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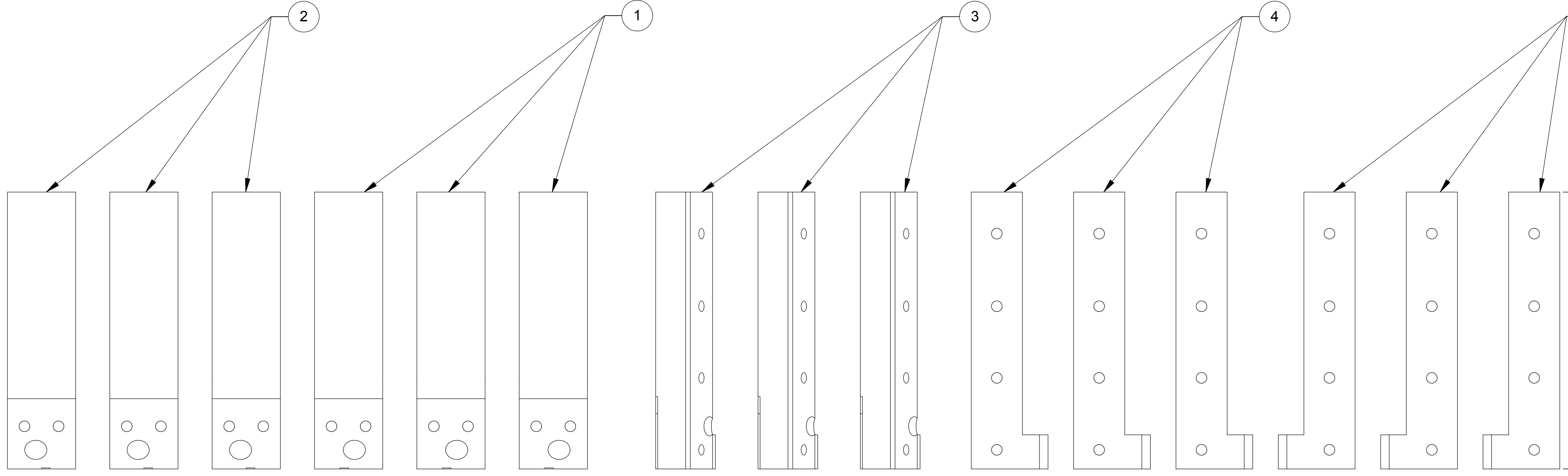
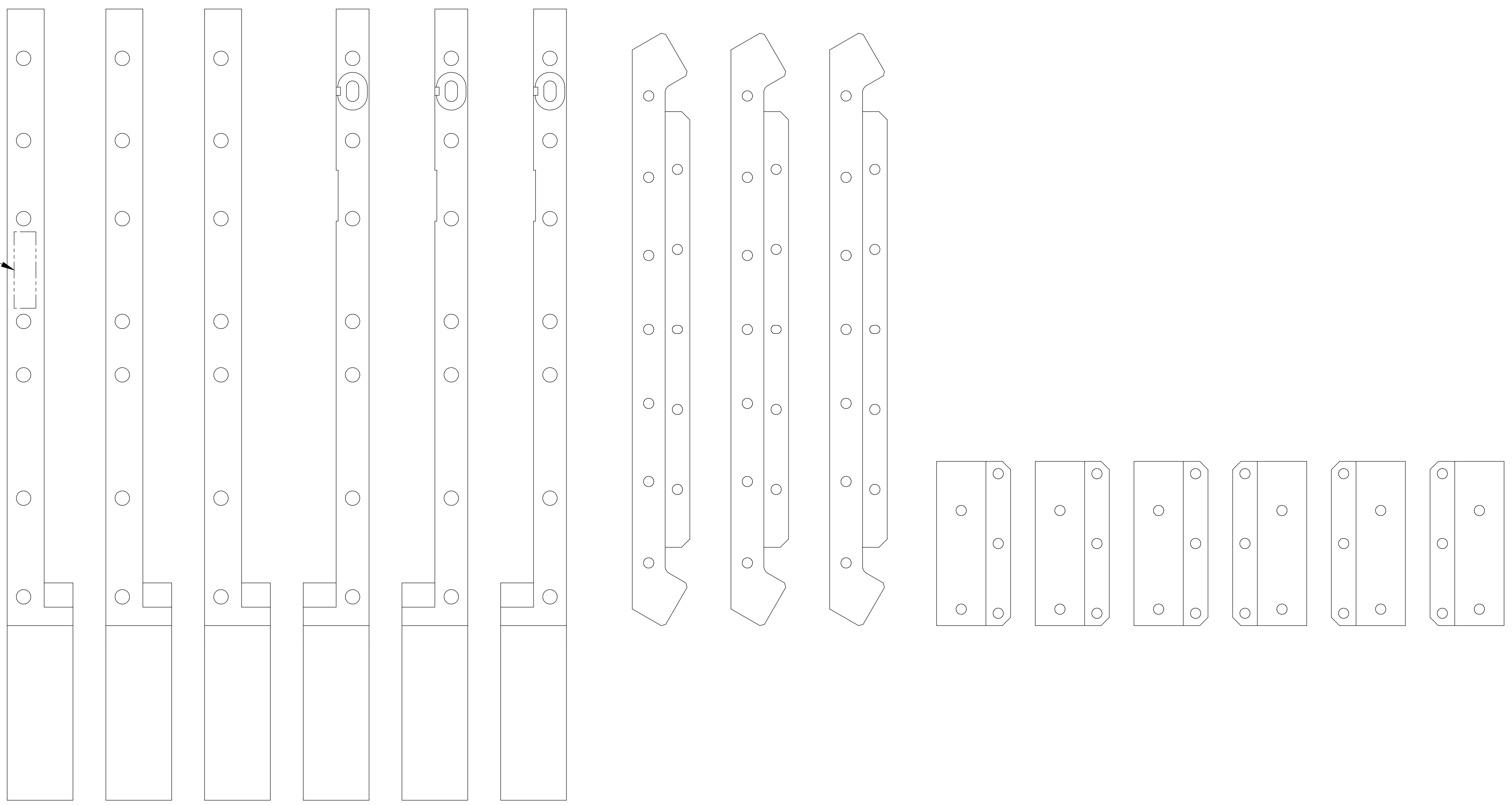
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LTR		REVISIONS										DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A		INITIAL RELEASE																				

