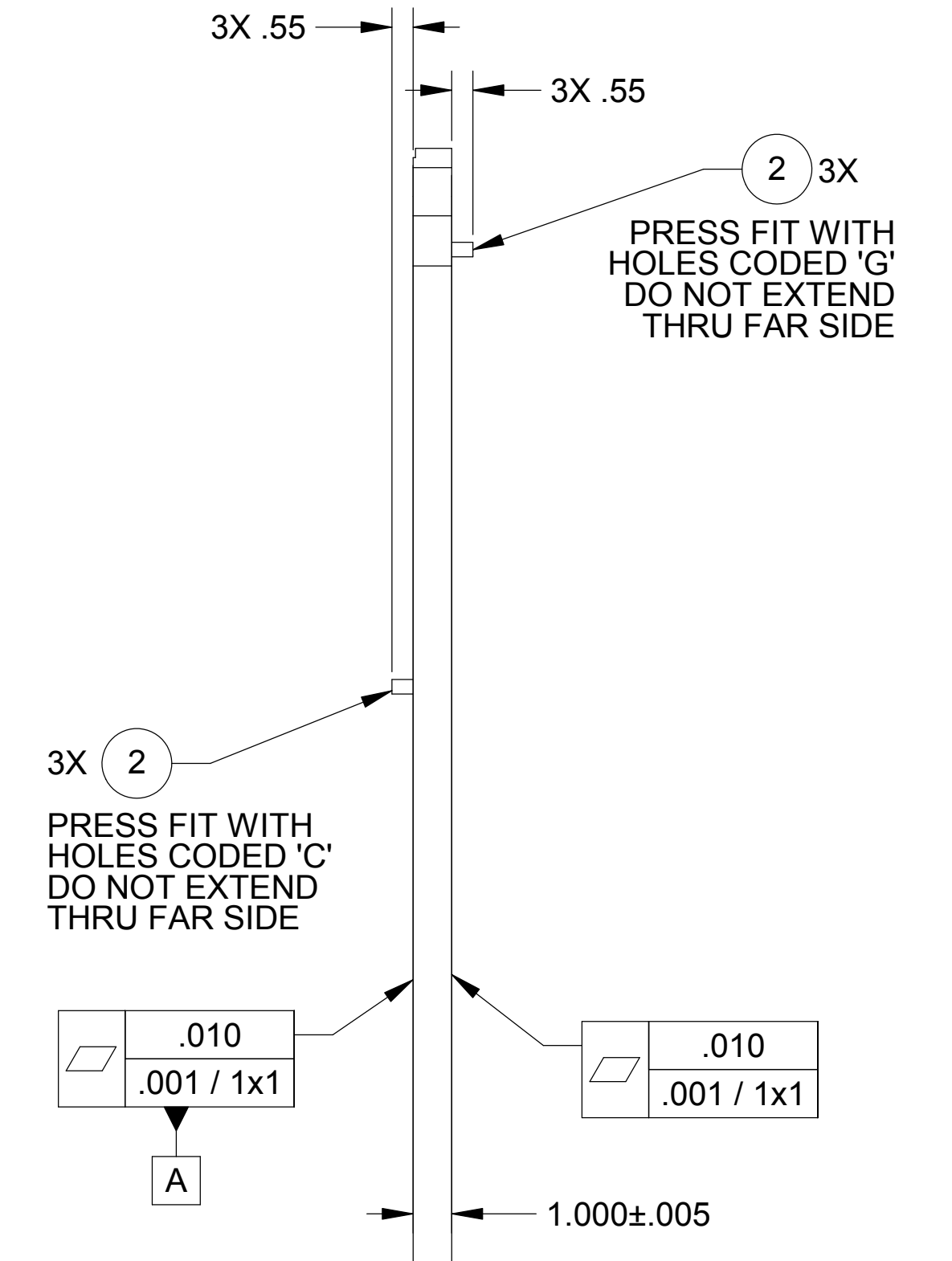
