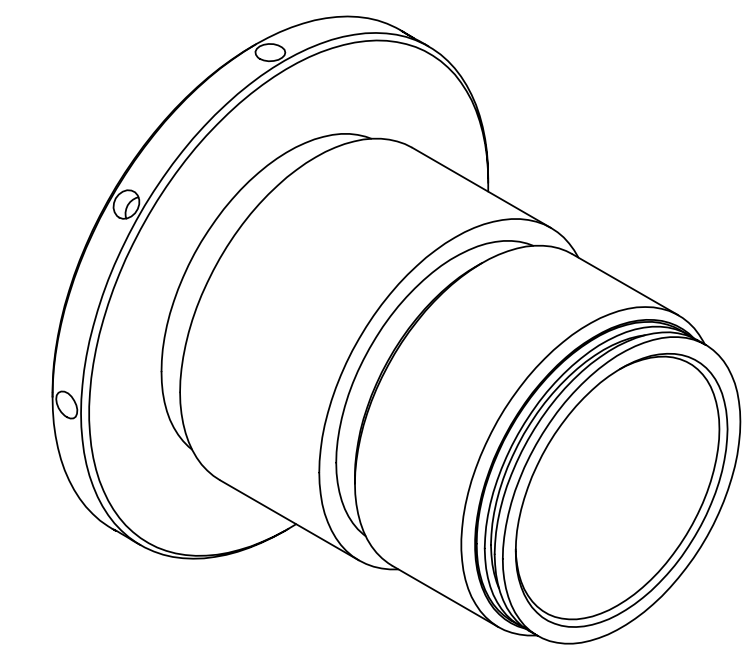
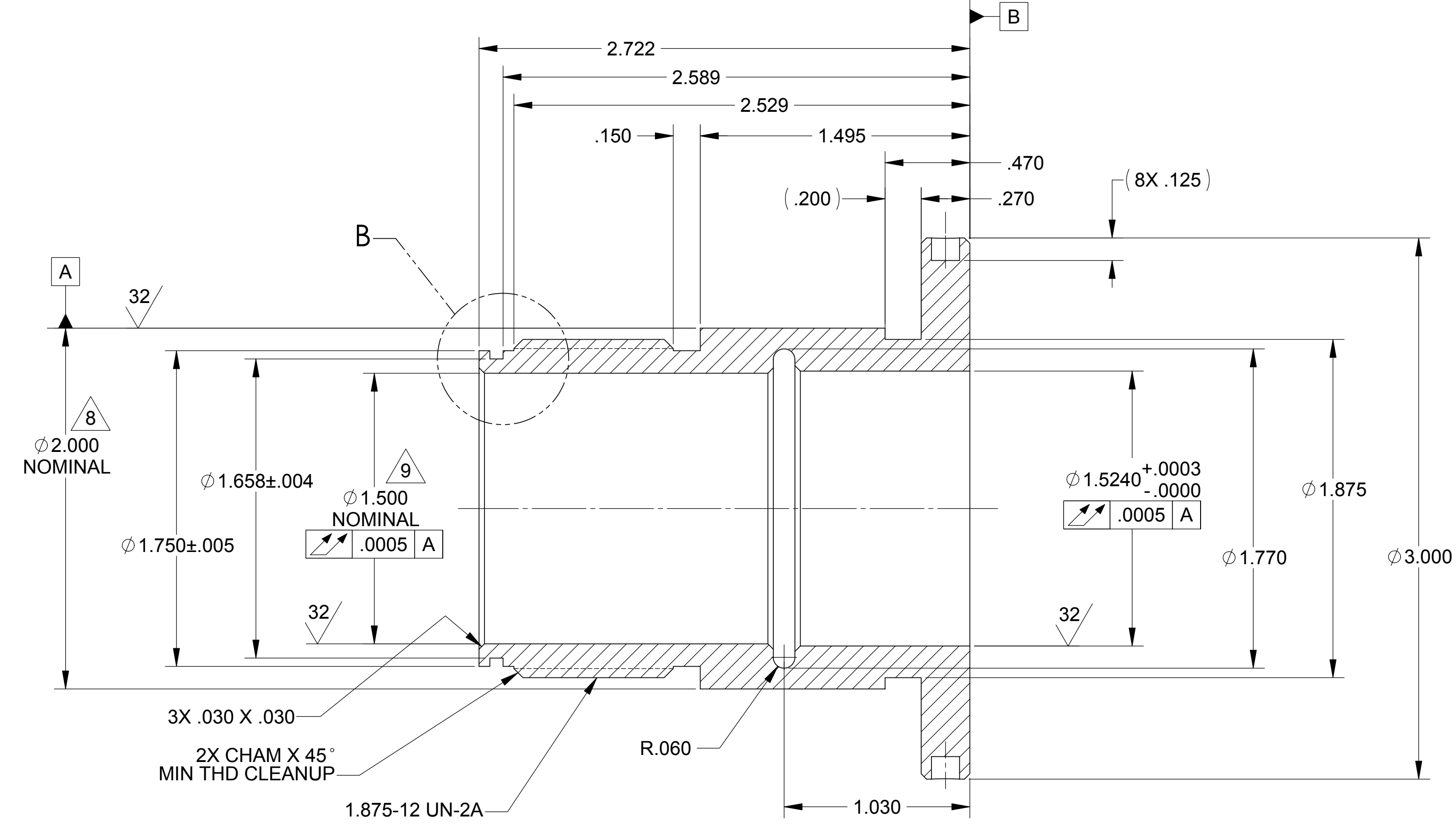
