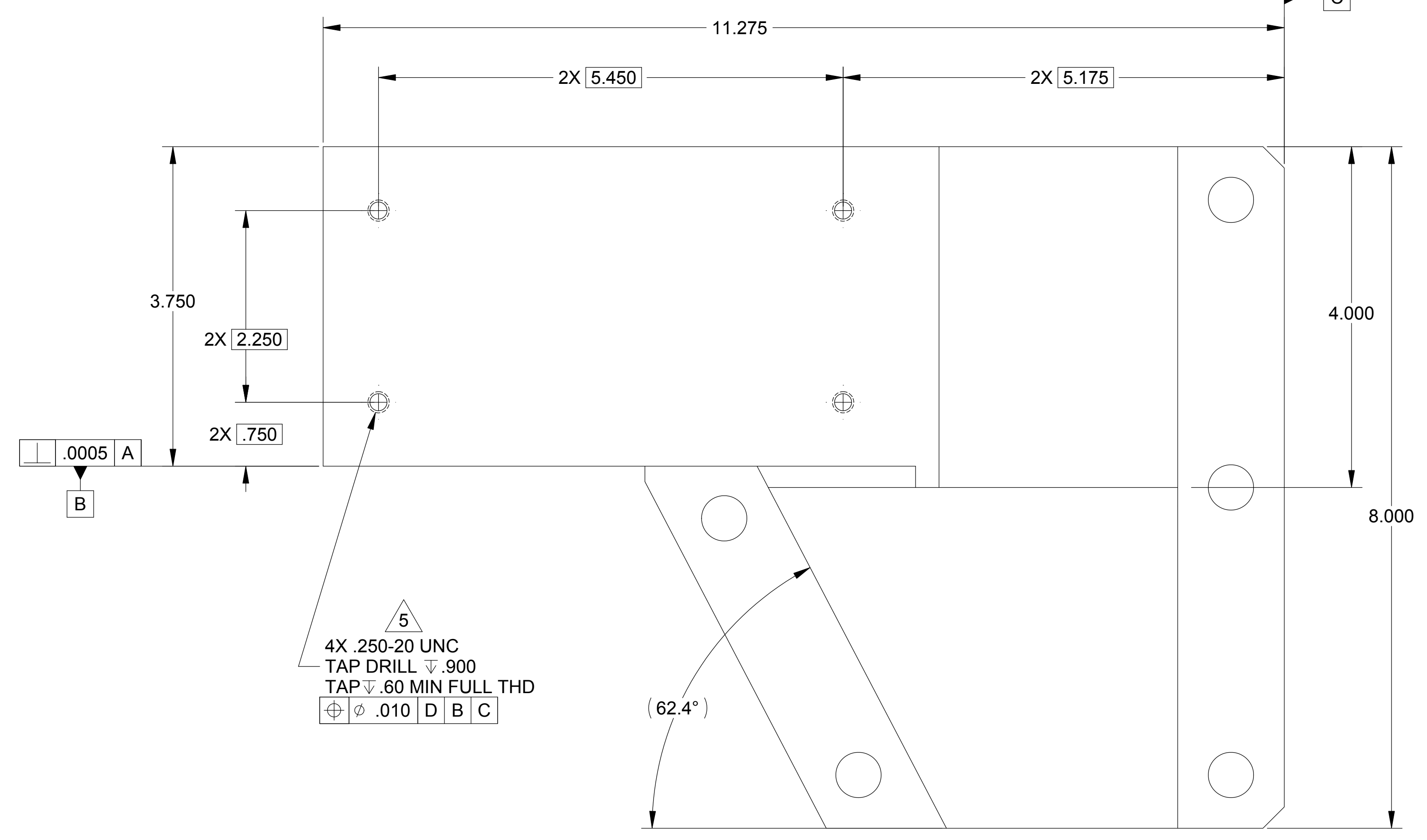