3  
15 PARTS

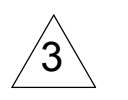


15 SURFACES (ACROSS ALL PARTS)  
A .001 A

15X 8.120±.005

15 SURFACES  
A .001 A

A

- NOTES: UNLESS OTHERWISE SPECIFIED.
- THIS DOCUMENT CONTROLS FINAL HEIGHT OF STAGE 2 STRUCTURE WALLS.
  - PARTS SHALL NOT BE MARKED WITH THIS DOCUMENT NUMBER.
  -  SURFACE TO BE MACHINED IS MARKED WITH THE PART NUMBER, DASH NUMBER, AND THE LETTER "P". FOR EXAMPLE: 20007852-1P. THIS MARKING WILL BE REMOVED DURING THE MACHINING PROCESS. NO FURTHER MARKING IS REQUIRED.
  - 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.
  - COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
  - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.

CONTRACT NO	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
3	5			20007854-2P	HEX HALF WALL, RT, STAGE 2			
3	4			20007854-1P	HEX HALF WALL, LT, STAGE 2			
3	3			20007853-1P	ANGLED HEX WALL, STAGE 2			
3	2			20007852-1P	PLATE, SIDE (GS-13) STAGE 2			
3	1			20007851-1P	PLATE, SIDE STAGE 2			

<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES</p> <p>DECIMALS ANGLES</p> <p>.XX ±.03 XXX ±.010 ±1/2°</p> <p>MACHINE FINISH 125/</p> <p>DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994</p>		<p><b>RELEASED</b> 2/17/2005</p> <p>ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103</p> <p><b>FINAL CUT - WALL HEIGHT STAGE 2</b> <b>LIGO D047871-A</b></p> <p>SCALE 1:4</p>	<p>CONTRACT NO</p> <p>20007845</p> <p>NEXT ASSEMBLY</p> <p>1388</p> <p>PROJECT CODE</p> <p>APPLICATION</p>
<p>FILE ATTACHMENTS</p> <p>20007871 Final Wall Cut Stage 2.x_t</p>			

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

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