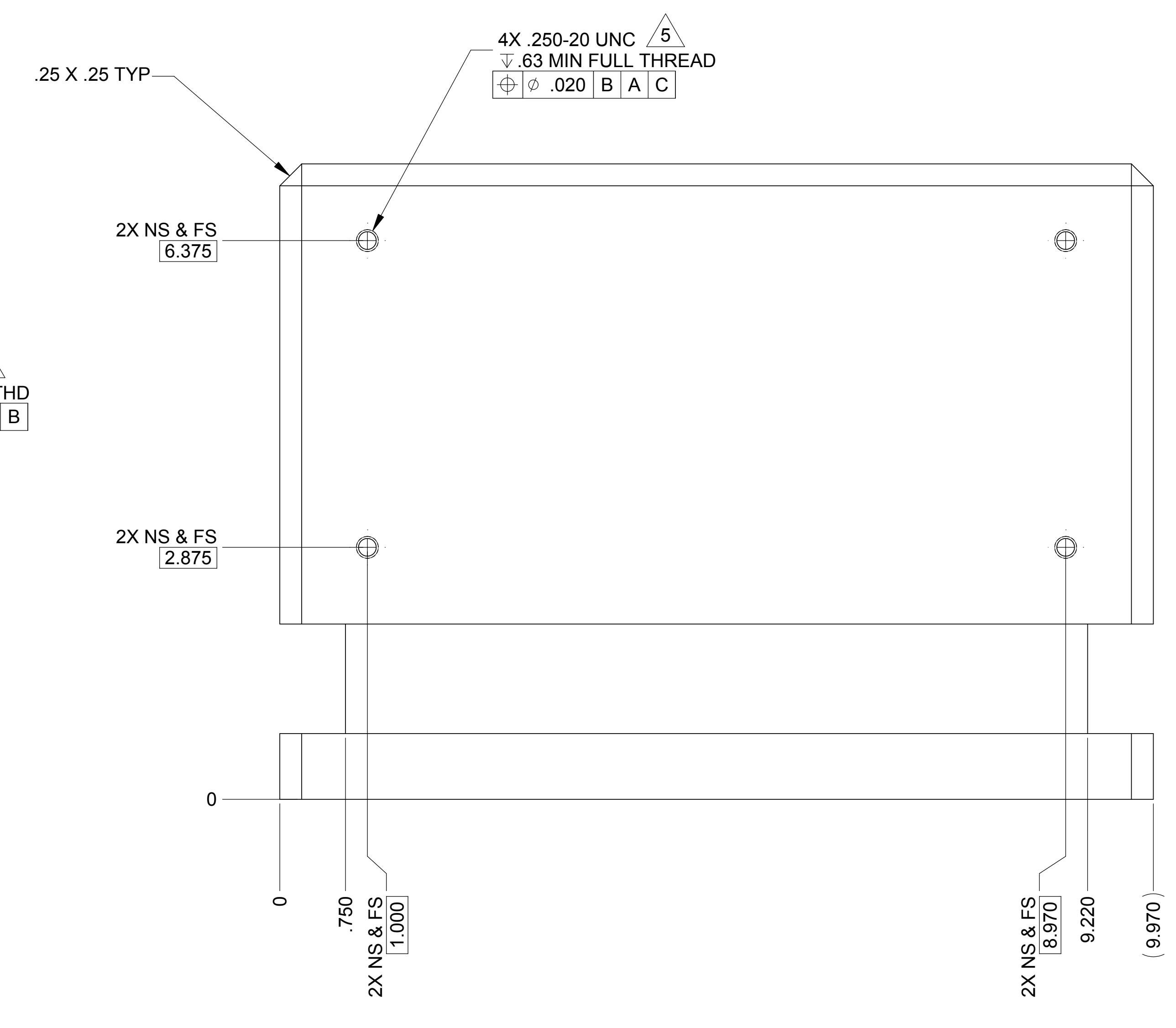
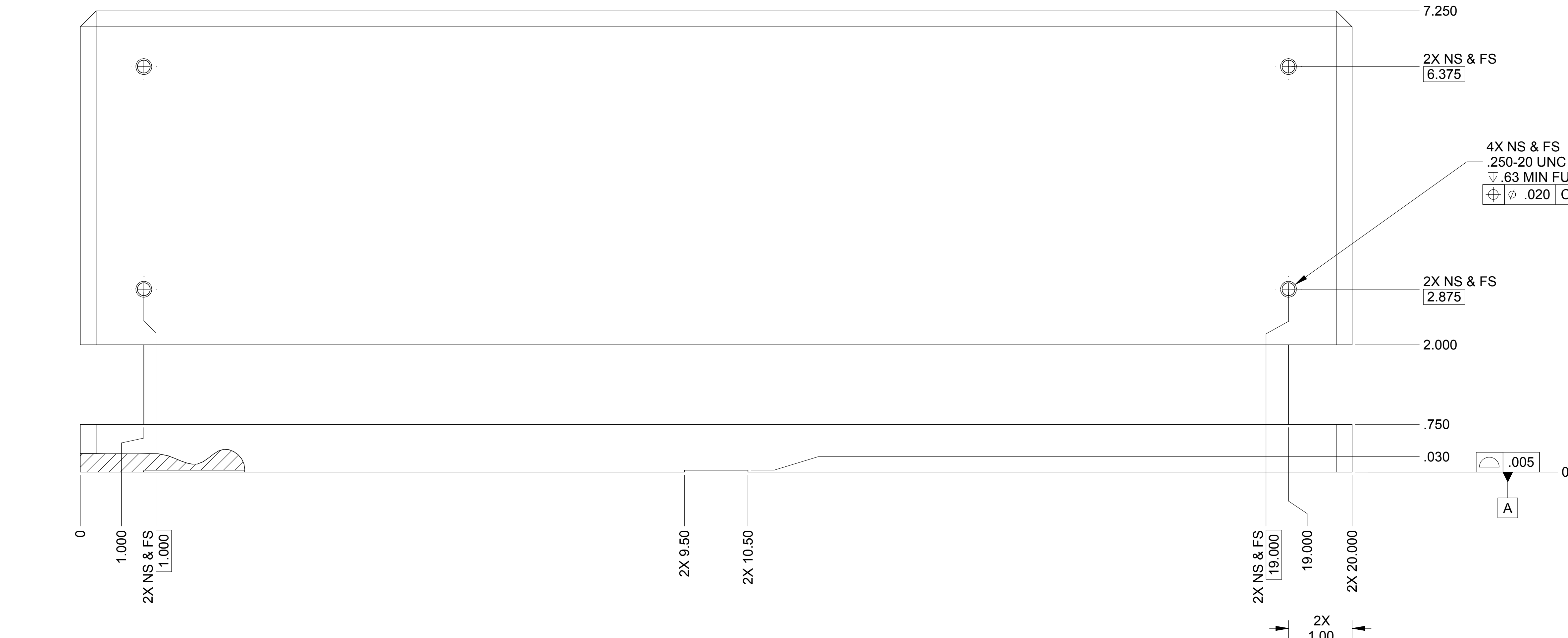
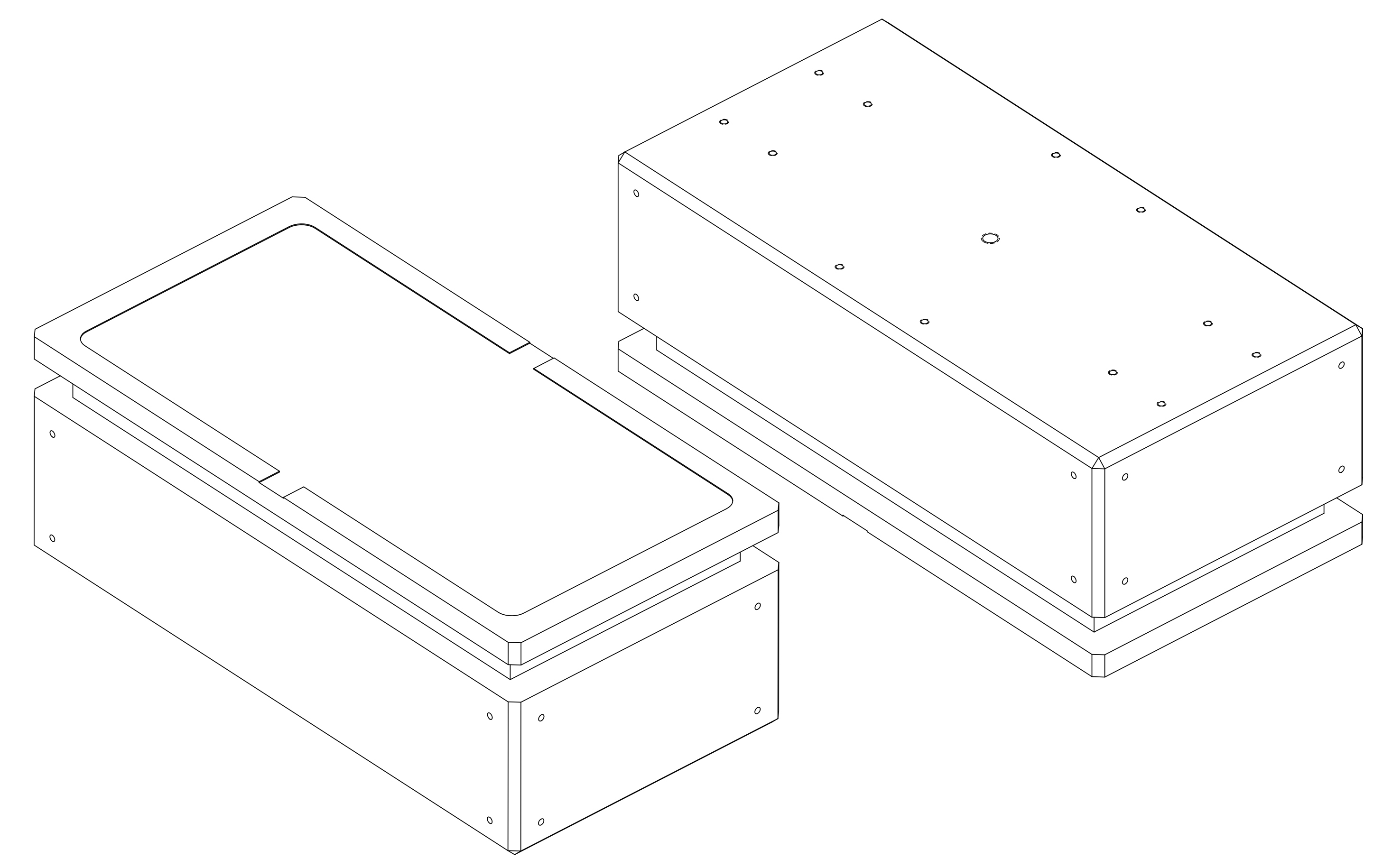
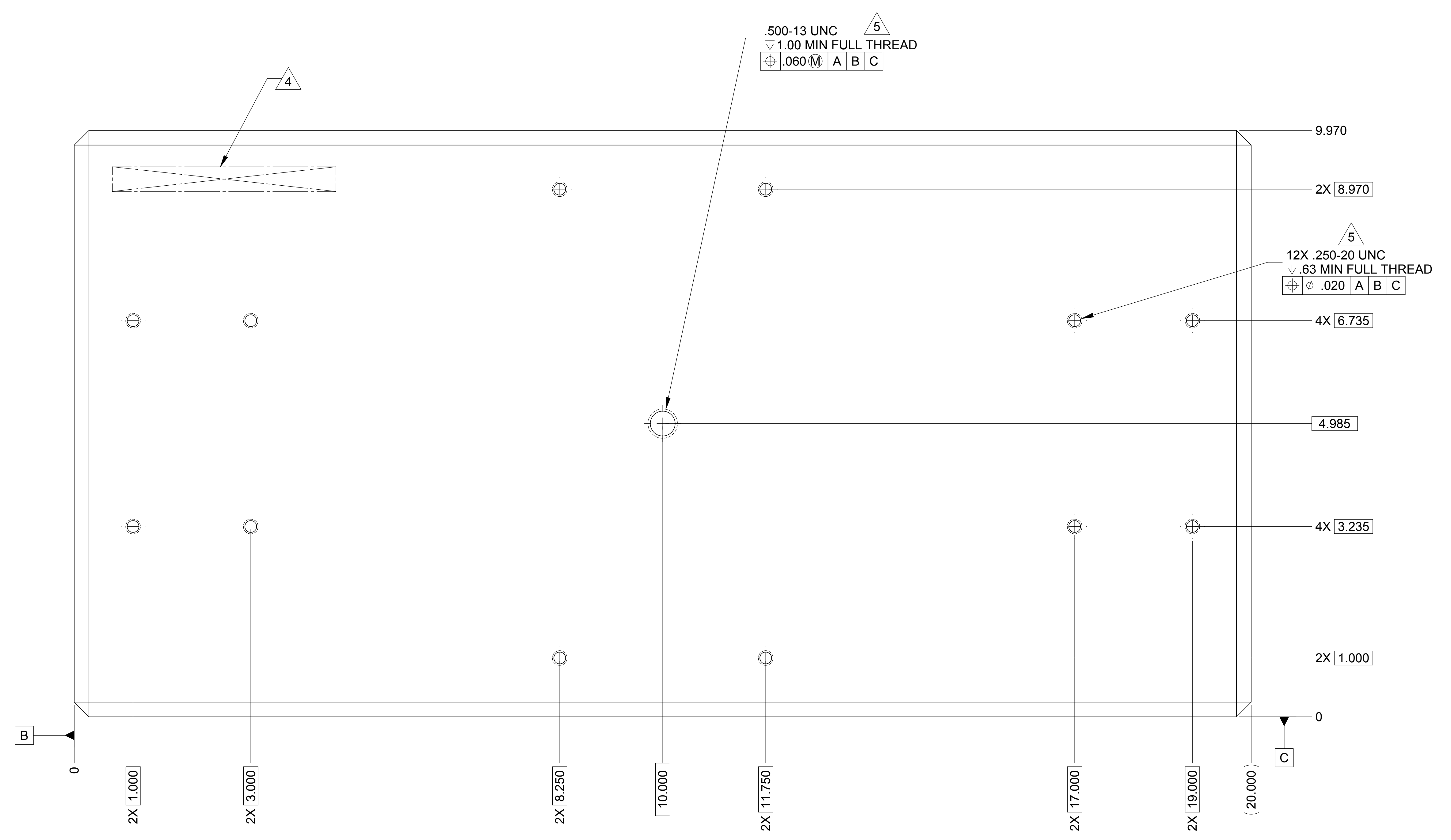


LTR		ZONE		REVISIONS										DWN		CHK		P-ENG		CONF		ME		STRS		MATL		PROJ		QA		RELEASE DATE	
A				INITIAL RELEASE																													



- 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 399.9 LBS.

QTY		REGD	ITEM NO	REF DES	CAGE NO	20007867-1	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		±.12°		125		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994	
20007970		1388		303 CRES FORGING AMS A473		20007867_x_1		303 CRES FORGING AMS A473		20007867	
NEXT ASSEMBLY		PROJECT CODE		APPLICATION		20007867-1		1388		20007867	
SIZE		CAGE CODE		SCALE		1:1		UNCLASSIFIED		SHEET 1 OF 1	
E		1KNU9		1:1		UNCLASSIFIED		SHEET 1 OF 1		REV A	

**RELEASED**  
2/25/2005

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

**KEEL WEIGHT  
STAGE 2  
LIGO-D047867-A**