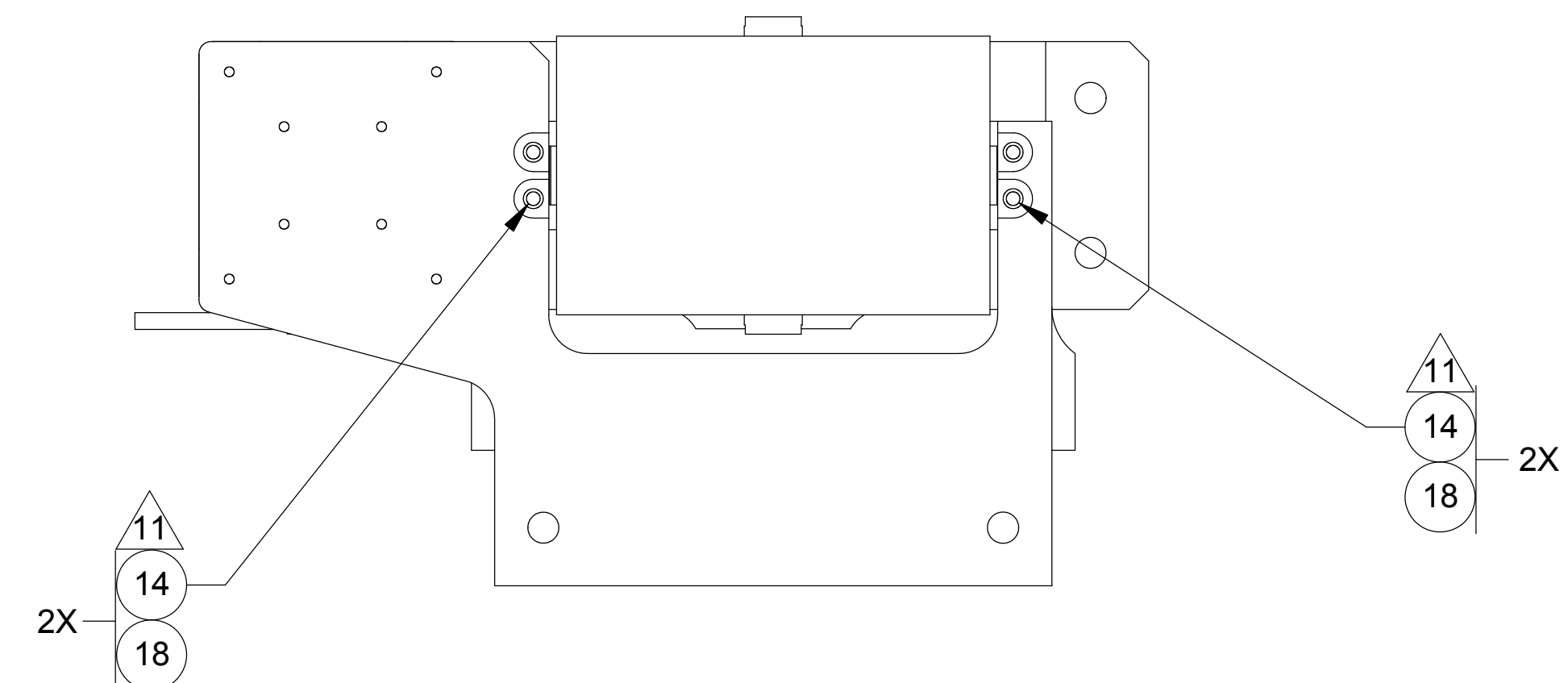
