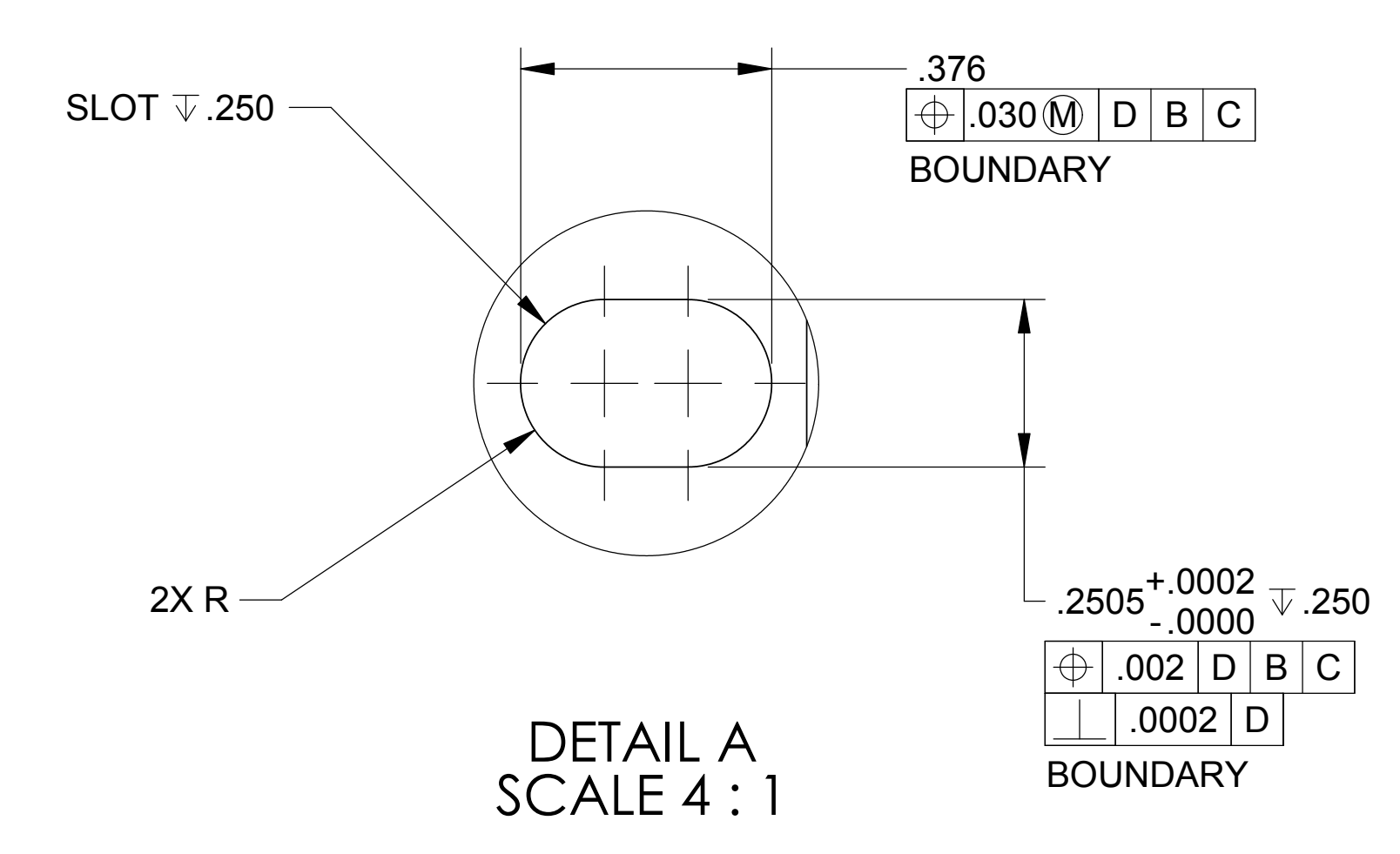
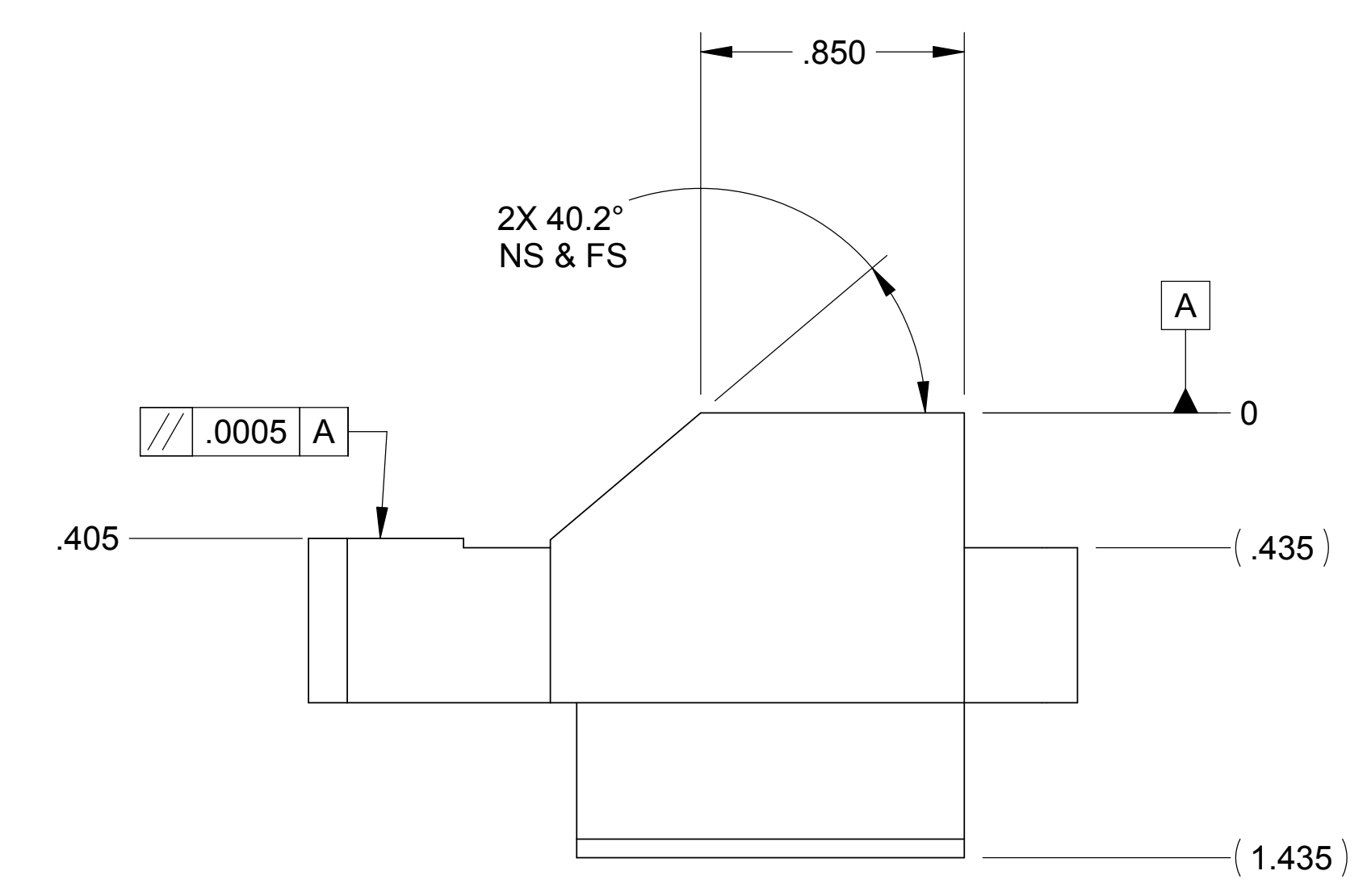
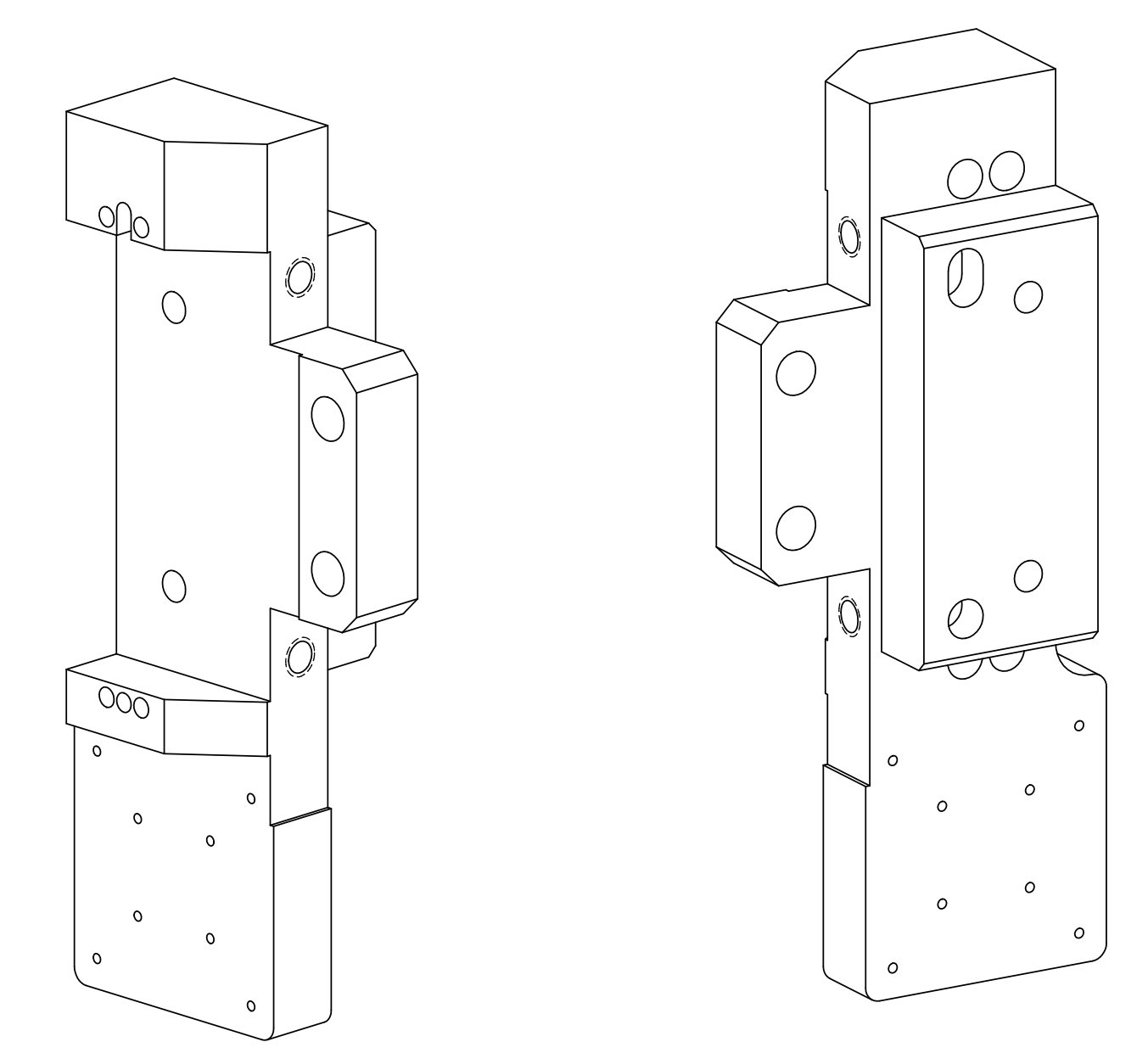
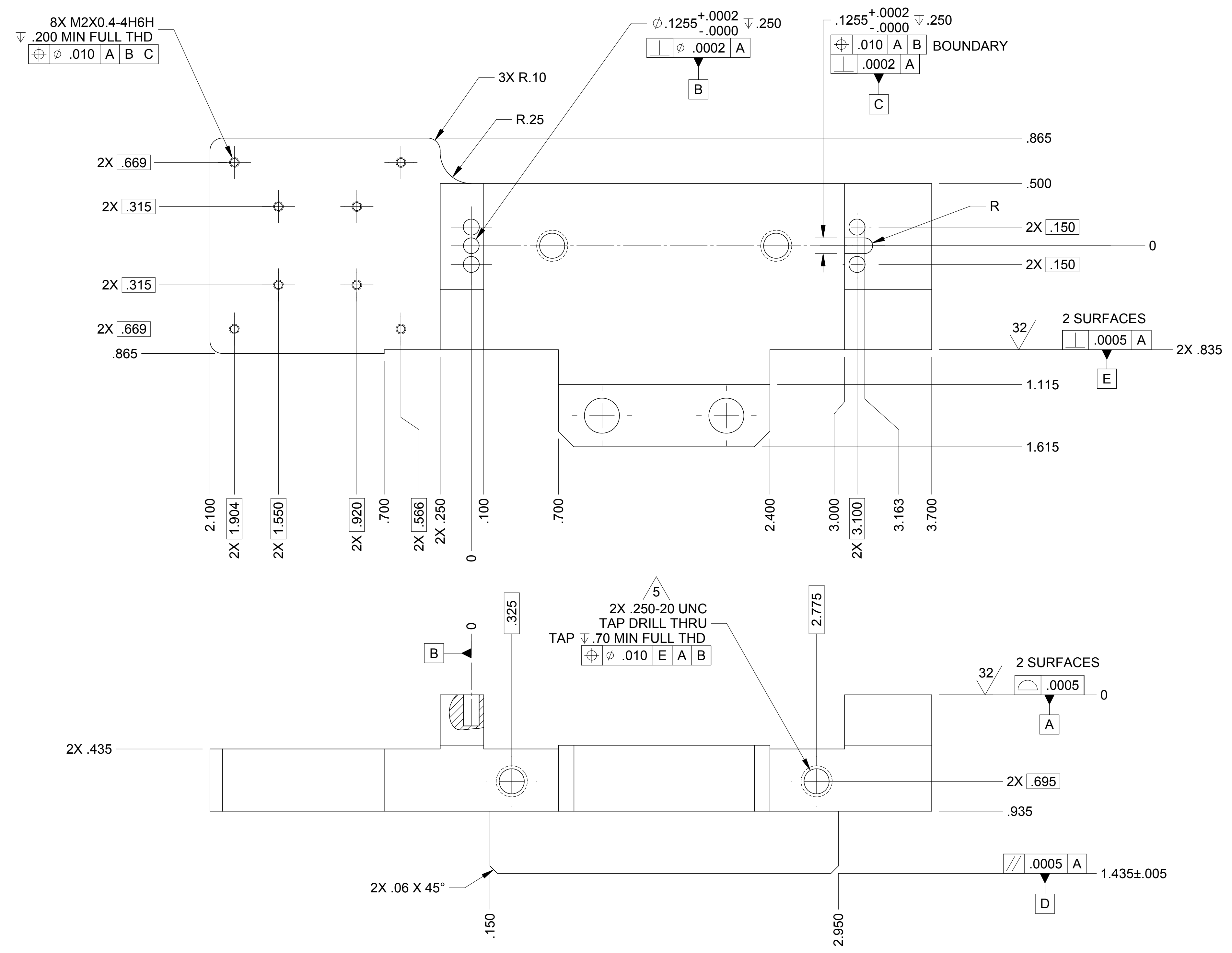


LTR		REVISIONS									
ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A	INITIAL RELEASE										1-24-05
B	250-20 UNC HOLE TAP CALLOUT WAS: ∇ 900 MIN. IS: THRU	RF		KS	RF		DK	DCW	DCW	SV	MK



- 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 20006886, 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 20006886, 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 OR M2 METRIC THREADS.
 - COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.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 0.7 LBS

QTY REQD		ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
					20007921-1				
					PARTS LIST				
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		RELEASED 2/17/2005		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103		REV B	
		DECIMALS .XX ±.03 ANGLES XXX ±.010 ±12°		MACHINE FINISH 63		BRACKET, STAGE 1-2 HORZ COIL ADAPTOR LIGO D7921-B		CAGE CODE 1KNU9	
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		MATERIAL 7075 T651 AL ALLY PER AMS-QQ-A-250/12		DWN R.D.BILLING 07/07/04		SCALE 2:1	
FILE ATTACHMENTS		20007968 1388		20007921_x_1		UNCLASSIFIED		SHEET 1 OF 1	

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