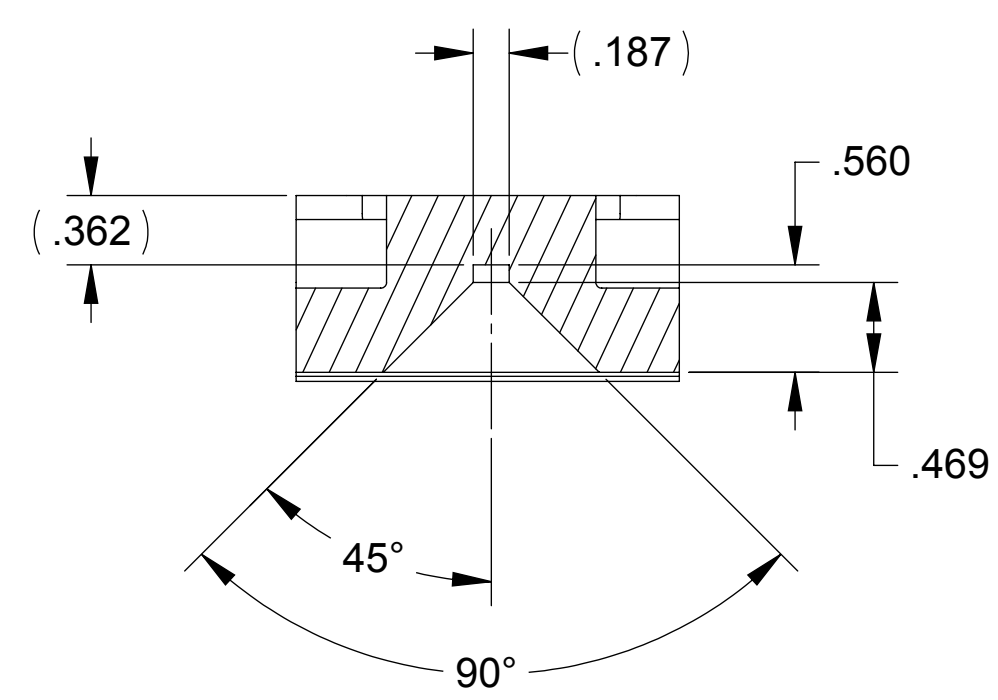
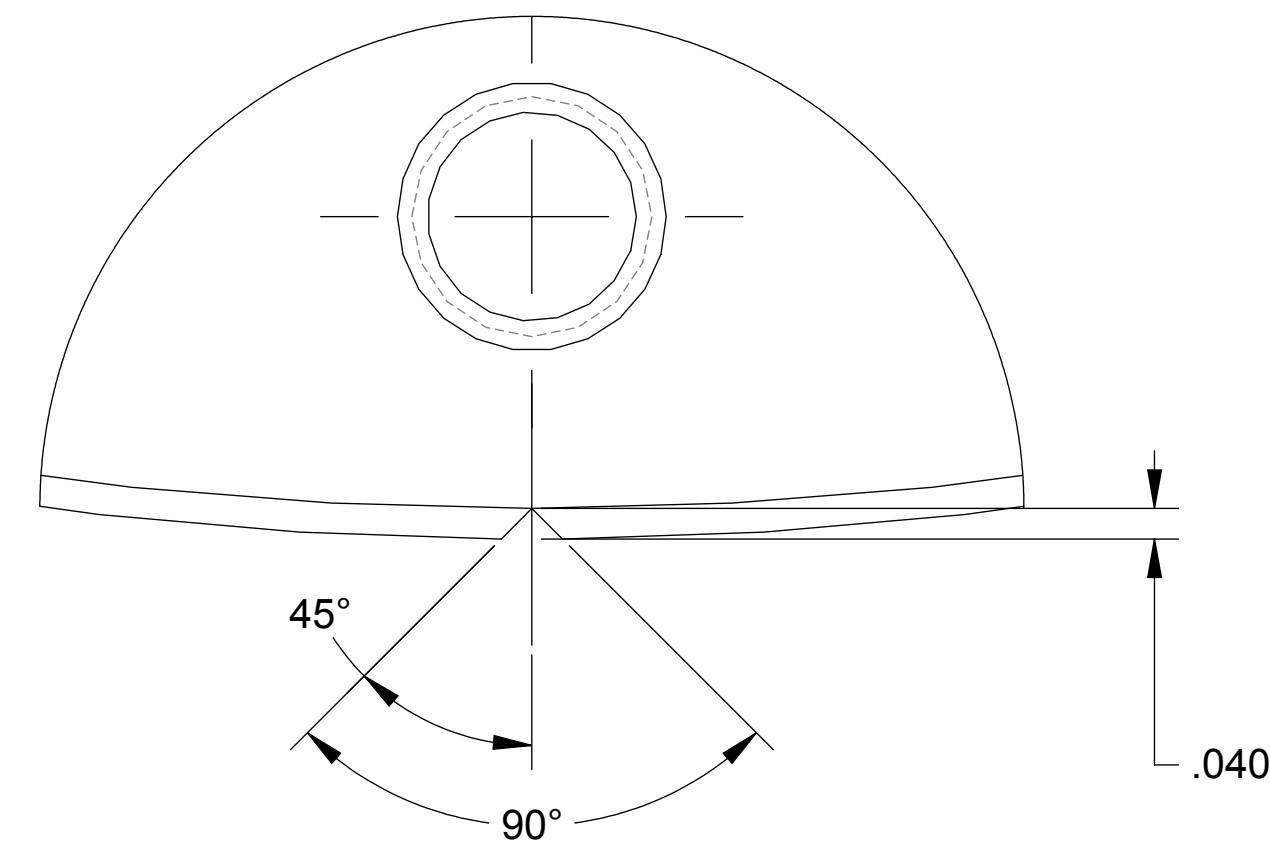