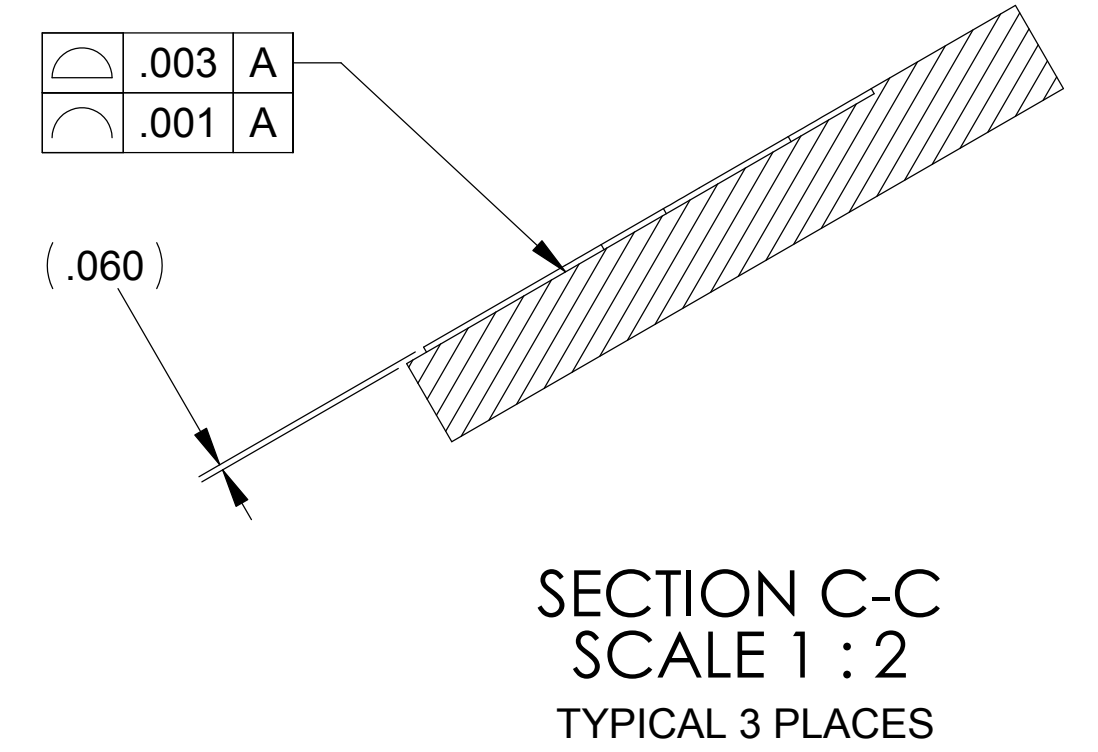
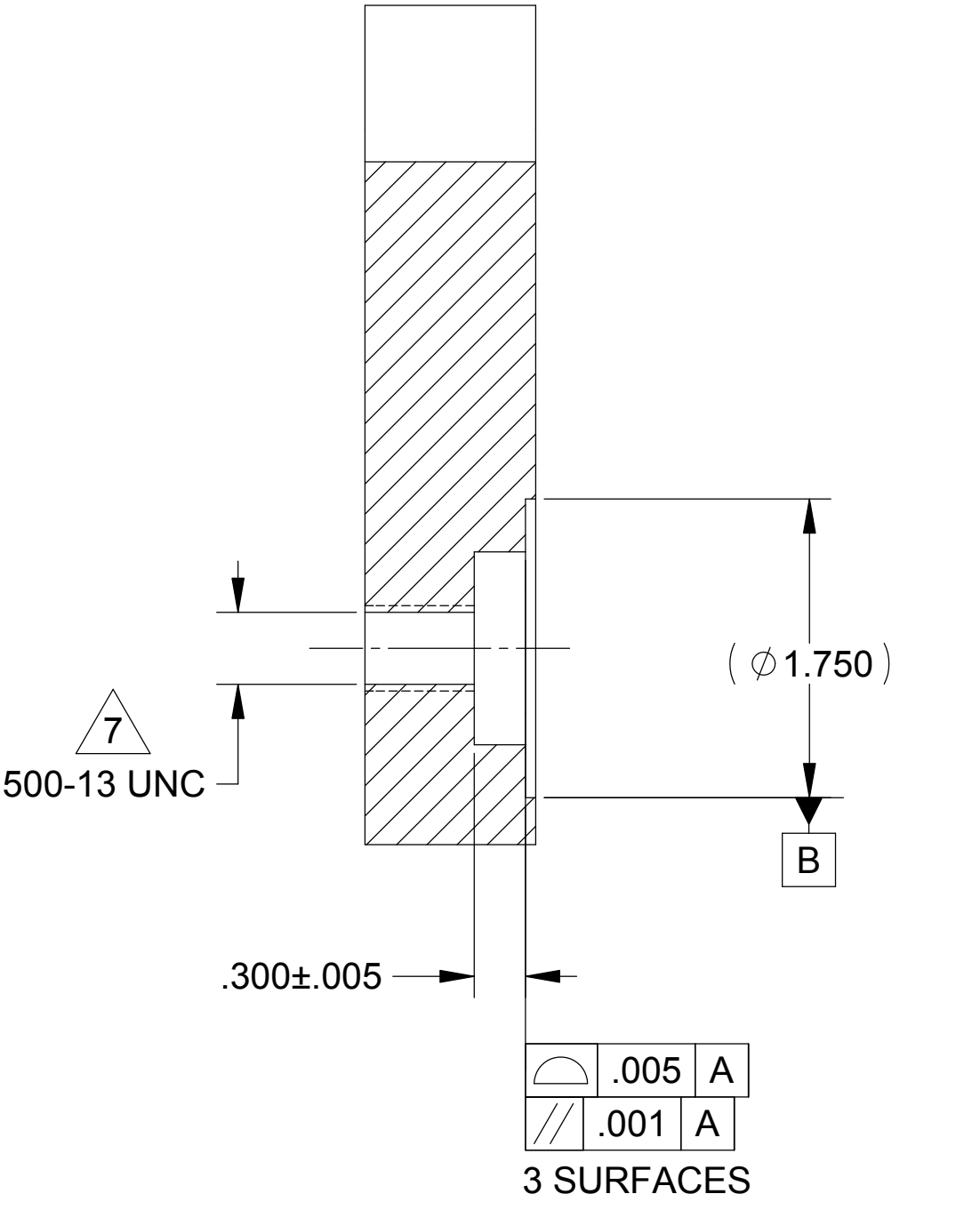