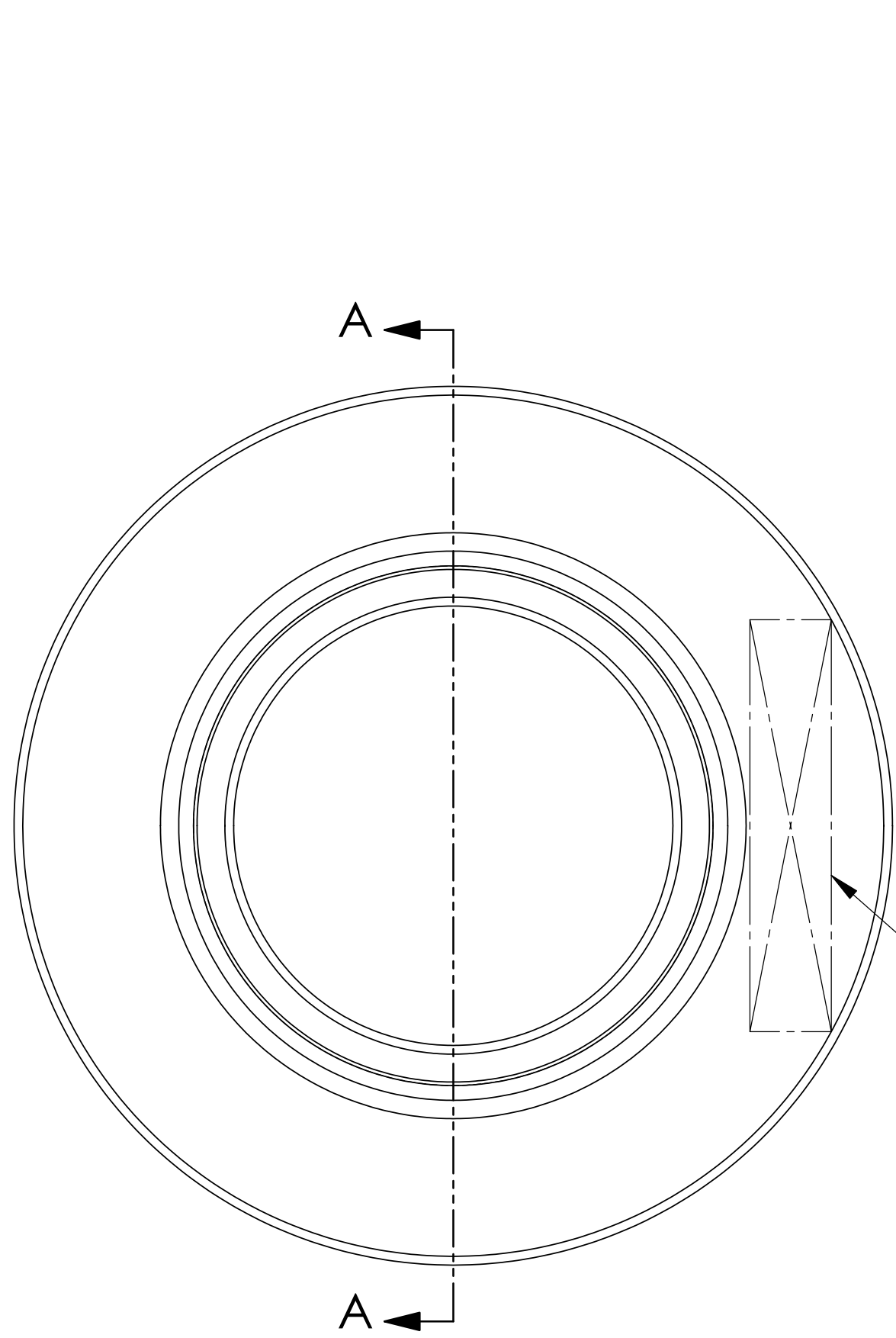


