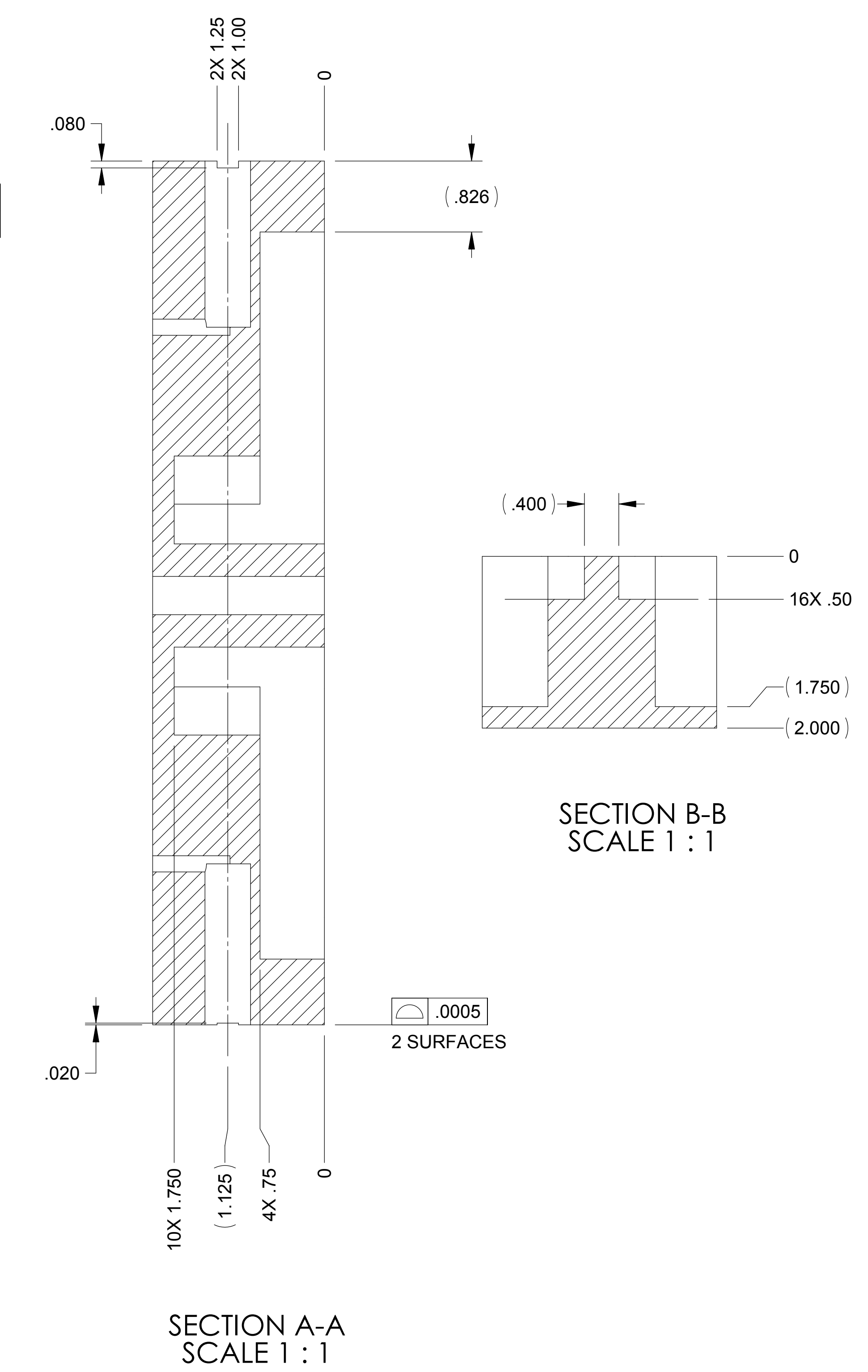
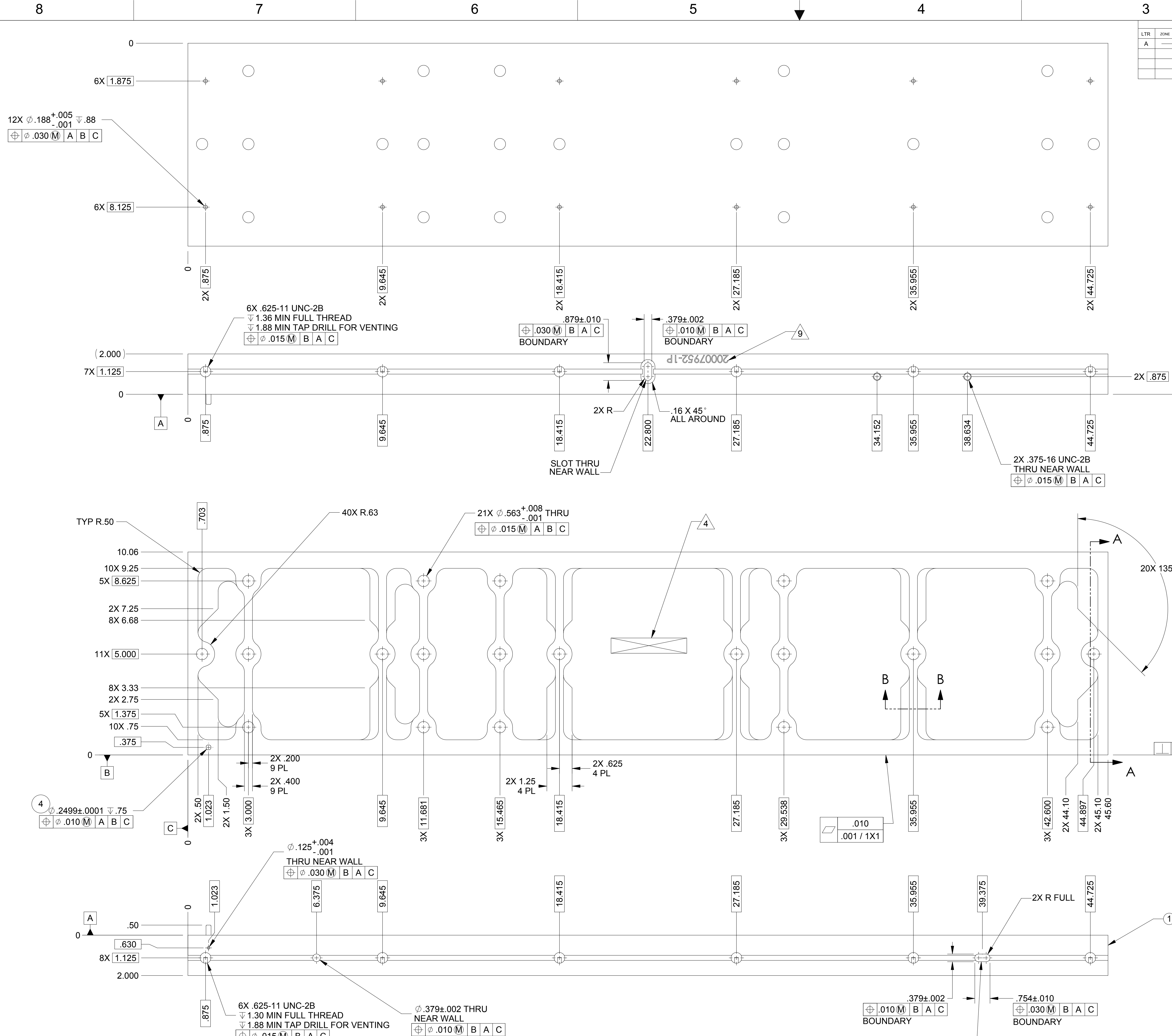


LTR		ZONE	DESCRIPTION	REVISIONS									
A			INITIAL RELEASE	DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE



- 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 NOT REQUIRING INSERTS SHALL BE TAPPED .004-.006 OVERSIZE.
