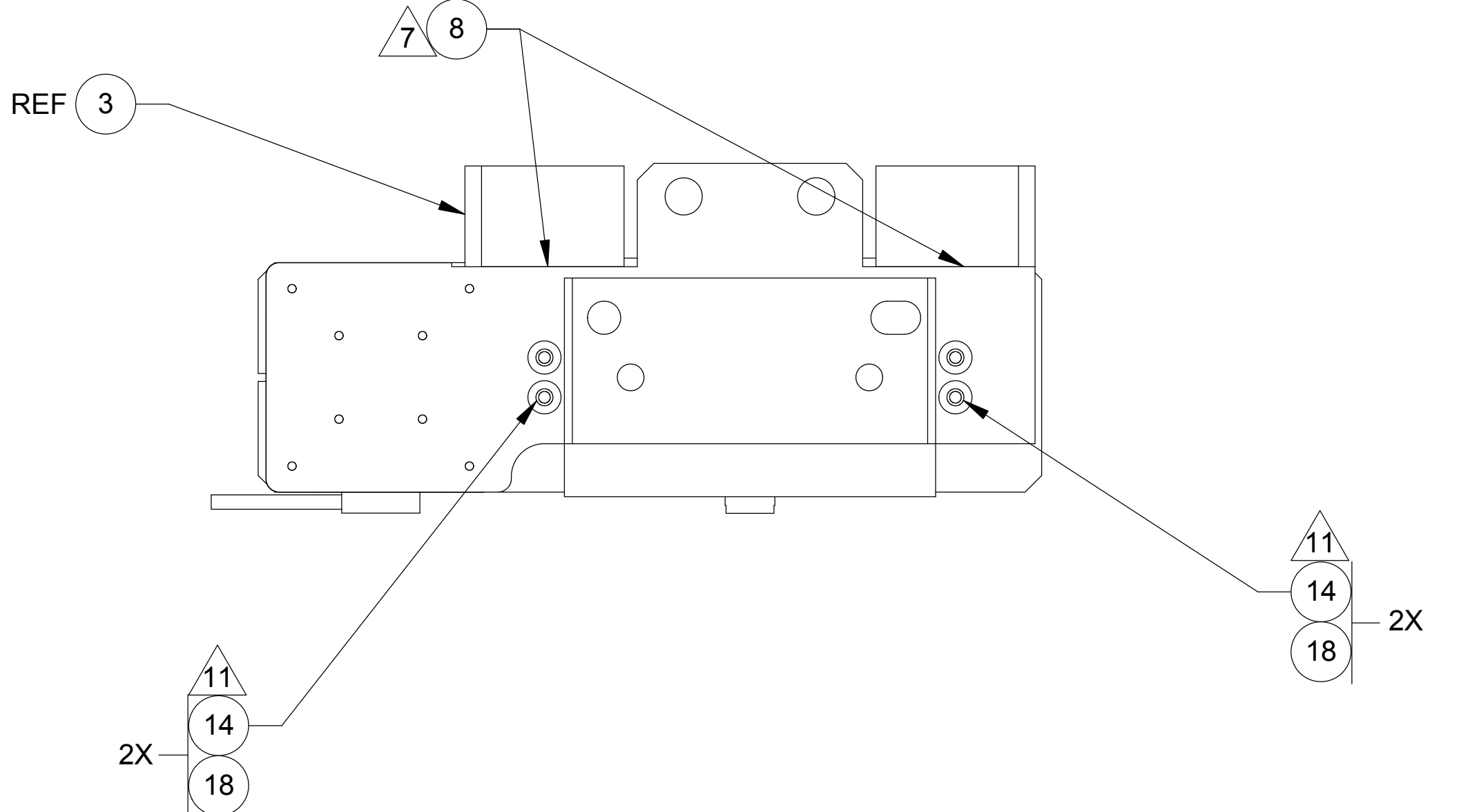
