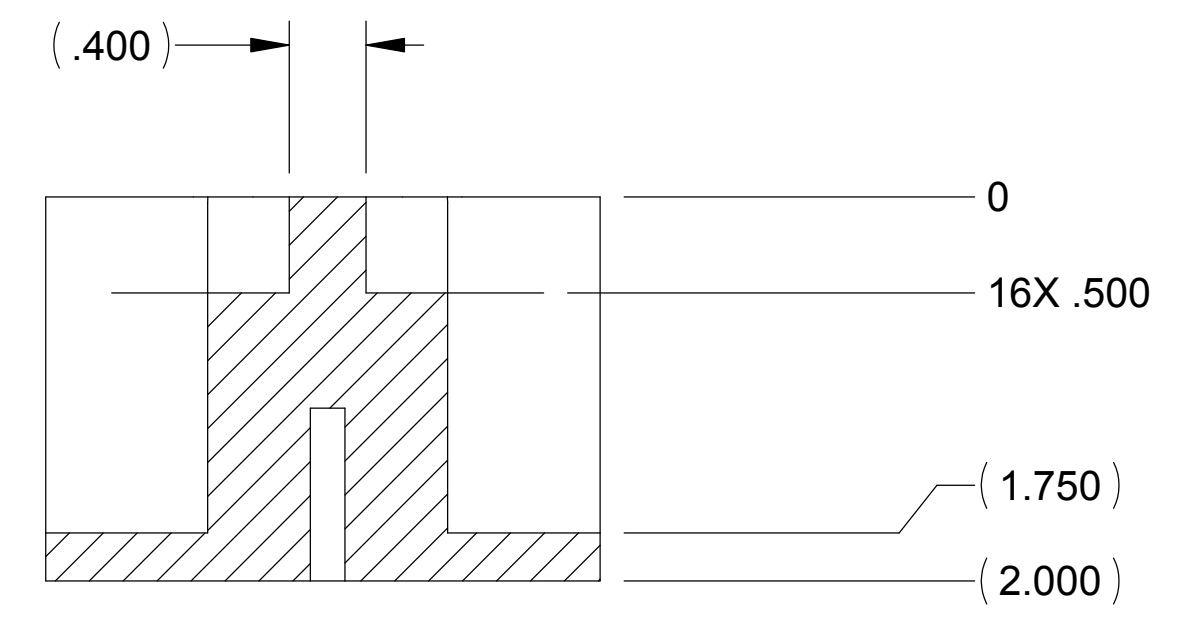
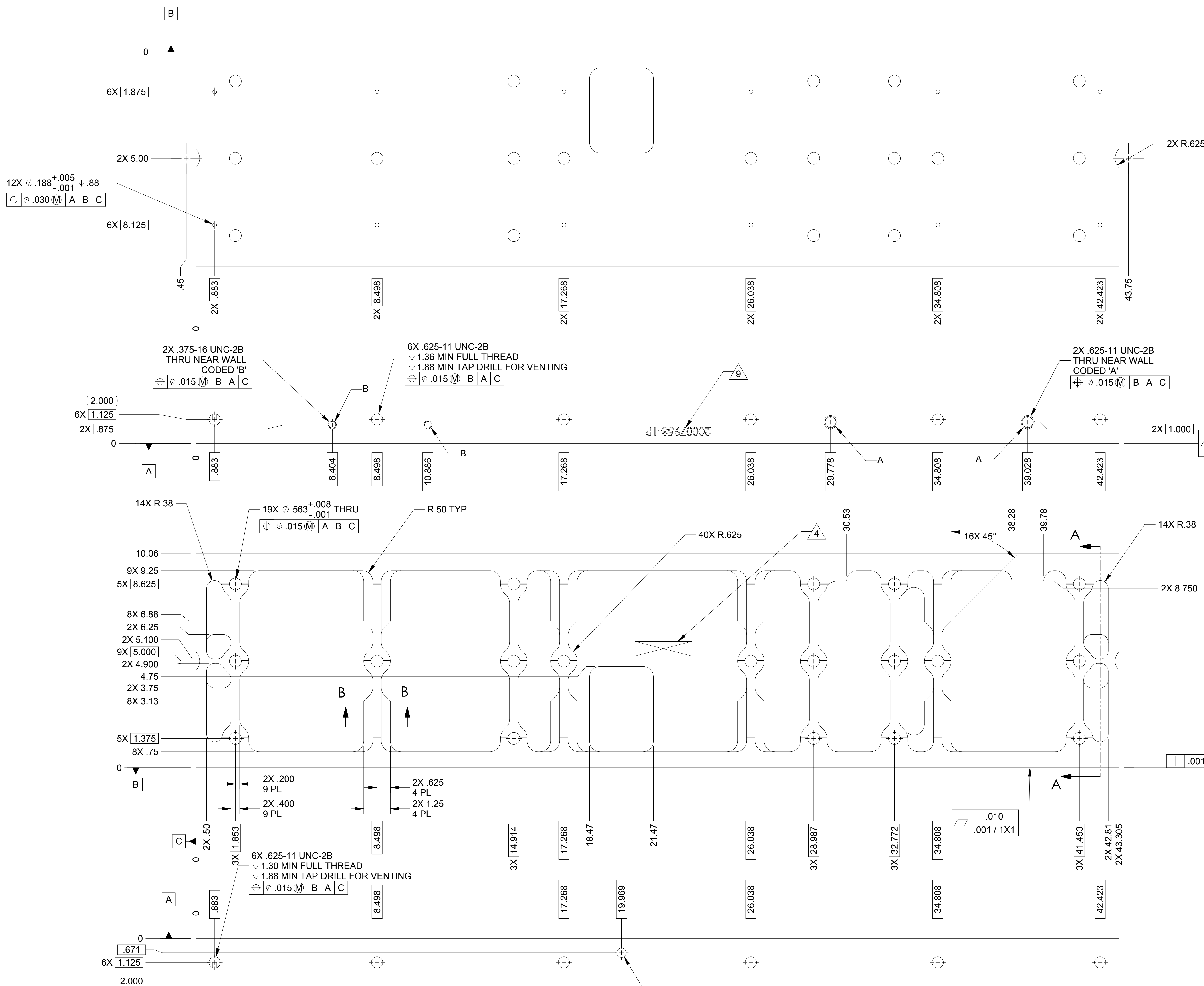
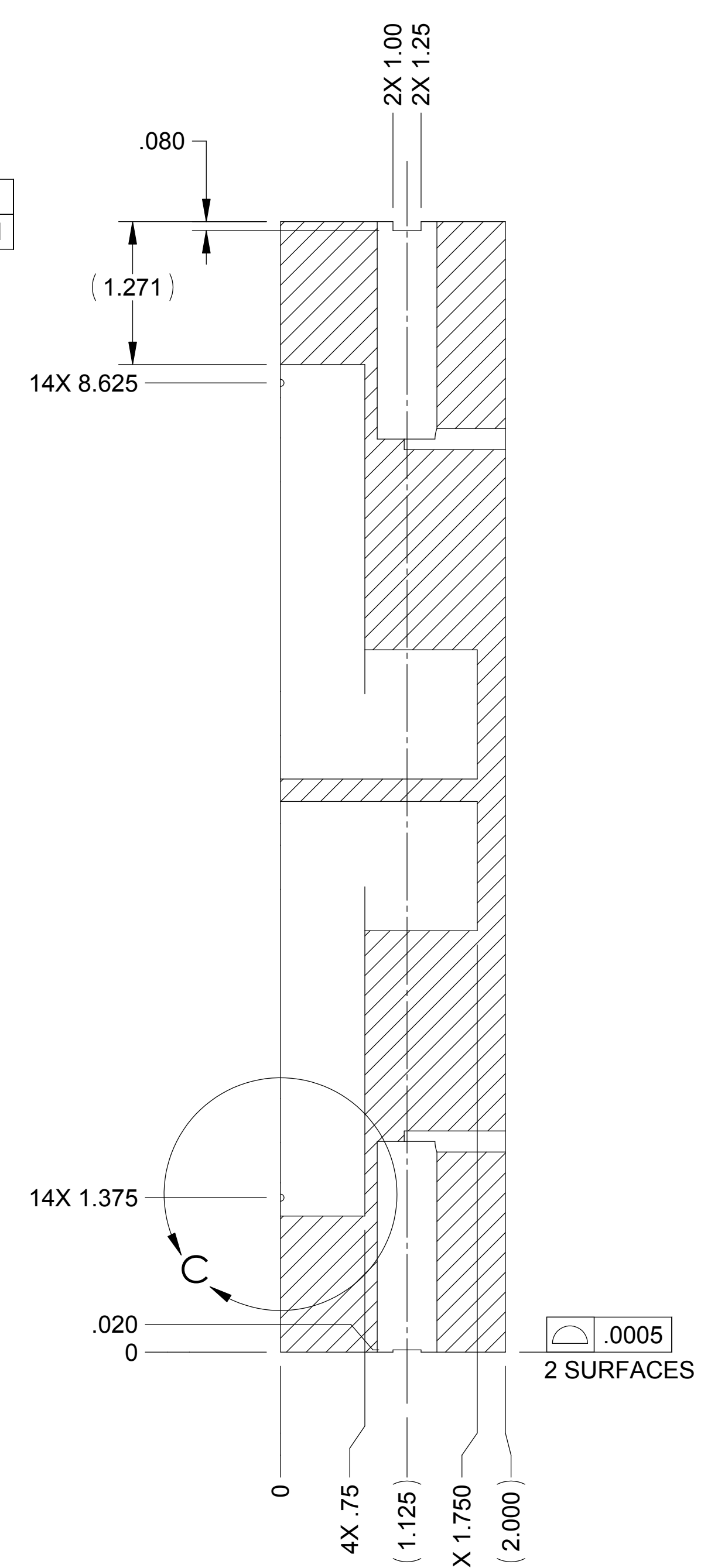


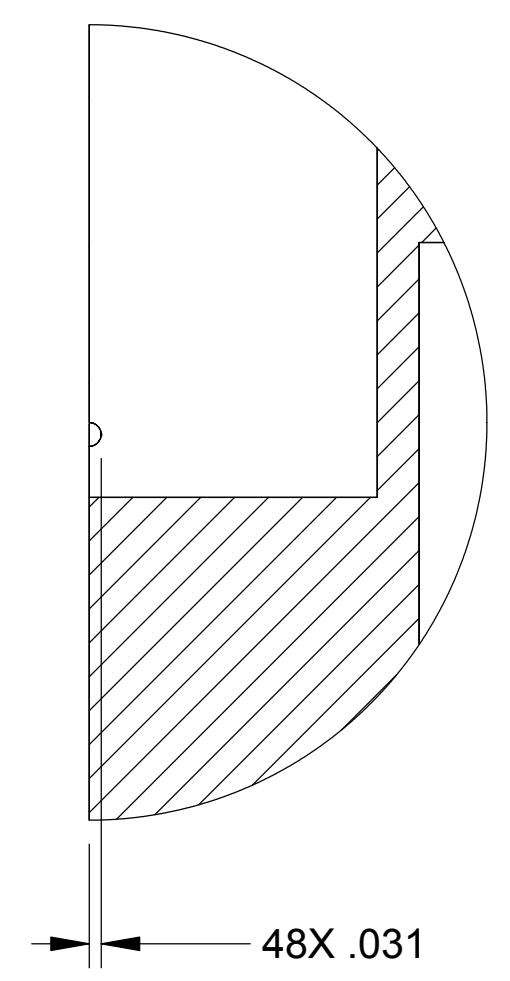
LTR		ZONE		REVISIONS									
NO	DATE	BY	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE		
A													
INITIAL RELEASE													



SECTION B-B  
SCALE 1 : 1



SECTION A-A  
SCALE 1 : 1



DETAIL C  
SCALE 2 : 1

- 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 20006886, 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 20006886, TYPE II.
  - THREADED HOLES NOT REQUIRING INSERTS SHALL BE TAPPED .004-.006 OVERSIZE.
  - COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-0.00.
  - 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 PER DASH NUMBER IS: 20007953-1P=34.1 LBS, 20007953-2P=34.2 LBS, 20007953-3P=34.6 LBS
  - MARK PART NUMBER AND DASH NUMBER WITH THE LETTER P AFTER THE DASH NUMBER IN APPROXIMATE LOCATION SHOWN. USE ANY METHOD THAT WILL NOT RUB OFF OR SMUDGE UNDER NORMAL HANDLING. THIS MARKING DOES NOT NEGATE NOTE 4 AND WILL BE REMOVED DURING SUBSEQUENT OPERATION DEPICTED IN DRAWING 20007960.
  - THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE THE MODEL DATABASE WILL TAKE PRECEDENCE.