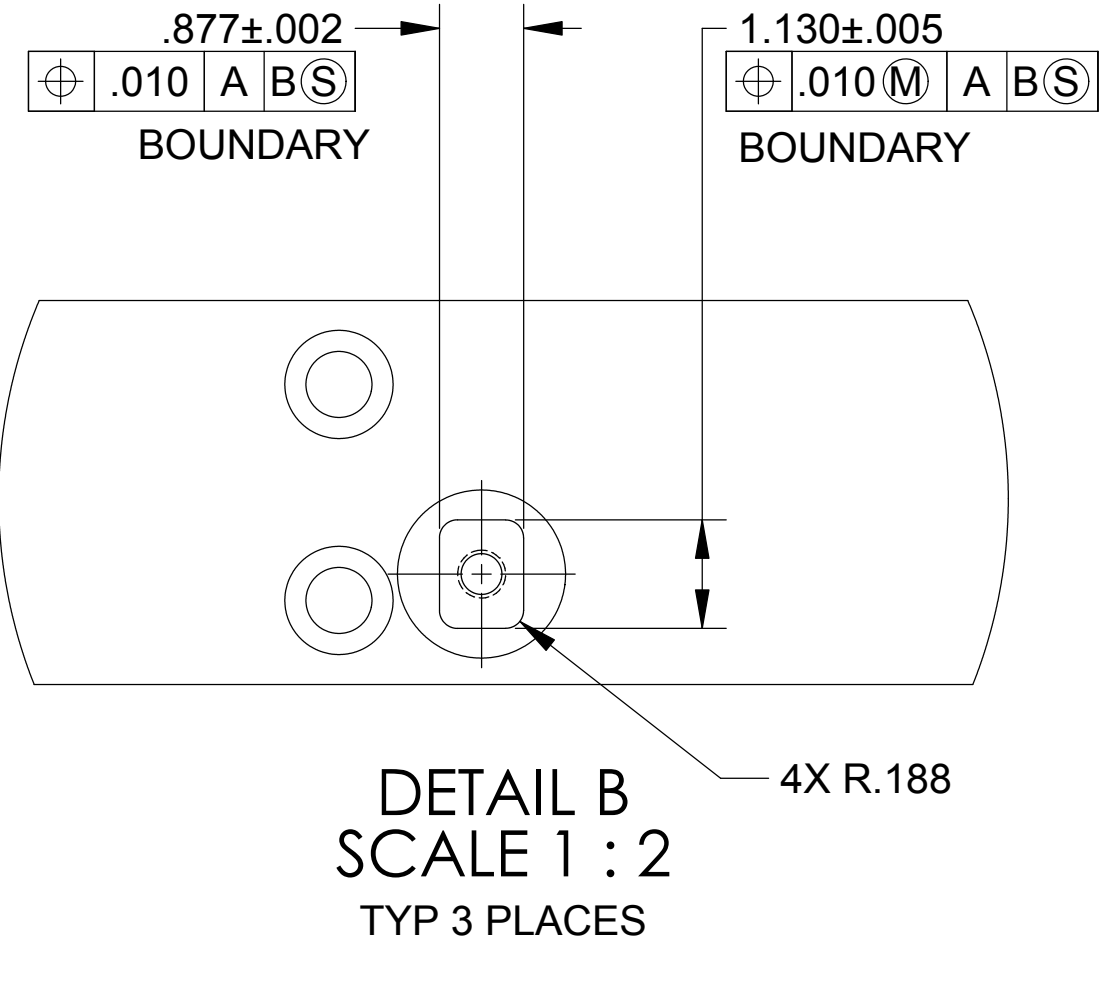