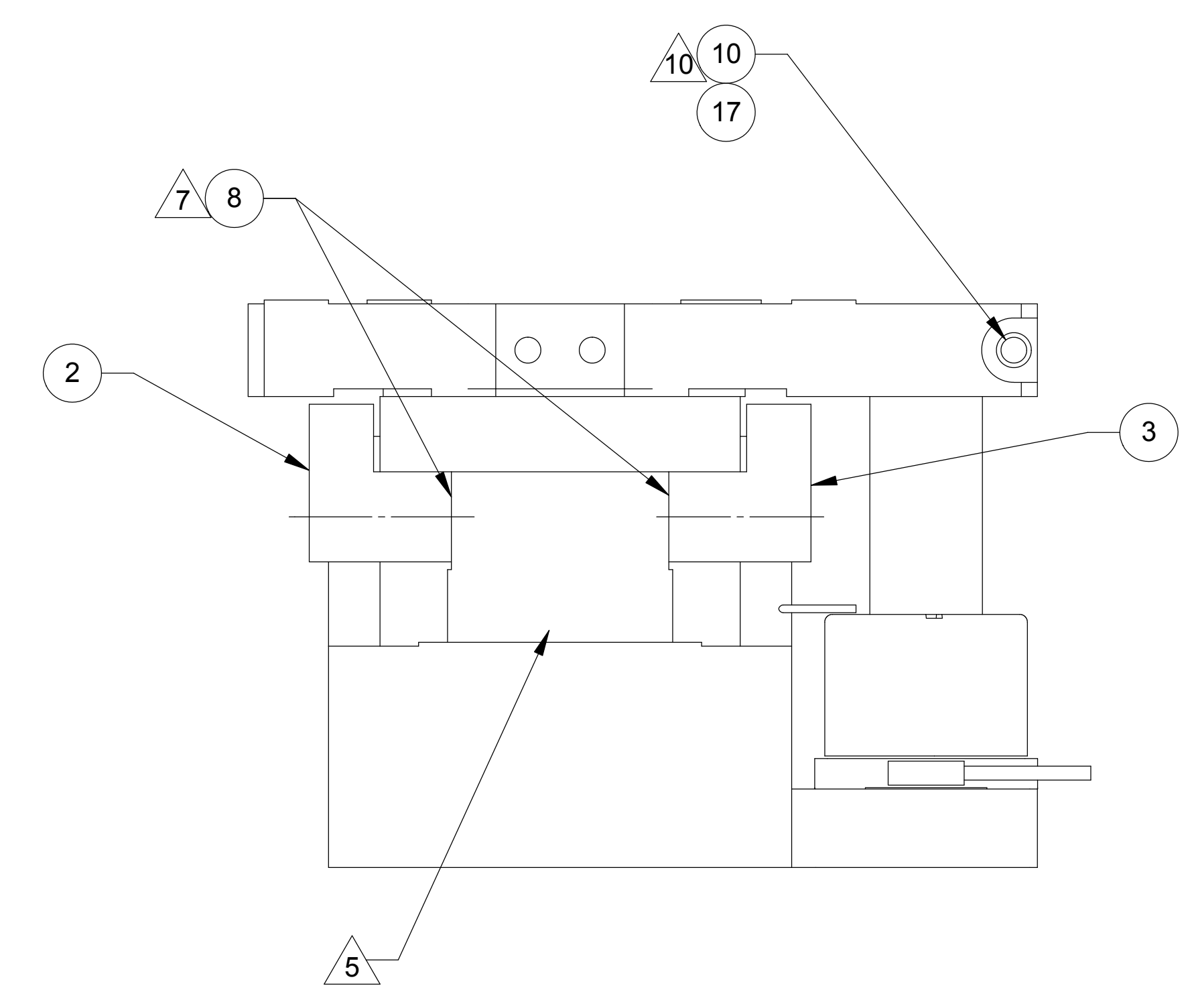
