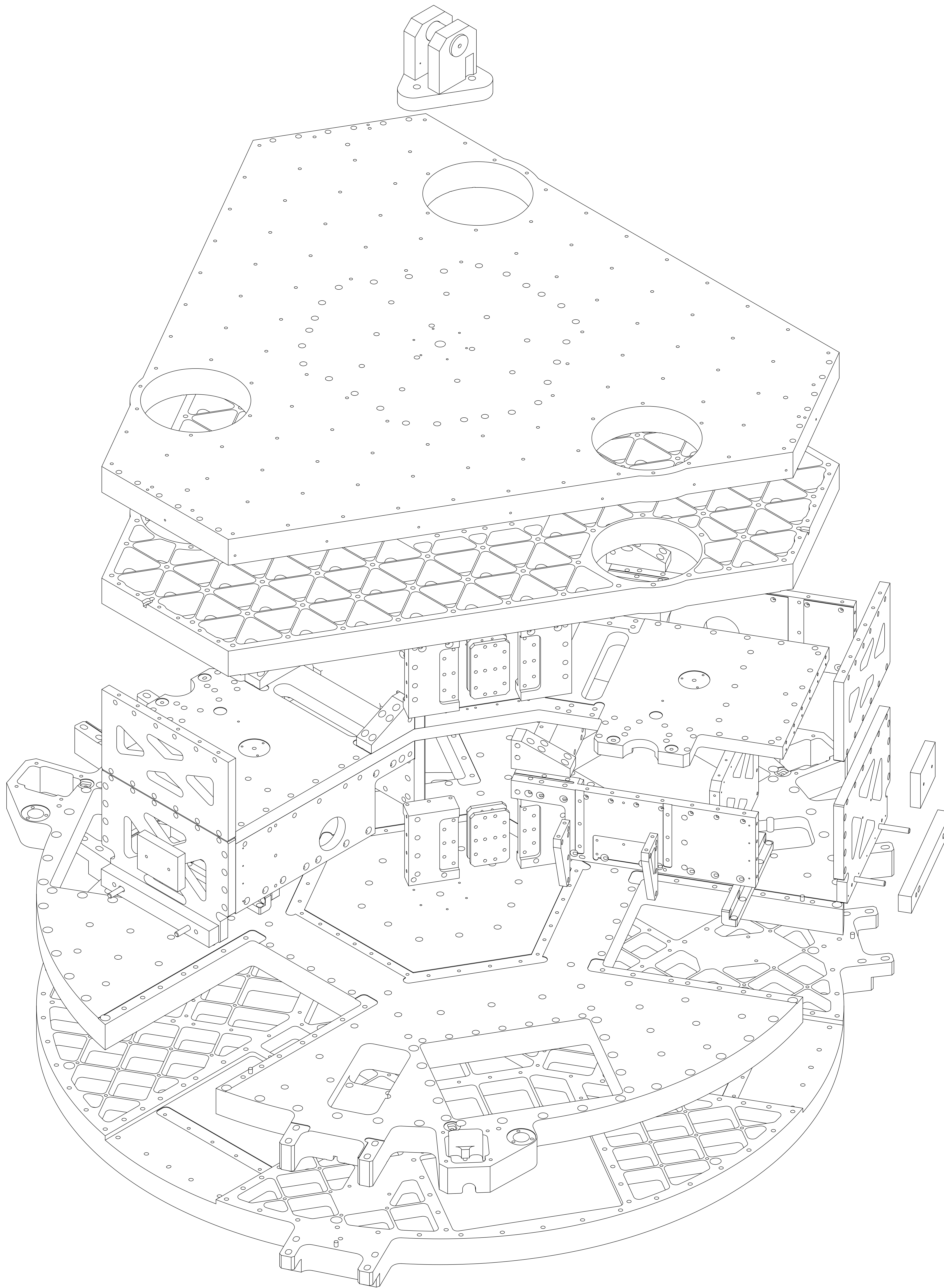


LTR		ZONE		DESCRIPTION										REVISIONS										DWN		CHK		P-ENG		CONF		ME		STRS		MATL		PROJ		QA		RELEASE DATE	
A				INITIAL RELEASE																																							



