

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

1


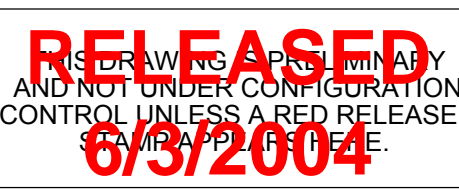
TABLE 1. TORQUE TABLE

ITEM NO.	TORQUE (IN-LB)
13	3
8	3
7	33
6	5

- 11. REMOVE ALL BURRS AND SHARP EDGES .003 - .010.
- 10. CLOCKING OF FEATURE NOT IMPORTANT.
- 9. INSTALL ITEM 2, CLAMP MOTOR MOUNT, USING ITEM 9, WASHER, AND ITEM 6, SCREW.
- 8. INSTALL ASSEMBLED ITEMS 1, 3, 8, 11, 13, AND 14, USING ITEM 7, SCREW, ITEM 10, WASHER, AND ITEM 12, NUT. USE EXISTING GS-13 SEISMOMETER HANDLE MOUNTING HOLE. ALIGN GEAR TEETH PROPERLY PRIOR TO FASTENER TORQUING.
- 7. REMOVE AND DISCARD GS-13 SEISMOMETER SUPPLIED HANDLE AND CORRESPONDING FASTENERS.
- 6. REPLACE GS-13 SEISMOMETER GEAR ONTO GS-13 SEISMOMETER LOCK SHAFT, USING ROLL PIN DESCRIBED IN NOTE 4.
- 5. ASSEMBLE ITEM 4, GEAR GS-13 LOCK, AND GS-13 SEISMOMETER LOCK SHAFT, USING ITEM 5, ROLL PIN, WITHIN SEISMOMETER, IN POSITION SHOWN.
- 4. REMOVE GS-13 SEISMOMETER LOCK SHAFT FROM GS-13 SEISMOMETER BEFORE MATCH DRILL OPERATION, BY PRESSING OUT ROLL PIN AND REMOVING TOP THUMB WHEEL. SAVE GEAR, SHAFT AND ROLL PIN.
- 3. ASSEMBLE ITEM 14, AND ITEM 3, PINION GS-13 LOCK, USING ITEM 13, SET SCREW. ENGAGE SET SCREW ON GEARBOX SHAFT FLAT. ITEM 3 POSITIONING SHOWN IN VIEW A.
- 2. ASSEMBLE ITEM 1, MOUNT MOTOR, AND ITEM 14, MOTOR/GEARHEAD, USING ITEM 11, WASHER, AND ITEM 8, SCREW.
- 1. TORQUE INDICATED FASTENERS PER TABLE 1.

