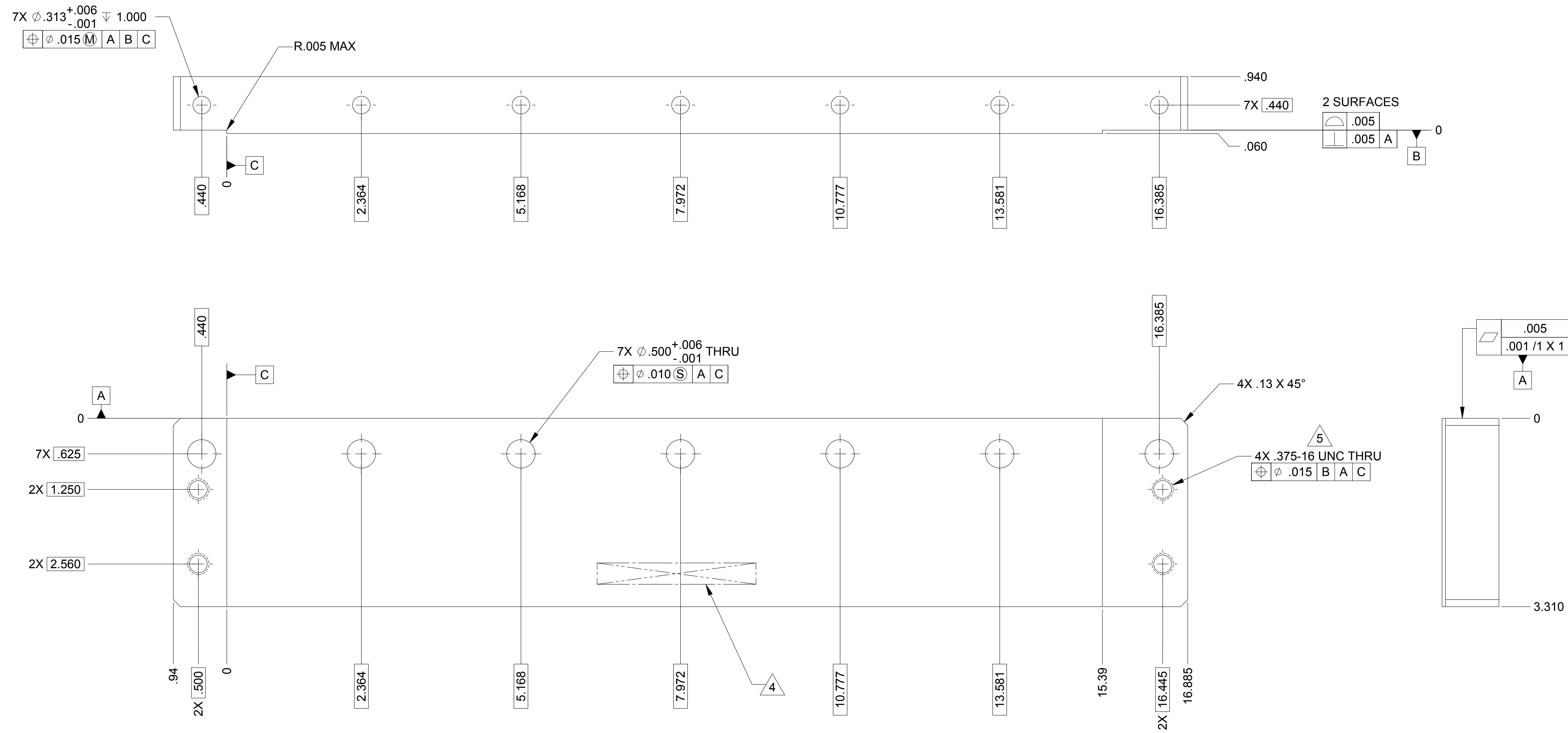


LTR		ZONE	DESCRIPTION	REVISIONS									
DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE				
A				INITIAL RELEASE									



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 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 5.5 LBS.

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

FILE ATTACHMENTS
 20007832.x_t

20007832-1										
QTY REQD	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		RELEASED 11/17/2005 DWN KEVIN J SPINK 07/22/04 PROJ ENGR STRS		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103		HEX INNER STIFFENING BAR STAGE 1 LIGO-D017831-A		
		DECIMALS .XX ±.03 .XXX ±.010 ± 1/2" ANGLES ± 1/2° MACHINE FINISH 125 ✓ DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		CHK ME		MATL PROJ QA		SIZE D CAGE CODE 1KNU9 SCALE 1:2		REV A
20007825		1388		AL ALY 6061-T651 PER AMS-QQ-A-250/11				20007832 UNCLASSIFIED SHEET 1 OF 1		
NEXT ASSEMBLY		PROJECT CODE		APPLICATION				REV 6/04		