13. ALL SCREWS SHALL BE SILVER PLATED. DIMENSIONAL TOLERANCES PER UNC /UNF 2A APPLY AFTER PLATING
12. BOLT TORQUING PROCEDURE SHALL ENSURE THAT THE SPECIFIED TORQUE IS APPLIED WITHIN A TOLERANCE OF +5% / -10%.
- ▲11 TORQUE INDICATED FASTENERS TO 1200 IN-LBS
 - ▲10 TORQUE INDICATED FASTENERS TO 960 IN-LBS
 - ▲9 TORQUE INDICATED FASTENERS TO 276 IN-LBS
 - ▲8 TORQUE INDICATED FASTENERS TO 240 IN-LBS
 - ▲7 TORQUE INDICATED FASTENERS TO 192 IN-LBS
 - ▲6 TORQUE INDICATED FASTENERS TO 144 IN-LBS
 - ▲5 TORQUE INDICATED FASTENERS TO 85 IN-LBS
 - ▲4 TORQUE INDICATED FASTENERS TO 81 IN-LBS
 - ▲3 TORQUE INDICATED FASTENERS TO 75 IN-LBS
 - ▲2 TORQUE INDICATED FASTENERS TO 72 IN-LBS
 - ▲1 TORQUE INDICATED FASTENERS TO 60 IN-LBS
- NOTES: UNLESS OTHERWISE SPECIFIED