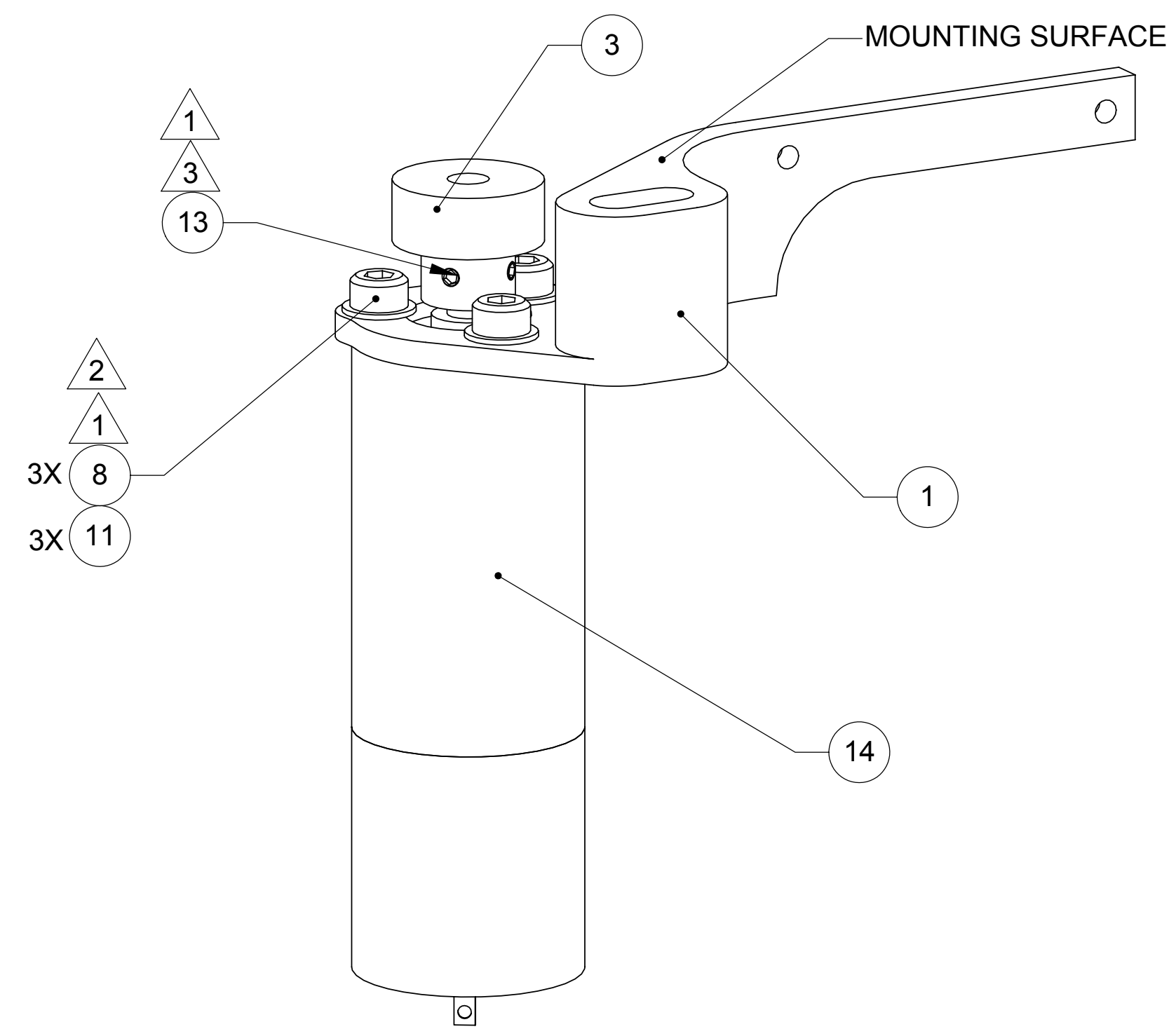
NOTES: UNLESS OTHERWISE SPECIFIED

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
-1				20008590-1	MOTOR/GEARHEAD ASSEM			
	1	14		92311A073 McMASTER CARR	SET SCREW	.086-56 UNC X .094 L	18-8 CRES	
	1	13		90257A411 McMASTER CARR	NUT	.190-32 UNF	316 CRES	
	1	12		93475A210 McMASTER CARR	WASHER, METRIC	3.2 ID, 7 OD .45 - .55 THK	18-8 CRES	
	3	11		92141A011 McMASTER CARR	WASHER	.203 ID, .438 OD .032 THK	18-8 CRES	
	2	10		98019A309 McMASTER CARR	WASHER	.125 ID, .250 OD .017 - .028 THK	18-8 CRES	
	2	9		91292A111 McMASTER CARR	SCREW, CAP, SKT HEAD	MJ3 X 0.5 X 6MM L	18-8 CRES	
	3	8		92196A292 McMASTER CARR	SCREW, CAP, SKT HEAD	.190-32 UNF X 1.625 L	18-8 CRES	
	1	7		92196A107 McMASTER CARR	SCREW, CAP, SKT HEAD	.112-40 UNC X .313 L	18-8 CRES	
	2	6		92373A143 McMASTER CARR	ROLL PIN	Ø .094 X .500 L	18-8 CRES	
	1	5		20008592-1	GEAR, GS-13 LOCK			
	1	4		20008591-1	PINION, GS-13 LOCK			
	1	3		20008589-1	CLAMP, MOTOR MOUNT			
	1	2		20008588-1	MOUNT, MOTOR			