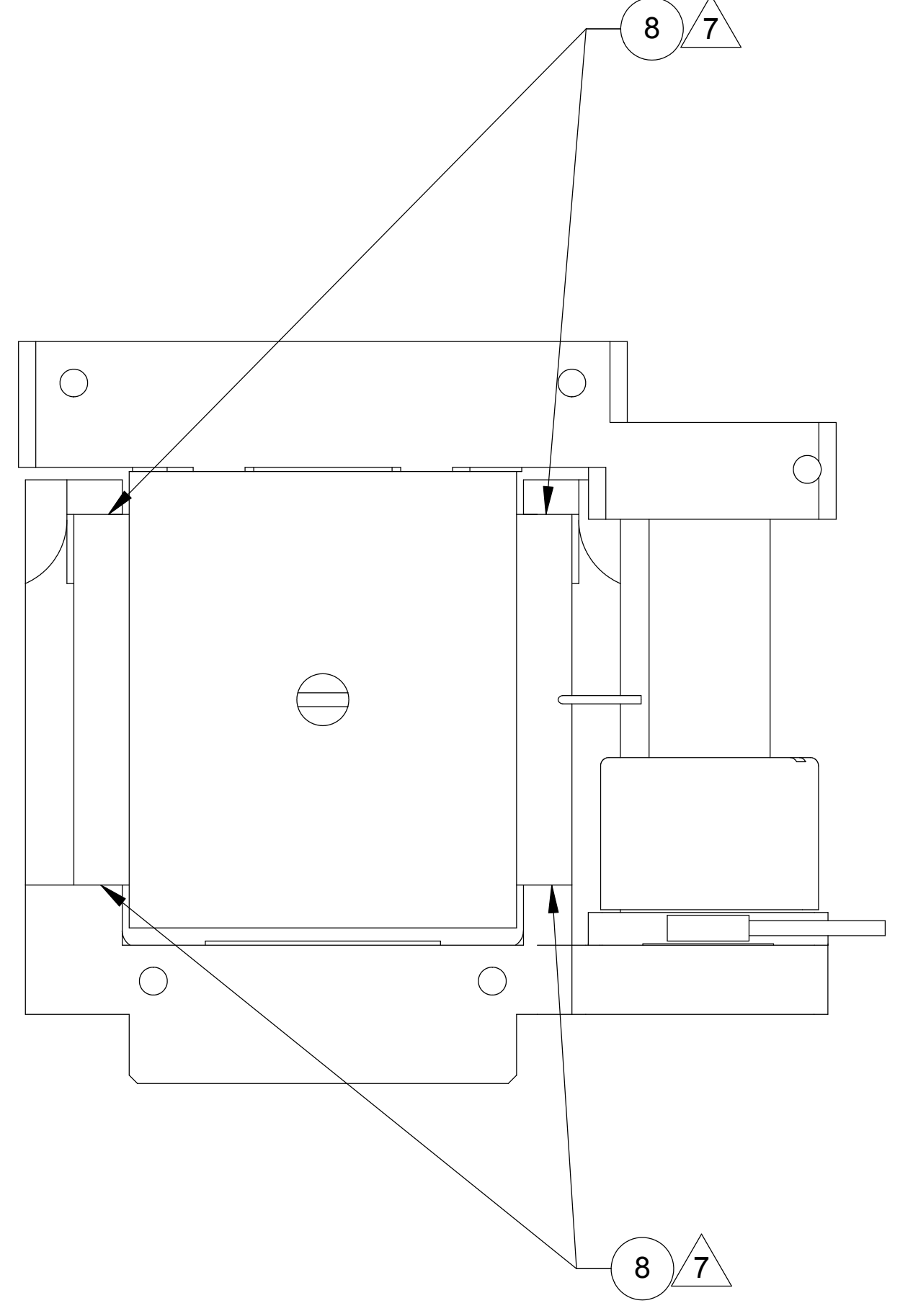
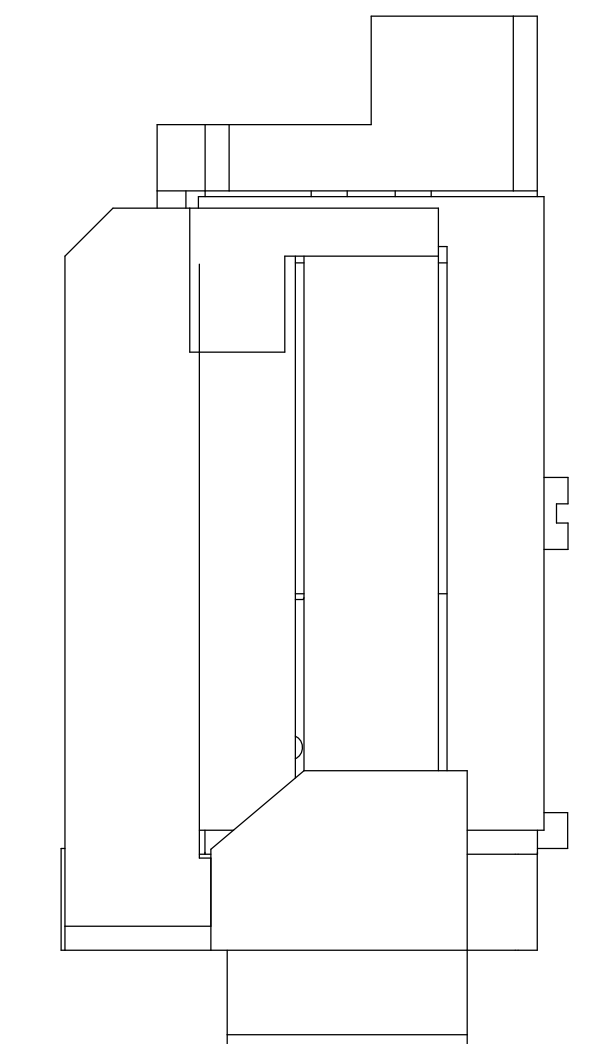