 - 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 PER DASH NUMBER IS: 20007952-1P=35.6 LBS, 20007952-2P=35.7 LBS, 20007952-3P=35.7 LBS
 - MARK PART NUMBER AND DASH NUMBER WITH THE LETTER P AFTER THE DASH NUMBER IN APPROXIMATE LOCATION SHOWN. USE ANY METHOD THAT WILL NOT RUB OFF OR SMUDGE UNDER NORMAL HANDLING. THIS MARKING DOES NOT NEGATE NOTE 4 AND WILL BE REMOVED DURING SUBSEQUENT OPERATION DEPICTED IN DRAWING 20007960.
 - THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE THE MODEL DATABASE WILL TAKE PRECEDENCE.

**-1 SHOWN
-2 SEE SHEET 2
-3 SEE SHEET 3**

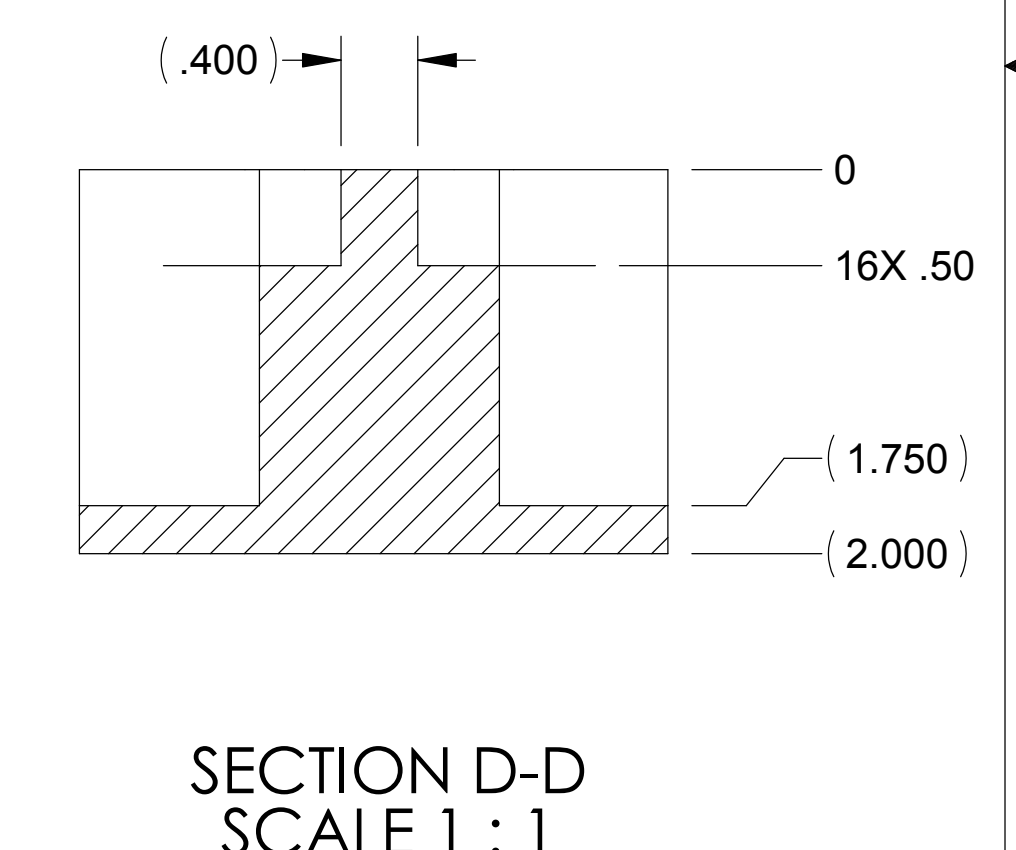
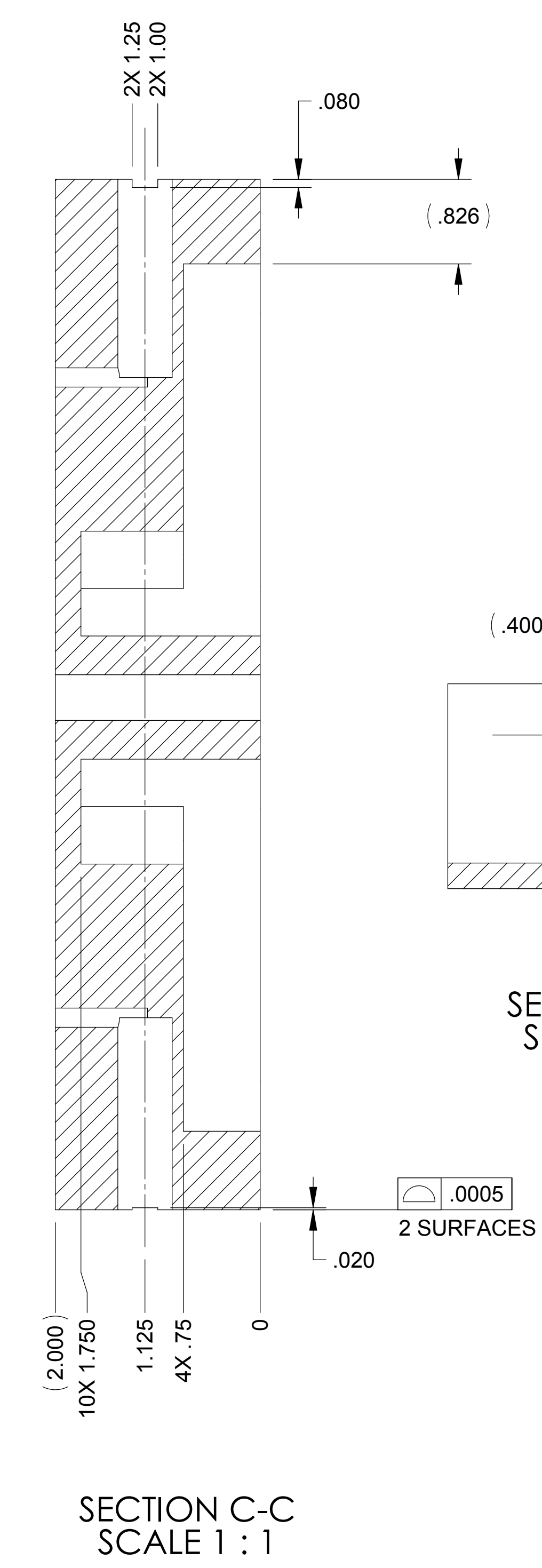
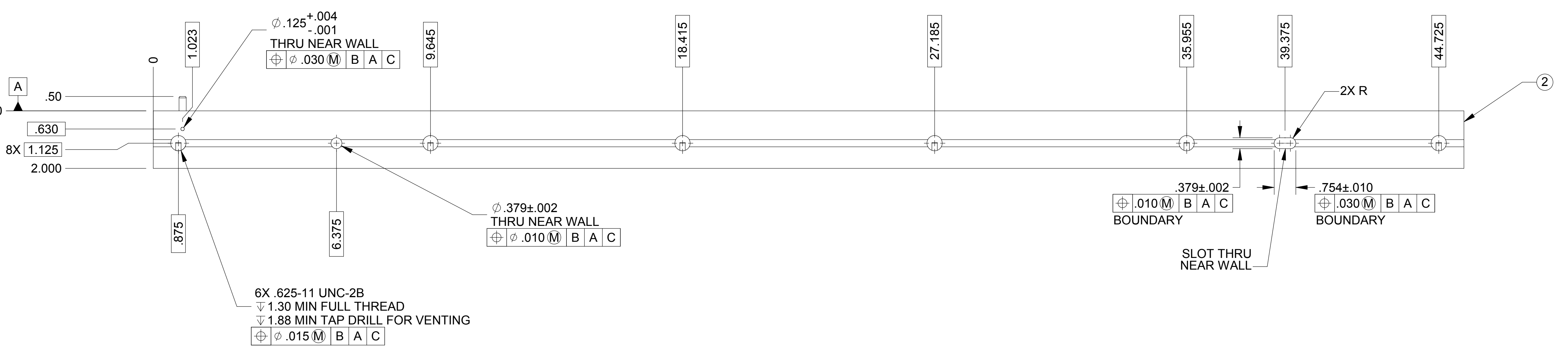
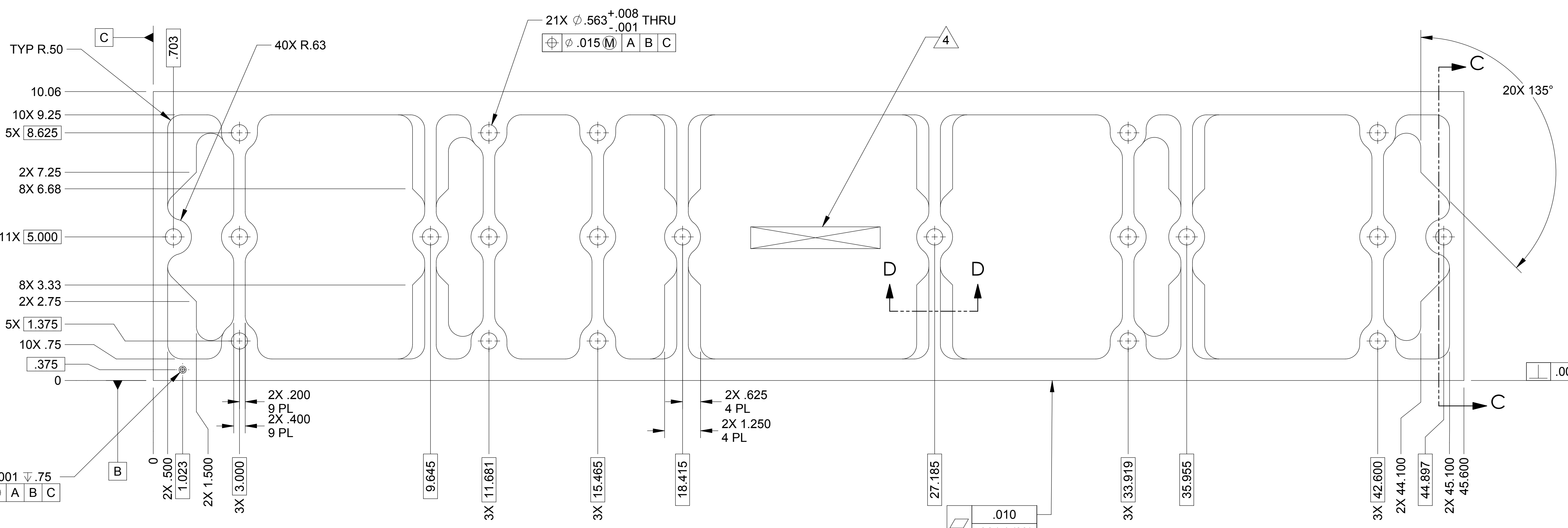
