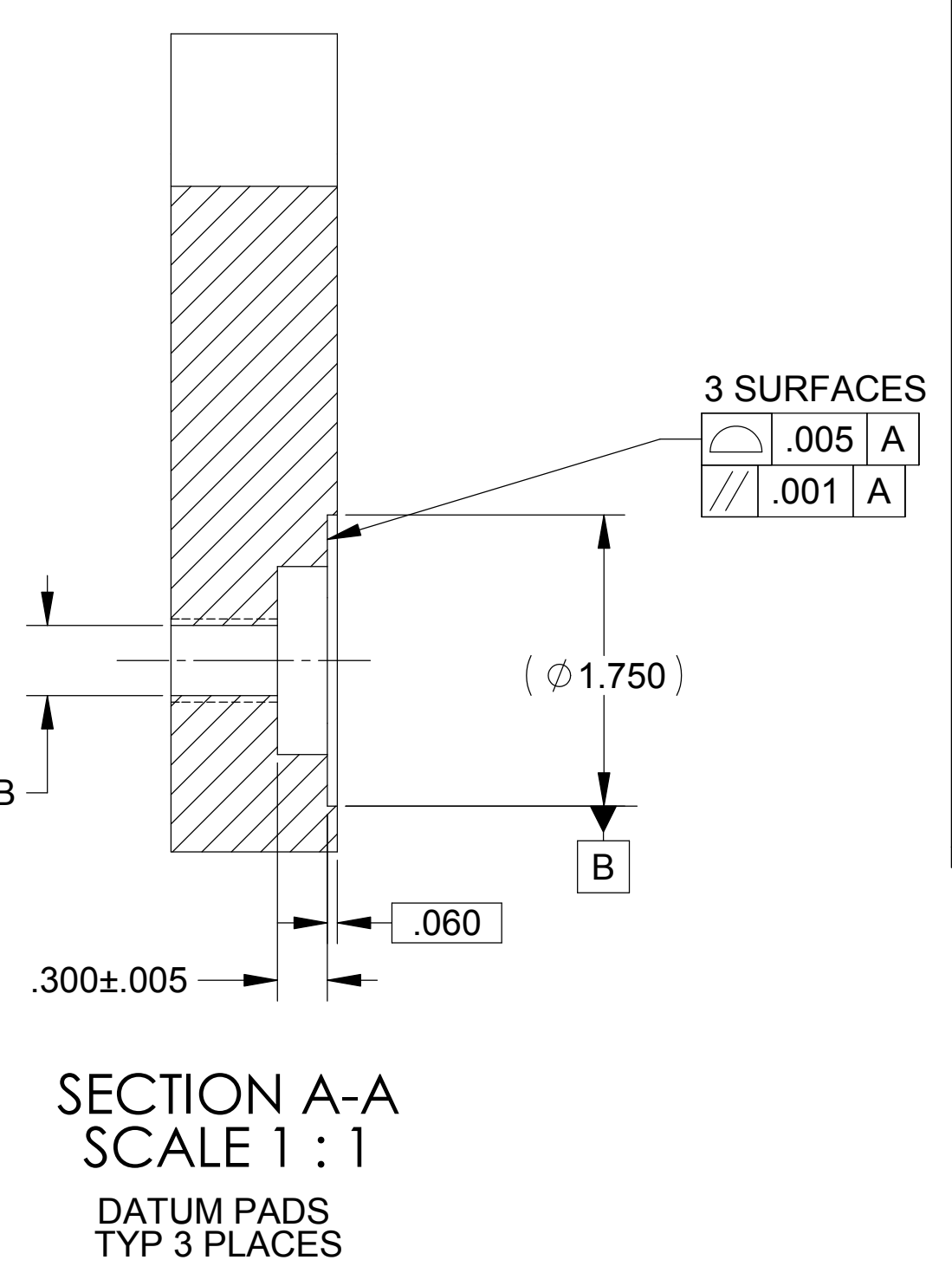
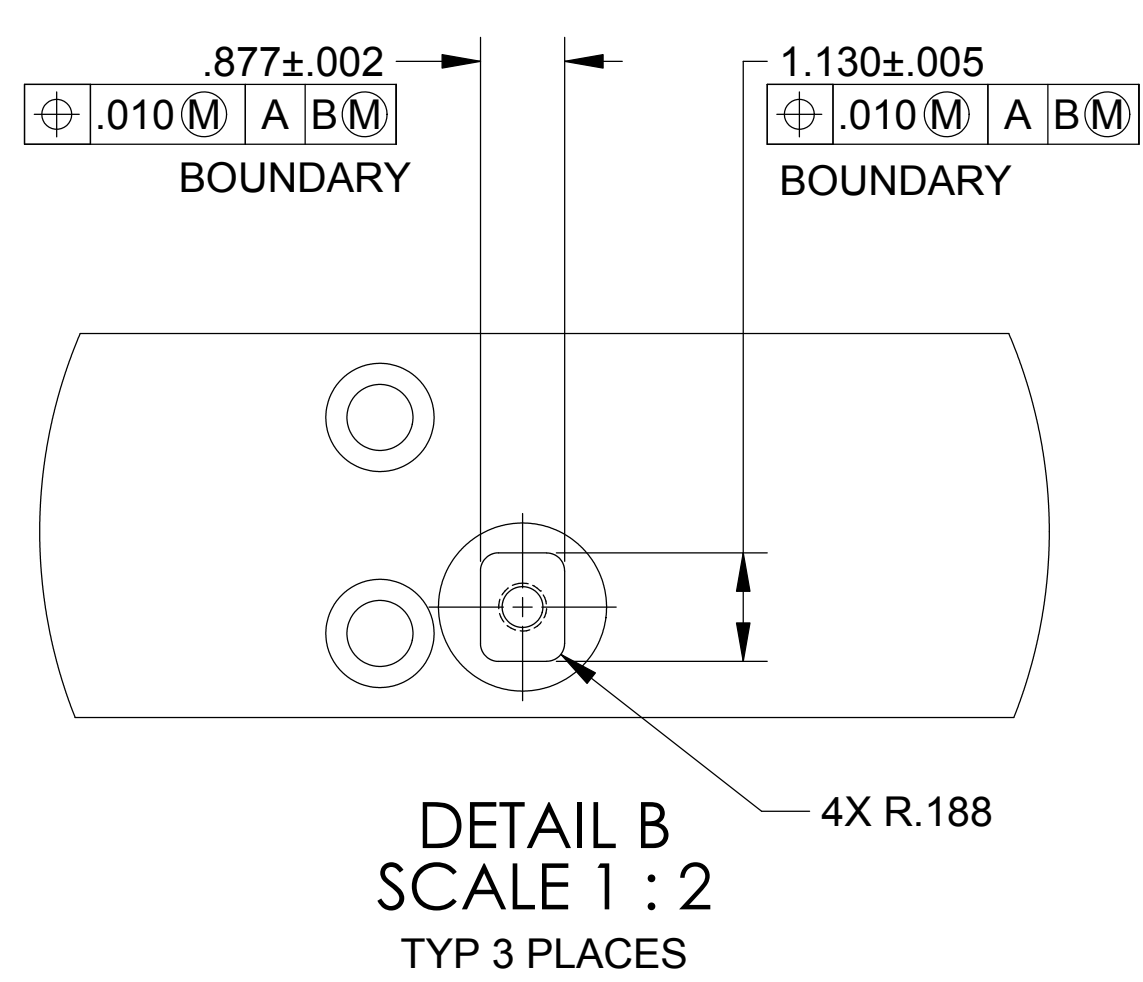