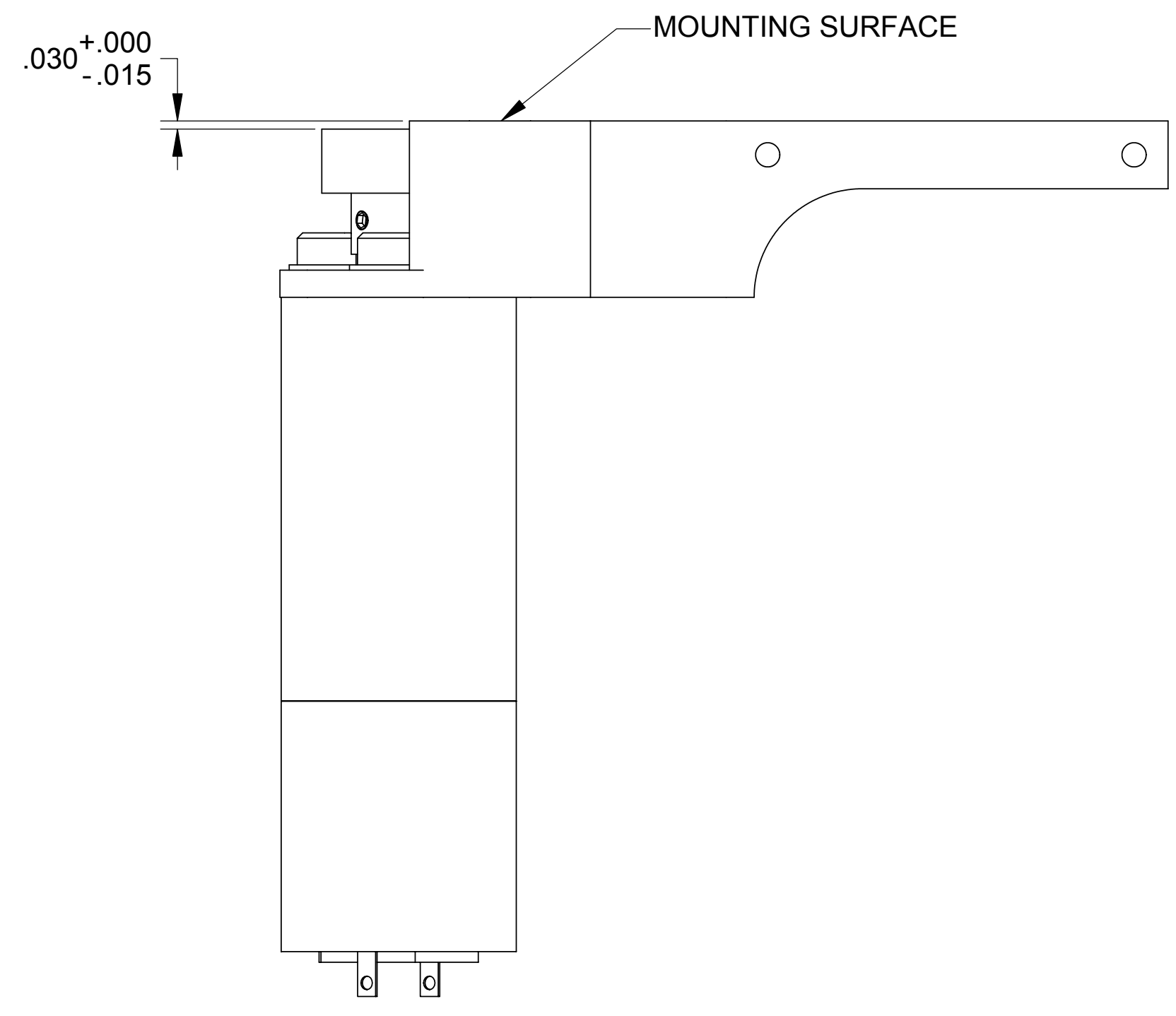
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST		ALLIANCE SPACESYSTEMS, INC.	
		TOLERANCES				1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
		DECIMALS .XX ±.03 .XXX ±.010		DRAWING IS FOR INFORMATION ONLY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS THEREON.		 <b>ASSEMBLY, GS-13 SEISMOMETER LOCK</b>	
		ANGLES ± 1/2°					
		MACHINE FINISH 63		DWN J. LARAMEE 05/10/04		<b>20008593</b>	
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M		ENGR NA STRS NA			
		MATERIAL		CHK NA MATL		<b>1KNU9</b>	
		PROJECT CODE 1422		THRM NA PROJ		<b>20008593</b>	
		APPLICATION		ME NA QA NA		<b>A</b>	