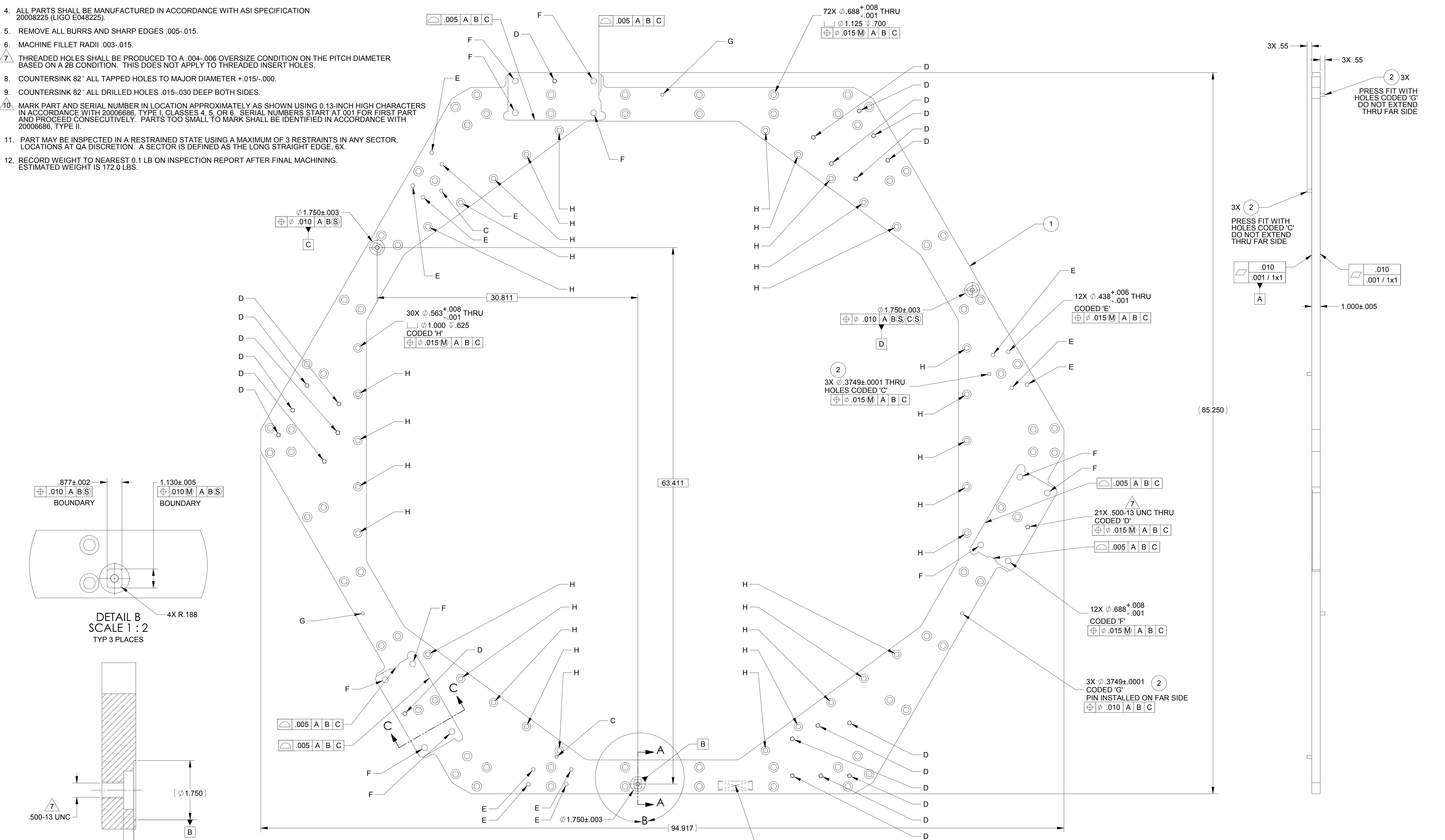


