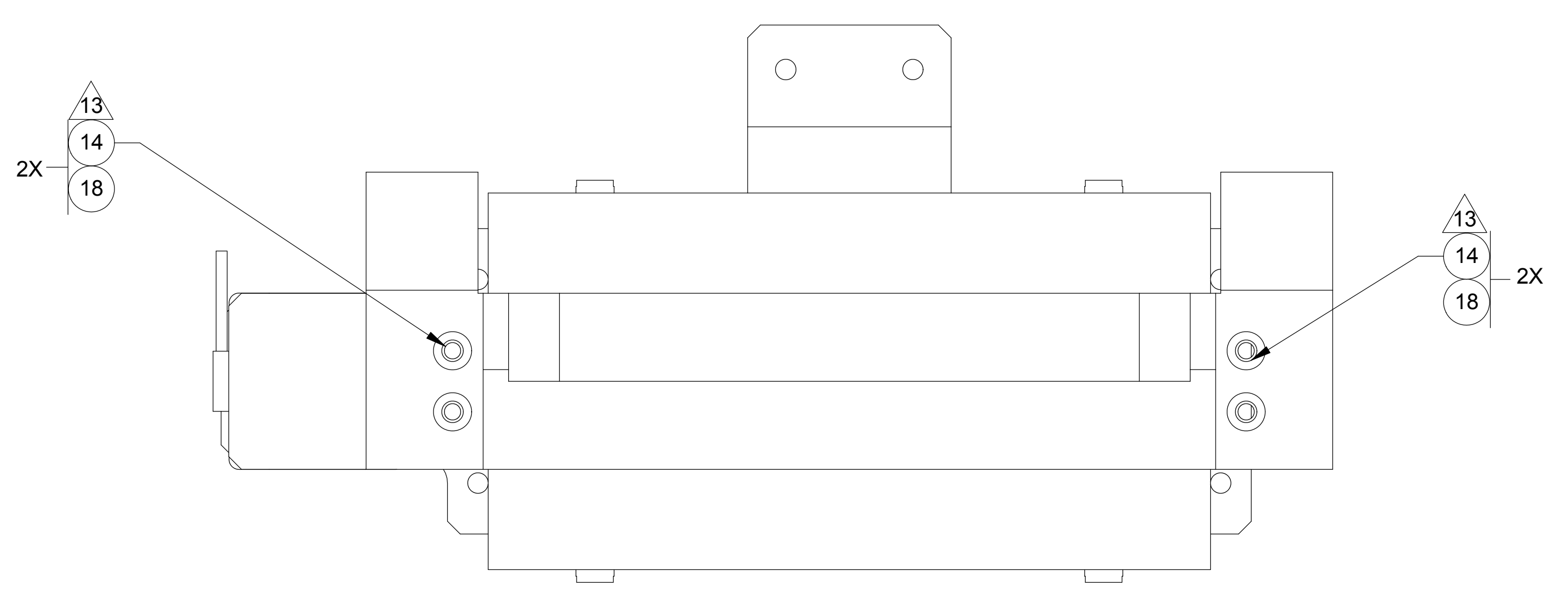
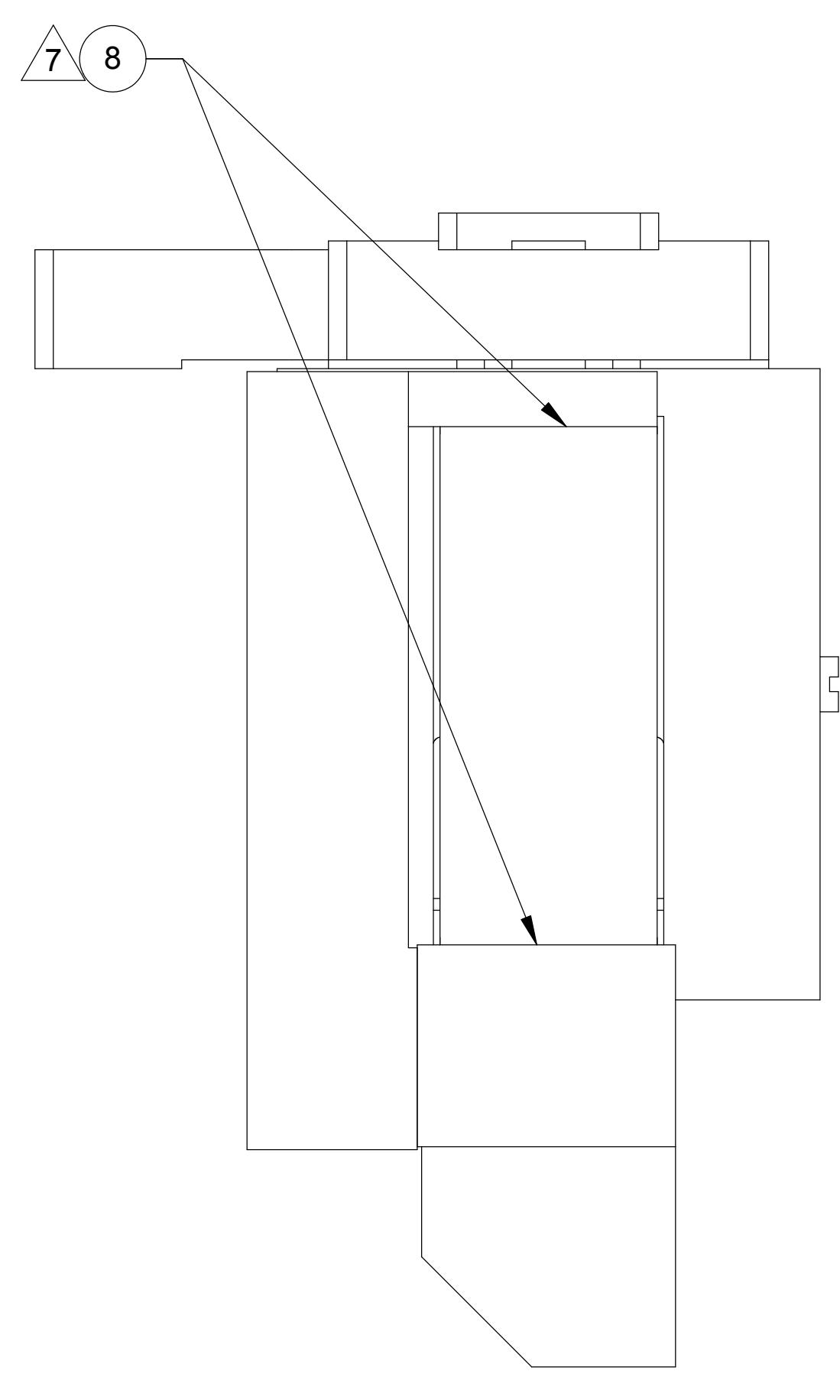
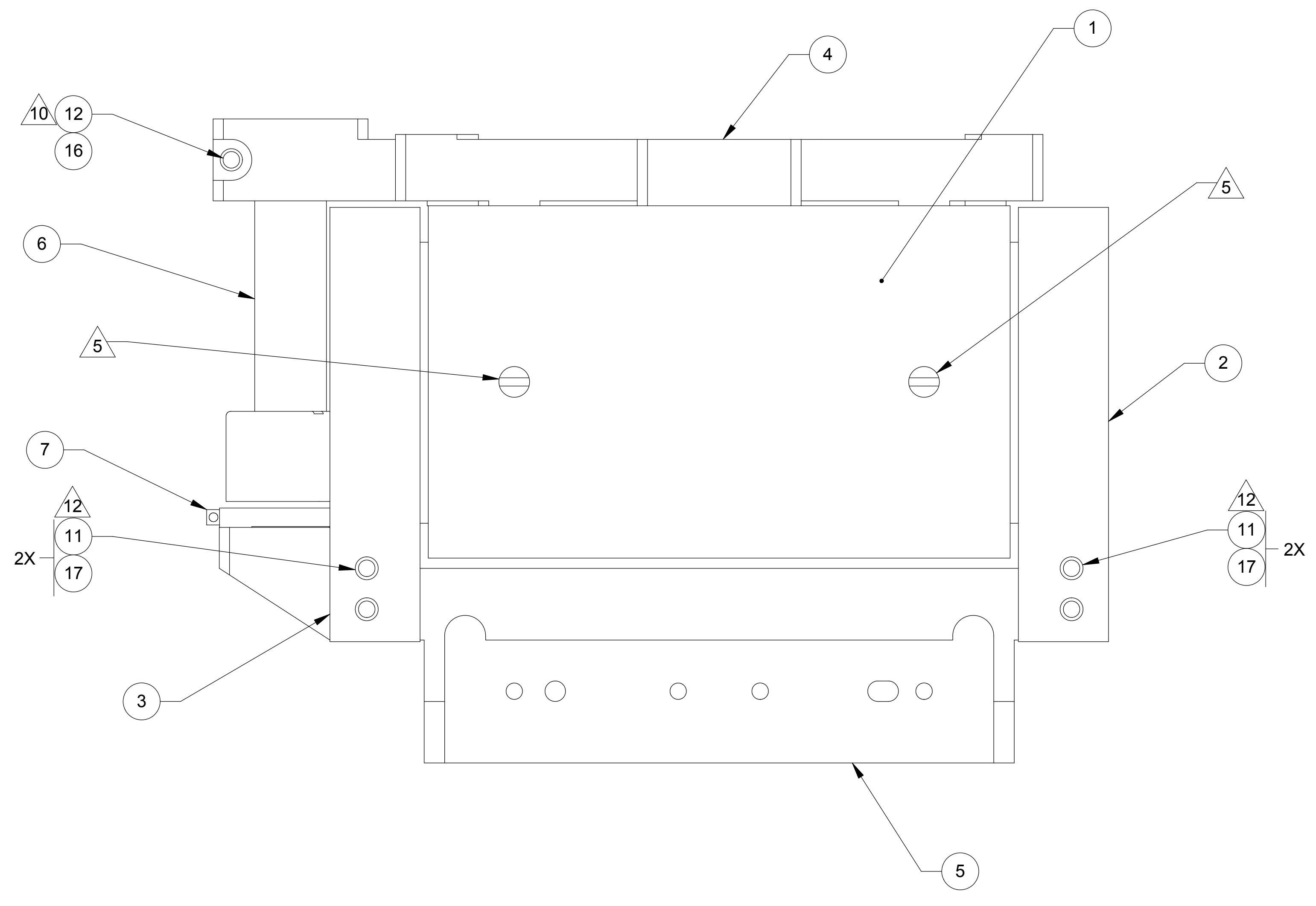
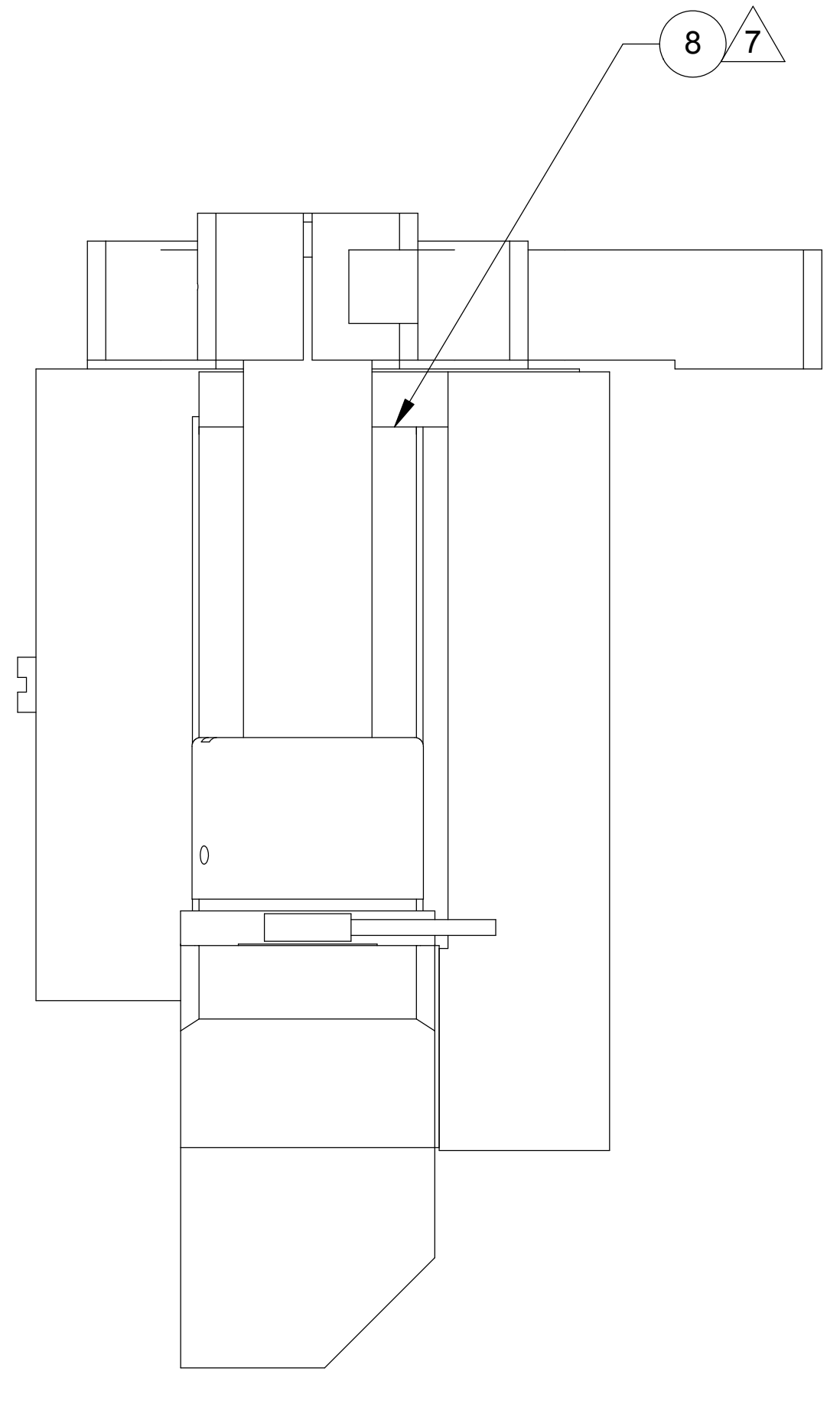