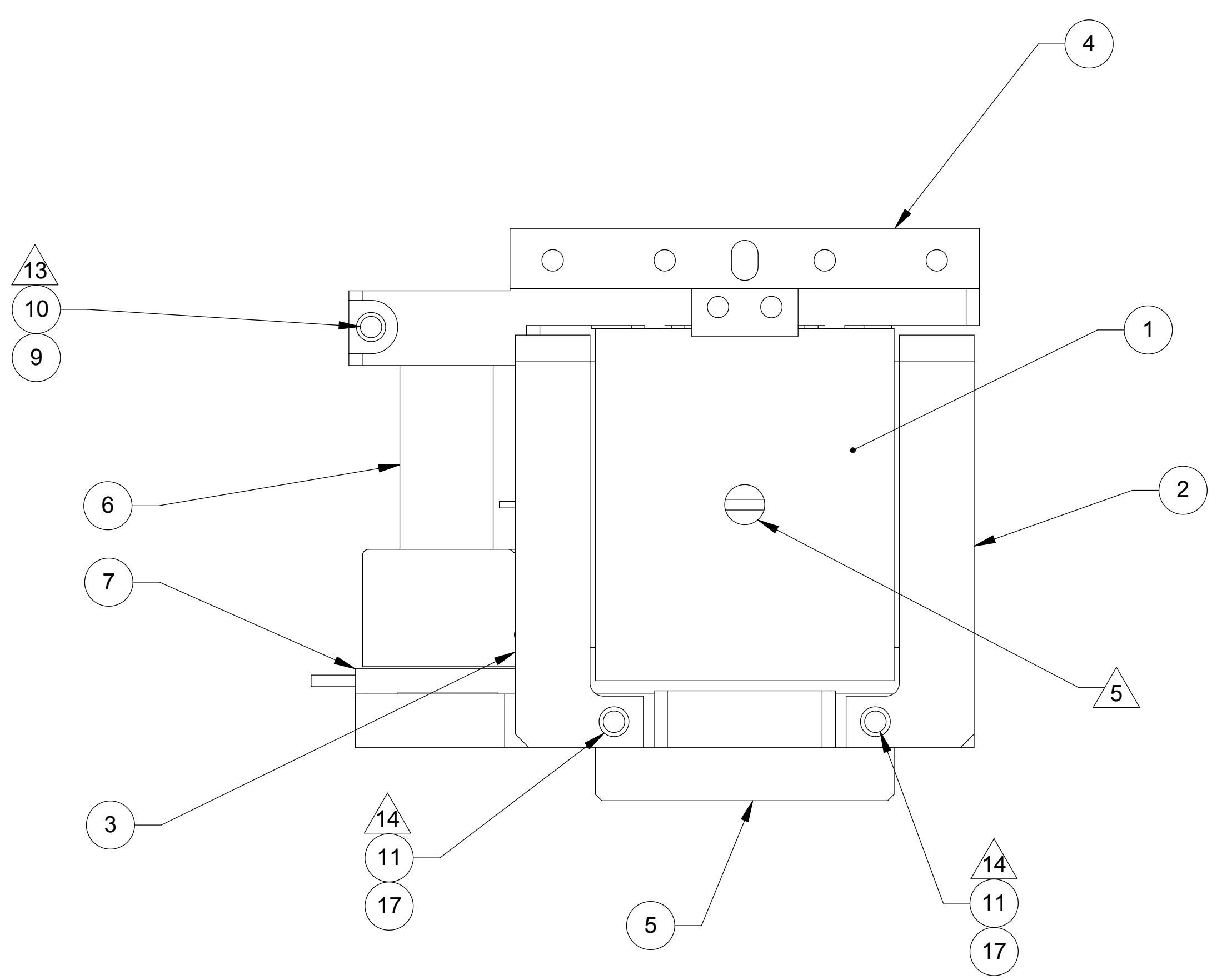