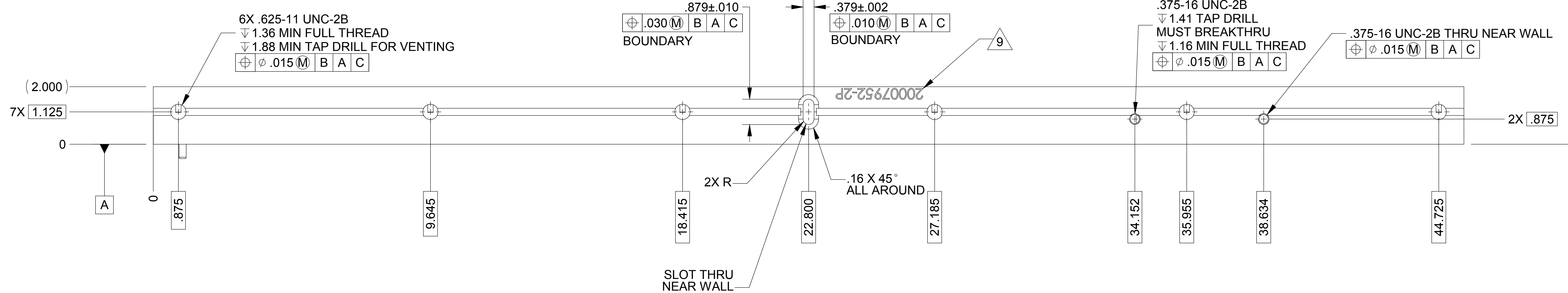
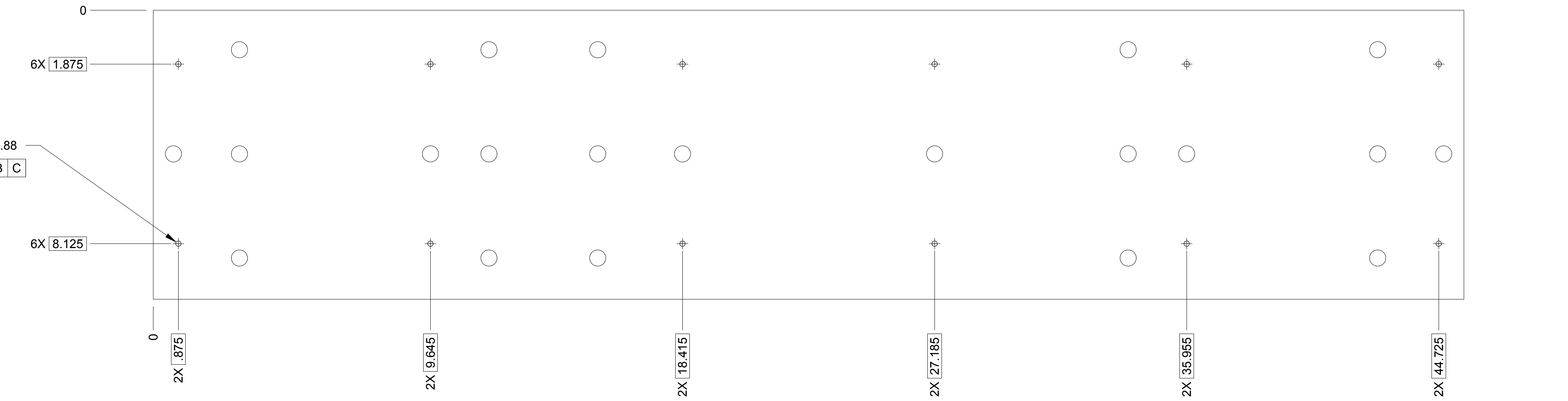
QTY	REQD	-2P	-1P	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
1	1	1	4			3A054	98380A624	PIN, .3752 X 1.00L		MCMaster-CARR	CRES
1			3				20007952-103	OUTER WALL, STEP3	AMS-QQ-A-250/12		AL 7075-T651
1			2				20007952-102	OUTER WALL, STEP2	AMS-QQ-A-250/12		AL 7075-T651