QTY	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE
3	51				SCREW, SOCKET HEAD CAP., .625-11 X 2.75L		A286 CRES
12	50				SCREW, SOCKET HEAD CAP., .625-11 X 2.0L		18-8 CRES
15	49				WASHER, FLAT, .625, 1.188 OD MIN, .032 THK	VENTED	300 SERIES CRES
99	48		20007891-2		BARREL NUT .375		AL ALLOY 7075-T6B1
222	47		20007891-1		BARREL NUT .25		AL ALLOY 7075-T6B1
81	46				WASHER, FLAT, .50, .87 OD MIN, .032 THK	VENTED	300 SERIES CRES
433	45				WASHER, FLAT, .375, .06 OD MIN, .032 THK	VENTED	300 SERIES CRES
390	44				WASHER, FLAT, .25, .463 OD MIN, .032 THK	VENTED	300 SERIES CRES
24	43				SCREW, SOCKET HEAD CAP., .250-20 X 1.5L		85 KSI CRES
81	42				SCREW, SOCKET HEAD CAP., .500-13 X 1.5L	VENTED	130 KSI CRES
124	41				SCREW, SOCKET HEAD CAP., .375-16 X 1.125L	VENTED	18-8 CRES
39	40				SCREW, SOCKET HEAD CAP., .250-20 X 1.5L	VENTED	18-8 CRES
24	39				SCREW, SOCKET HEAD CAP., .250-20 X 1.75L		18-8 CRES
117	38				SCREW, SOCKET HEAD CAP., .375-16 X 1.5L		80 KSI CRES
51	37				SCREW, SOCKET HEAD CAP., .250-20 X 4.5L		80 KSI CRES
69	36				SCREW, SOCKET HEAD CAP., .375-16 X 5.0L		18-8 CRES
42	35				SCREW, SOCKET HEAD CAP., .250-20 X 1.0L		18-8 CRES
30	34				SCREW, SOCKET HEAD CAP., .375-16 X 3.75L		18-8 CRES
48	33				SCREW, SOCKET HEAD CAP., .375-16 X 1.0L		18-8 CRES
39	32				SCREW, SOCKET HEAD CAP., .375-16 X 1.25L		18-8 CRES
234	31				SCREW, SOCKET HEAD CAP., .250-20 X 1.5L		18-8 CRES
1	30		20007846-1		UPPER OPTICAL TABLE		
1	29		20007847-1		LOWER OPTICAL TABLE		
1	28		20007848-1		UPPER KEEL PLATE		
1	27		20007849-1		LOWER KEEL PLATE		
1	26		20007850-1		BASE PLATE		
3	25		20007851-1		SIDE PLATE		
3	24		20007852-1		SIDE PLATE (GS-13)		
3	23		20007853-1		ANGLED HEX WALL, OPTICAL TABLE SIDE		
3	22		20007854-1		HEX WALL HALF, LEFT, OPTICAL TABLE SIDE		
3	21		20007854-2		HEX WALL HALF, RIGHT, OPTICAL TABLE SIDE		
3	20		20007855-1		HEX WALL SPLICE, THRU HOLES, OPT TBLE SIDE		
3	19		20007855-2		HEX WALL SPLICE, THD HOLES, OPT TABLE SIDE		
3	18		20007856-1		ANGLED HEX WALL, KEEL TABLE SIDE		
3	17		20007857-1		HEX WALL HALF, LEFT, KEEL TABLE SIDE		
3	16		20007857-2		HEX WALL HALF, RIGHT, KEEL TABLE SIDE		
3	15		20007858-1		HEX WALL SPLICE, THRU HOLES, KEEL TABLE SIDE		
3	14		20007858-2		HEX WALL SPLICE, TAPPED HOLES, KEEL TABLE SIDE		
3	13		20007859-1		GS-13 GUSSET, SOLID		
3	12		20007859-2		GS-13 GUSSET, CUTOUT		
3	11		20007860-1		BASEPLATE STIFFENING GUSSET, LEFT		
3	10		20007860-2		BASEPLATE STIFFENING GUSSET, RIGHT		
3	9		20007861-1		GS-13 BAY CLOSEOUT PLATE		
3	8		20007862-1		KEEL TABLE BRACE PLATE		
3	7		20007863-1		GS-13 BAY BULKHEAD PLATE		
3	6		20007864-1		GS-13 BAY BULKHEAD ANGLE BRACKET, LONG		
3	5		20007865-1		GS-13 BAY BULKHEAD ANGLE BRACKET, SHORT		
A/R	4		20007866-1		TRIM WEIGHT PLATE (MULTIPLE STACKED PIECES)		
6	3				SCREW, SOCKET HEAD CAP .375-16	LENGTH A/R - 3 THREAD MIN	18-8 CRES
3	2		20007877-1		WEIGHT ACTUATOR COMPENSATION - STAGE 2		
1	1		20008048-1		LIFT HOOK ASSEMBLY		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

