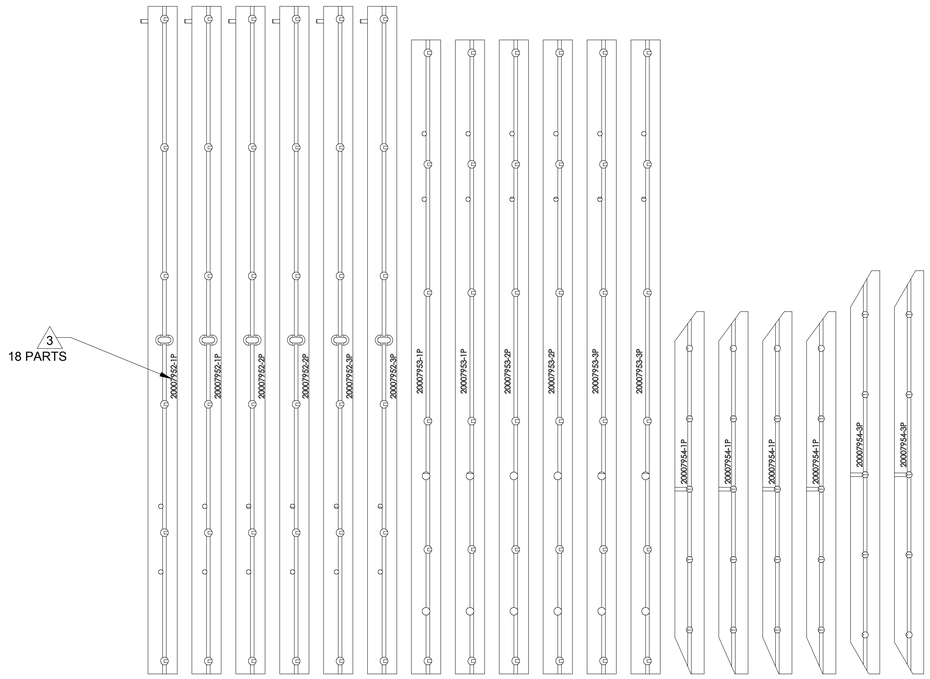
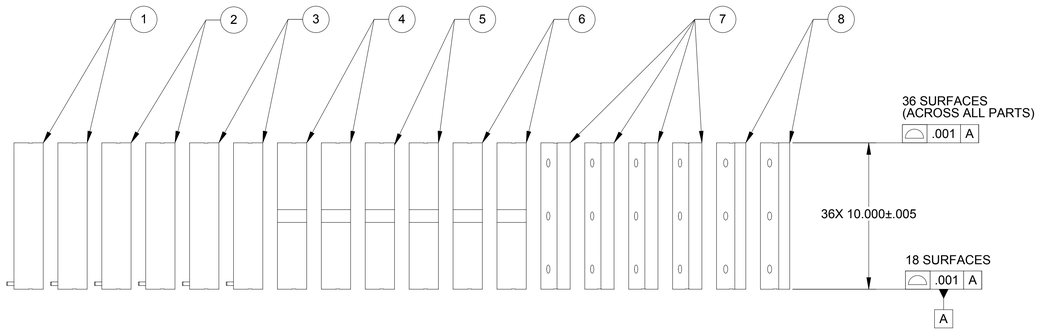
REVISIONS											
LTR	ZONE	DESCRIPTION	DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE										





NOTES: UNLESS OTHERWISE SPECIFIED.

1. THIS DOCUMENT CONTROLS FINAL HEIGHT OF STAGE 0 STRUCTURE WALLS.
2. PARTS SHALL NOT BE MARKED WITH THIS DOCUMENT NUMBER.
3. SURFACE TO BE MACHINED IS MARKED WITH THE PART NUMBER, DASH NUMBER, AND THE LETTER "P". FOR EXAMPLE: 20005952-1P. THIS MARKING WILL BE REMOVED DURING THE MACHINING PROCESS. NO FURTHER MARKING IS REQUIRED.
4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
5. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
6. MACHINE FILLET RADII .003-.015.
7. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
8. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.

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

QTY	QTY	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
	2	8			20007954-3P	GUSSET, INNER HEX WALL, .060 OVERSIZE			
	4	7			20007954-1P	GUSSET, INNER HEX WALL, .060 OVERSIZE			
	2	6			20007953-3P	INNER HEX WALL, .060 OVERSIZE			
	2	5			20007953-2P	INNER HEX WALL, .060 OVERSIZE			
	2	4			20007953-1P	INNER HEX WALL, .060 OVERSIZE			
	2	3			20007952-3P	OUTER HEX WALL, .060 OVERSIZE			
	2	2			20007952-2P	OUTER HEX WALL, .060 OVERSIZE			
	2	1			20007952-1P	OUTER HEX WALL, .060 OVERSIZE			

PARTS LIST

CONTRACT NO

FILE ATTACHMENTS

20007960 Final Wall Cut Stage 0.x_t

NEXT ASSEMBLY	PROJECT CODE
20007950	1388

APPLICATION

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS .XX ±.03 .XXX ±.010
ANGLES ±1/2°
MACHINE FINISH 125
DO NOT SCALE DRAWING
INTERPRET DWG PER ASME Y14.5M
MATERIAL
SEE PARTS LIST

RELEASED
THIS DRAWING IS RELEASED AND NO FURTHER CONFIGURATION CONTROL UNLESS A REV RELEASED
21/7/2005

DWN KEVIN J SPINK 07/29/04
PROJ ENGR
STRS
CHK
MATL
CONFIG
PROJ
ME
QA

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

FINAL CUT - WALL HEIGHT STAGE 0 LIGO D047960-A

SIZE	CAGE CODE		REV
E	1KNU9	20007960	A

SCALE 1:8 UNCLASSIFIED SHEET 1 OF 1

REV 6/04