NOTES: UNLESS OTHERWISE SPECIFIED.

- 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.
- PART SHALL BE CHECKED USING THE MODEL DATABASE.
- SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUM(S). A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
- 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.
- 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.
- 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.
- PART MAY BE INSPECTED IN A RESTRAINED STATE USING A MAXIMUM OF 3 RESTRAINTS IN ANY SECTOR. LOCATIONS AT QA DISCRETION. A SECTOR IS DEFINED AS THE LONG STRAIGHT EDGE, 6X.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 172.0 LBS.

REVISIONS		DWN	CHK	ENGR	STRESS	MATL	CONF	ME	PROJ	QA	RELEASE DATE
A	INITIAL RELEASE	KJS	RDB	KS	DCW	DCW	RF	RM	AA	GD	9-14-04
B	ADDED RELIEF FEATURE DEPICTED IN SECTION VIEW C-C. REVISED NOTE 7 AND ADDED DELTA.	RF									



10. MARK FAR SIDE IN LOCATION SHOWN

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
6	2			3AO54	98380A618	PIN, Ø.3752 X 1.5 L		MCMaster-CARR	CRES
1	1			20007957-101		PLATE, TOP		AMS-QQ-A-250/11	AL 6061-T651

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
20007950	1388	DECIMALS	XX ±.03	ANGLES	XXX ±.010 ±12°
		MACHINE FINISH	125	DO NOT SCALE DRAWING	INTERPRET DWG PER ASME Y14.5M, 1994
		MATERIAL	SEE PARTS LIST		

FILE ATTACHMENTS	SCALE	CAGE CODE	REV
20007957-1-x_1	1:4	1KNU9	B

ASSEMBLY		ALLIANCE SPACESYSTEMS, INC.	
20007957-101	20007957-101	1250 Lincoln Ave., Suite 100	Pasadena, CA 91103
TOP PLATE		LIGO-D047957-A	
SCALE 1:4		UNCLASSIFIED SHEET 1 OF 1	

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