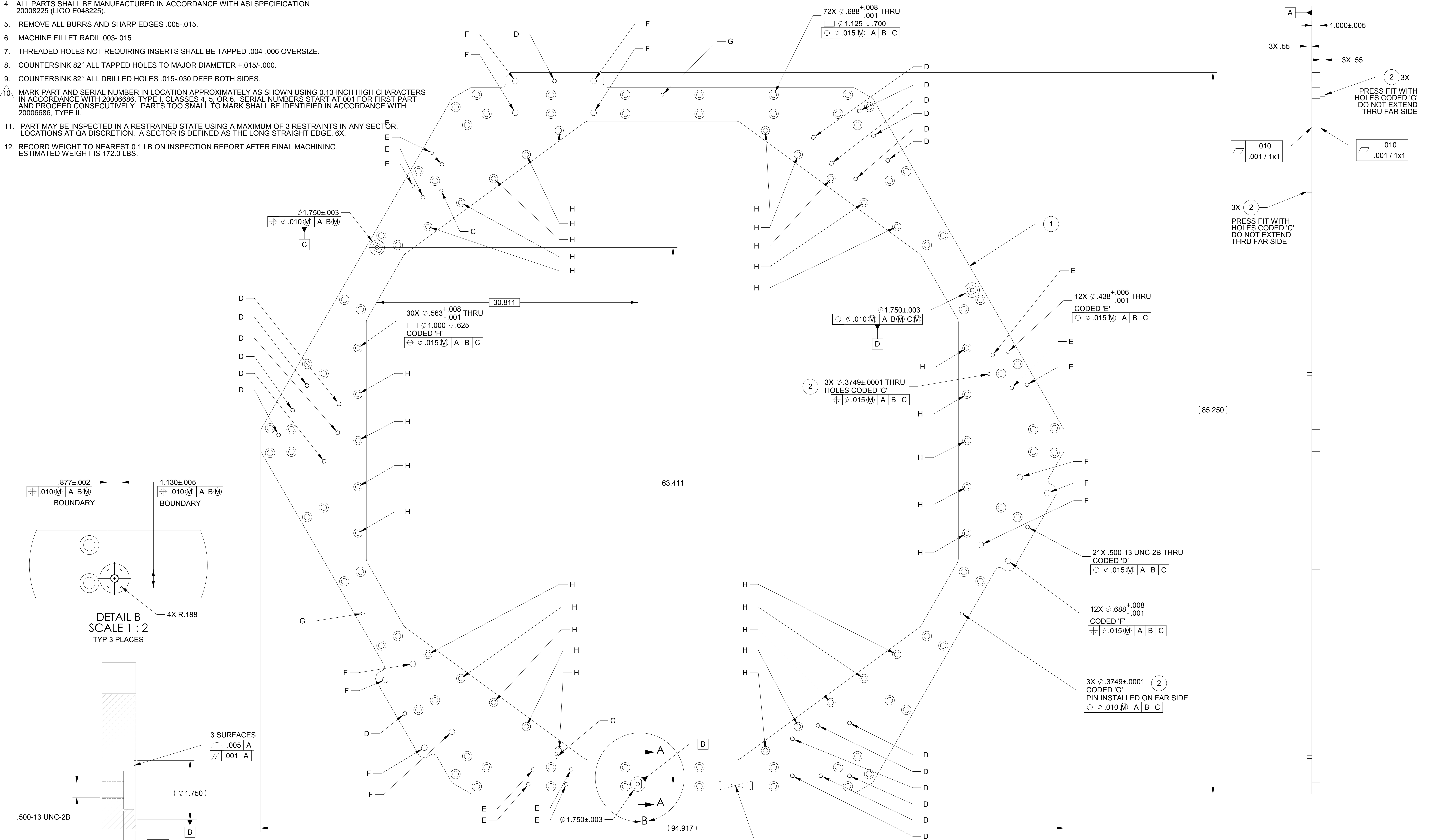


