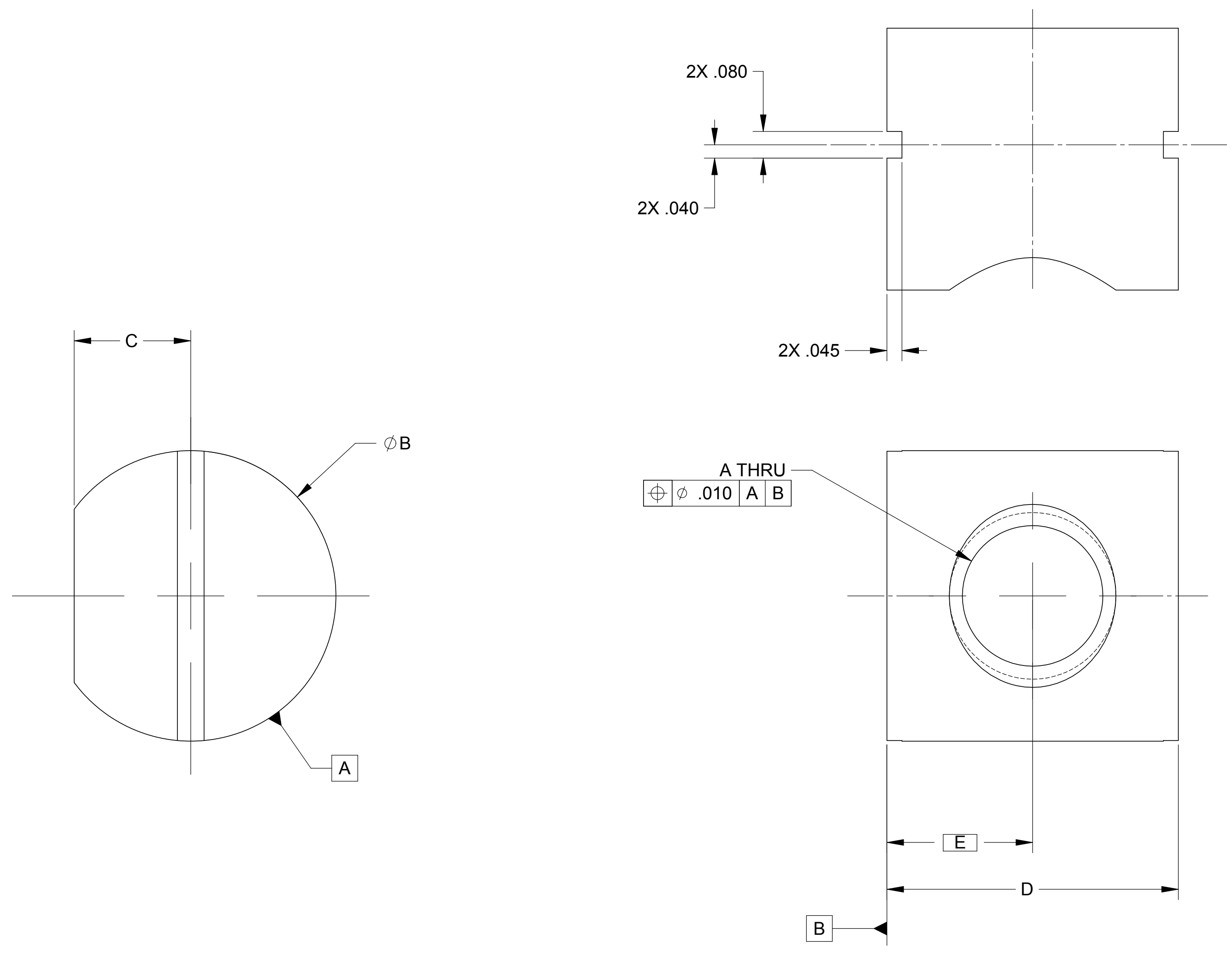


LTR		REVISIONS									
ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A	INITIAL RELEASE										



BARREL NUT DIMENSIONS					
DASH NO.	THREAD A	ØB	C	D	E
-1	.250-20 UNC	.497 ± .001	.210	.500	.250
-2	.375-16 UNC	.747 ± .001	.320	.750	.375
-3	.500-13 UNC	.872 ± .001	.350	.875	.438

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.
- IN ACCORDANCE WITH ASI SPECIFICATION 20006686, TYPE II.
- THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/- .000.
- RECORD WEIGHT IN INSPECTION REPORT USING SUITABLE LOT SAMPLING METHOD. ESTIMATED WEIGHT AFTER FINAL MACHINING:
 - 1: 0.037 LBS.
 - 2: 0.025 LBS.
 - 3: 0.007 LBS.

20007991-3	BARREL NUT, .500-13
20007991-2	BARREL NUT, .375-16
20007991-1	BARREL NUT, .250-20

QTY REQD	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 .XX ± .03 .XXX ± .010 ANGLES ± 1/2° MACHINE FINISH 63 DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994			ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103		BARREL NUT LIGO D-047991-A	
20007845 1388		MATERIAL AL ALY 7075-T651 BAR PER AMS-QQ-A-225/9						
20007825 1388		NEXT ASSEMBLY PROJECT CODE			DWN KEVIN J SPINK 02/11/05 PROJ ENGR STRS		SIZE D CAGE CODE 1KNU9 SCALE 8:1	
20007970 1388		APPLICATION			ME PROJ ME QA		20007991 UNCLASSIFIED SHEET 1 OF 1	



RELEASED
2/22/2005

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