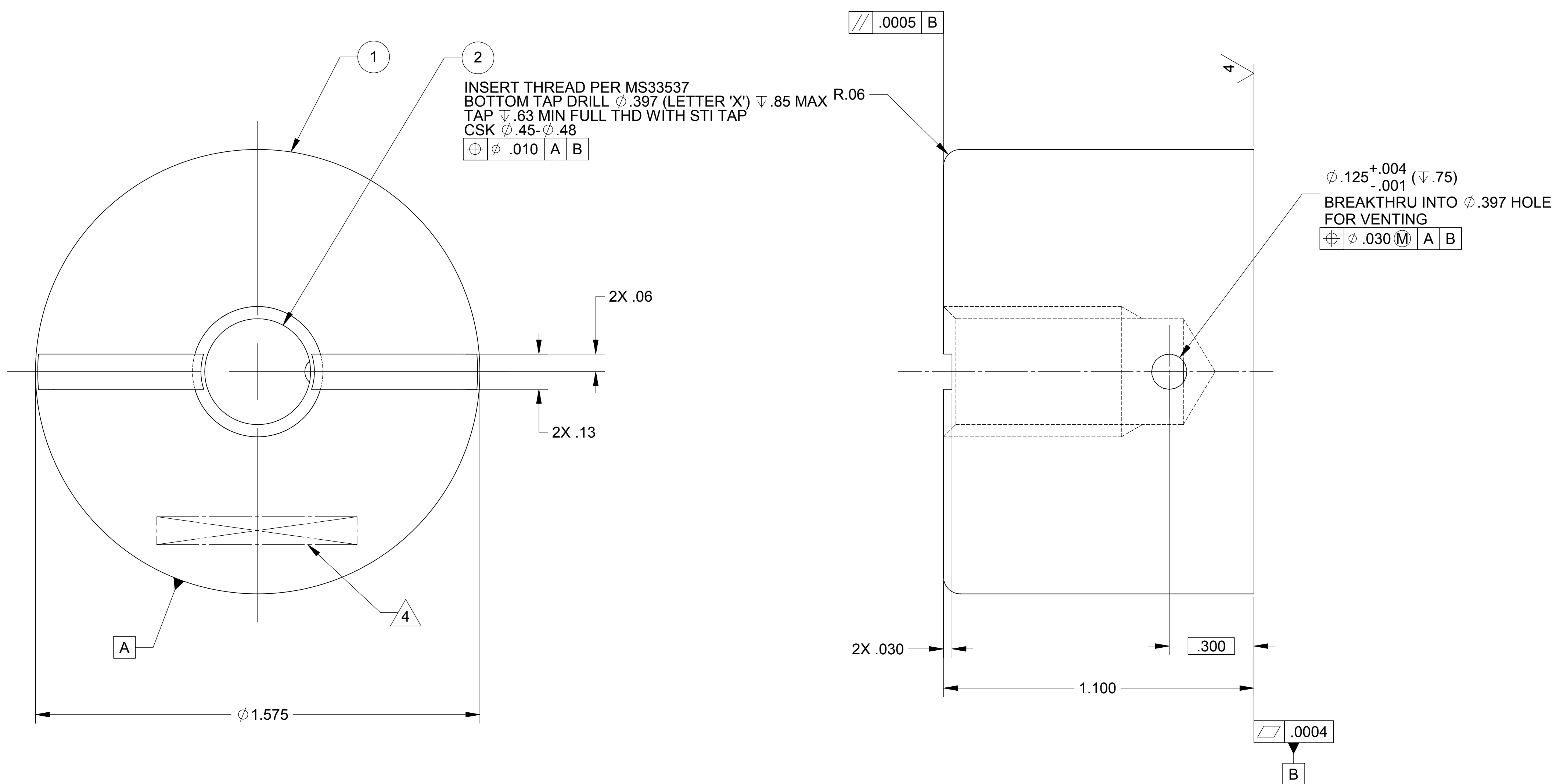


LTR		ZONE	DESCRIPTION	REVISIONS										
DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE					
A			INITIAL RELEASE											



NOTES: UNLESS OTHERWISE SPECIFIED.

- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
- 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. THIS DOES NOT APPLY TO THREADED INSERT HOLES.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER $+.015/-0.000$.
- 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 .2 LBS.

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
1	2			91732A214	INSERT, HELICAL	.375-16 X .562L	18-8 CRES	
1	1			20007914-101	TARGET	AMS-QQ-A-225/1	1100 AL ALY	

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .XX $\pm .03$.XXX $\pm .010$ ANGLES $\pm 1/2^\circ$ MACHINE FINISH 63 DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		RELEASED 1/17/2005 DWN KEVIN J SPINK 10/06/04 PROJ ENGR STRS CHK MATL CONFIG PROJ ME QA		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
20007912		1388		SEE PARTS LIST		STAGE 0-1 DISPLACEMENT SENSOR TARGET LIGO-D047914-A	
NEXT ASSEMBLY		PROJECT CODE		APPLICATION		SIZE D CAGE CODE 1KNU9 20007914 REV A SCALE 4:1 UNCLASSIFIED SHEET 1 OF 1	

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

FILE ATTACHMENTS
20007914.x_t