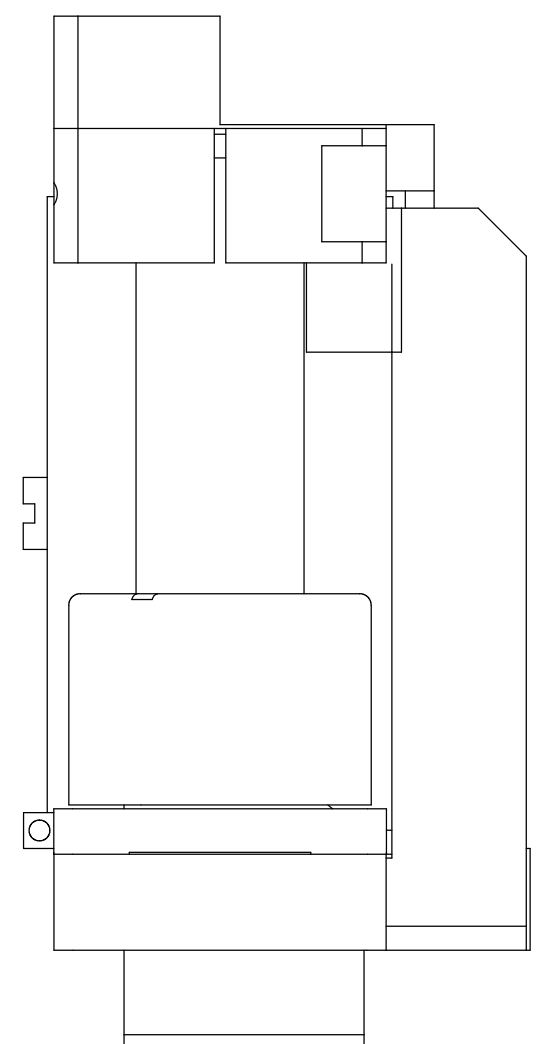
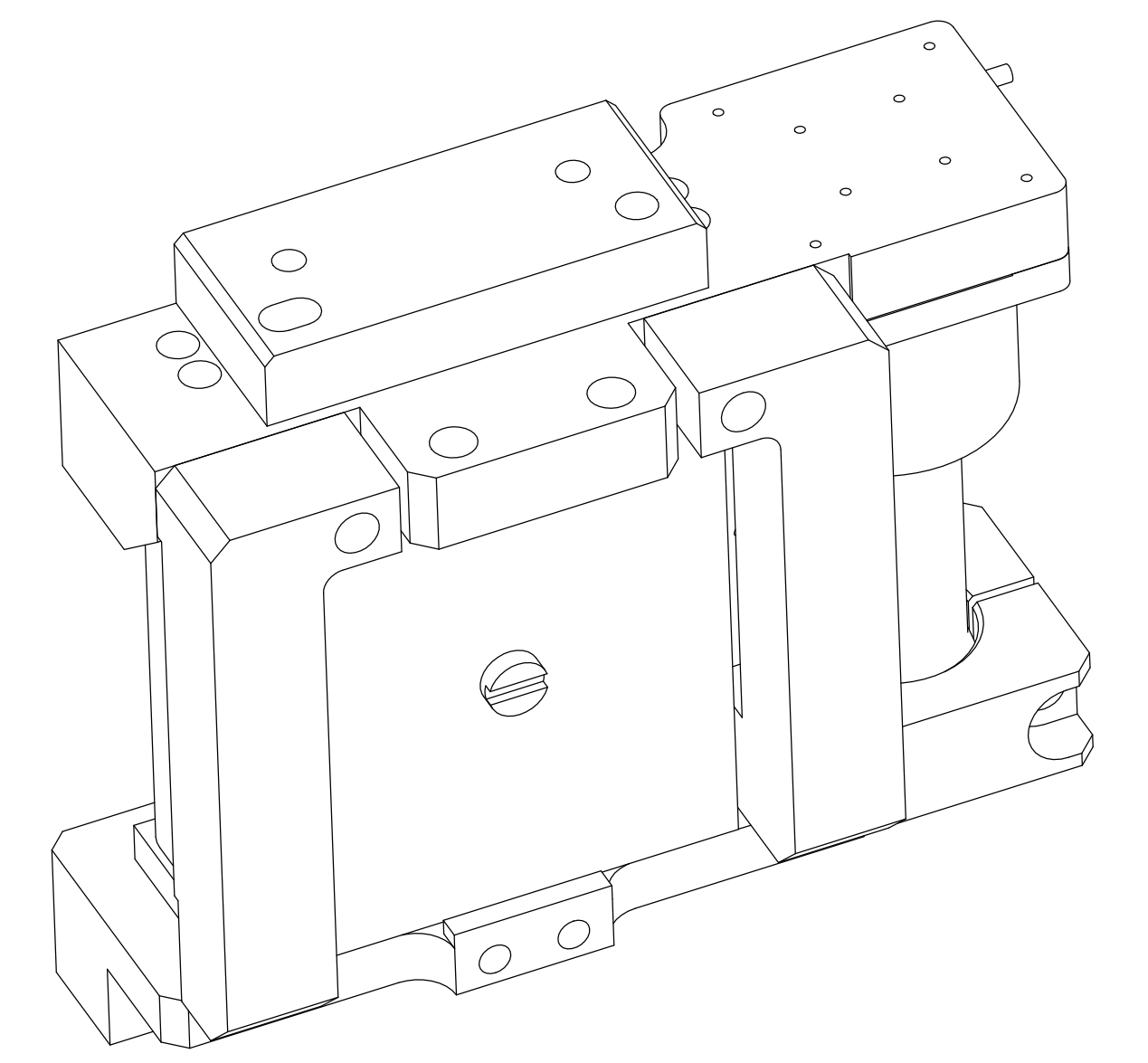