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

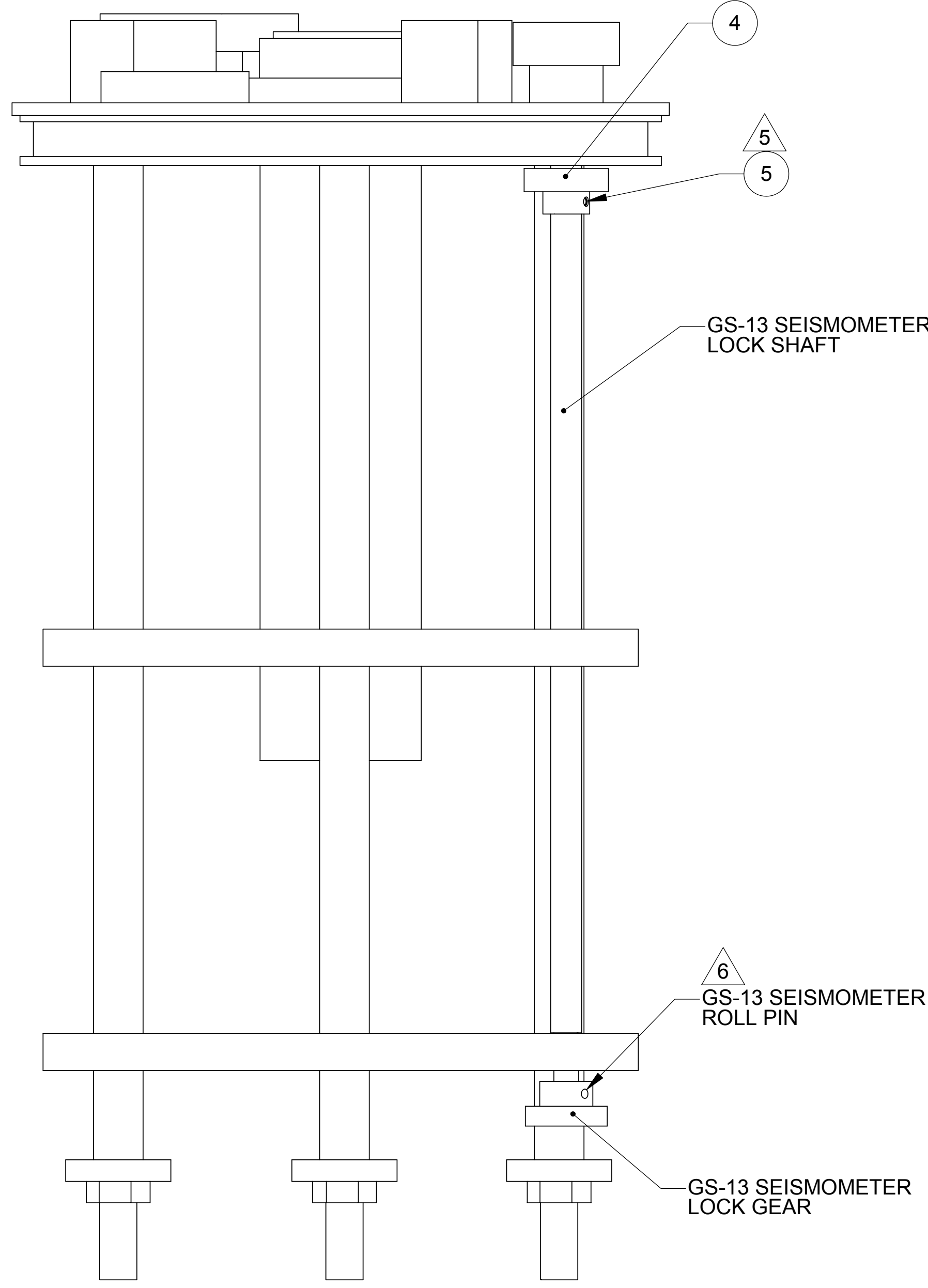
THIS DRAWING IS PRELIMINARY  
AND NOT UNDER CONFIGURATION  
CONTROL UNLESS A RED RELEASED  
STAMP IS PRESENT  
**RELEASED**  
6/3/2004