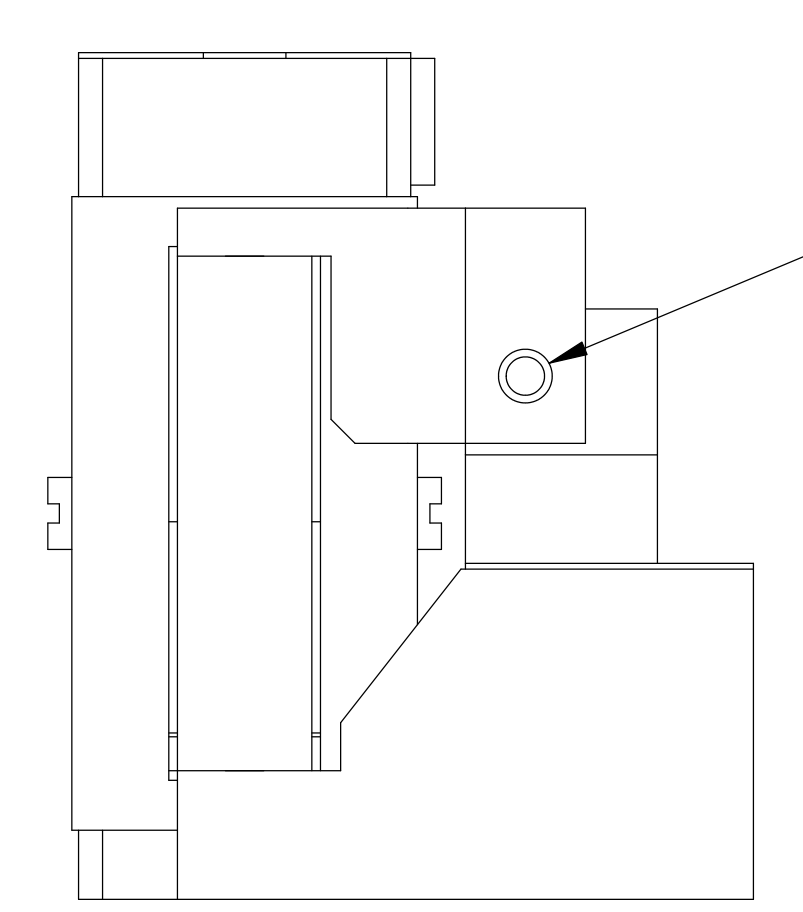
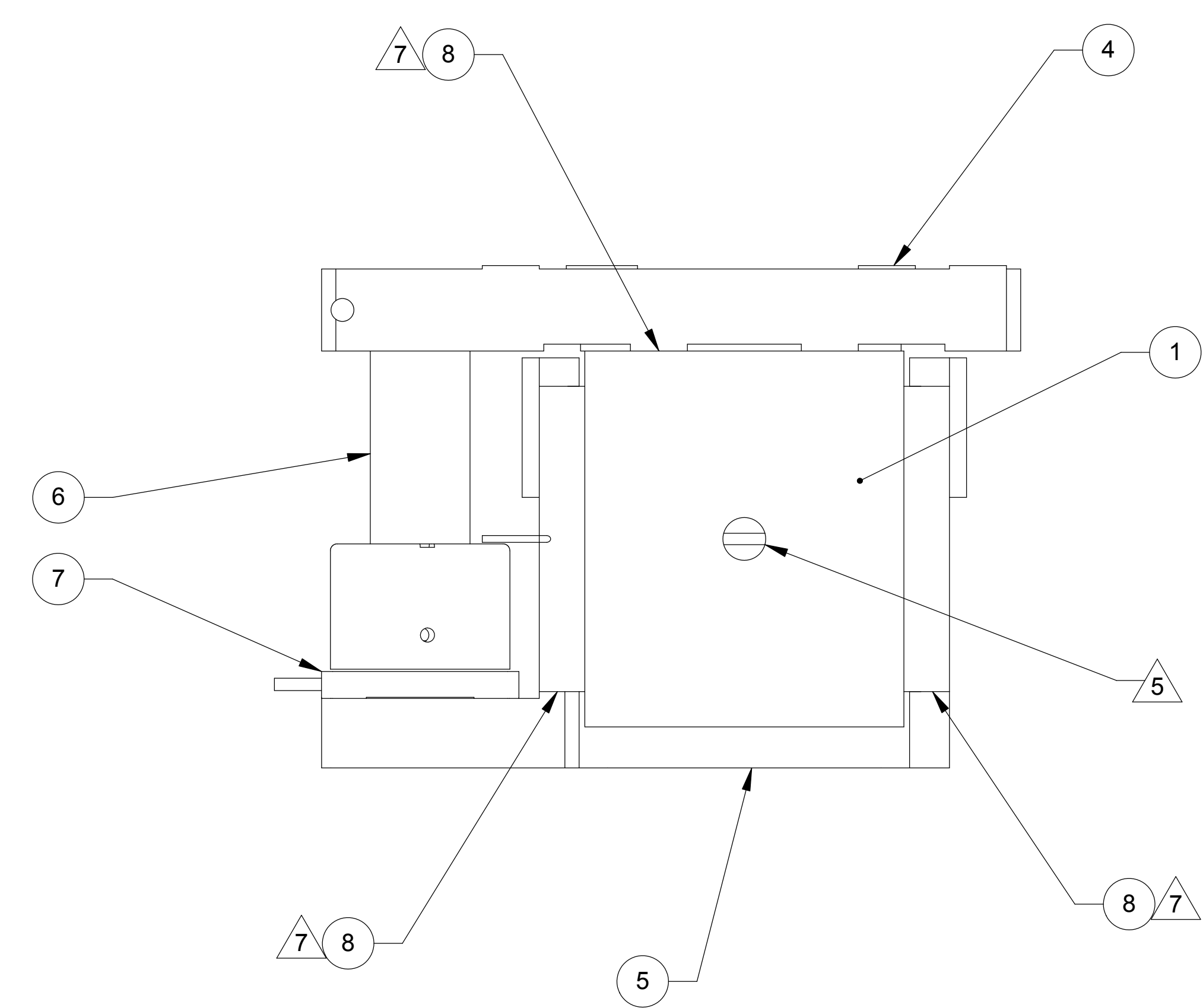