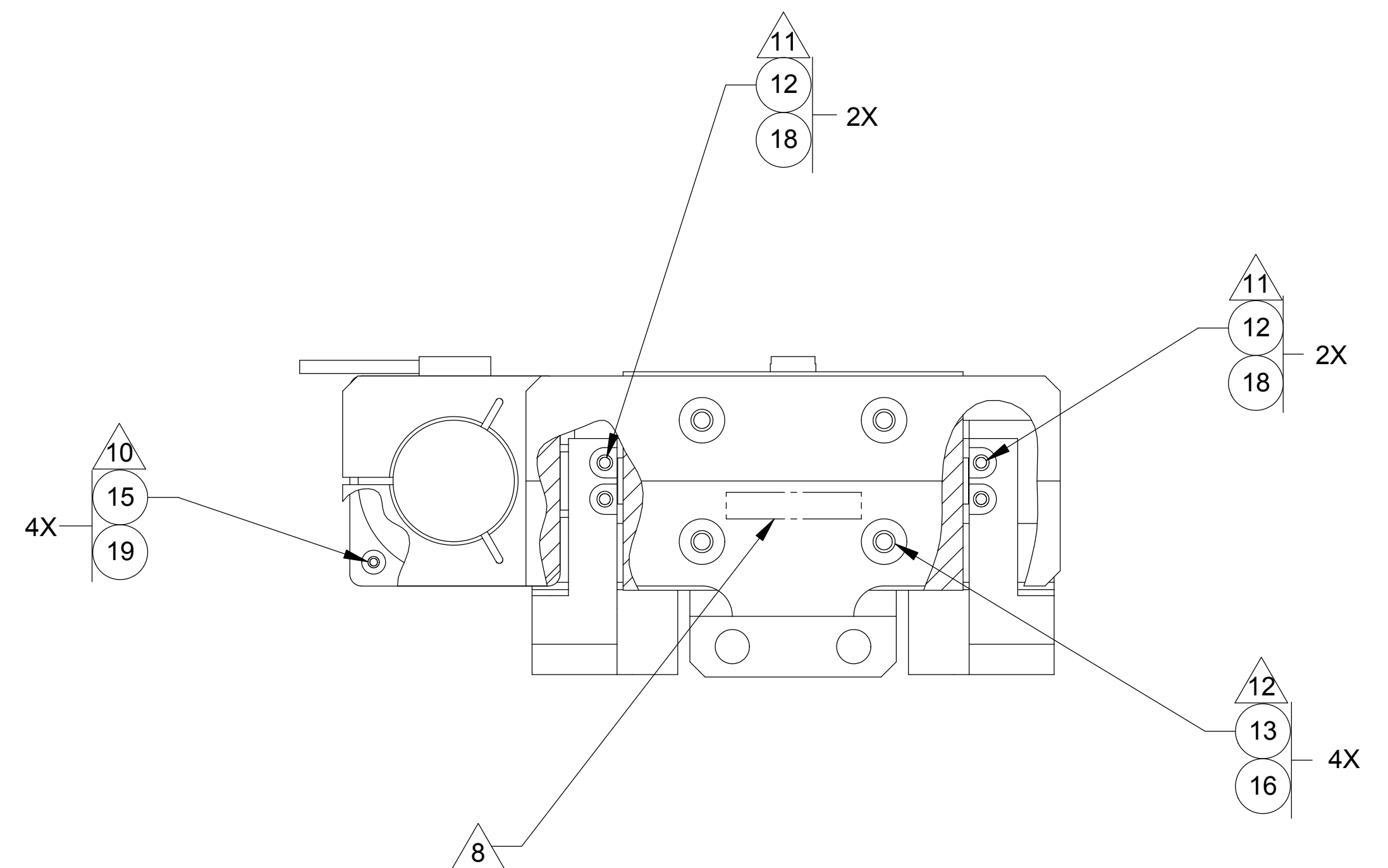