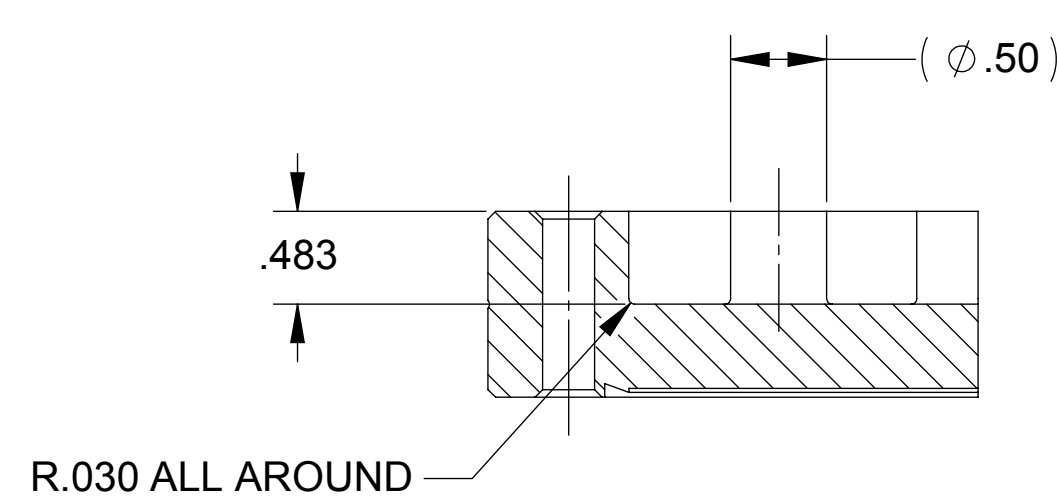
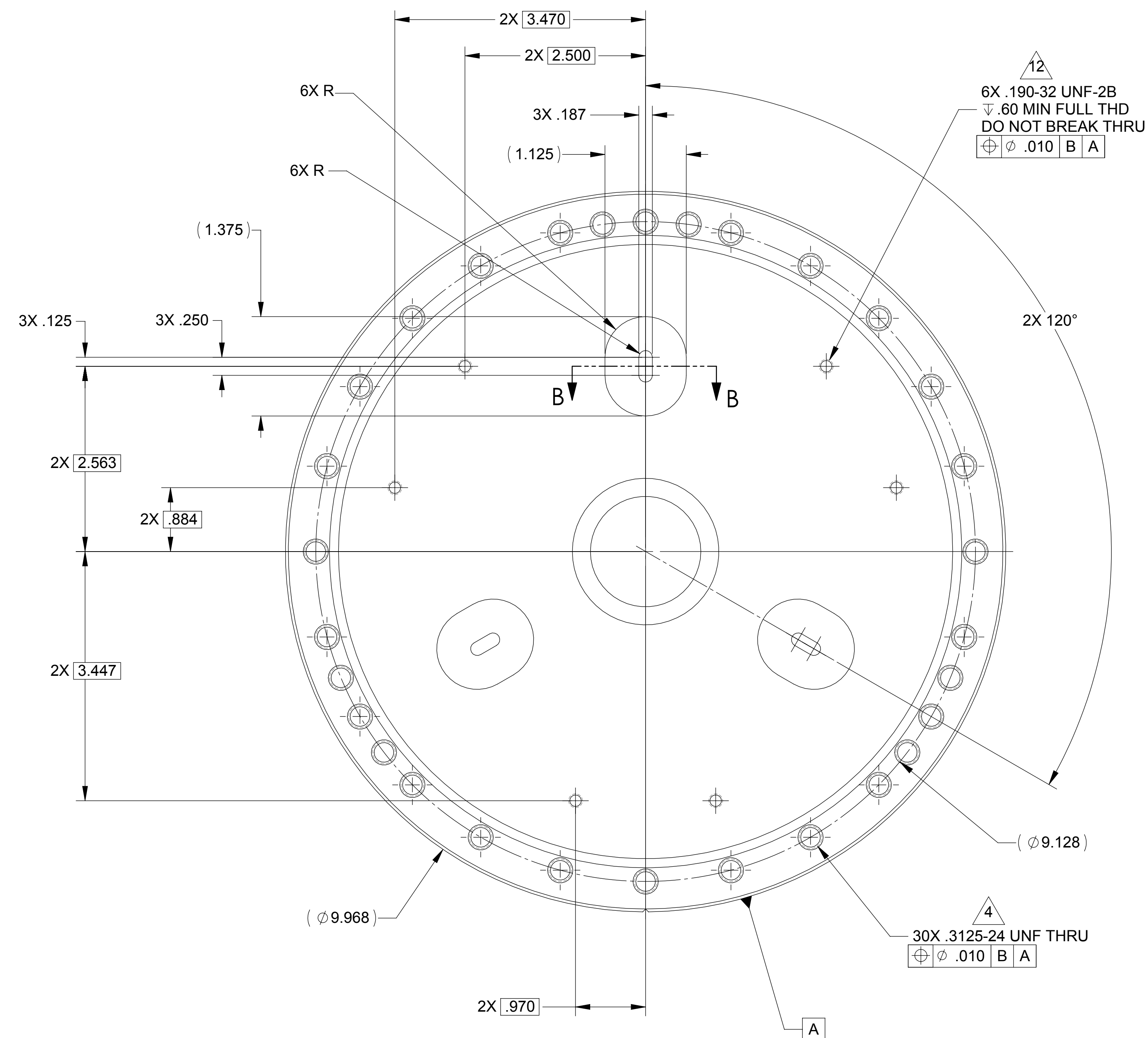
		REVISIONS										
LTR	ZONE	DESCRIPTION	DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE										
B		ADD 6 PERIM .3125-24 HOLES, ADD THIRD MTG. HOLE, MTG. BOSSES, AND TAPS TO TYPE -01, HPD ECO 1065										02/21/2007
C		MULTIPLE MINOR CHANGES HPD ECO 1067										