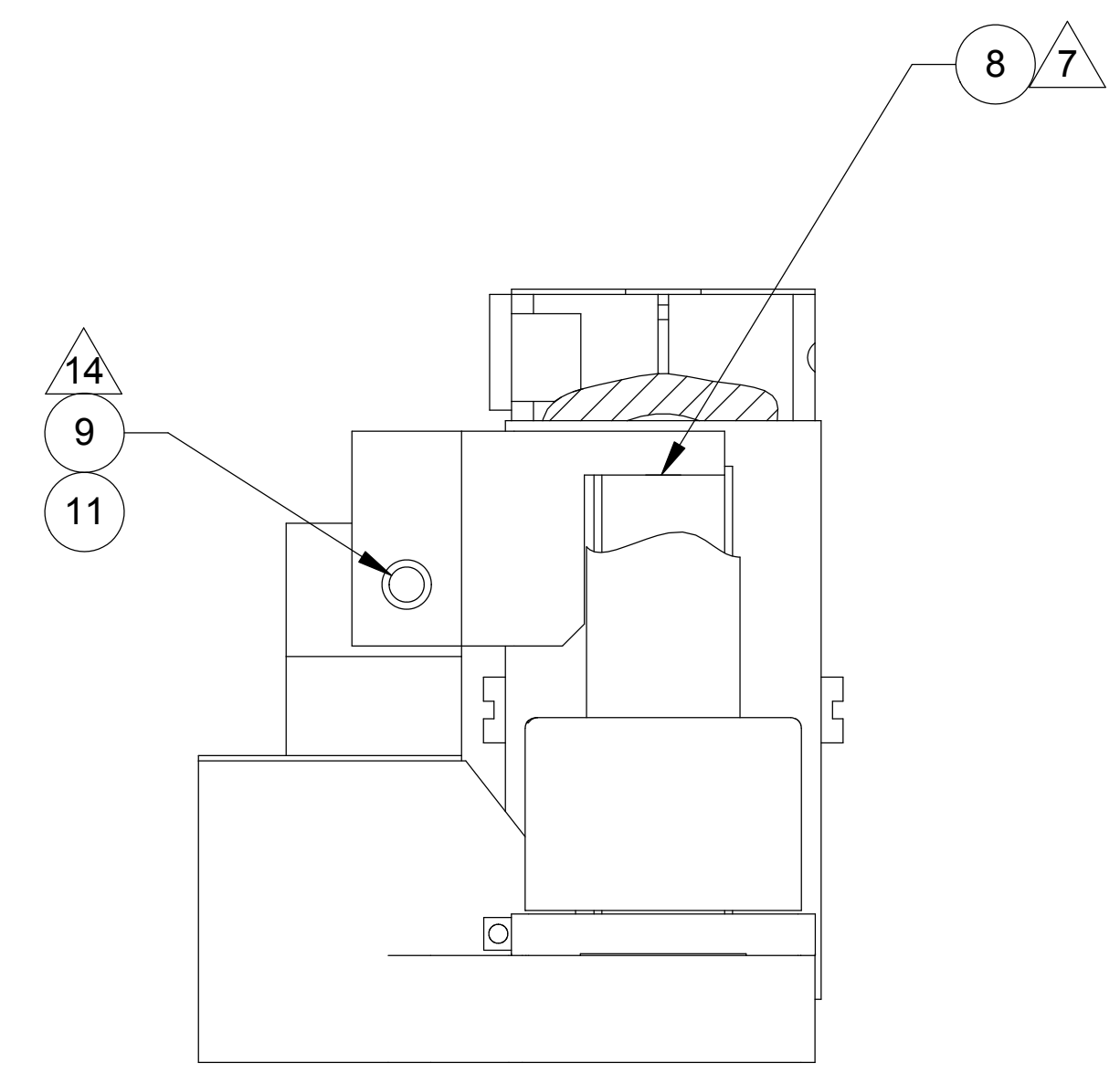