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

CONTRACT NO: _____

PROJECT CODE: 1388

APPLICATION: _____

FILE ATTACHMENTS: _____

SEE PARTS LIST

SCALE: 1:8

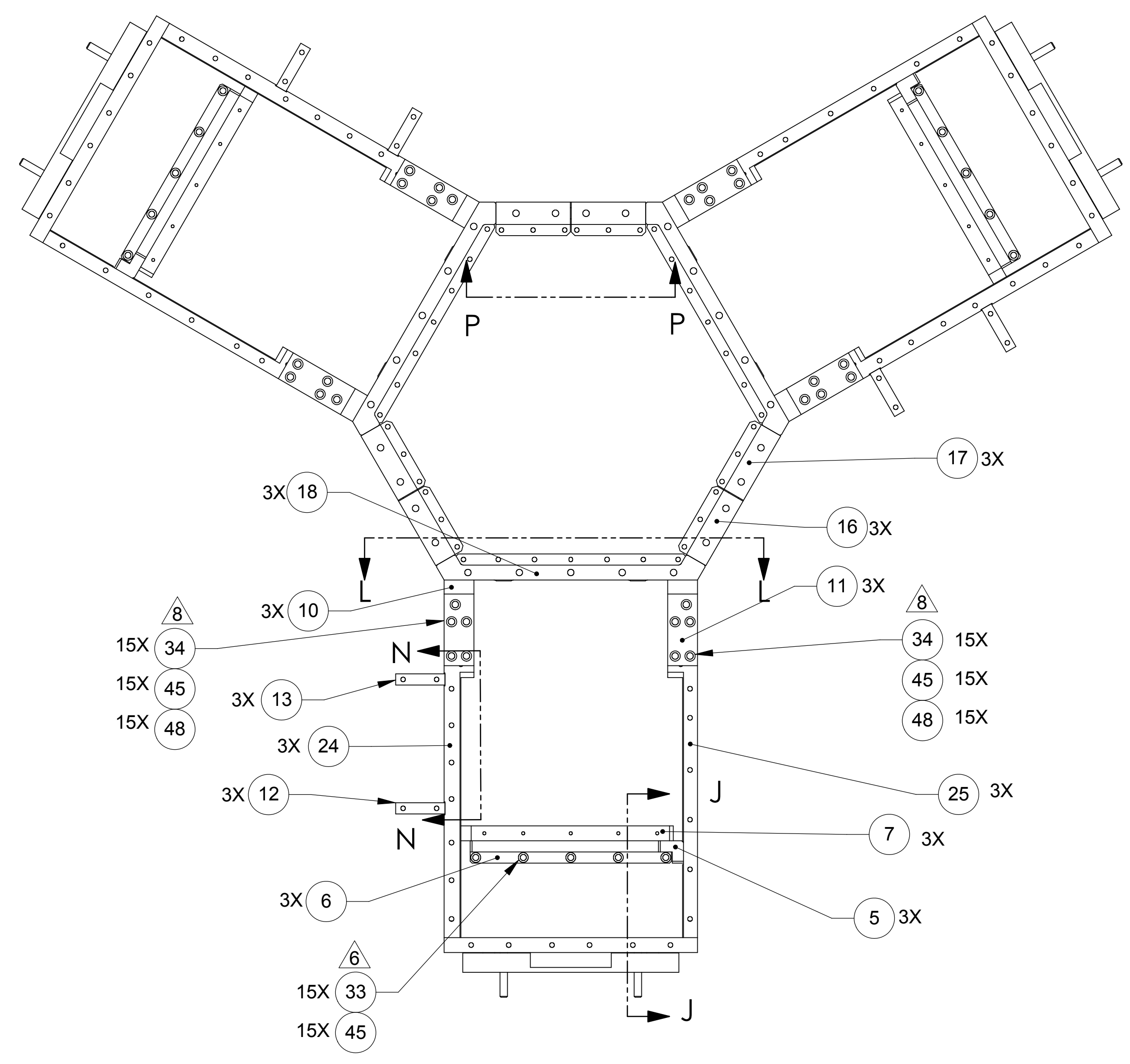
UNCLASSIFIED SHEET 1 OF 5

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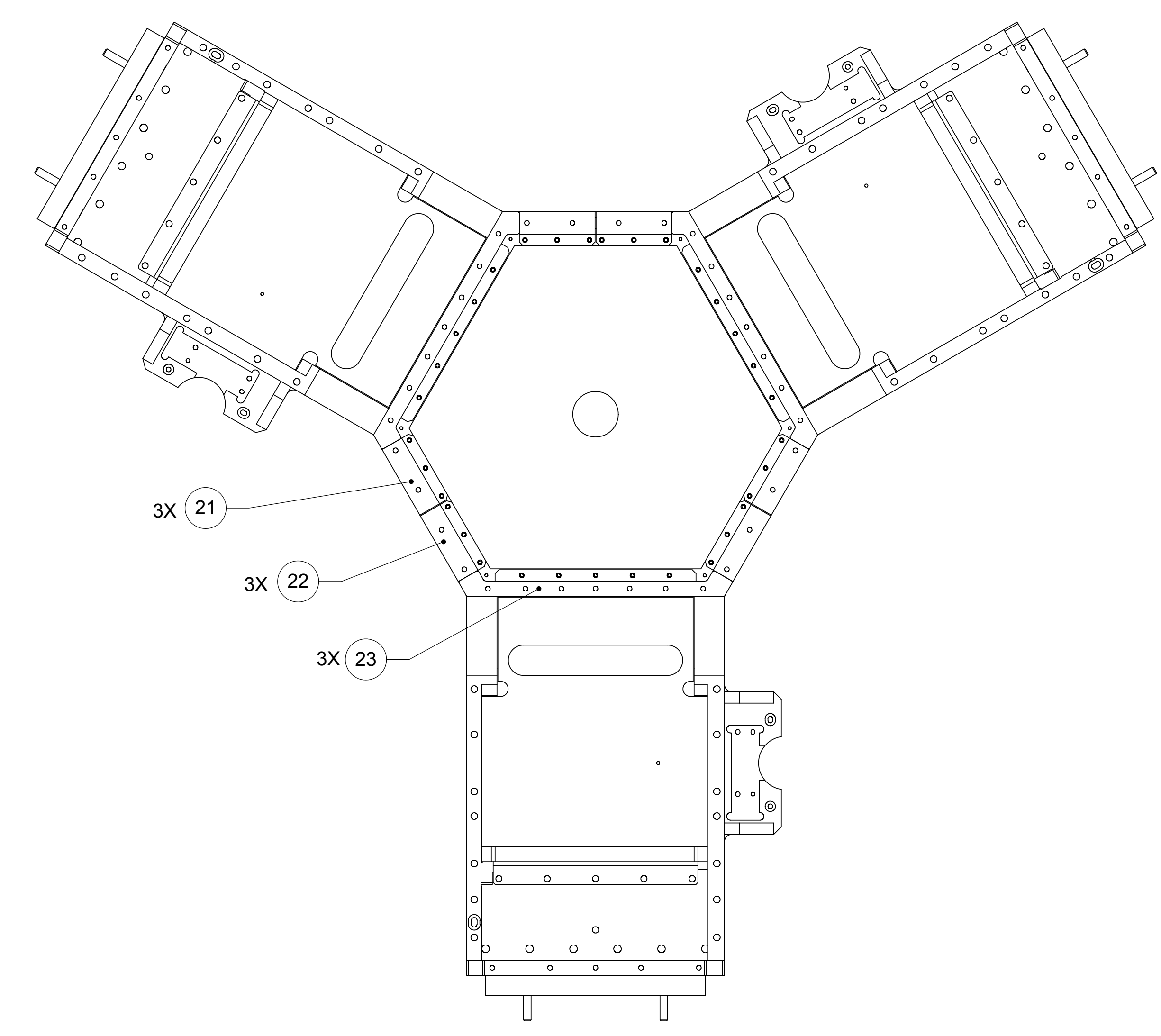
STAGE 2 STRUCTURE SUB-ASSEMBLY