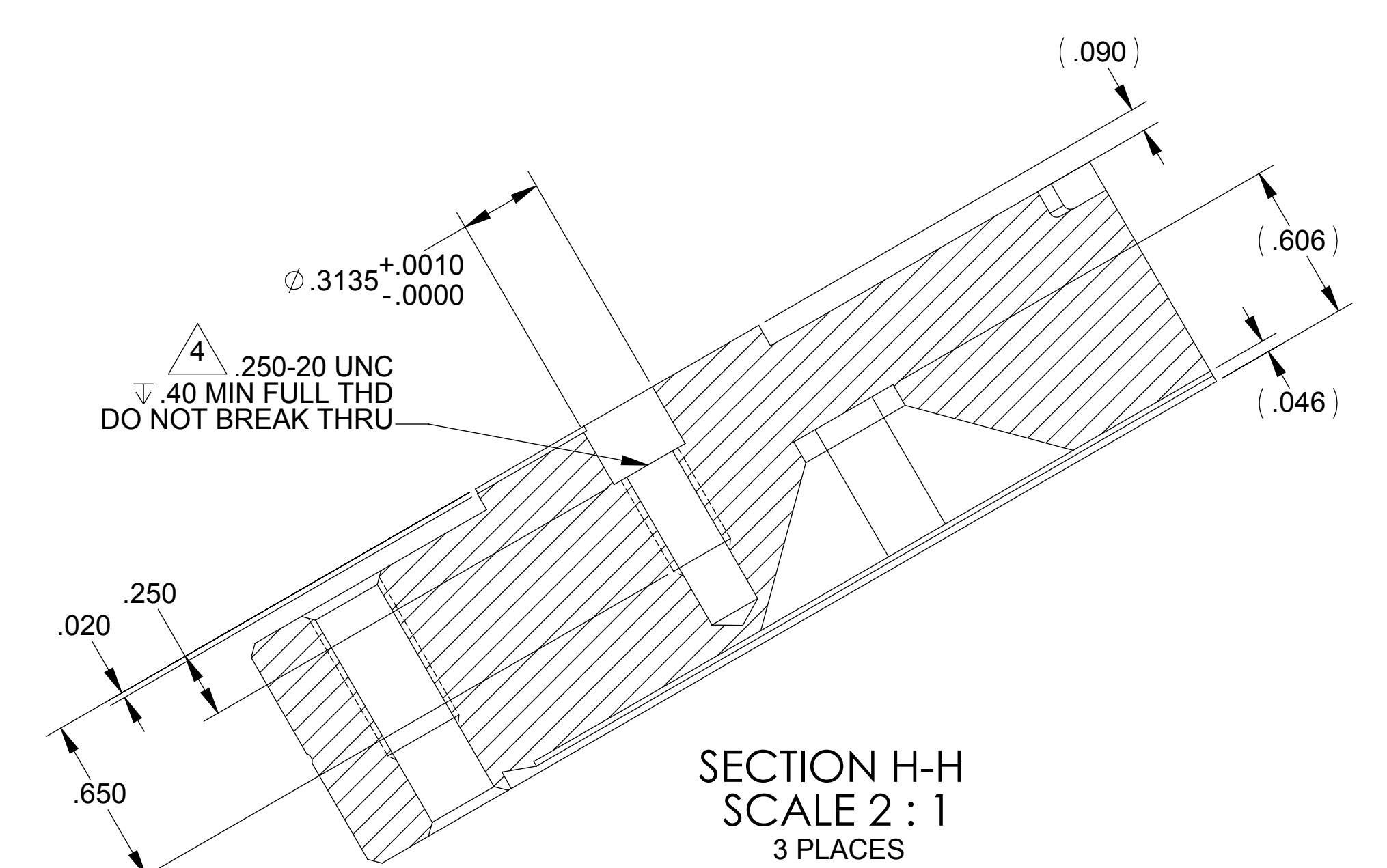
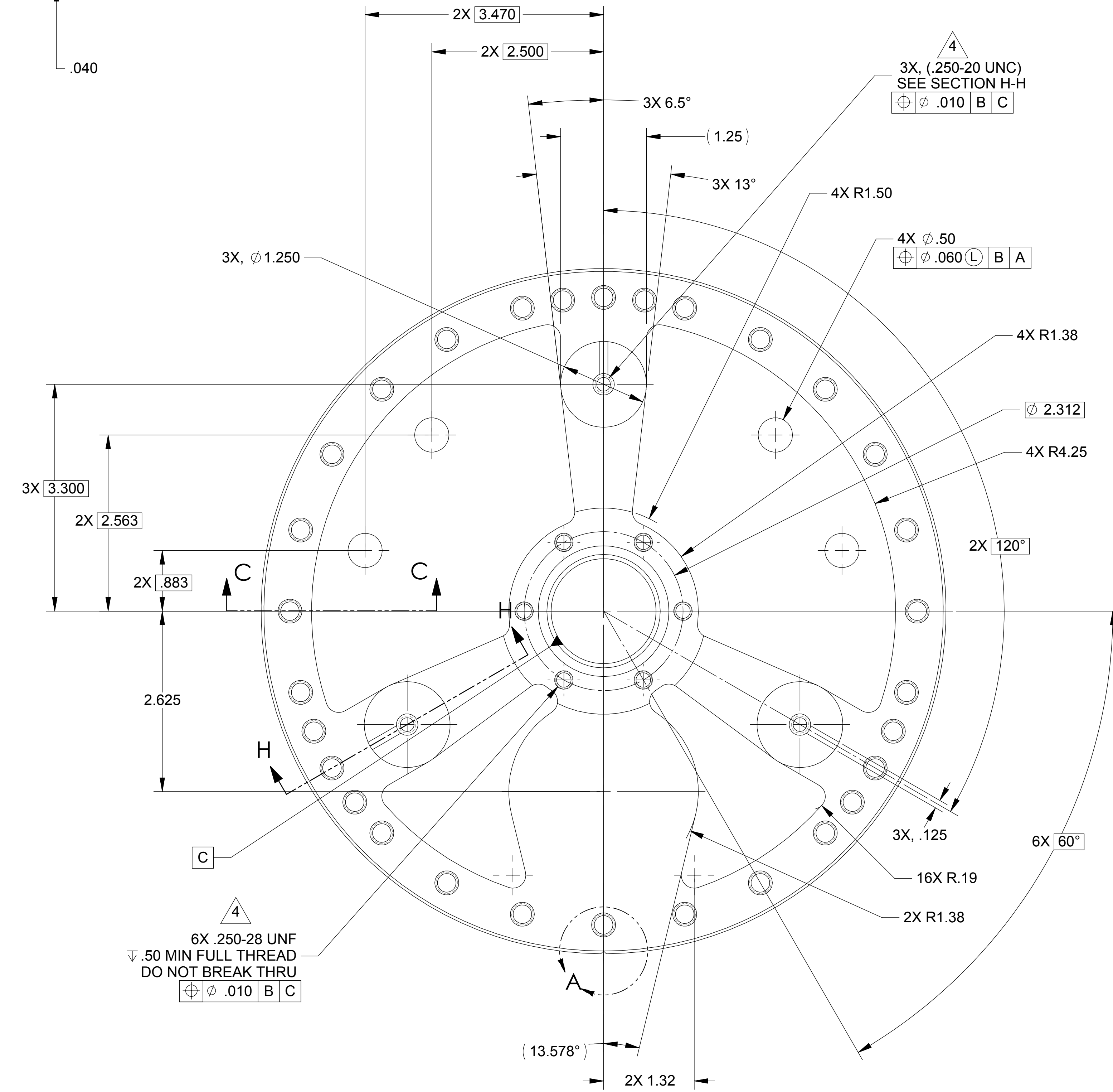
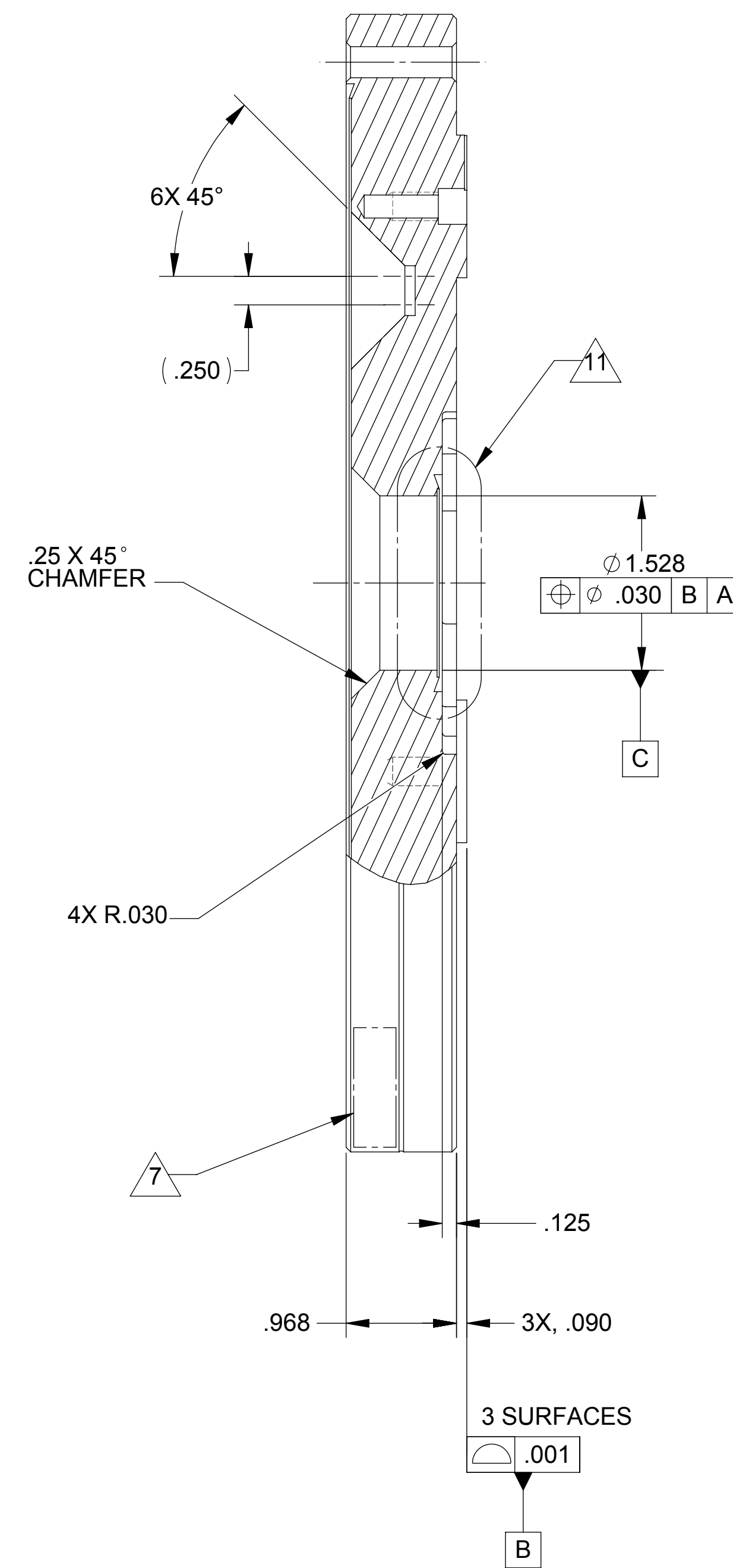
SECTION B-B  
TYPICAL 3 PLACES