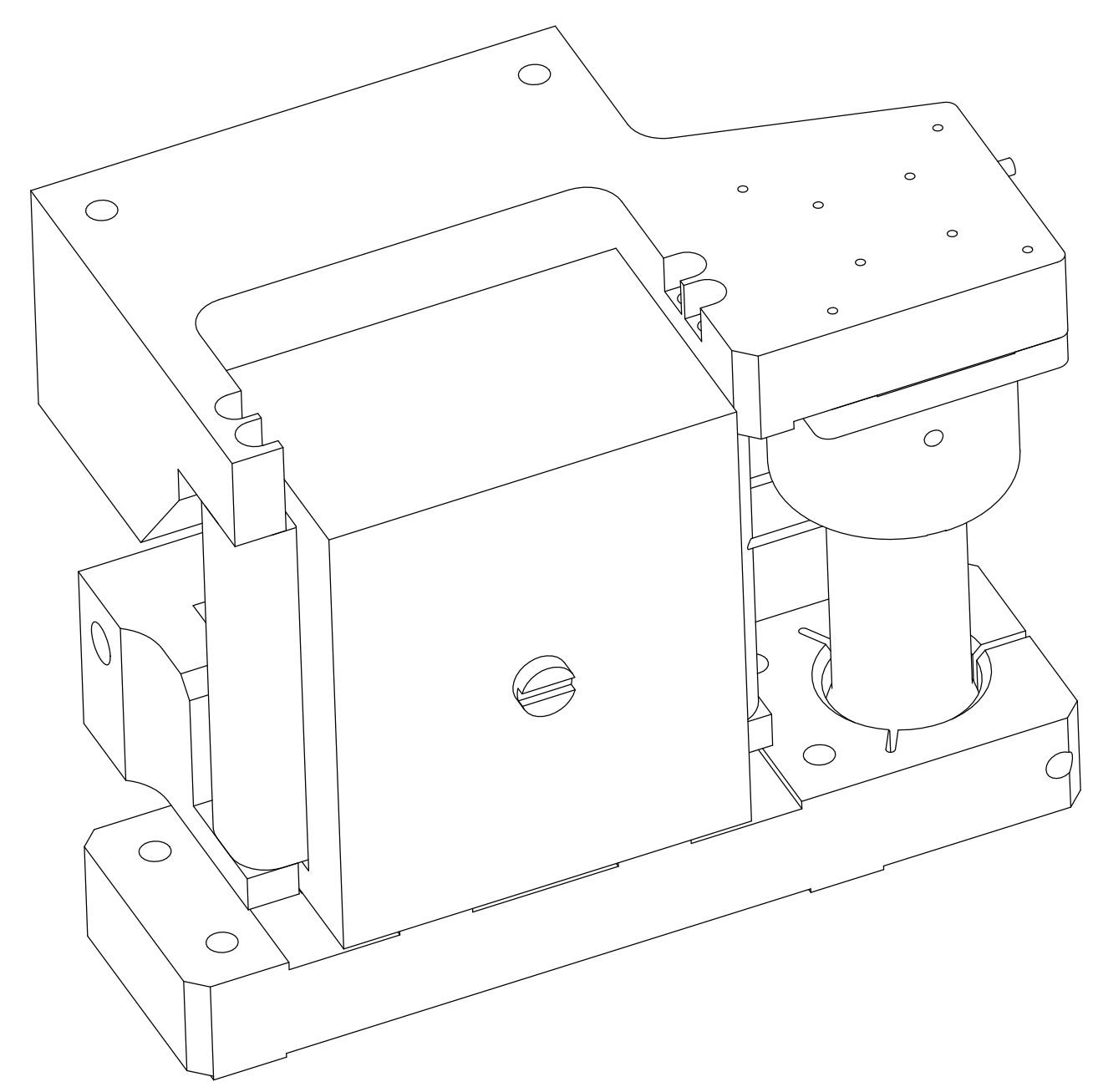