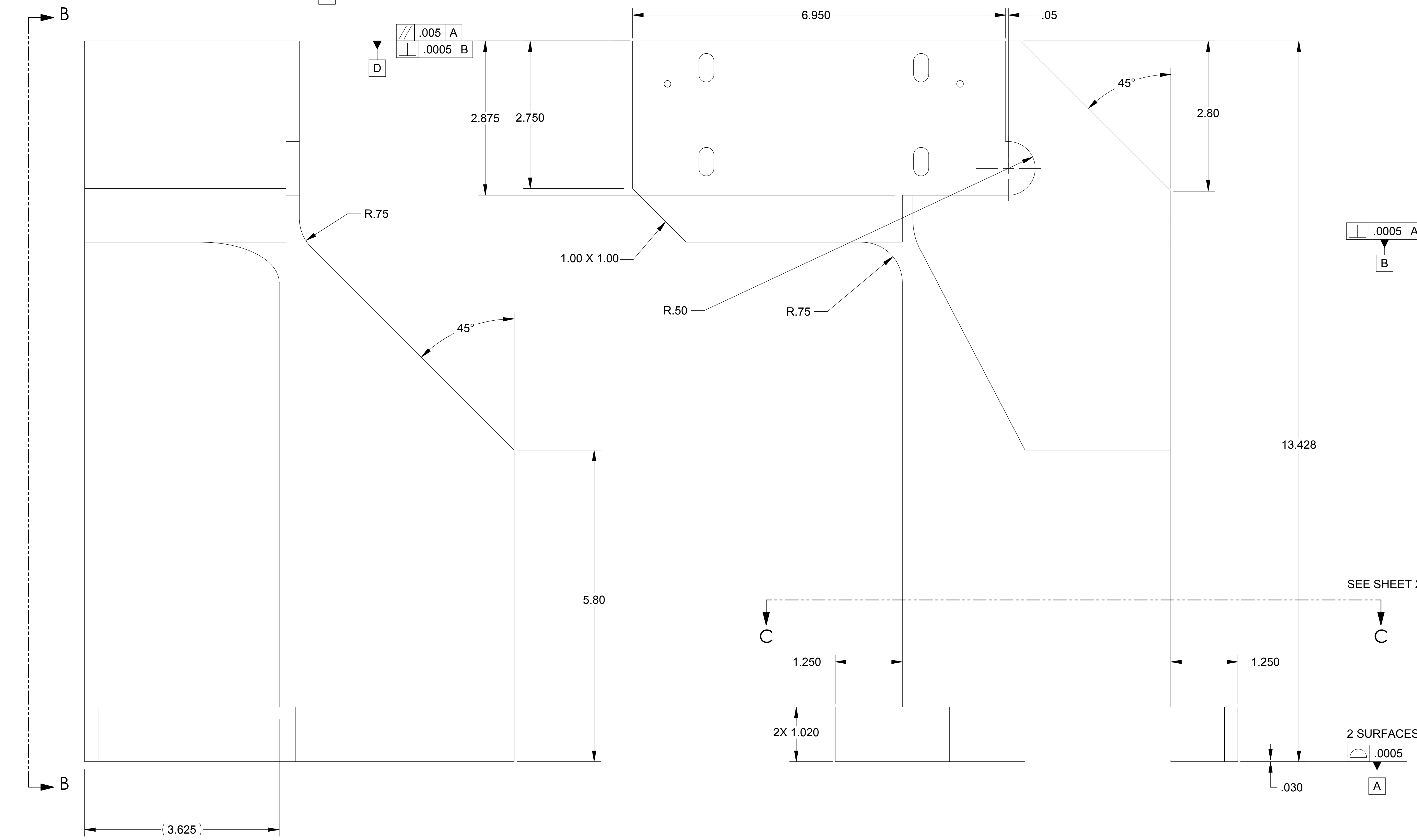