NOTES: UNLESS OTHERWISE SPECIFIED.

- 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.
- PART SHALL BE CHECKED USING THE MODEL DATABASE.
- A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
- 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.
- 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.
- 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.
- PART MAY BE INSPECTED IN A RESTRAINED STATE USING A MAXIMUM OF 3 RESTRAINTS IN ANY SECTOR. LOCATIONS AT QA DISCRETION. A SECTOR IS DEFINED AS THE LONG STRAIGHT EDGE, 6X.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 172.0 LBS.

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



10. MARK FAR SIDE IN LOCATION SHOWN

6	2	3AO54	98380A618	PIN, .3752 X 1.5 L	MCMaster-CARR	CRES	
1	1	20007957-101	20007957-101	PLATE, TOP	AMS-QQ-A-250/11	AL 6061-T651	

QTY		REGD	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 ANGLES .XX ±.03 .XXX ±.010 ±12°								
MACHINE FINISH		125								
DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M, 1994		SEE PARTS LIST								
MATERIAL		SEE PARTS LIST								
FILE ATTACHMENTS		20007957-1_x_1								
20007950		1388								
NEXT ASSEMBLY		PROJECT CODE								
APPLICATION										
DWN		KEVIN J SPINK 07/21/04								
PROJ ENGR		STRS								
CHK		MATL								
CONFIG		PROJ								
ME		QA								
SIZE		E								
CAGE CODE		1KNU9								
SCALE		1:4								
REV		A								
UNCLASSIFIED		SHEET 1 OF 1								

RELEASED
S/N 42004

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

**TOP PLATE
STAGE 0
LIGO-D047957-A**

20007957

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