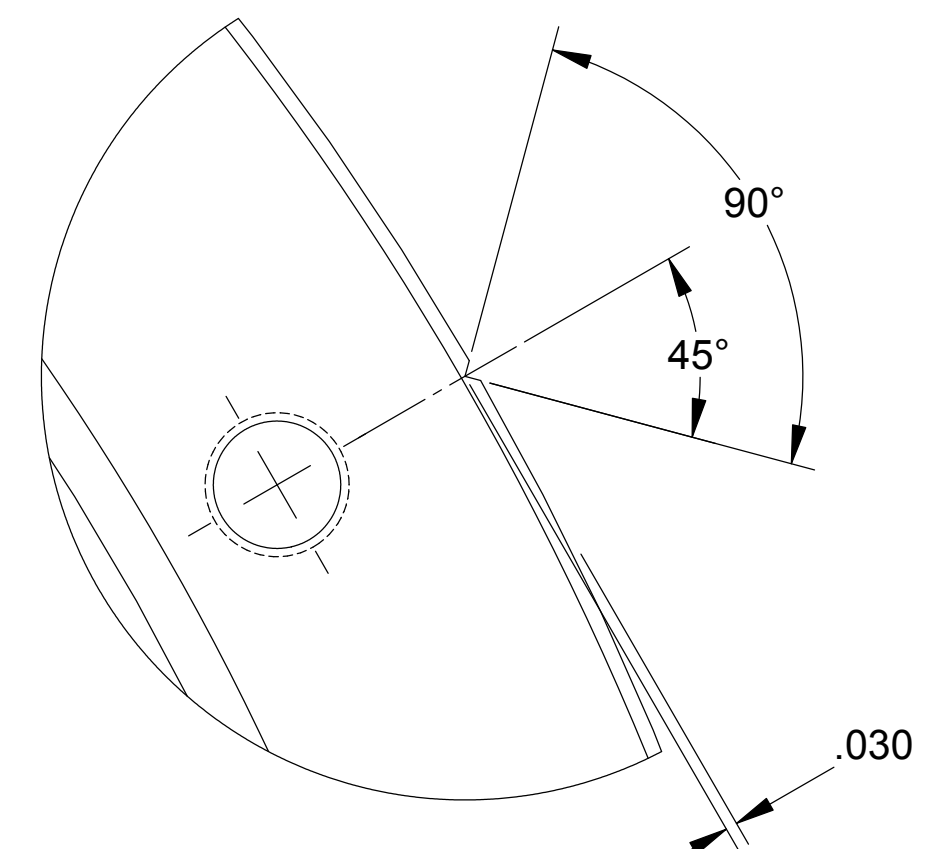
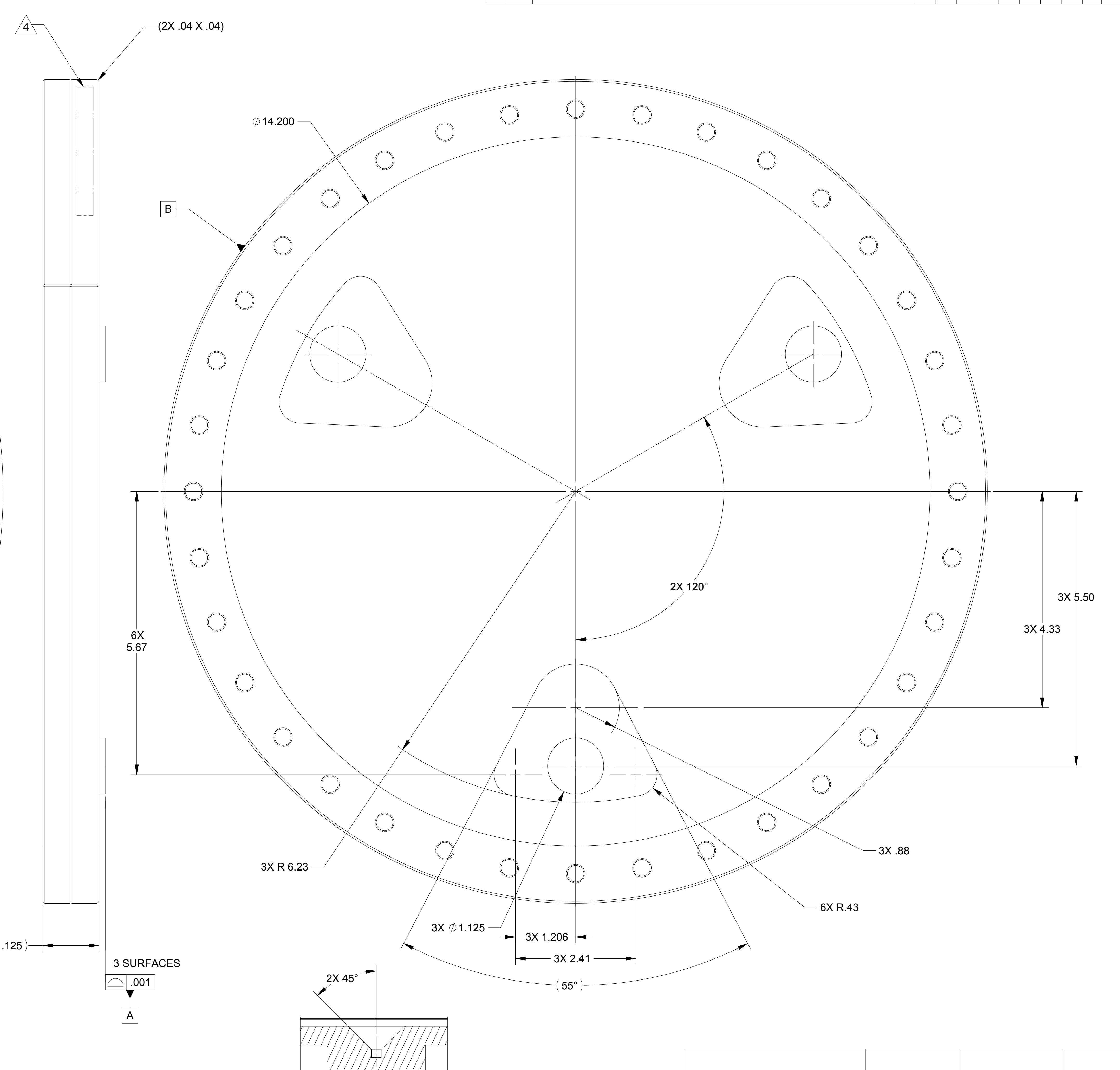
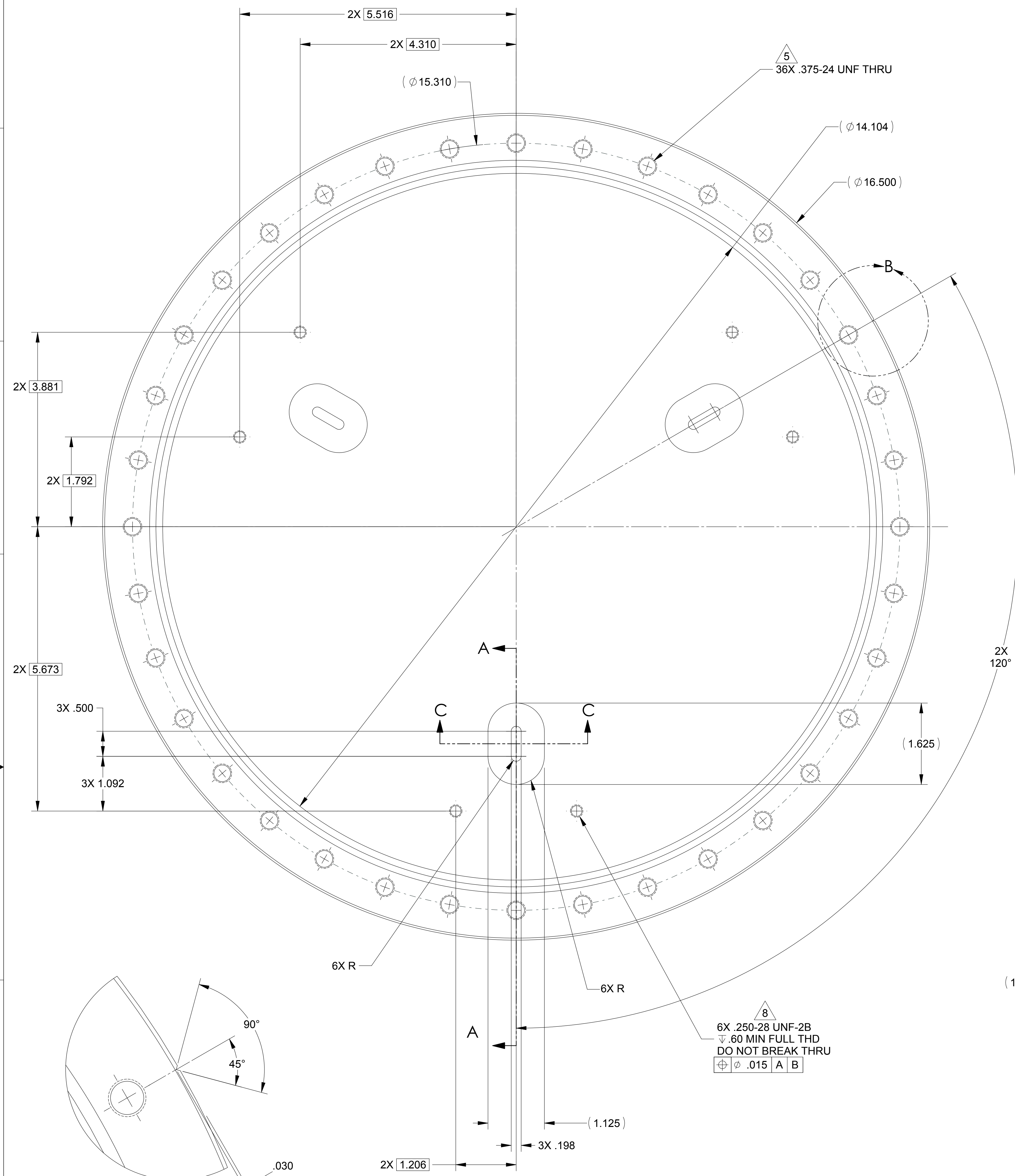