LTR		REVISIONS										DWN	CHK	P-ENG	CONFG	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A		INITIAL RELEASE																				



- 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 INC.
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.
 - 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: 1.5 IN LB.
 - TORQUE: 5 IN LB.
 - TORQUE: 20 IN LB.
 - TORQUE: 60 IN LB.
 - TORQUE: 168 IN LB.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL ASSEMBLY. ESTIMATED WEIGHT IS: 8.1 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-04	WASHER, FLAT, VENTED	.115 ID, .209 OD, .016 THK	18-8 CRES	
4		2	17		WFV-25	WASHER, FLAT, VENTED	.255 ID, .468 OD, .032 THK	18-8 CRES	
4		4	16		WFV-08	WASHER, FLAT, VENTED	.169 ID, .304 OD, .032 THK	18-8 CRES	
4		4	15		MP-206-A	SCREW, PN HD, VENTED	M2 X 0.4 X 6MM	18-8 CRES	
4		4	14		C-412-A	SCREW, SHC, VENTED	.112-40 UNC X .750 L	18-8 CRES	
4		4	13		C-806-A	SCREW, SHC, VENTED	.164-32 UNC X .375 L	18-8 CRES	
4		4	12		C-405-A	SCREW, SHC, VENTED	.112-40 UNC X .3125 L	18-8 CRES	
4		2	11		C-286-2022-NA	SCREW, SHC	.250-20 UNC X 1.375 L	A286 CRES	
4		1	10		C-2016-NA	SCREW, SHC	.250-20 UNC X 1.000 L	18-8 CRES	
		1	9		NAS620C-416	WASHER, FLAT	.255 ID, .468 OD, .063 THK	18-8 CRES	
		AR	8			FOIL, .001 IN THK	ASTM B 479-00	1100 AL ALLOY	
3		1	7		033968-01	SENSOR, ADE 20MM			
		1	6		20007912-2	DISPLACEMENT SENSOR TARGET ASSY			
		1	5		20007921-1	ADAPTER, COIL			
		1	4		20007920-1	ADAPTER, FIELD			
		1	3		20007979-2	THERMAL BAR, RIGHT			
		1	2		20007979-1	THERMAL BAR, LEFT			
2		1	1		0487-LIGO-D110-050904-SCS	ACTUATOR			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES: DECIMALS: .XX ± .03 ANGLES: XXX ± .010 ± 1/2° MACHINE FINISH: V DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994

CONTRACT NO: 20007970 1388
NEXT ASSEMBLY: PROJECT CODE: APPLICATION:

FILE ATTACHMENTS: 20007968_x_1

SEE PARTS LIST

RELEASED 3/4/2005

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

STAGE 1-2 HORIZONTAL ACTUATOR ASSEMBLY
LIGO D047968-A

SCALE: 1:1

UNCLASSIFIED SHEET 1 OF 1

REV A