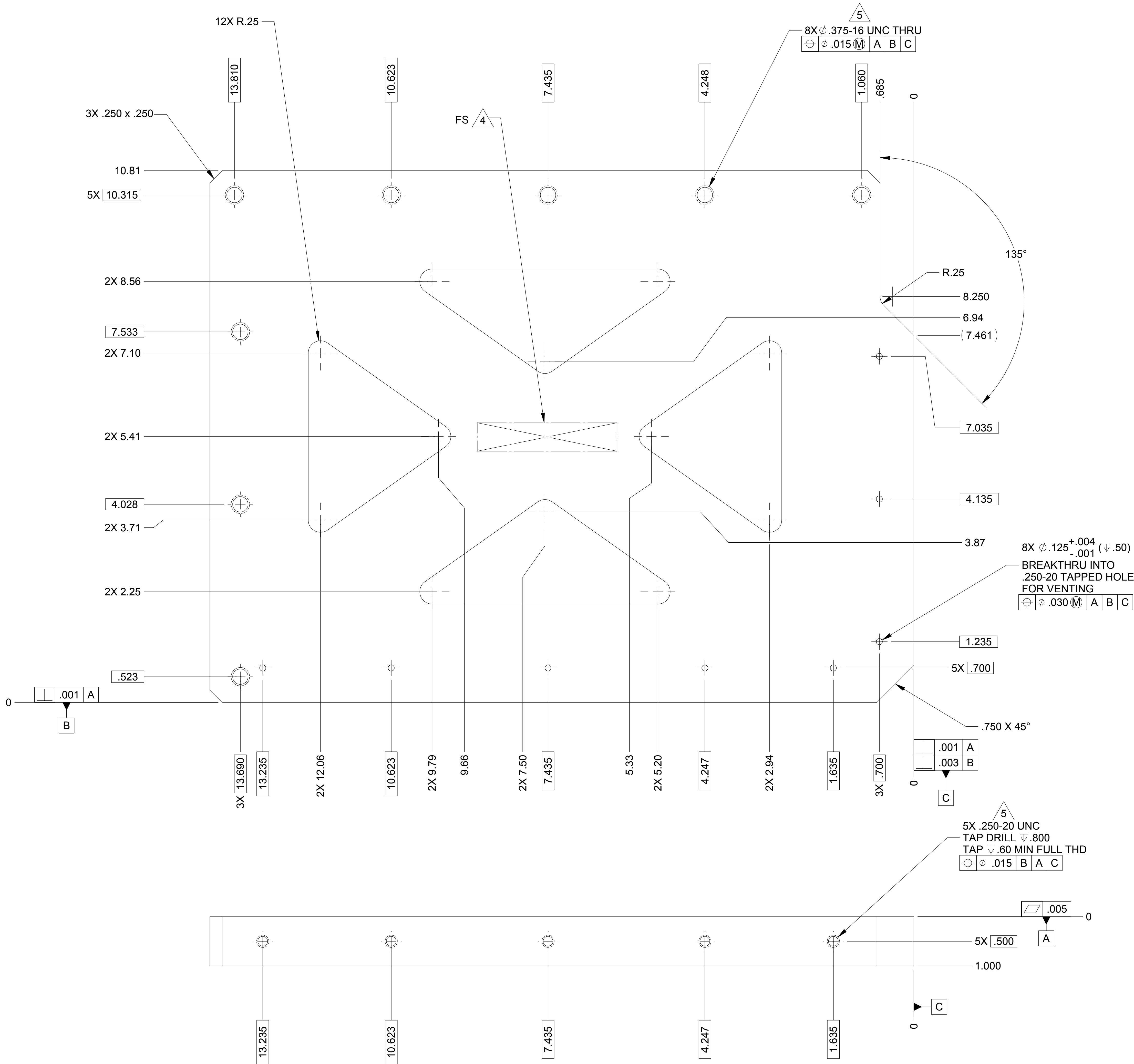


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		REVISIONS													
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A		INITIAL RELEASE													



NOTES: UNLESS OTHERWISE SPECIFIED.