DETAIL A  
SCALE 4:1



SECTION C-C  
TYPICAL 4 PLACES



SECTION H-H  
SCALE 2:1  
3 PLACES

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.
- THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION INCLUDING THREADED FEATURES SPECIFIED AS PART OF NOR-CAL PRODUCTS PART NO. 1000-000NT AND REFERENCED IN NOTE 11.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE (VIBRATORY ACCEPTABLE) THE FOLLOWING INFORMATION AS SHOWN BELOW: LIGO P/N-REVISION-TYPE, FOLLOWED ON THE NEXT LINE BY "S/N-" AND A THREE DIGIT SERIAL NUMBER, STARTING AT 100, AND PROCEEDING CONSECUTIVELY. USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER.  
D047813-C-1 (SHEET 1), D047813-C-2 (SHEET 2)  
S/N-100 (EXAMPLE) S/N-101 (EXAMPLE)
- FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO TO NOR-CAL PRODUCTS PART NUMBER 1000-000NT.
- REFERENCE MATING PART DRAWING 20007812.
- PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- CONFIGURATION OF KNIFE EDGE, GASKET RELIEF AREAS, AND THEIR RELATIONSHIP TO THE SURROUNDING BOLT PATTERN AND MATING FLANGE AREA SHALL CONFORM TO A 2.75 CF FLANGE SUCH AS A 275-150N.
- NOTE 4 DOES NOT APPLY.