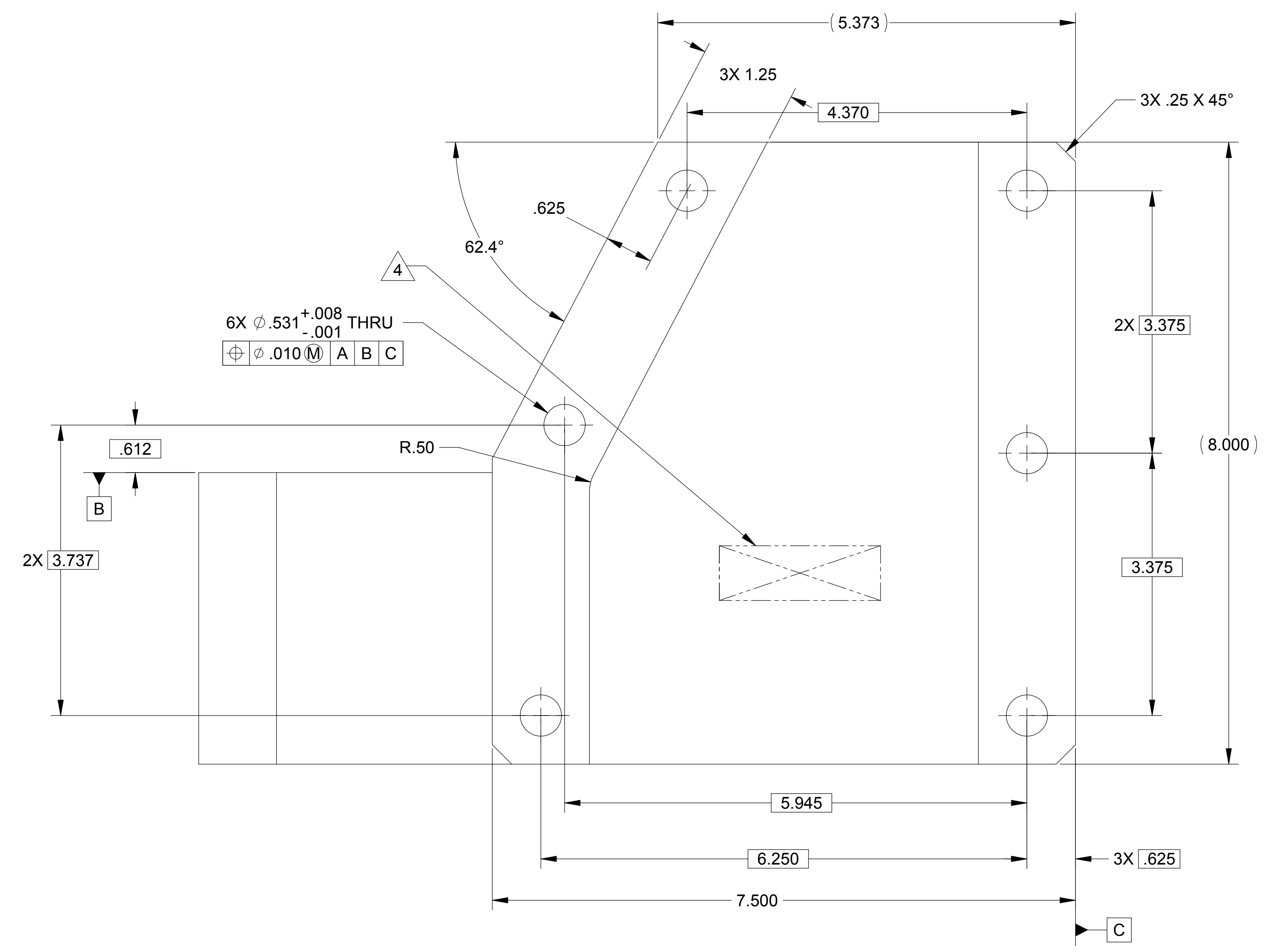
LTR		ZONE		REVISIONS										DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A				INITIAL RELEASE																				

