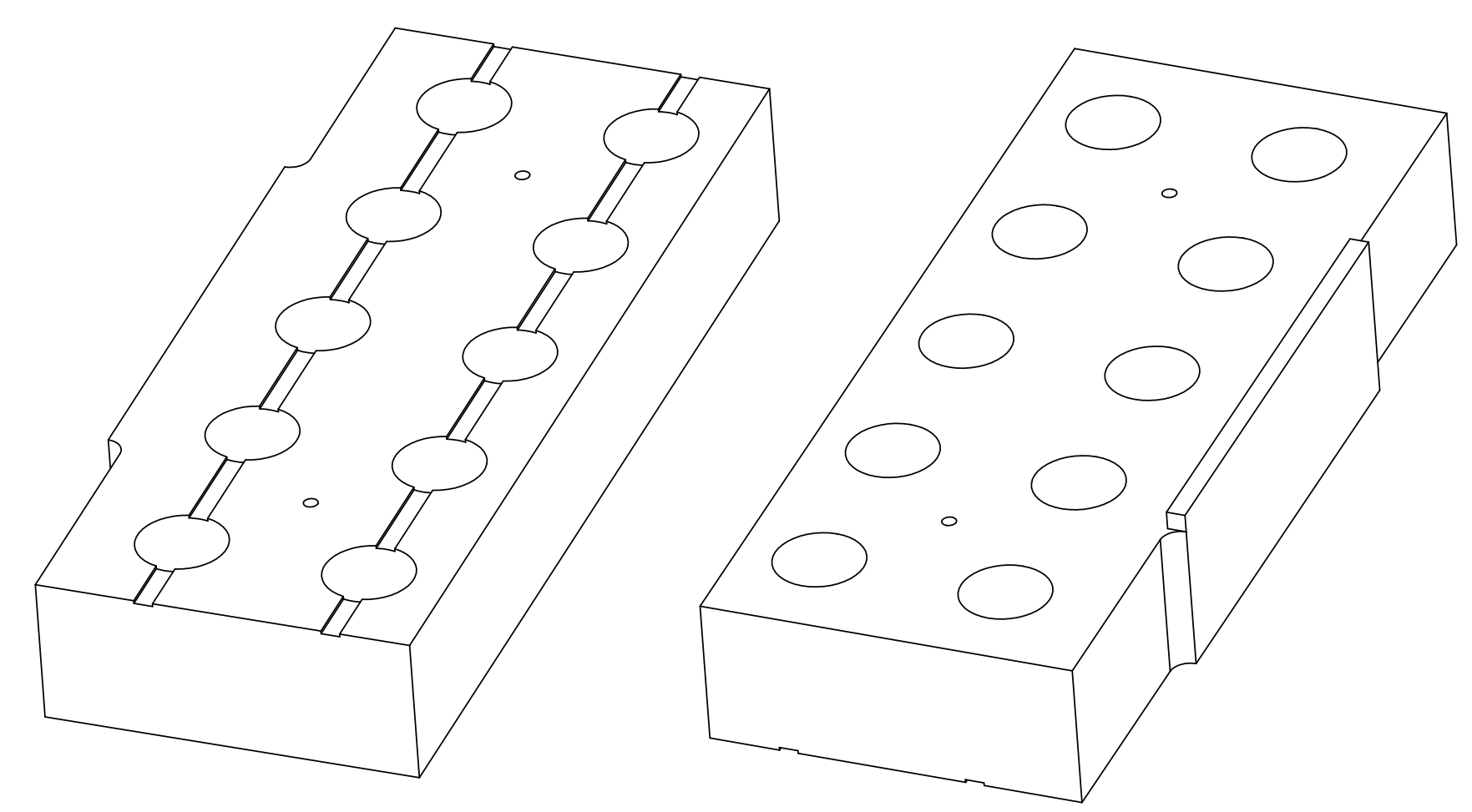
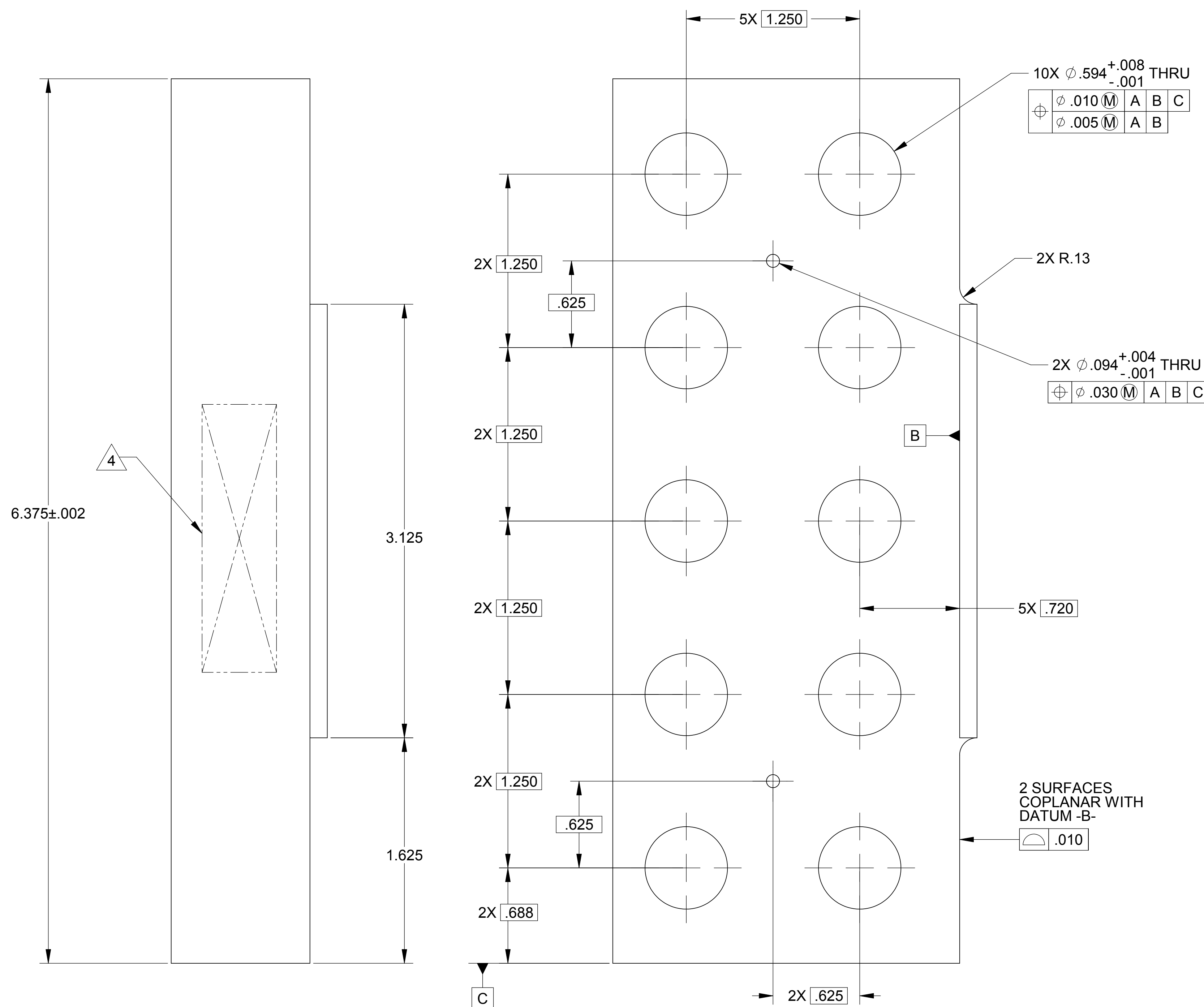