**-1 SHOWN  
-2 SHEET 2**

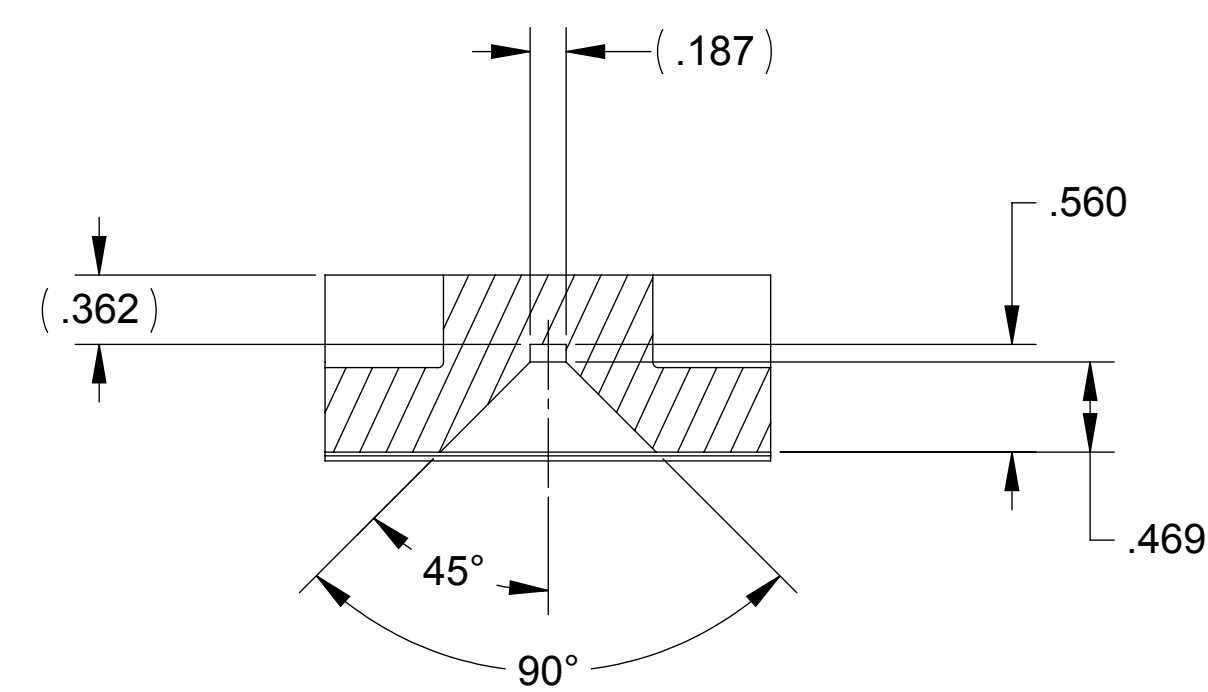
20007813-1	BASE PLATE, HORIZONTAL
20007813-2	BASE PLATE, VERTICAL

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
CONTRACT NO									
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES									
DECIMALS ANGLES									
.XX ±.03 .XXX ±.010 ±1/2°									
MACHINE FINISH 125									
DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M									
MATERIAL									
304 CRES - ARGON OXYGEN DECARBURIZATION PER ASTM-240									
DWN KEVIN J SPINK 06/28/04									
PROJ ENGR STRS									
CHK MATL									
CONFIG PROJ									
ME QA									
SCALE 1:1									
UNCLASSIFIED SHEET 1 OF 2									

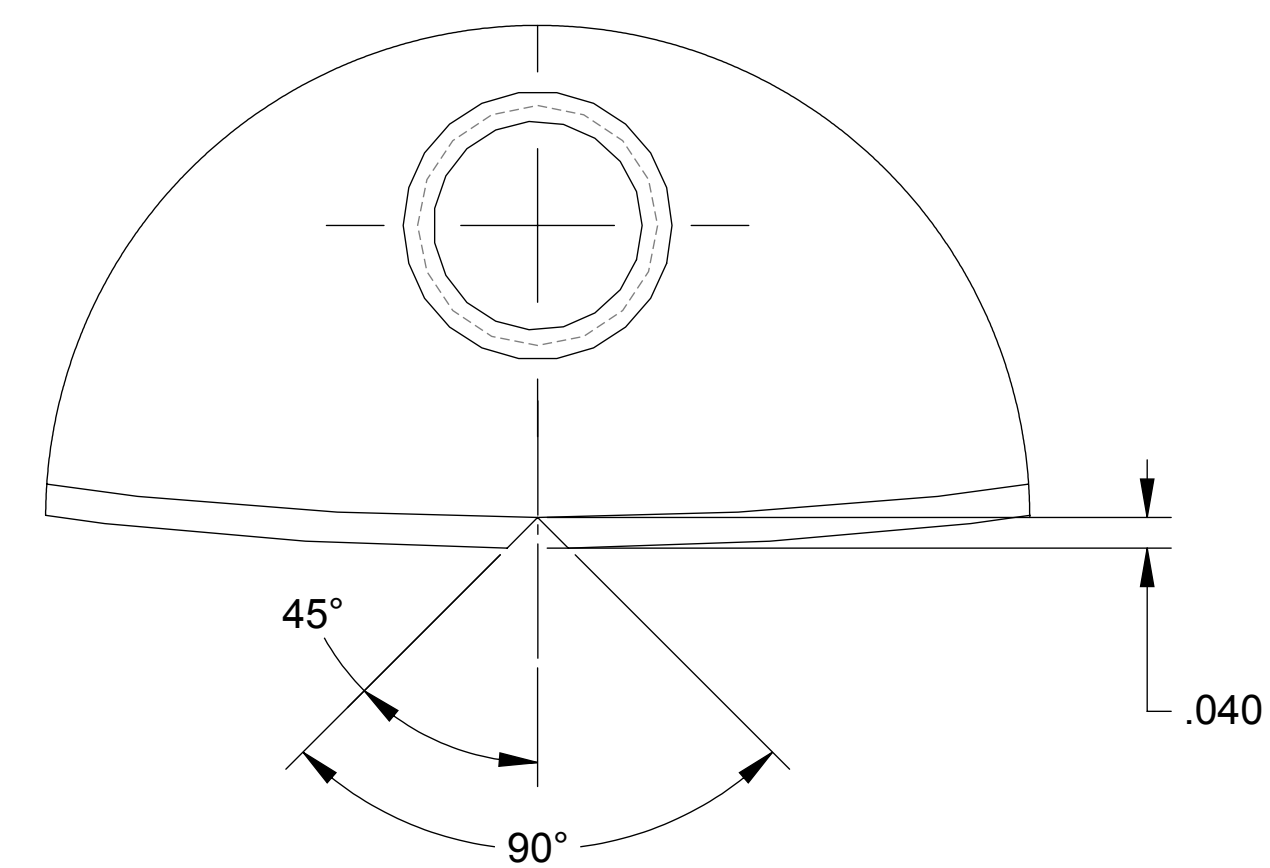
ALLIANCE SPACESYSTEMS, INC.  
1250 Lincoln Ave., Suite 100  
Pasadena, CA 91103