SEE SHEET 2



VIEW A-A

5  
4X .250-20 UNC  
TAP DRILL  $\nabla$ .900  
TAP  $\nabla$ .60 MIN FULL THD  
 $\oplus$   $\phi$  .010 | D | B | C



- 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 44.6 LBS.

QTY REQD		ITEM NO	REF DES	CAGE NO	20007903-1	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	
MATERIAL		AL 6061-T651		AMS-QQ-A-250/11		DWN R.D.BILLING		07/22/04		STRS	
20007970		1388				DWN R.D.BILLING		07/22/04		STRS	
NEXT ASSEMBLY		PROJECT CODE				DWN R.D.BILLING		07/22/04		STRS	
APPLICATION						DWN R.D.BILLING		07/22/04		STRS	
FILE ATTACHMENTS		20007903.x_1				DWN R.D.BILLING		07/22/04		STRS	
SCALE		1:1				DWN R.D.BILLING		07/22/04		STRS	
UNCLASSIFIED		SHEET 1 OF 2				DWN R.D.BILLING		07/22/04		STRS	

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

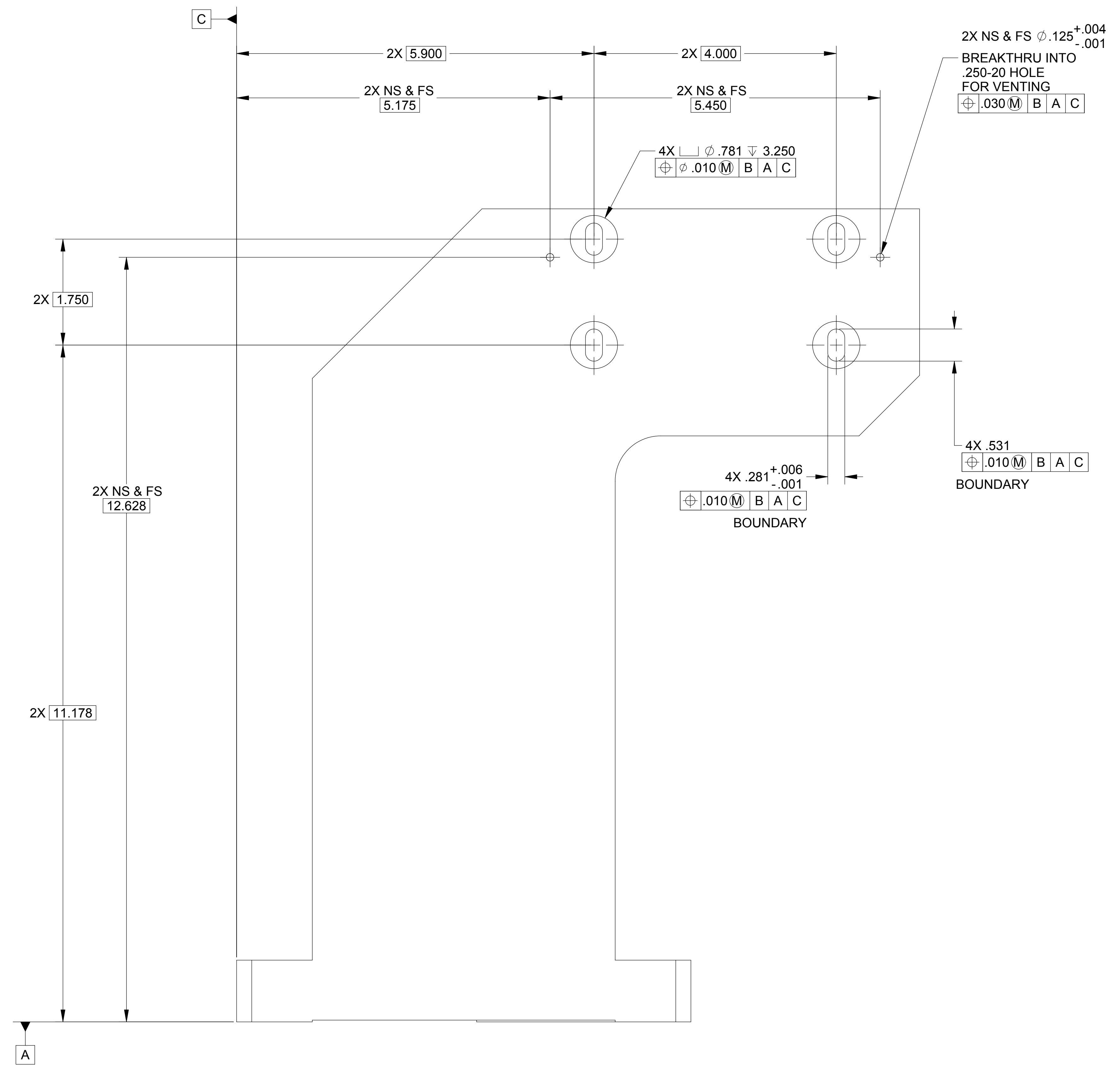
asi ALLIANCE SPACESYSTEMS, INC.  
1250 Lincoln Ave., Suite 100  
Pasadena, CA 91103