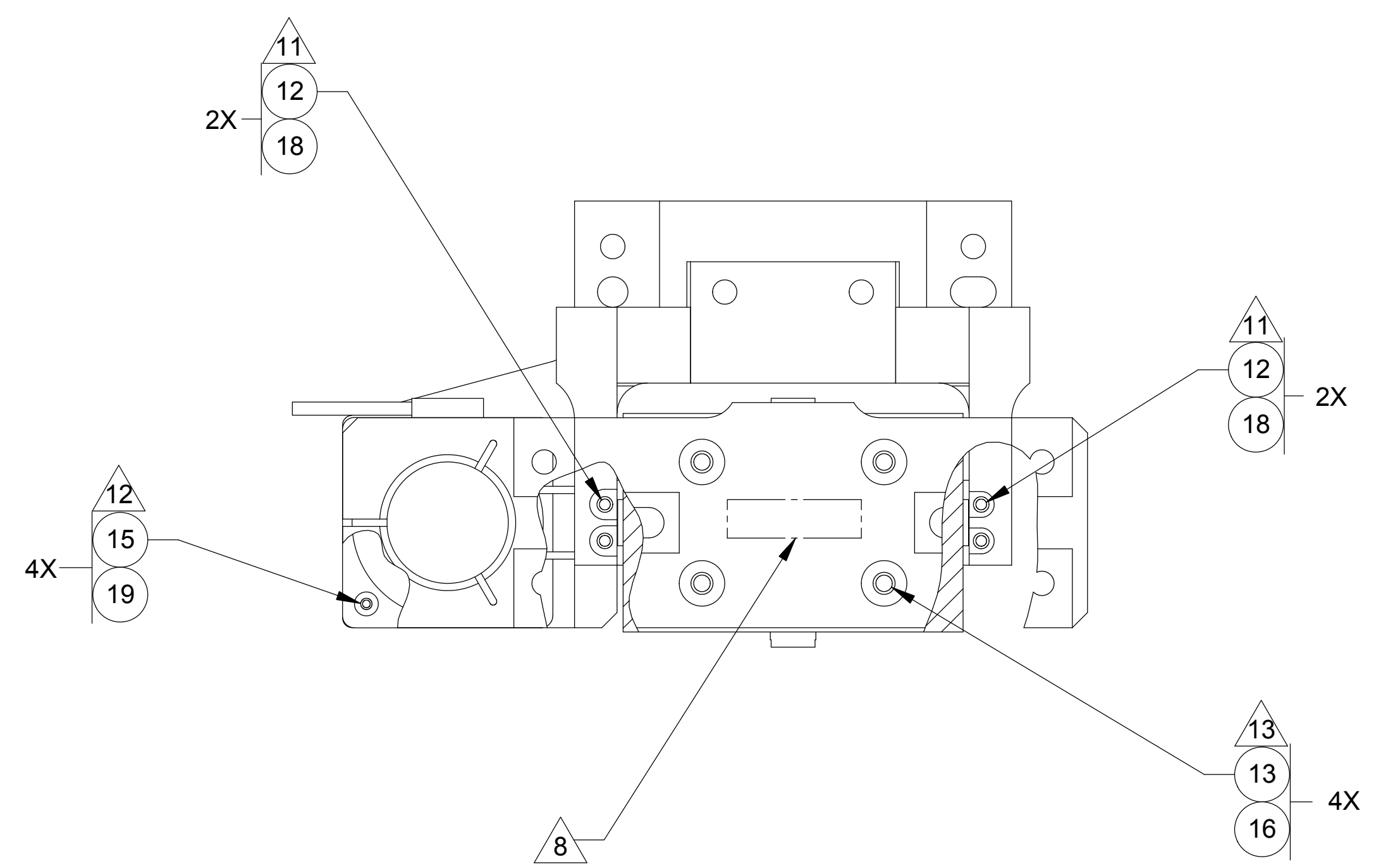