**BASEPLATE, GS-13  
HORIZONTAL & VERTICAL  
LIGO-D047813**

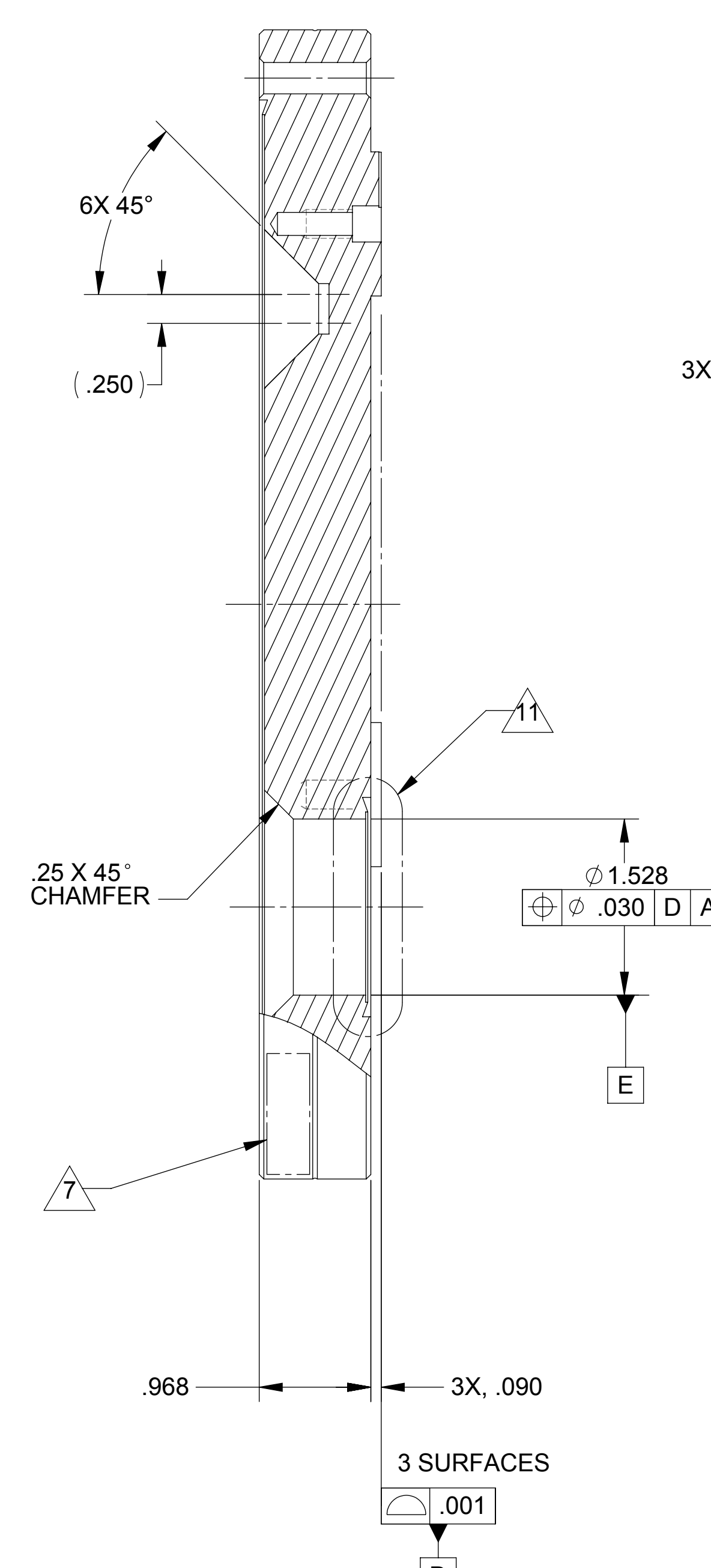
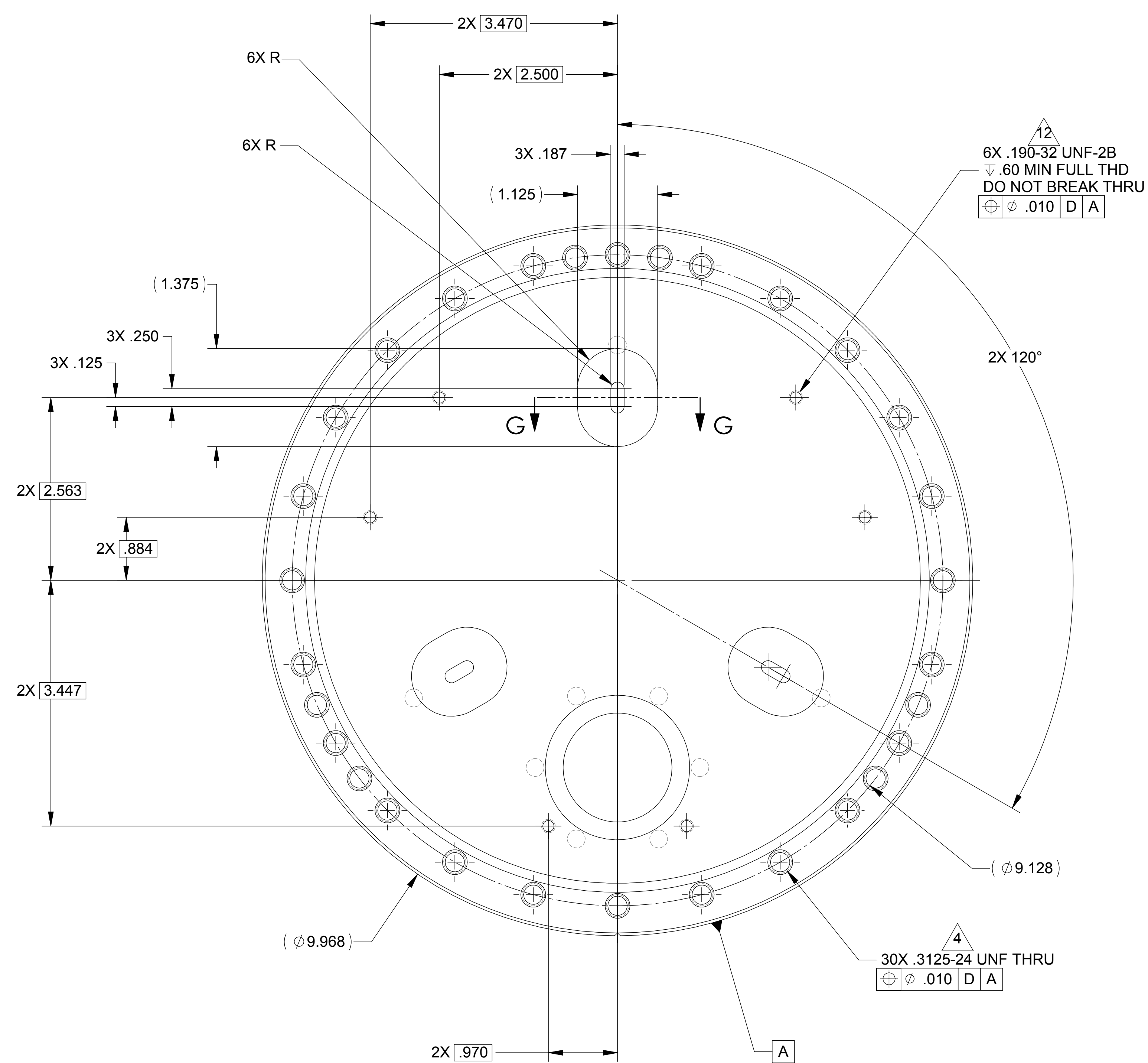
**20007813**  
REV C