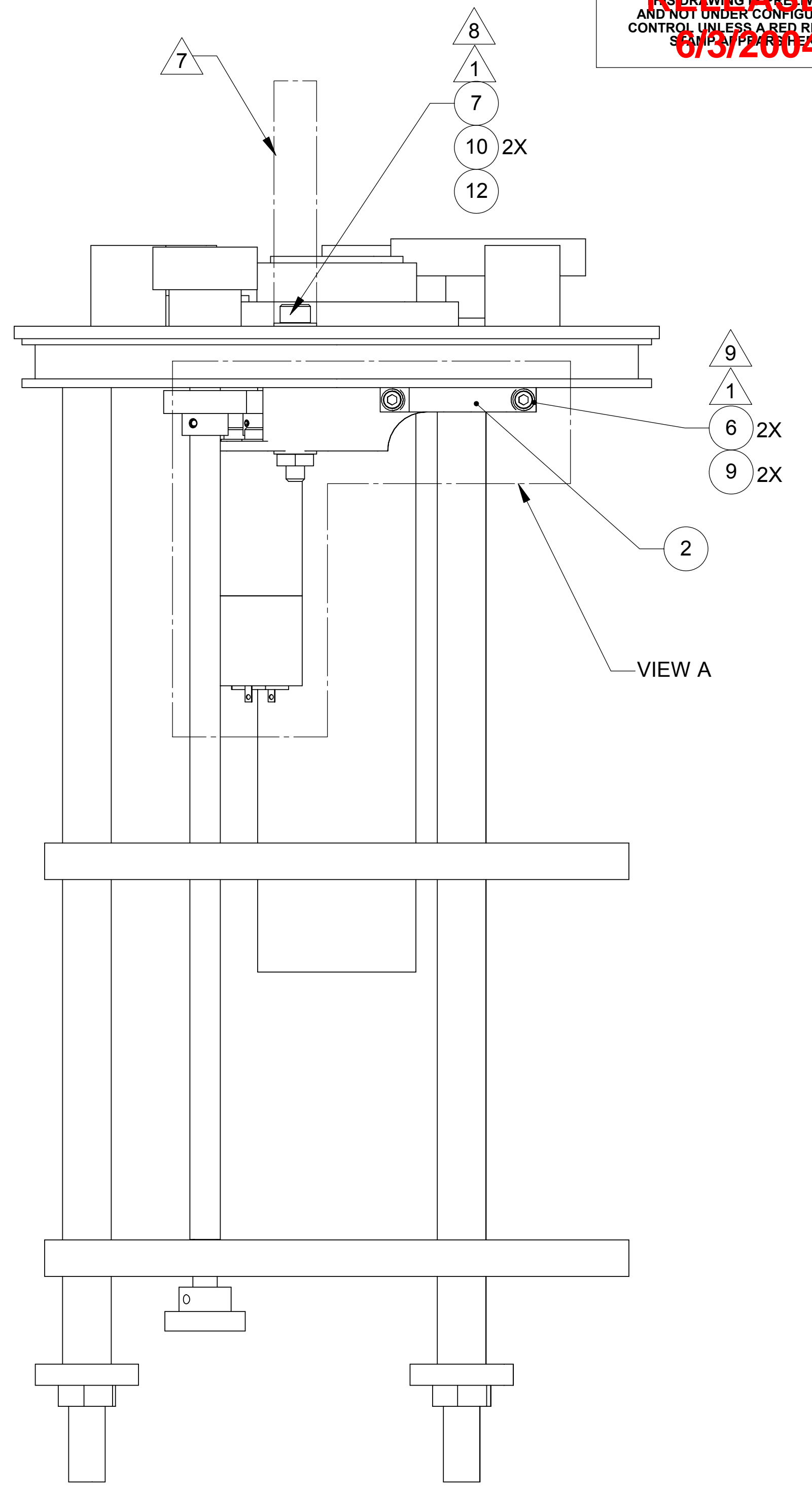
ISOMETRIC VIEW SHOWN FOR CLARITY



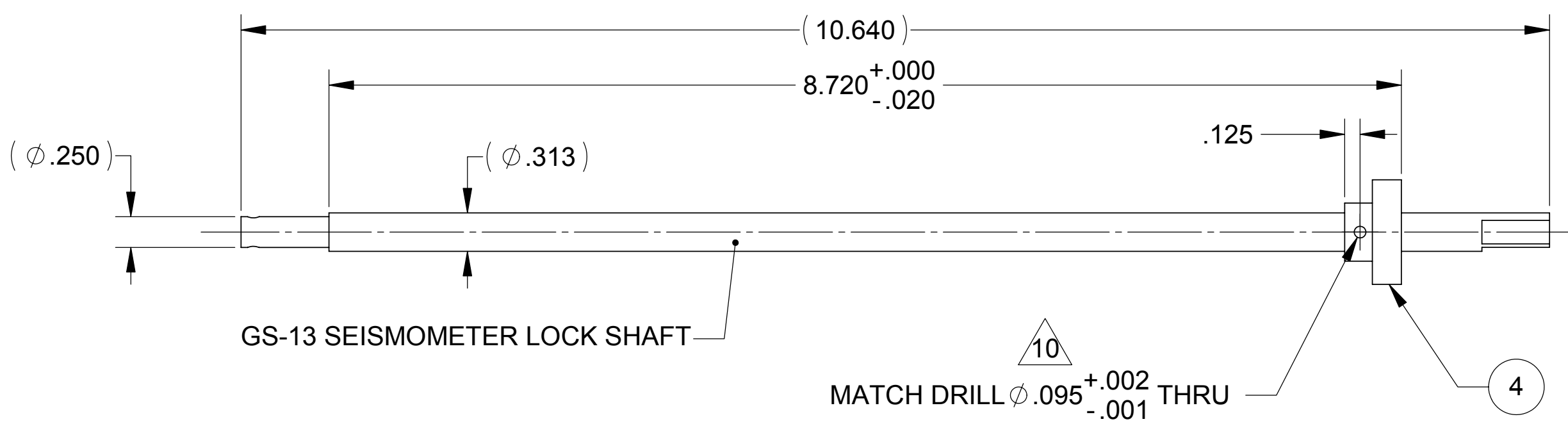
**VIEW A**  
GS-13 SEISMOMETER NOT SHOWN  
FOR CLARITY



INTERNAL FEATURES OF SEISMOMETER  
REMOVED FOR CLARITY



INTERNAL FEATURES OF SEISMOMETER  
REMOVED FOR CLARITY



GS-13 SEISMOMETER LOCK SHAFT

MATCH DRILL  $\phi .095^{+.002}_{-.001}$  THRU

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

		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
SIZE <b>D</b>	CAGE CODE 1KNU9	<b>20008593</b>	REV <b>A</b>
SCALE 1:2		SHEET 2 OF 2	

REV 3/03