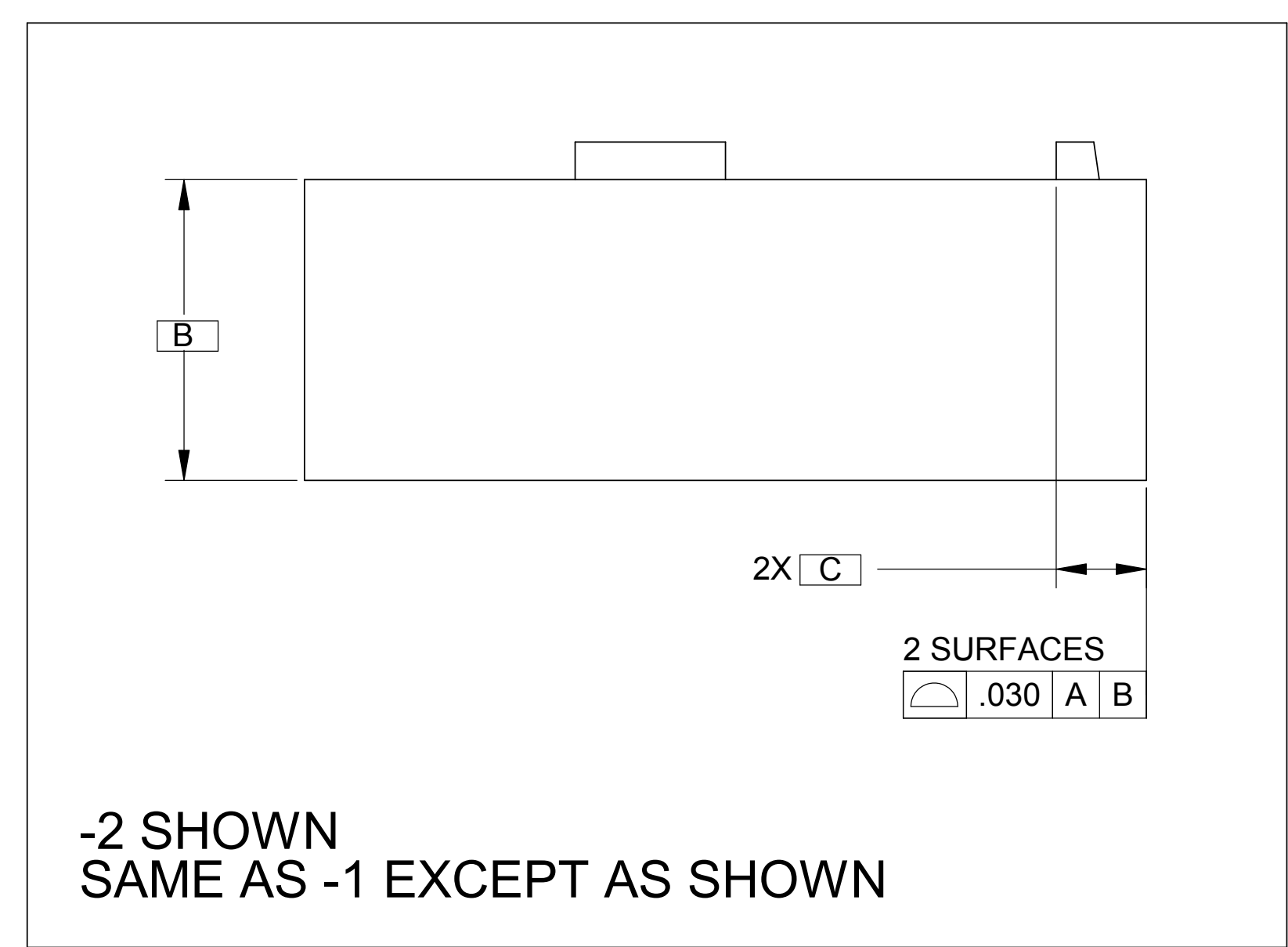
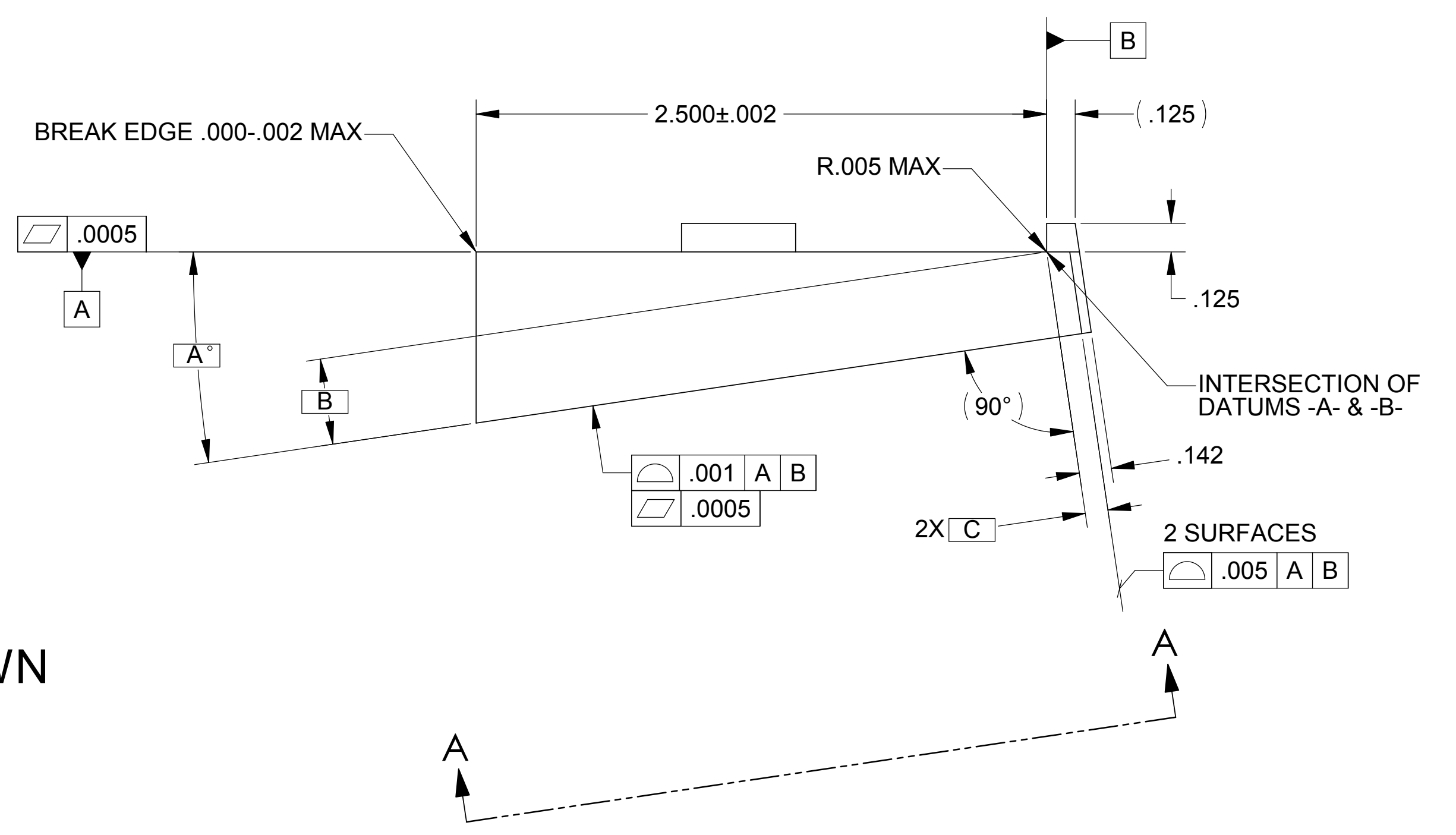
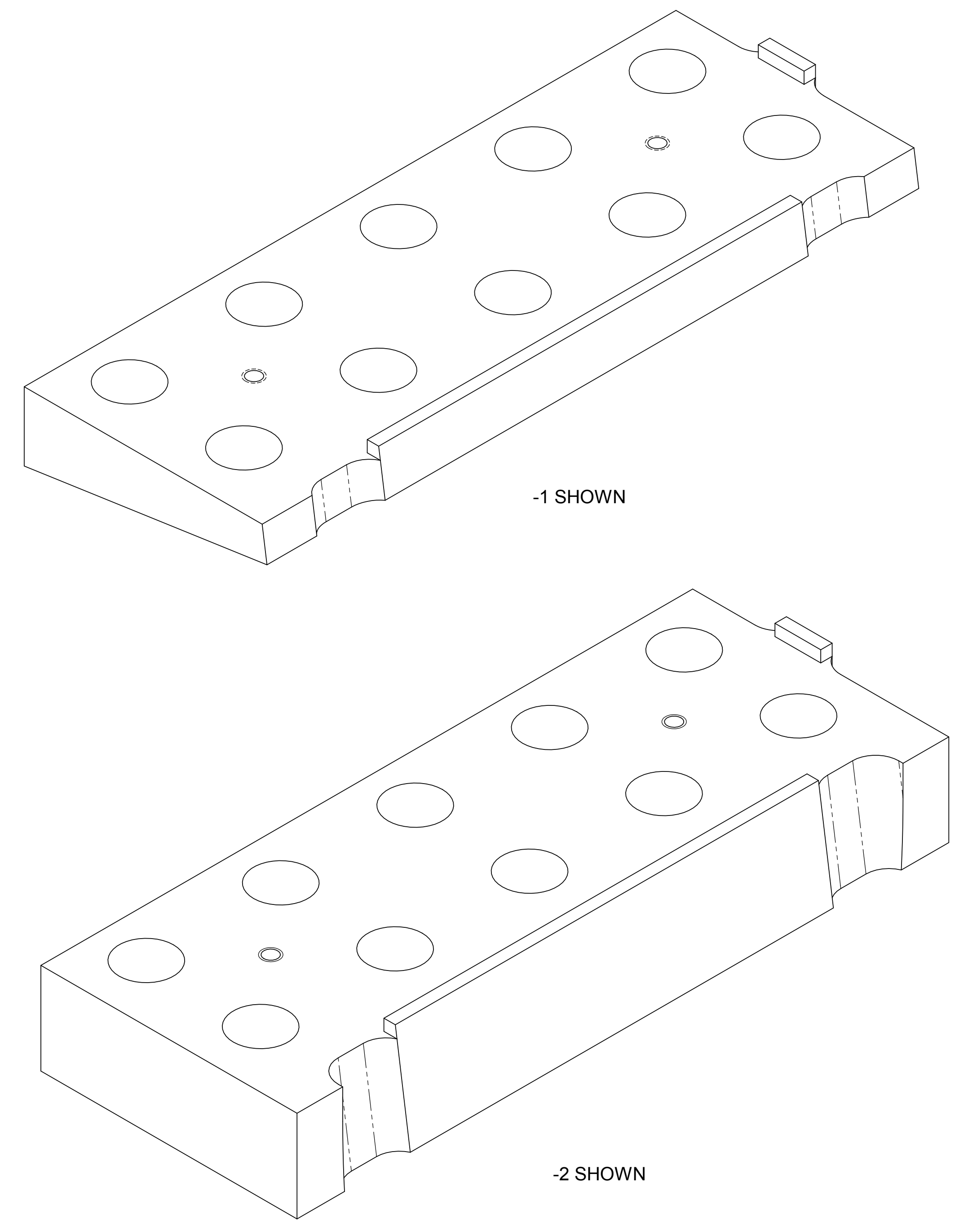
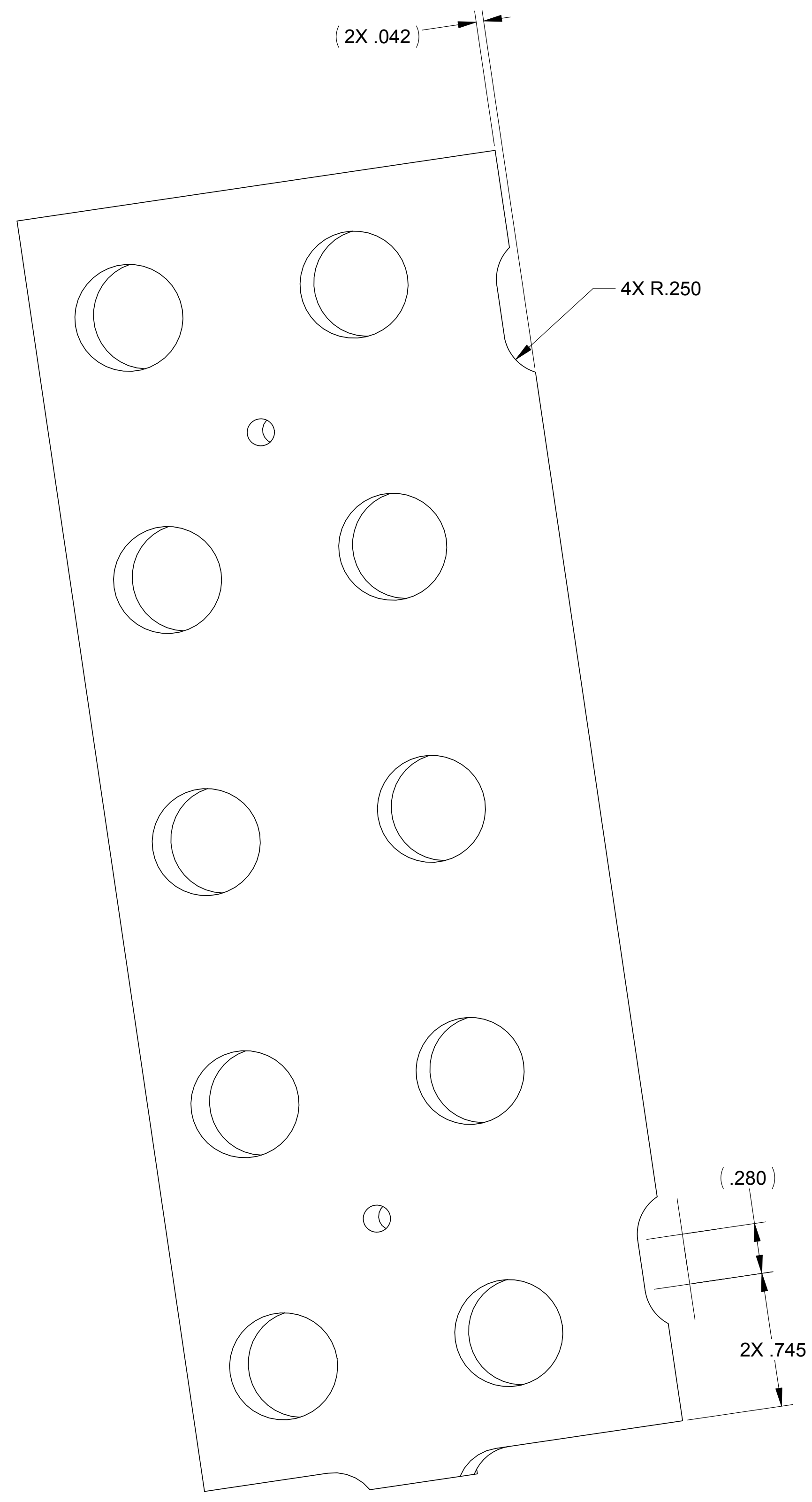
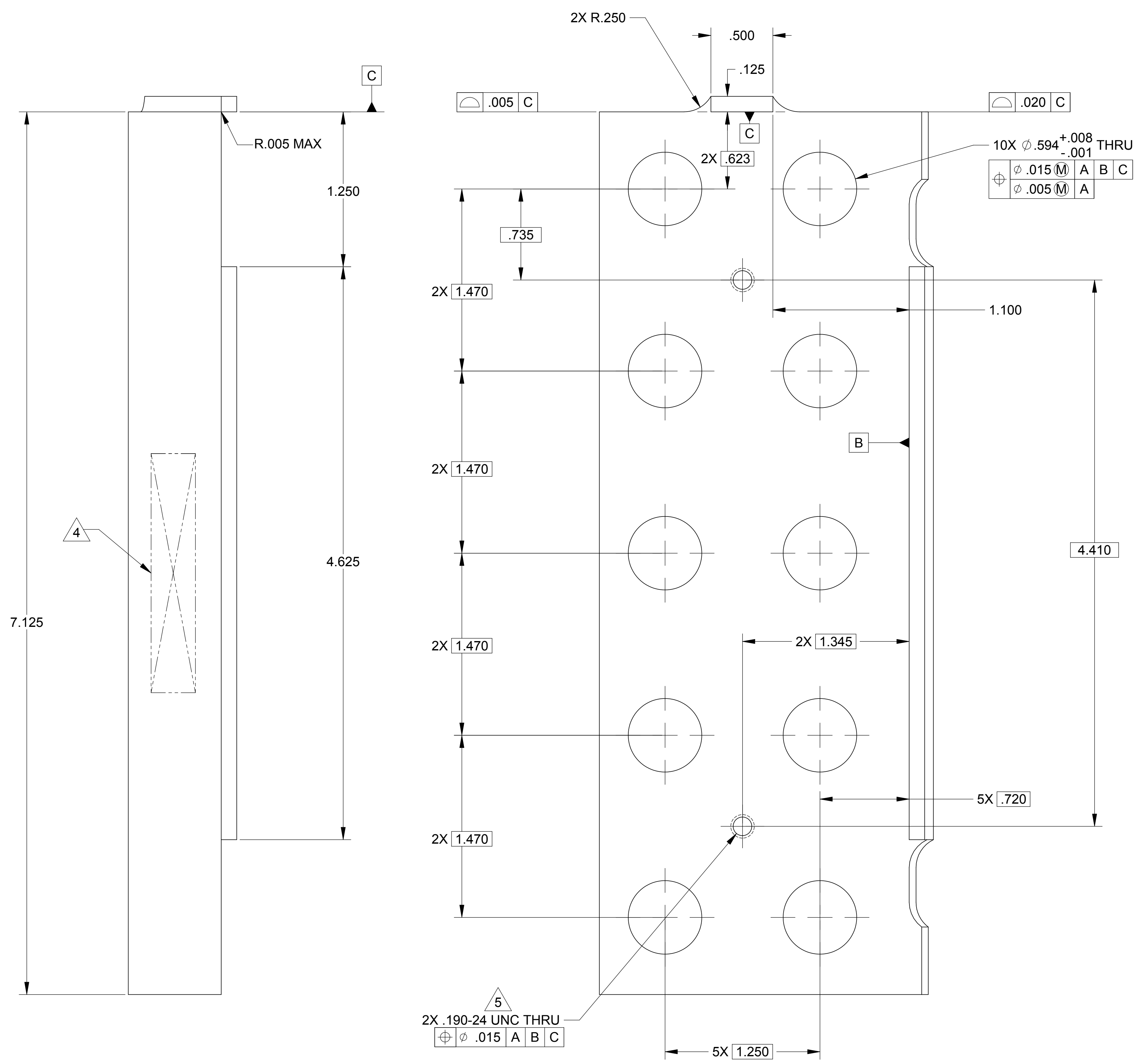


LTR		ZONE		REVISIONS										DWN		CHK		P-ENG		CONF		ME		STRS		MATL		PROJ		QA		RELEASE DATE	
A				INITIAL RELEASE																													



- 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 .005-.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 2.8 LBS.
 - TABLE SHOWS PARAMETRIC VALUES FOR NOMINAL AND UNCUT SHIM. NOMINAL VALUES FOR DIMENSIONS A, B, AND C SUBJECT TO CHANGE AFTER FIRST INSTALLATION AND PERFORMANCE EVALUATION.

CONFIG	A°	B	C
-1	8.400	3.770	0.100
-2	0.000	1.000	0.300

20007885-2	SHIM, UNCUT
20007885-1	SHIM, CUT

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		RELEASED 2/25/2005		asi ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
NEXT ASSEMBLY		MACHINE FINISH 125/		DWN R.D.BILLING 07/23/04 PROJ ENGR STRS		STAGE 0-1 SHIM, BLADE SPRING LIGO-D047885-A	
APPLICATION		MATERIAL CRES 303 FORGING PER AMS A473		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994		SIZE E CAGE CODE 1KNU9 SCALE 2:1	
				20007878 1388 PROJECT CODE		20007885 UNCLASSIFIED SHEET 1 OF 1	

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