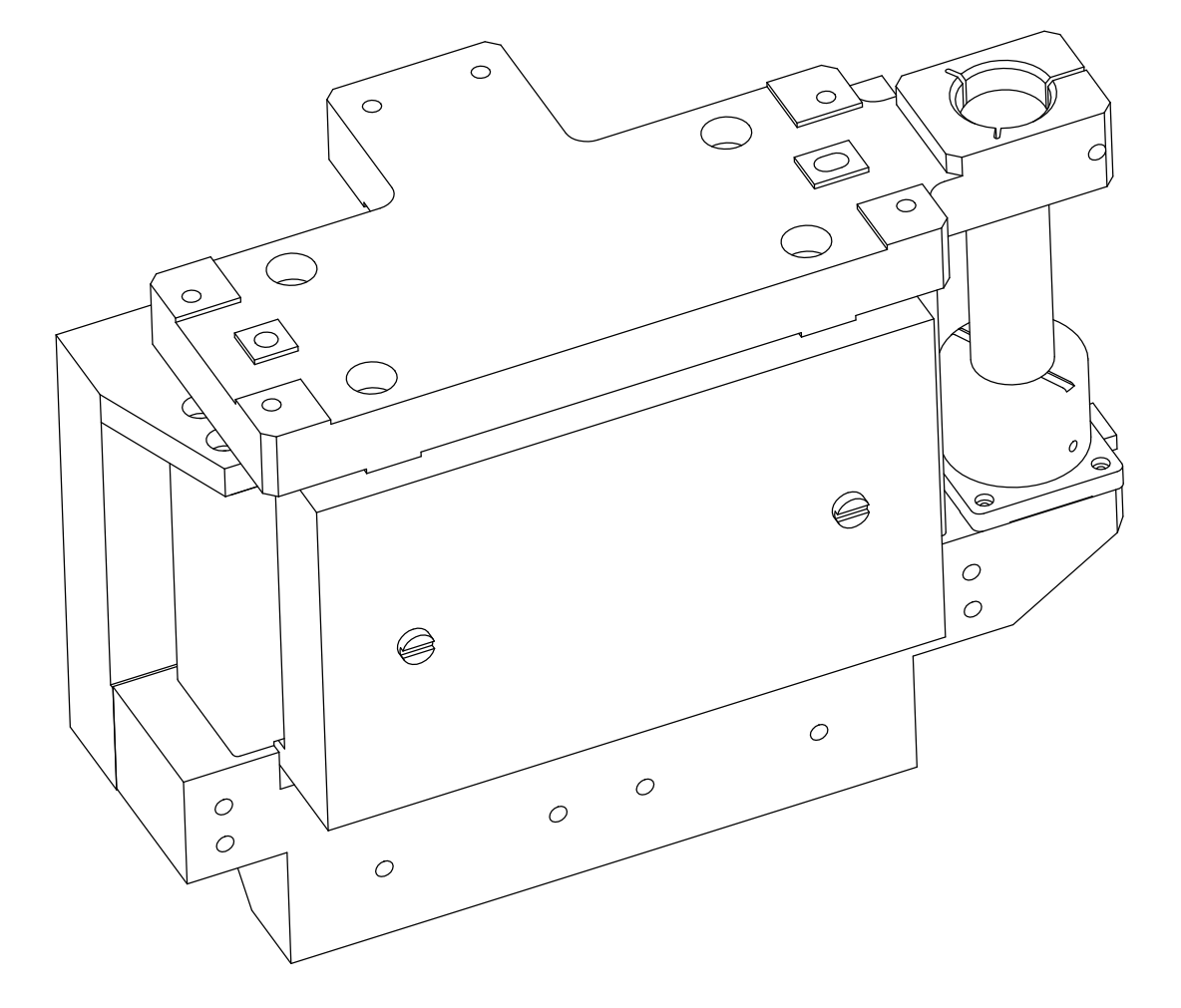
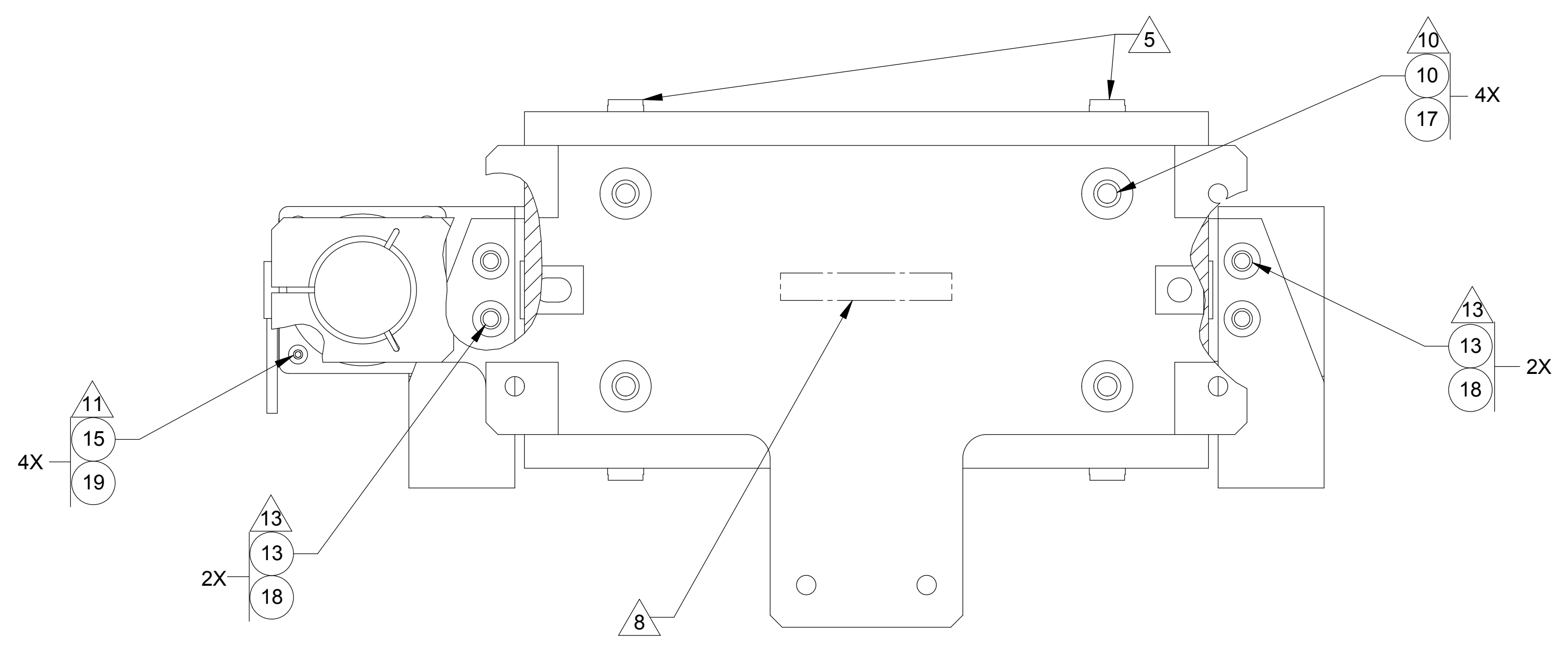


LTR		ZONE		REVISIONS										DWN		CHK		P-ENG		CONFIG		ME		STRS		MATL		PROJ		QA		RELEASE DATE	
A				INITIAL RELEASE																													



- NOTES: UNLESS OTHERWISE SPECIFIED.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
 - SOURCE OF SUPPLY: PLANNING SYSTEMS INCORPORATED MELBOURNE, FLORIDA 32901
 - SOURCE OF SUPPLY: ADE TECHNOLOGIES NEWTON, MARYLAND 02466
 - SOURCE OF SUPPLY: U-C COMPONENTS, INC. MORGAN HILL, CALIFORNIA 95037
 - REMOVE SHIPPING SCREWS PRIOR TO TEST AND OPERATION.