			1	1			20007952-101	OUTER WALL, STEP1	AMS-QQ-A-250/12		AL 7075-T651

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		RELEASED 2007/03/2004 ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
20007960		1388		DWN KEVIN J SPINK 07/13/04		OUTER HEX WALL STAGE 0 LIGO-D047952-A	
20007952-1P.x_t		20007952-2P.x_t		MACHINE FINISH 125		SIZE E CAGE CODE 1KNU9 20007952	
20007952-1P.x_t		20007952-3P.x_t		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		SCALE 1:2 UNCLASSIFIED SHEET 1 OF 3	
APPLICATION		PROJECT CODE		MATERIAL		REV A	

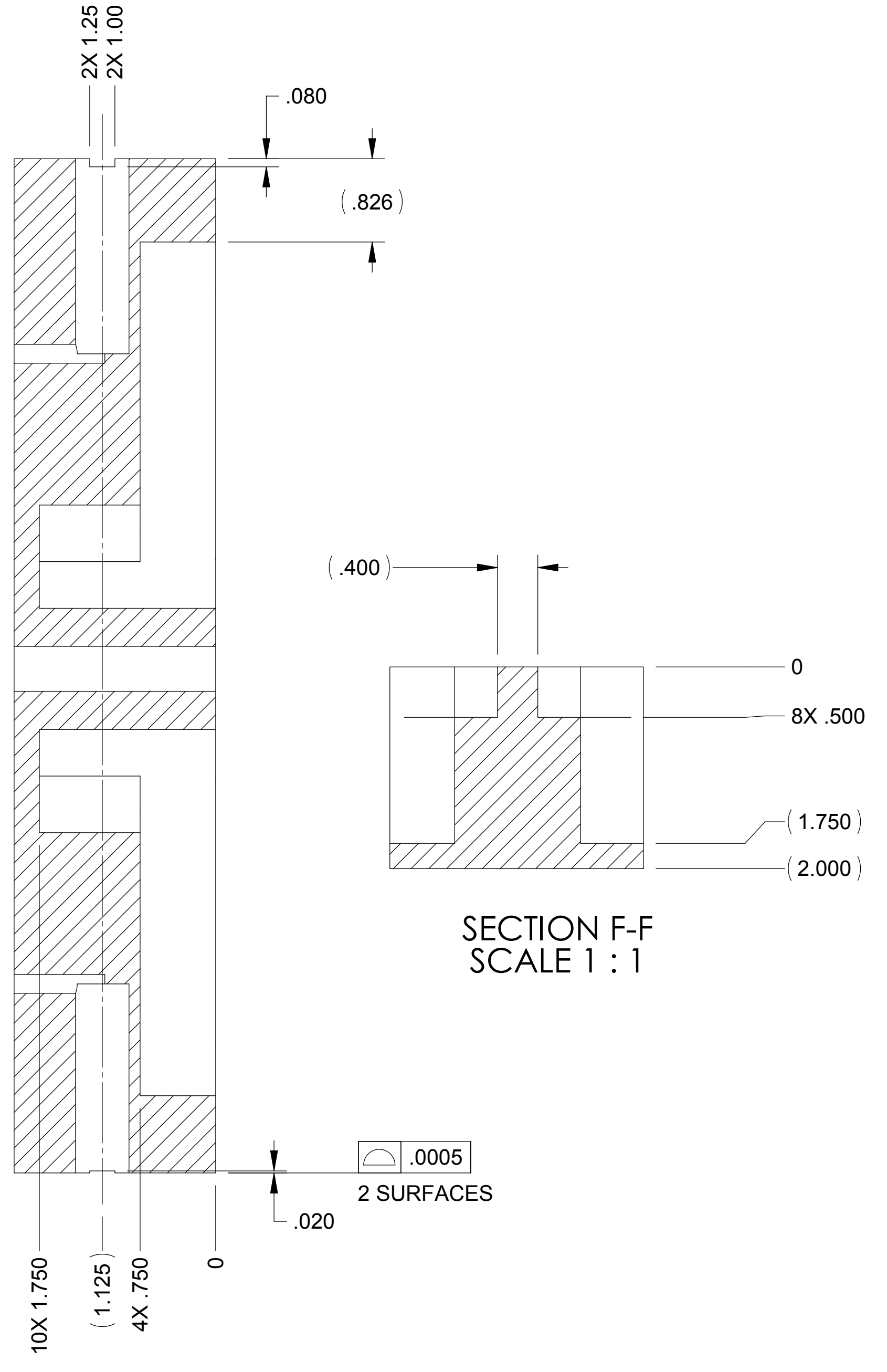
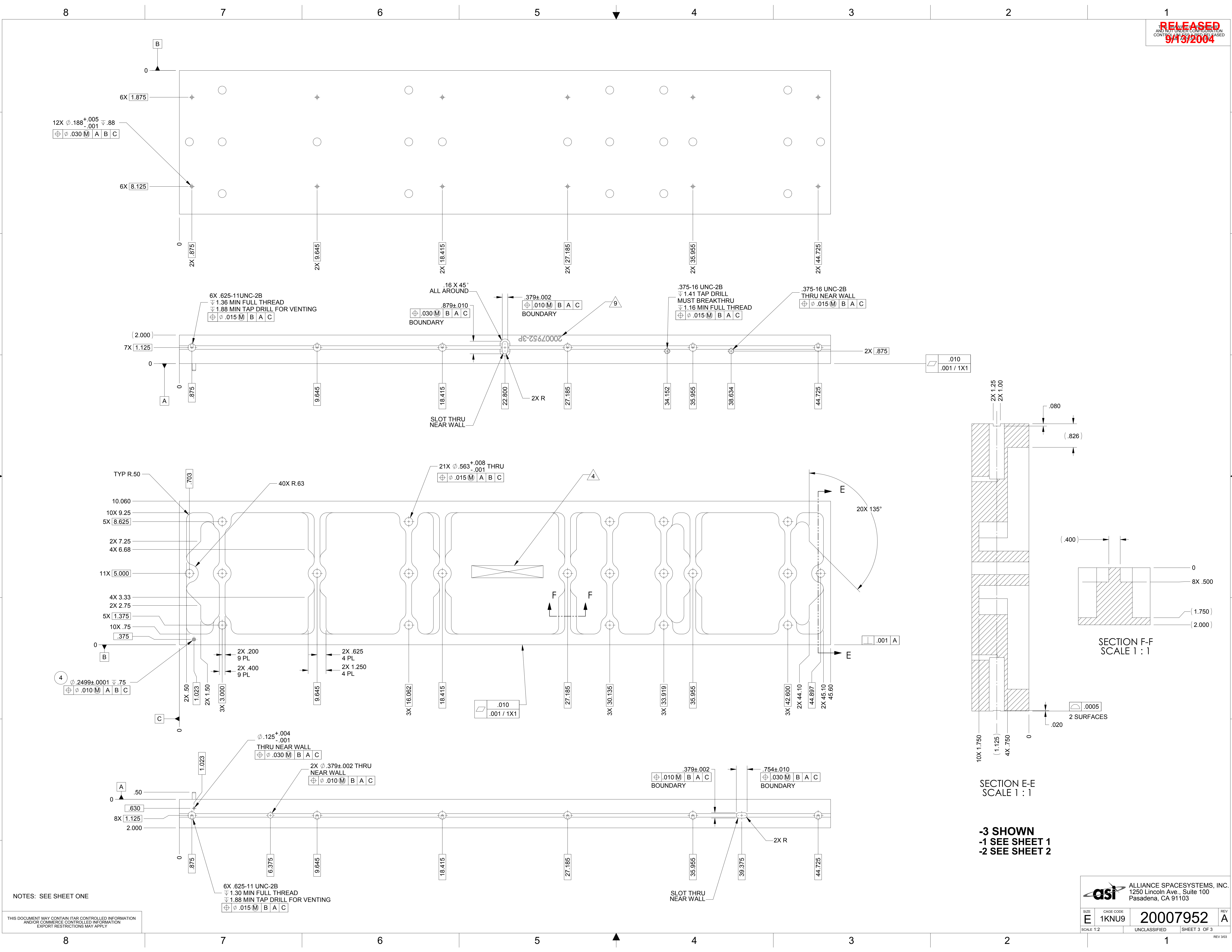
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12X $\phi .188^{+0.005}_{-.001}$ $\nabla .88$
 $\oplus \phi .015 \overline{M}$ | A | B | C

6X $\nabla 8.125$



-2 SHOWN
-1 SEE SHEET 1
-3 SEE SHEET 3



SECTION E-E
SCALE 1:1

-3 SHOWN
-1 SEE SHEET 1
-2 SEE SHEET 2

NOTES: SEE SHEET ONE

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asi ALLIANCE SPACESYSTEMS, INC.
1250 Lincoln Ave., Suite 100
Pasadena, CA 91103

SIZE	CAGE CODE	REV
E	1KNU9	A
SCALE 1:2		UNCLASSIFIED
20007952		SHEET 3 OF 3