		REVISIONS																				
LTR	ZONE	DESCRIPTION										DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A		INITIAL RELEASE										RB	RF	KS	RF	RK	DCW	DCW	SV	GDL	1-24-05	
B	C4	ADDED 2X ϕ .094 HOLE FOR VENTING										RF										

D
C
B
A

D
C
B
A



6.375±.002

3.125

1.625

C

10X ϕ .594^{+0.008}/_{-.001} THRU
 ϕ .010 (M) A B C
 ϕ .005 (M) A B

2X R.13

2X ϕ .094^{+0.004}/_{-.001} THRU
 ϕ .030 (M) A B C

5X .720

2 SURFACES
COPLANAR WITH
DATUM -B-
 ϕ .010

BREAK EDGE .000-.002 MAX

2.500±.002

R.005 MAX

.125

.125

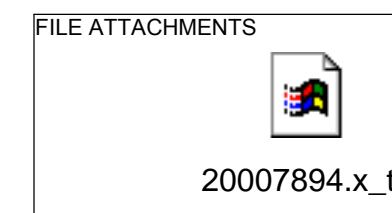
12X .020

/// .002 A
3 SURFACES

1.000±.005

12X .13

6X .78



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.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 4.0 LBS.

20007894-1

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 .XX ±.03 .XXX ±.010 ± 1/2" ANGLES 63 MACHINE FINISH ✓ DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994			RELEASED 2/24/2005		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
20007890		1388			DWN R.D.BILLING 07/27/04		STAGE 1-2 BLADE SPRING CAP PLATE LIGO-D047894-B	
NEXT ASSEMBLY		PROJECT CODE			CHK MATL		SIZE D CAGE CODE 1KNU9 20007894 SCALE 2:1	
APPLICATION					CONFIG PROJ		UNCLASSIFIED SHEET 1 OF 1	
					ME QA		REV B	

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