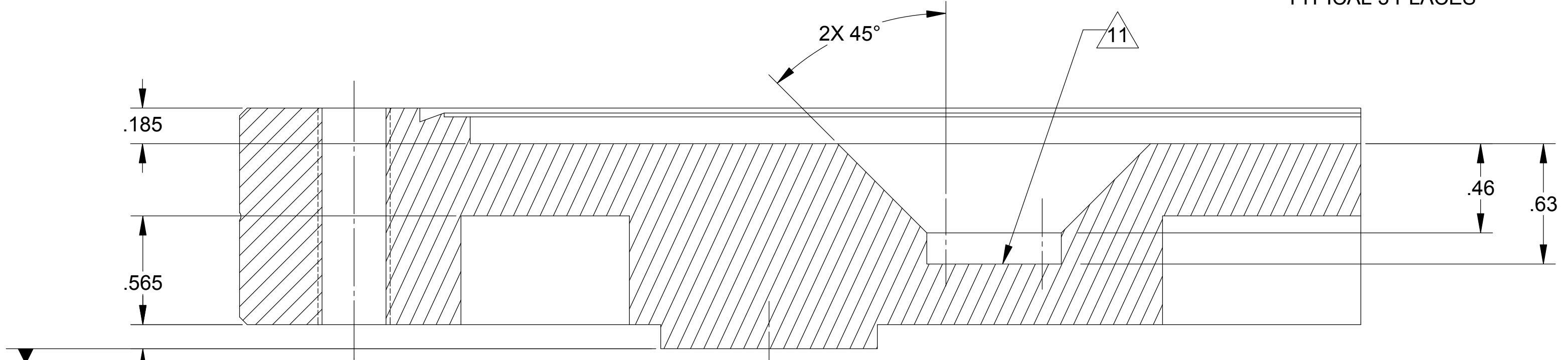
LTR		ZONE		REVISIONS											
				DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE		
A															
				INITIAL RELEASE											