 - ALUMINUM ALLOY FOIL, ANNEALED, .001 INCH THICK, CONFORMING TO ASTM B 479-00.
 - APPLY FOIL TO FAYING SURFACES OF ITEMS 3, 1 AND 5, AND 2, 1 AND 5.
 - MARK ASSY AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING .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.
 - BOLT TORQUING PROCEDURE SHALL ENSURE THAT THE SPECIFIED TORQUE IS APPLIED WITHIN A TOLERANCE OF +5% / -10%.
 - TORQUE: 60 IN LBS.
 - TORQUE: 1.5 IN LBS.
 - TORQUE: 168 IN LBS.
 - TORQUE: 30 IN LBS.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL ASSEMBLY. ESTIMATED WEIGHT IS: 42.9 LBS.
 - ALL SCREWS SHALL BE SILVER PLATED. DIMENSIONAL TOLERANCES PER UNC/UNF-2A APPLY AFTER PLATING.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
4		4	19		MFVW-02	WASHER, FLAT, VENTED	.087 ID, .197 OD, .012 THK	18-8 CRES	
4		8	18		WFV-10	WASHER, FLAT, VENTED	.195 ID, .354 OD, .032 THK	18-8 CRES	
4		8	17		WFV-25	WASHER, FLAT, VENTED	.255 ID, .468 OD, .032 THK	18-8 CRES	
		1	16		NAS620C-416	WASHER, FLAT	.255 ID, .468 OD, .063 THK	18-8 CRES	
4		4	15		MP-206-A	SCREW, PN HD, VENTED	M2 X 0.4 X 6MM L	18-8 CRES	
4		4	14		C-1008-A	SCREW, SHC, VENTED	.190-32 UNF X .500 L	18-8 CRES	
4		4	13		C-1006-A	SCREW, SHC, VENTED	.190-32 UNF X .375 L	18-8 CRES	
4		1	12		C-2012-NA	SCREW, SHC	.250-20 UNC X .750 L	18-8 CRES	
4		4	11		C-286-2028-NA	SCREW, SHC	.250-20 UNC X 1.750 L	A286 CRES	
4		4	10		C-2012-A	SCREW, SHC, VENTED	.250-20 UNC X .750 L	18-8 CRES	
		9							
		AR	8			FOIL, .001 IN THK	ASTM B 479-00	1100 AL ALLOY	
3		1	7		033968-01	SENSOR, ADE 20MM			
		1	6		20007912-1	DISPLACEMENT SENSOR TARGET ASSY			
		1	5		20007906-1	ADAPTER, COIL			
		1	4		20007905-1	ADAPTER, FIELD			
		1	3		20007977-2	THERMAL BAR, RIGHT			
		1	2		20007977-1	THERMAL BAR, LEFT			
2		1	1		0487-LIGO-D210-050904-SCS	ACTUATOR			

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

FILE ATTACHMENTS
20007967.XLT

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		RELEASED 3/4/2005		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
20007970		1388		DECIMALS .XX ±.03 ANGLES XXX ±.010 ±12° MACHINE FINISH ▽ DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		DWN KEVIN J SPINK 12/02/04 PROJ ENGR STRS CHK MATL CONFIG PROJ ME QA	
NEXT ASSEMBLY		PROJECT CODE		SEE PARTS LIST		STAGE 0-1 VERTICAL ACTUATOR ASSEMBLY LIGO D047967-A	
APPLICATION		SCALE 1:1		CAGE CODE 1KNU9 20007967		REV A UNCLASSIFIED SHEET 1 OF 1	