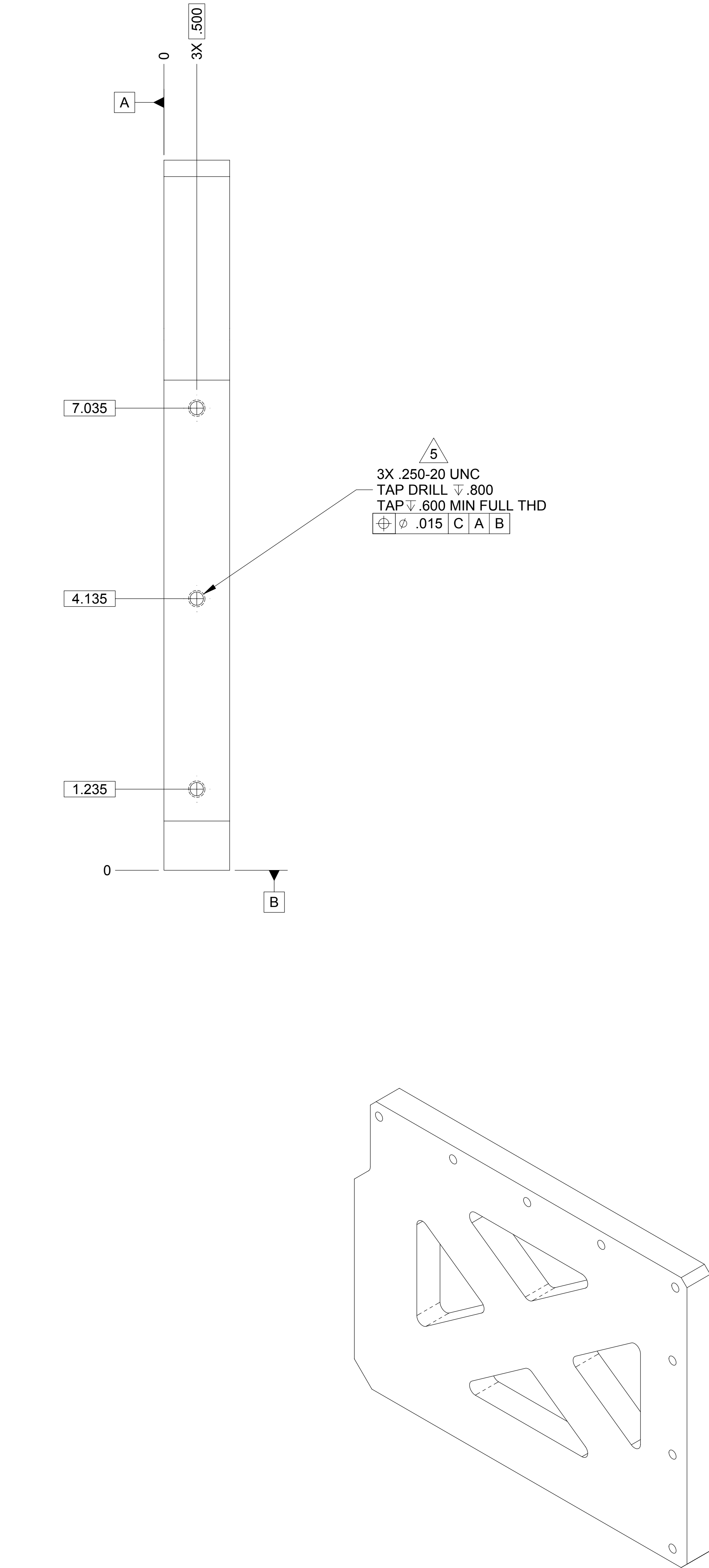
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
- REMOVE ALL BURRS AND SHARP EDGES .005-.015.
- MACHINE FILLET RADII .003-.015.

4 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.

5 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.

8. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 12.3 LBS.



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

FILE ATTACHMENTS
20007863_X_1

				20007863-1							
QTY REQD		ITEM NO	REF DES	CAGE NO	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 .XX ±.03 .XXX ±.010 ±.12° MACHINE FINISH 125/ DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M, 1994 MATERIAL AL ALY 6061-T651 AMS QQ-A-250/11				RELEASED FOR PUBLIC RELEASE CONTRACT DOCUMENT CONTAINS UNCLASSIFIED INFORMATION 1372505				ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
						DWN N.BRAZEAU 07/06/04		PLATE, BAY BULKHEAD STAGE 2 LIGO-DO47863-A		REV A	
						PROJ ENGR STRS					
						CHK MTRL					
						CONFIG PROJ					
20007845		1388				ME QA		E		CAGE CODE	
NEXT ASSEMBLY		PROJECT CODE						1KNU9		20007863	
APPLICATION								SCALE 1:1		UNCLASSIFIED SHEET 1 OF 1	