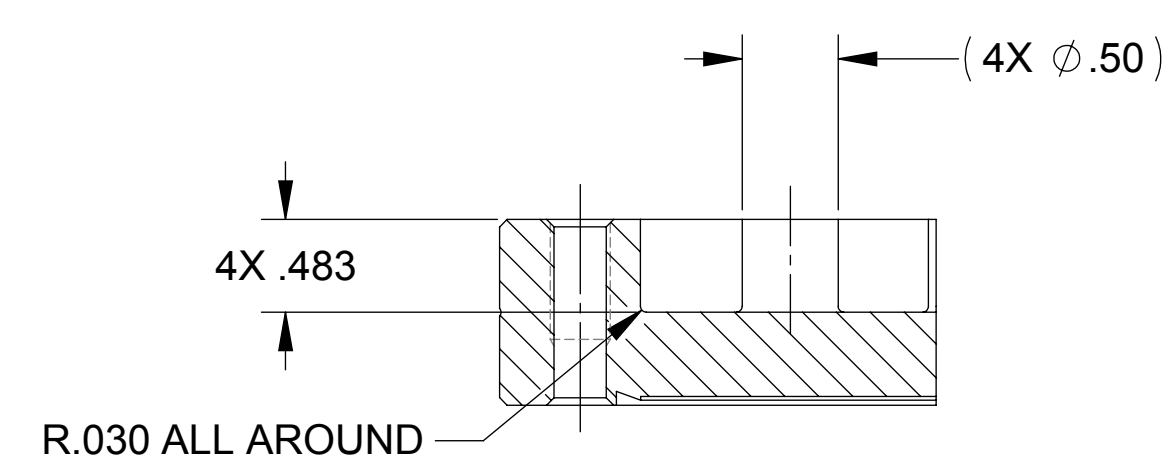
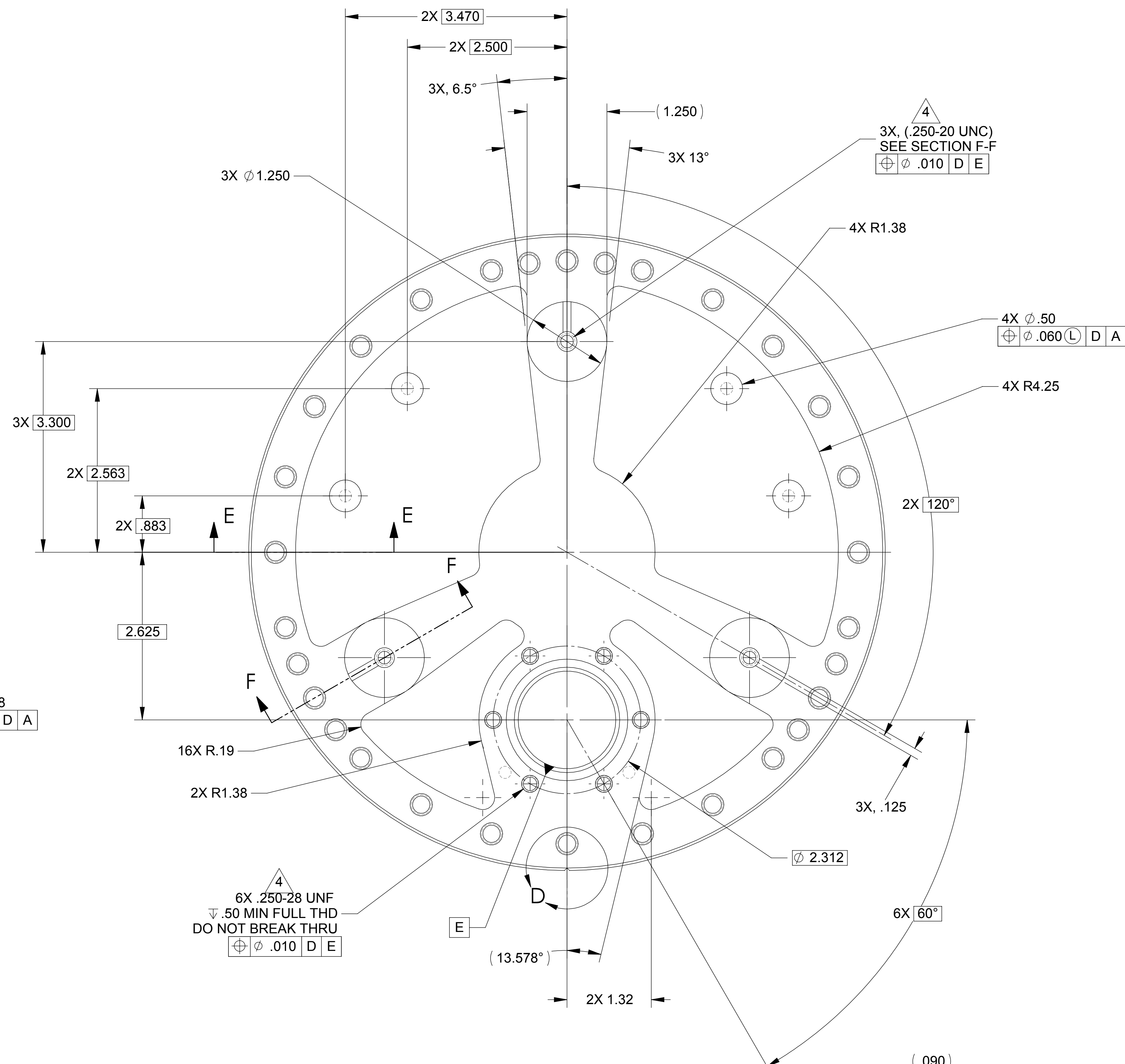
SECTION G-G  
TYPICAL 3 PLACES