LTR		ZONE	DESCRIPTION	REVISIONS											
DWN	CHK	P-ENG	CONFG	ME	STRS	MATL	PROJ	QA	RELEASE DATE						
A			INITIAL RELEASE												



- NOTES: UNLESS OTHERWISE SPECIFIED.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
  - SOURCE OF SUPPLY: PLANNING SYSTEMS INCORPORATED  
MELBOURNE, FLORIDA 32901
  - SOURCE OF SUPPLY: ADE TECHNOLOGIES INC.  
NEWTON, MARYLAND 02466
  - SOURCE OF SUPPLY: U-C COMPONENTS, INC.  
MORGAN HILL, CALIFORNIA 95037
  - REMOVE SHIPPING SCREWS PRIOR TO TEST AND OPERATION.
  - ALUMINUM ALLOY FOIL, ANNEALED, .001 INCH THICK, CONFORMING TO ASTM B 479-00.
  - APPLY FOIL TO FAYING SURFACES.
  - MARK ASSY AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING .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.
  - BOLT TORQUING PROCEDURE SHALL ENSURE THAT THE SPECIFIED TORQUE IS APPLIED WITHIN A TOLERANCE OF +5% / -10%.
  - TORQUE: 60 IN LBS.
  - TORQUE: 5 IN LBS.
  - TORQUE: 1.5 IN LBS.
  - TORQUE: 20 IN LBS.
  - TORQUE: 168 IN LBS.
  - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL ASSEMBLY. ESTIMATED WEIGHT IS: 8.3 LBS.
  - ALL SCREWS SHALL BE SILVER PLATED. DIMENSIONAL TOLERANCES PER UNC/UNF-2A APPLY AFTER PLATING.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
4		4	19		MFVW-02	WASHER, FLAT, VENTED	.087 ID, .197 OD, .012 THK	18-8 CRES	
4		8	18		WFV-04	WASHER, FLAT, VENTED	.115 ID, .209 OD, .016 THK	18-8 CRES	
		1	17		NAS620C-416	WASHER, FLAT	.255 ID, .468 OD, .063 THK	18-8 CRES	
4		4	16		WFV-08	WASHER, FLAT	.169 ID, .304 OD, .032 THK	18-8 CRES	
4		4	15		MP-206-A	SCREW, PN HD, VENTED	M2 X 0.4 X 6MM L	18-8 CRES	
4		4	14		C-410-A	SCREW, SHC, VENTED	.112-40 UNC X .625 L	18-8 CRES	
4		4	13		C-809-A	SCREW, SHC, VENTED	.164-32 UNC X .5625 L	18-8 CRES	
4		4	12		C-404-A	SCREW, SHC, VENTED	.112-40 UNC X .3125 L	18-8 CRES	
4		2	11		WFV-25	WASHER, FLAT	.255 ID, .468 OD, .032 THK	18-8 CRES	
4		1	10		C-2016-NA	SCREW, SHC	.250-20 UNC X 1.000 L	18-8 CRES	
4		2	9		C-286-2028-A	SCREW, SHC, VENTED	.250-20 UNC X 1.750 L	A286 CRES	
		AR	8			FOIL, .001 IN THK	ASTM B 479-00	1100 AL ALLOY	
3		1	7		033968-01	SENSOR, ADE 20MM			
		1	6		20007912-2	DISPLACEMENT SENSOR TARGET ASSY			
		1	5		20007918-1	ADAPTER, COIL			
		1	4		20007917-1	ADAPTER, FIELD			
		1	3		20007978-2	THERMAL BAR, RIGHT			
		1	2		20007978-1	THERMAL BAR, LEFT			
2		1	1		0487-LIGO-D110-050804-SCS	ACTUATOR			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES: DECIMALS: .XX ± .03 ANGLES: XXX ± .010 ± 12°

MACHINE FINISH: V DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994

MATERIAL: SEE PARTS LIST

CONTRACT NO: 20007970 PROJECT CODE: 1388

NEXT ASSEMBLY: APPLICATION:

SCALE: 1:1

UNCLASSIFIED SHEET 1 OF 1

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

STAGE 1-2 VERTICAL ACTUATOR ASSEMBLY LIGO D047969-A

20007969

REV A

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