STAGE 0-1  
ACTUATOR POST  
LIGO-D047903-A

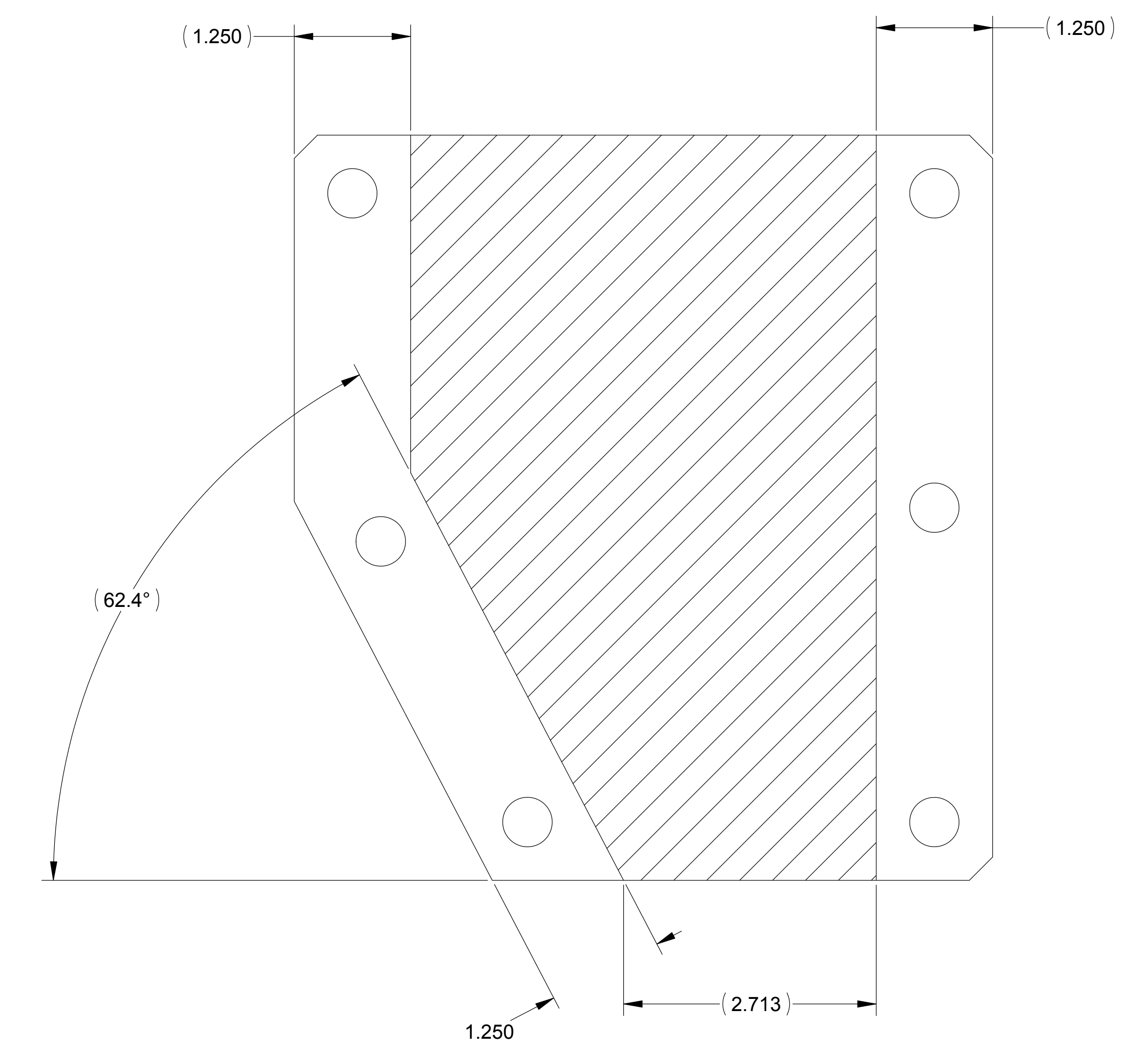
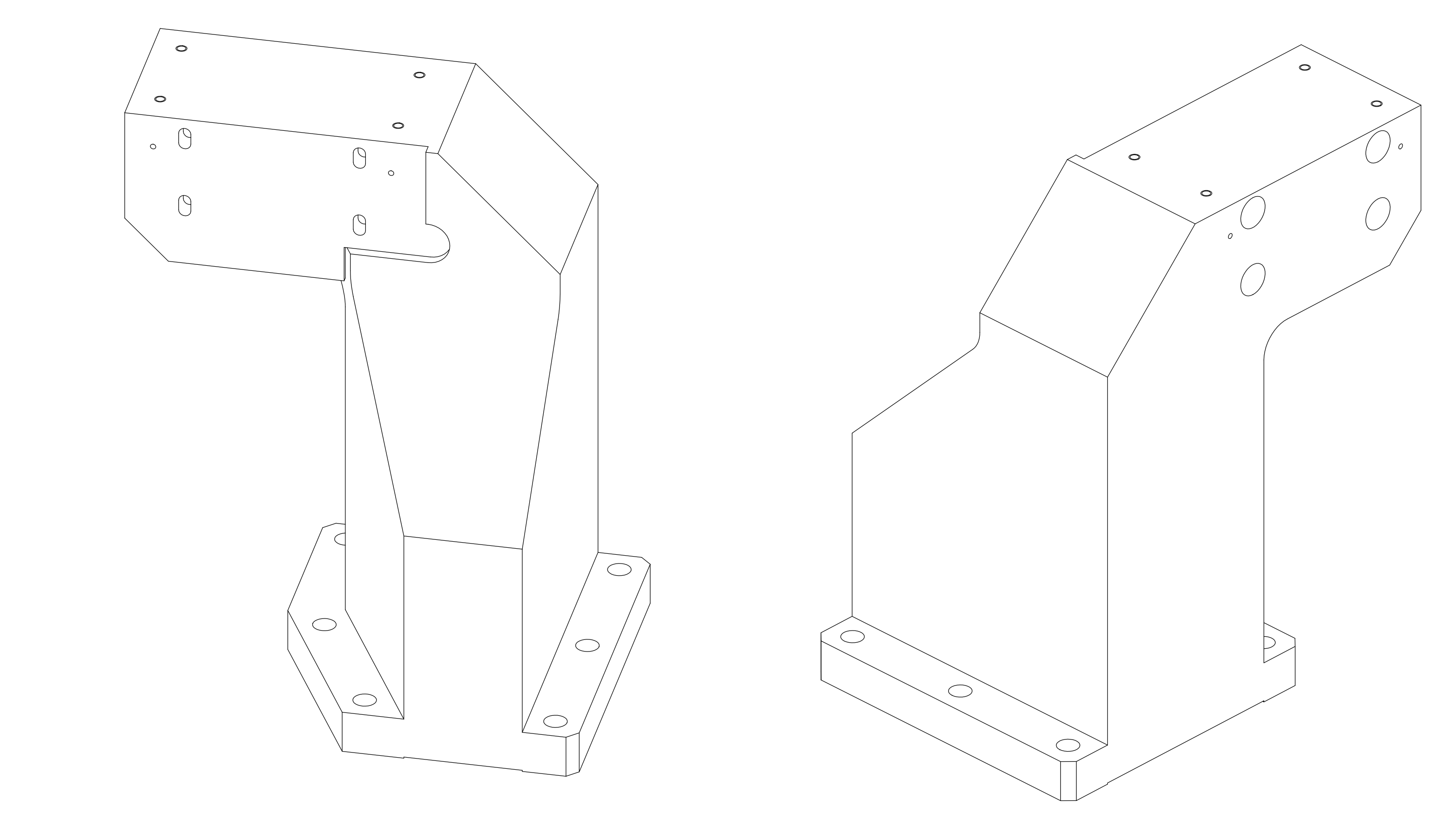
SIZE E CAGE CODE 1KNU9 20007903 REV A

8 7 6 5 4 3 2 1

H G F E D C B A



VIEW B-B



SECTION C-C

8 7 6 5 4 3 2 1

H G F E D C B A