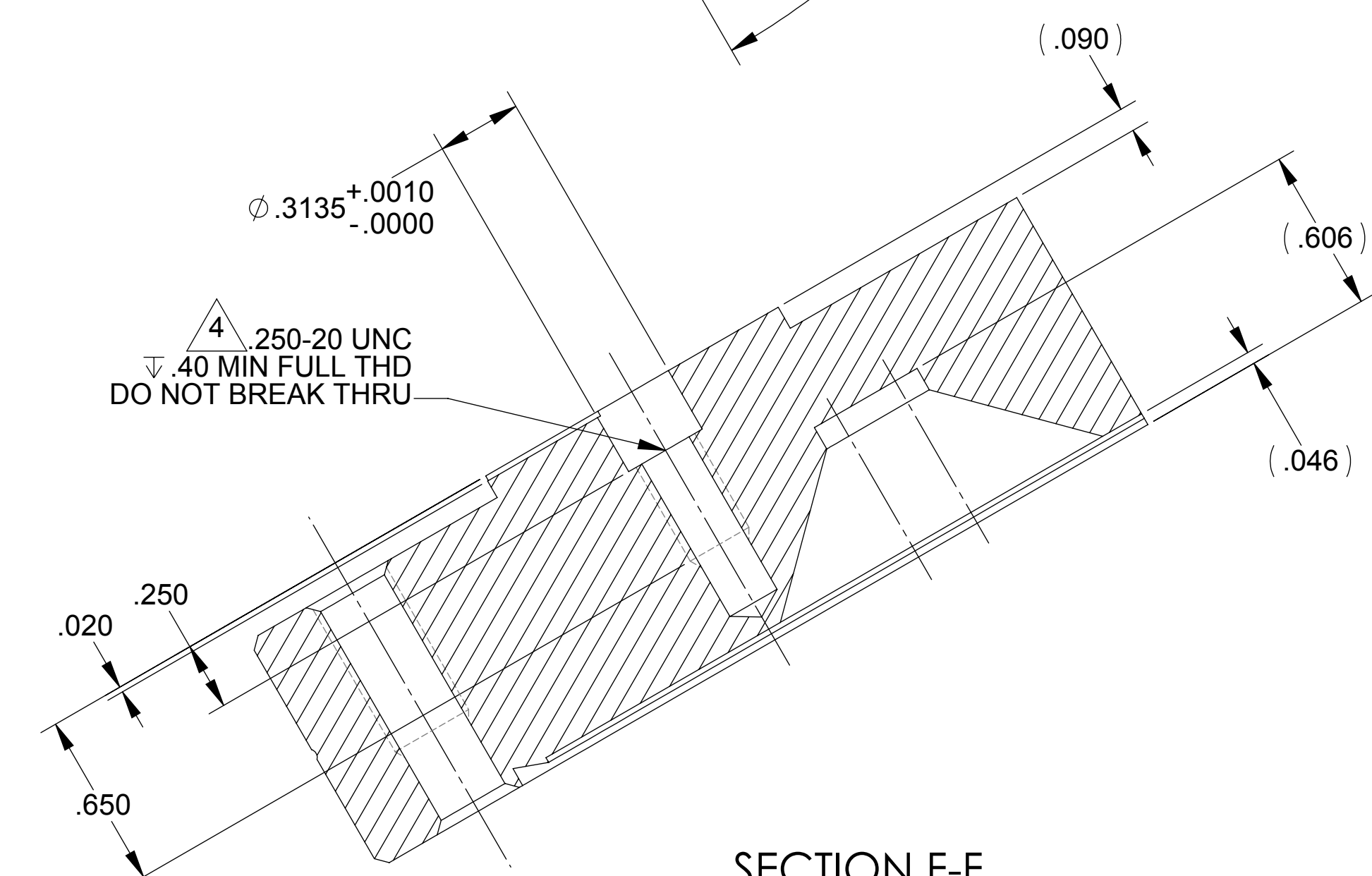
DETAIL D  
SCALE 4 : 1



**-2 SHOWN  
-1 SHEET 1**



SECTION E-E  
TYPICAL 4 PLACES



SECTION F-F  
SCALE 2 : 1  
3 PLACES