12  
DETAIL B  
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 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.
  - THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION INCLUDING THREADED FEATURES SPECIFIED AS PART OF NOR-CAL PRODUCTS PART NO. 1650-000NT.
  - COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
  - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
  - NOTE 5 DOES NOT APPLY.

8  
6X 250-28 UNF-2B  
▽.60 MIN FULL THD  
DO NOT BREAK THRU  
φ .015 | A | B



SECTION A-A  
SCALE 2 : 1  
TYPICAL 3 PLACES

- FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO NOR-CAL PRODUCTS PART NUMBER 1650-000NT.
- REFERENCE MATING PART DRAWING 20007795.
- BOTTOM CONFIGURATION OPTIONAL.
- PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 37.1 LBS.

NOR-CAL PRODUCTS, INC. YREKA, CALIFORNIA 96097	22804	ASI 20007796-1	
NAME AND ADDRESS	CAGE CODE	PART NO.	CONFIG.
APPROVED SOURCE OF SUPPLY			

SOURCE CONTROL DRAWING

ONLY THE ITEM DESCRIBED ON THIS DRAWING, WHEN PROCURED FROM THE SUPPLIER'S LISTED HEREIN, IS APPROVED BY ALLIANCE SPACESYSTEMS INC. FOR THE USE IN THE APPLICATION(S) SPECIFIED HEREIN. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY ALLIANCE SPACESYSTEMS INC. OR THEIR SUBSEQUENT CUSTOMER.

IDENTIFICATION OF THE APPROVED SOURCE(S) HEREIN IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR THE ITEM DESCRIBED ON THIS DOCUMENT.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
					20007796-101				

CONTRACT NO	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	<b>RELEASED</b> <b>2/16/2005</b>	<b>asi</b> ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103
	TOLERANCES		
	DECIMALS .XX ± .03	DWN R.D.BILLING 02/25/04 PROJ ENGR STRS CHK MATL CONFIG PROJ ME QA	<b>BASEPLATE, CHAMBER STS-2 SEISMOMETER LIGO-D047796-A</b>
	ANGLES XXX ± .010 ± 1/2°		
	MACHINE FINISH 125/	SIZE E	CAGE CODE 1KNU9
	DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994	SCALE 1:1	UNCLASSIFIED
	MATERIAL 304 CRES - ARGON OXYGEN DECARBURIZATION PER ASTM-240		SHEET 1 OF 1

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