**-1 SHOWN  
-2 SEE SHEET 2  
-3 SEE SHEET 3**

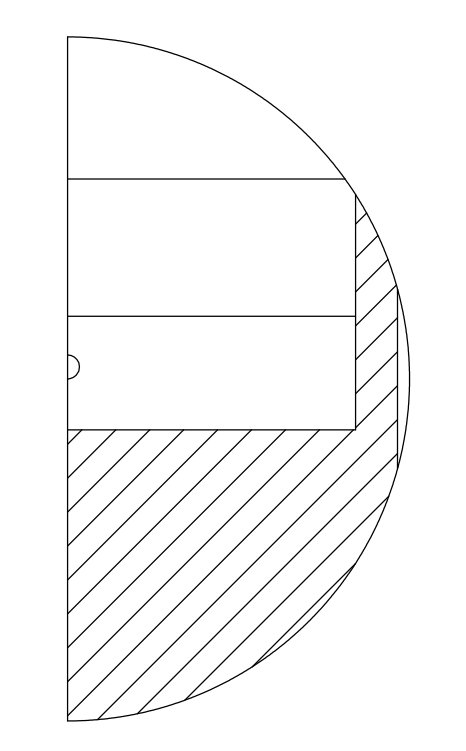
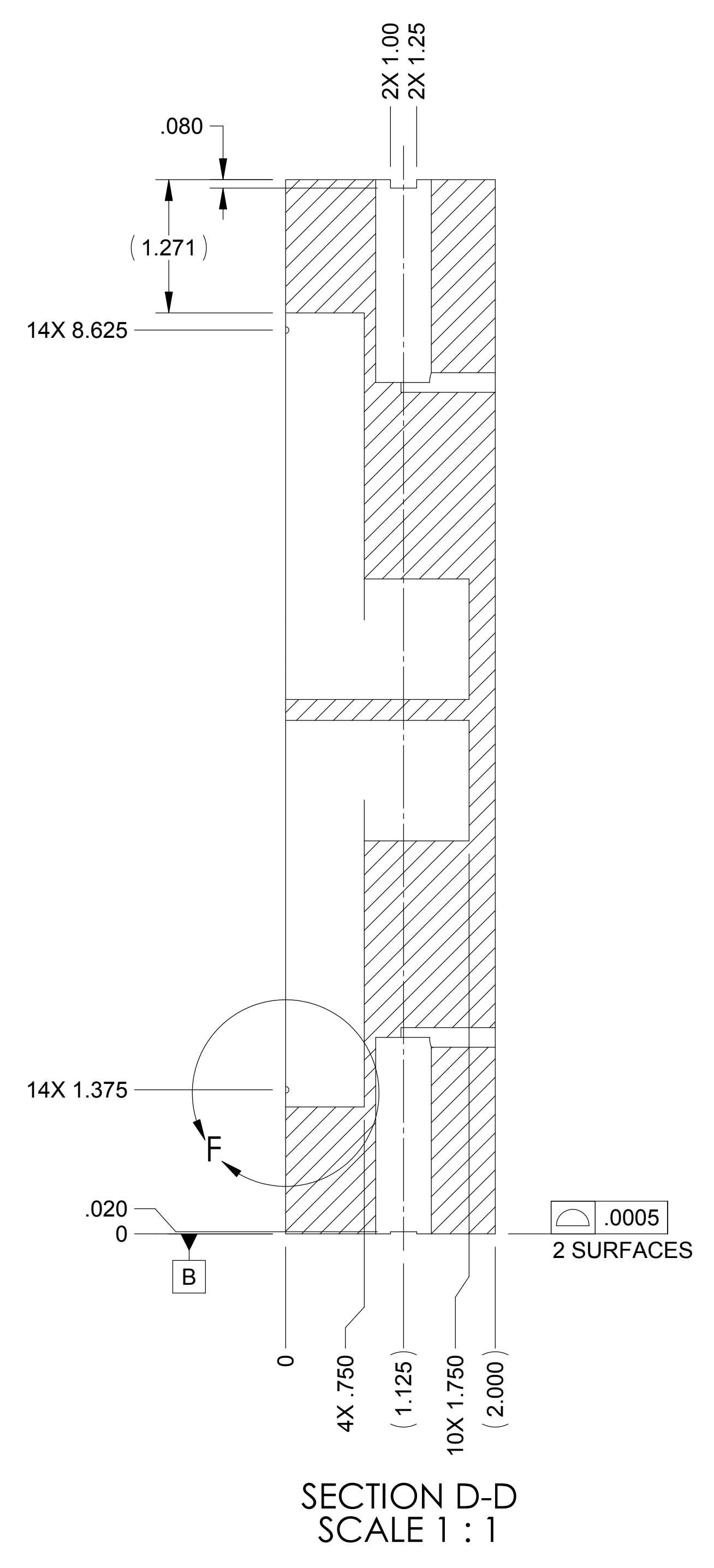
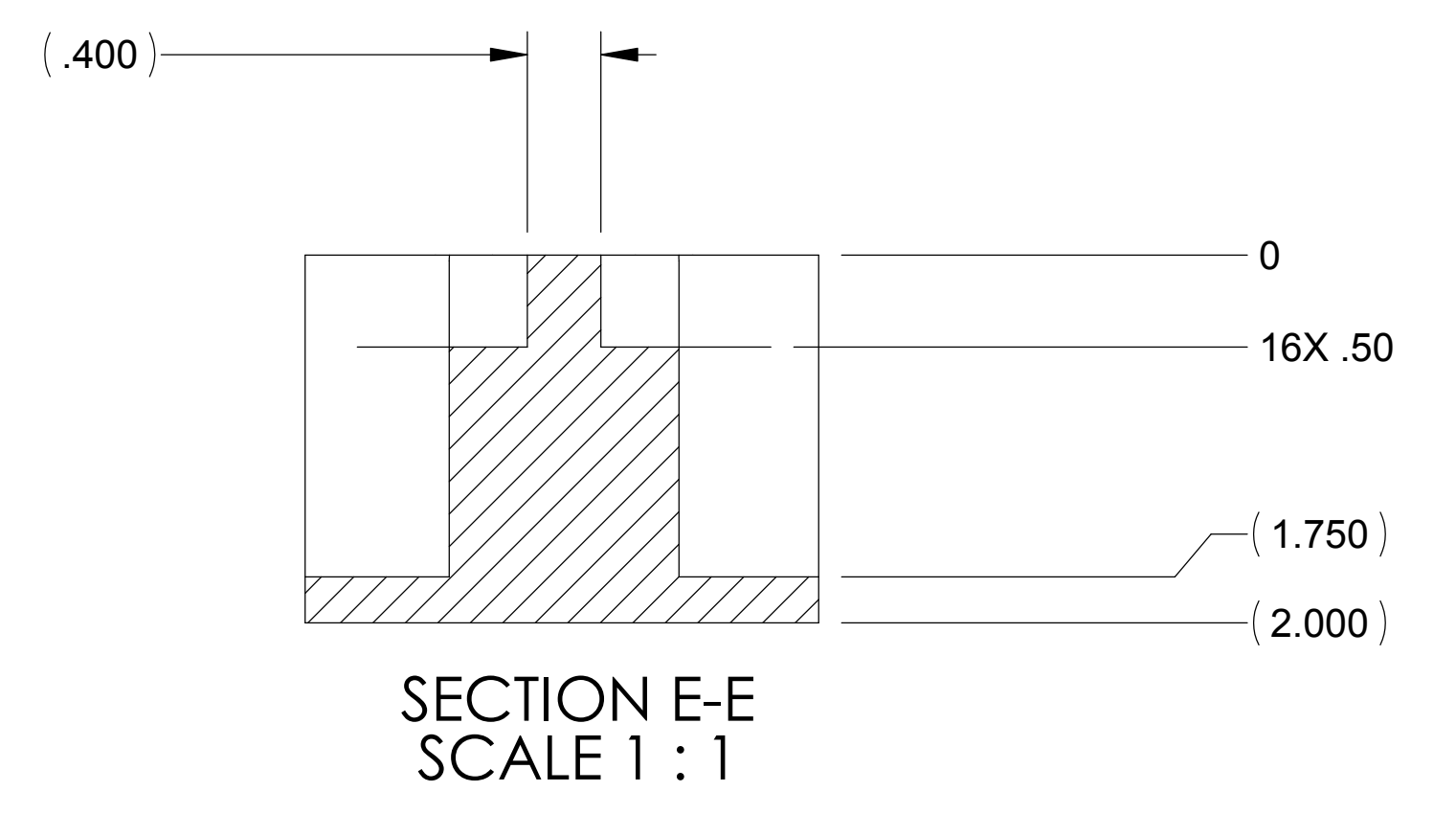
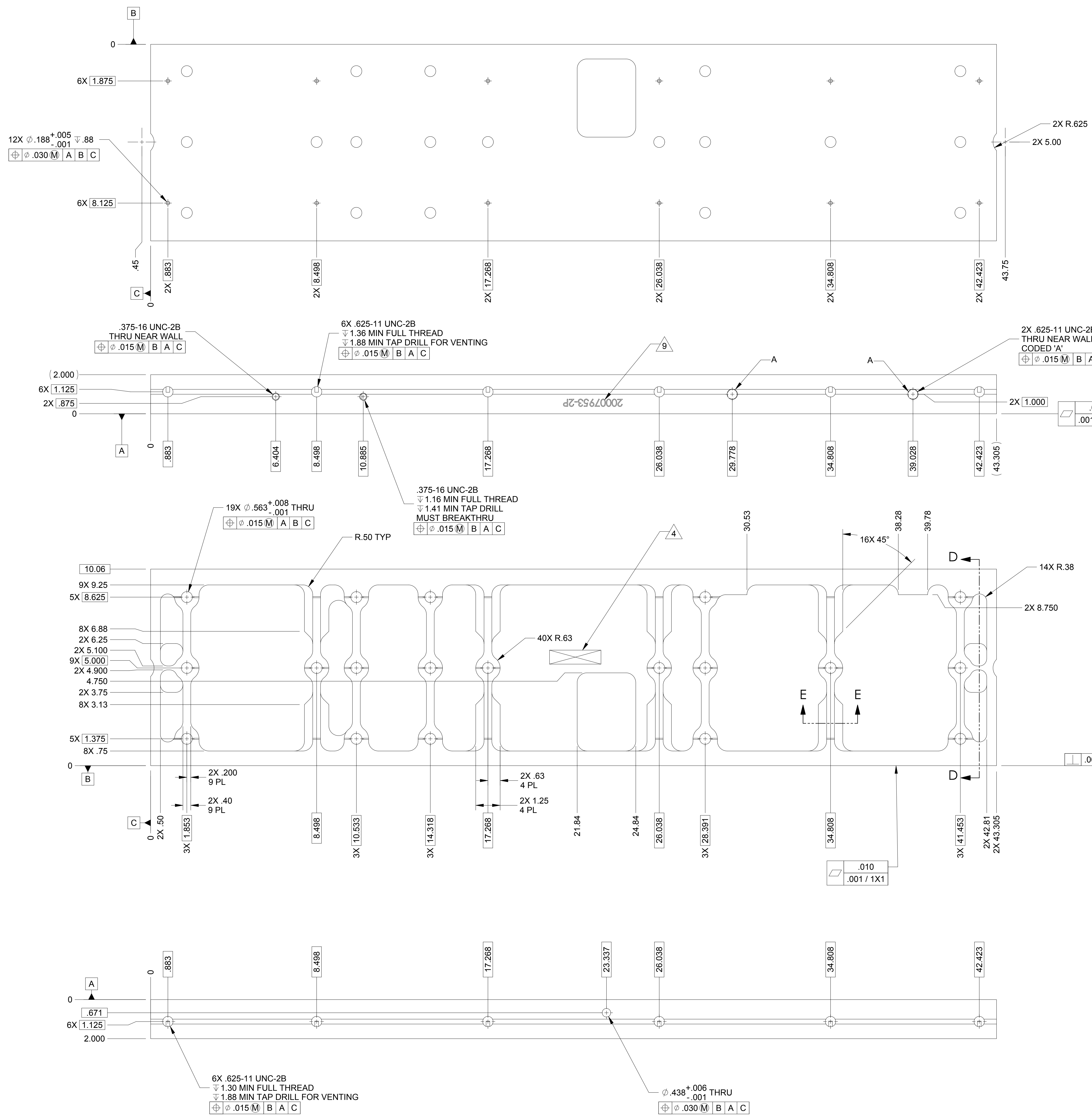
20007953-3P	WALL, INNER, STEP3
20007953-2P	WALL, INNER, STEP2
20007953-1P	WALL, INNER, STEP1

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 DECIMALS ANGLES .XX ±.03 .XXX ±.010 ±1/2°	<b>RELEASED</b> <b>3/13/2004</b>	<b>asi</b> ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
CONTRACT NO	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGLES .XX ±.03 .XXX ±.010 ±1/2°			
DATE	MACHINE FINISH 125/	DWN KEVIN J SPINK 07/09/04	<b>INNER HEX WALL STAGE 0 LIGO-D047953-A</b>	
DATE	DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994	PROJ ENGR STRS		
DATE	MATERIAL AL ALY 7075-T651 AMS-QQ-A-250/12	CHK MATL	<b>20007953</b>	
DATE	MATERIAL	CONFIG PROJ		
DATE	FILE ATTACHMENTS 20007953-2P_x_1 20007953-3P_x_1	ME QA	SIZE E CAGE CODE 1KNU9 SCALE 1:2	REV A SHEET 1 OF 3





-2 SHOWN  
-1 SEE SHEET 1  
-3 SEE SHEET 3