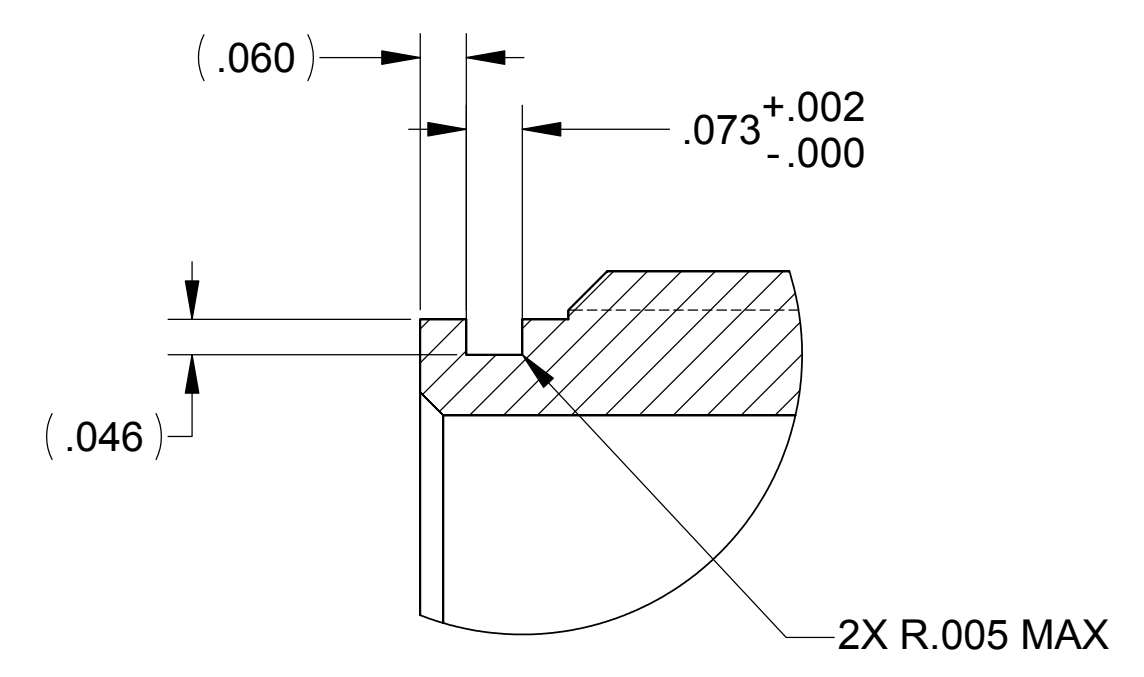
LTR		ZONE		REVISIONS									
				DESCRIPTION									
A				INITIAL RELEASE									
				DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE



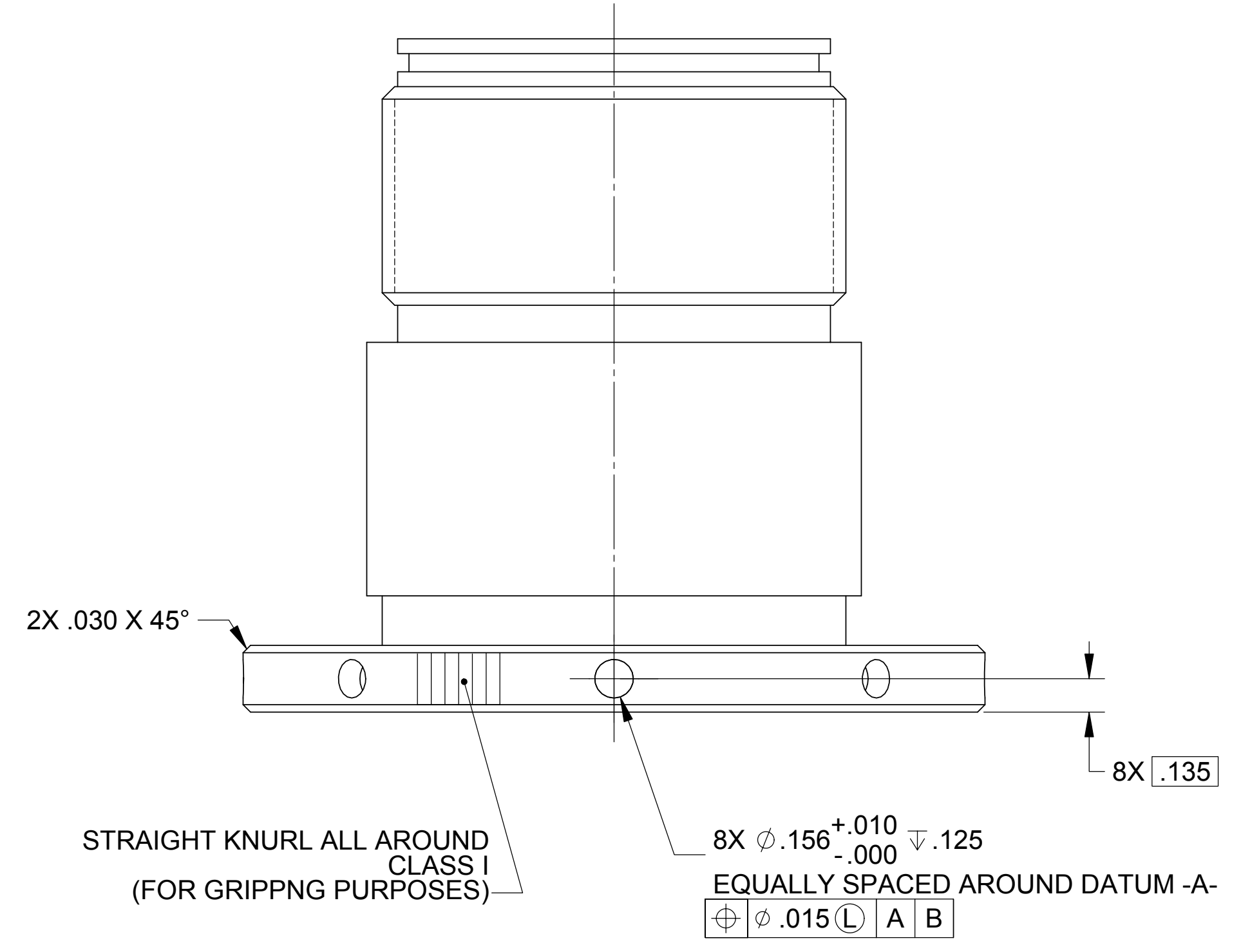
SECTION A-A

NOTES: UNLESS OTHERWISE SPECIFIED.

- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
- ALL DIMENSIONS APPLY AFTER HEAT-TREATING.
- 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.
- TOTAL INDICATED RUNOUT OF ALL COAXIAL FEATURES SHALL BE .010 MAX.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- INDICATED  $\phi 2.000$  FEATURE TO MATE WITH CORRESPONDING  $\phi 2.000$  BORED FEATURE SHOWN IN ZONE B1 OF DRAWING 20007932 FOR PART 20007932-1. FEATURES SHALL BE MATCH-FIT TO .0002-.0005 SMOOTH-RUNNING CLEARANCE AND PARTS SHALL BE MAINTAINED AS A MATCHED SET.
- INDICATED  $\phi 1.500$  BORED FEATURE TO MATE WITH CORRESPONDING  $\phi 1.500$  SPHERICAL FEATURE SHOWN IN ZONE B6 OF DRAWING 20007935 FOR PART 20007935-1. FEATURES SHALL BE MATCH-FIT TO .0002-.0005 SMOOTH-RUNNING CLEARANCE AND PARTS SHALL BE MAINTAINED AS A MATCHED SET.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 1.1 LBS.



DETAIL B  
SCALE 4 : 1



STRAIGHT KNURL ALL AROUND CLASS I (FOR GRIPPNG PURPOSES)

8X  $\phi .156^{+.010}_{-.000} \nabla .125$  EQUALLY SPACED AROUND DATUM -A-

$\phi .015$  A B

20007934-1									
QTY REQD	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 .XX ±.03 .XXX ±.010 ±1/2" ANGLES 63 MACHINE FINISH 63 DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994				
20007941					440C CRES FORGING PER AMS 5630 HEAT TREAT TO RC57 PER AMS-H-6875A				
1388					MATERIAL				
NEXT ASSEMBLY					PROJECT CODE				
APPLICATION					PARTS LIST				
					RELEASED 1/23/2005 THIS DRAWING IS THE PROPERTY OF ASI AND NOT BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISCLOSED TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION OF ASI.				
					DWN R.D.BILLING 07/20/04 PROJ ENGR STRS CHK MATL CONFIG PROJ ME QA				
					ASI ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103				
					SLEEVE, LOCK KINEMATIC LOCK LIGO-D047934-A				
					SIZE D CAGE CODE 1KNU9 20007934 REV A				
					SCALE 2:1 UNCLASSIFIED SHEET 1 OF 1				

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

FILE ATTACHMENTS  
20007934.x\_1