20007845

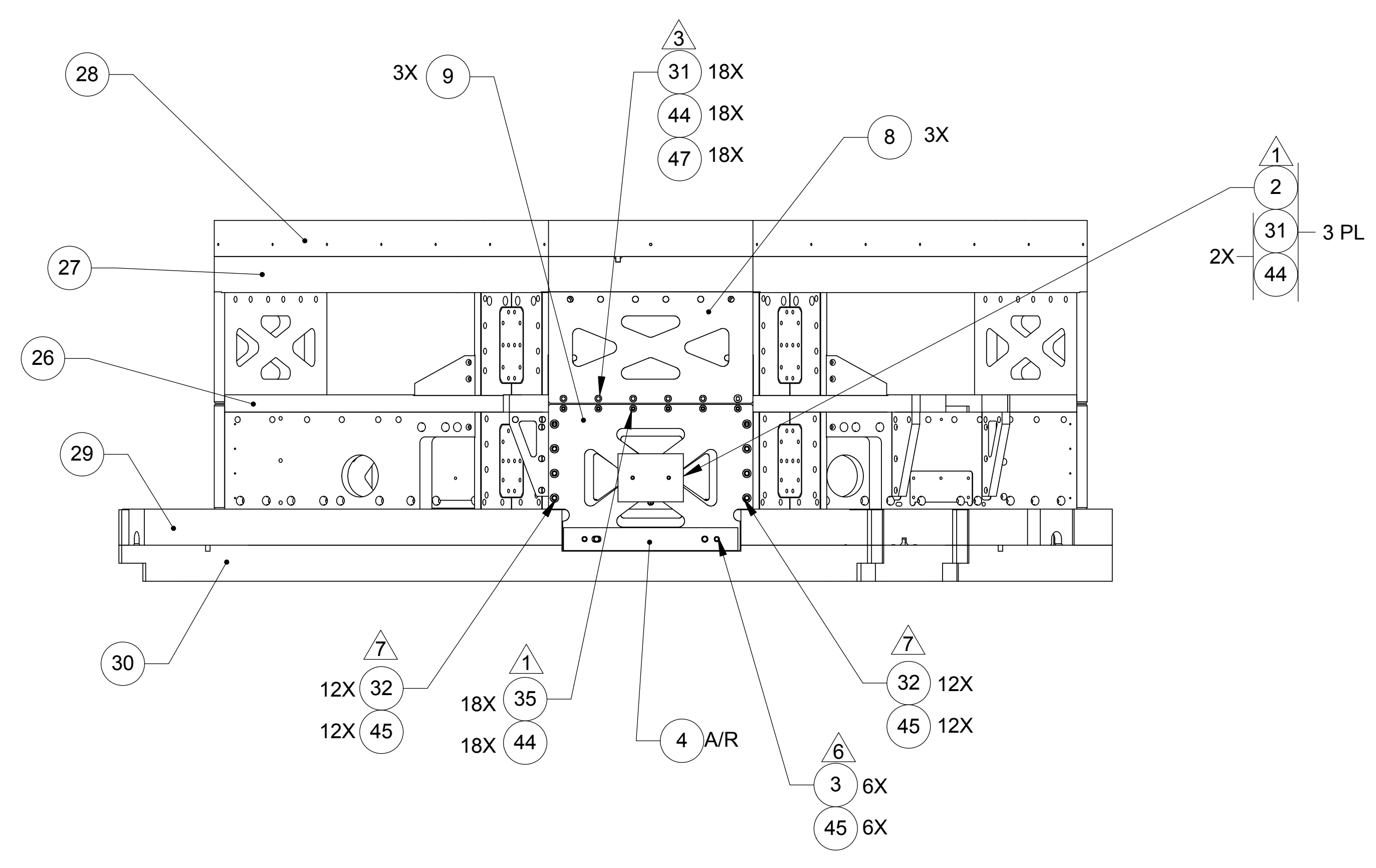
REV A



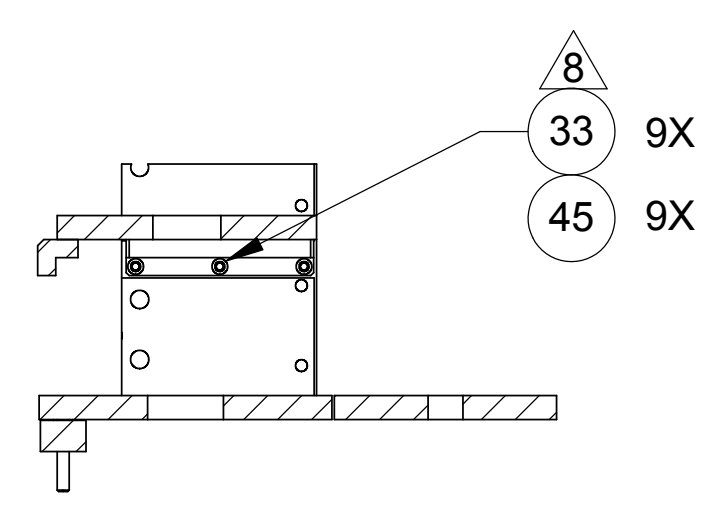
TOP VIEW
ITEMS 26, 27, 28, 29, 30 REMOVED FOR CLARITY



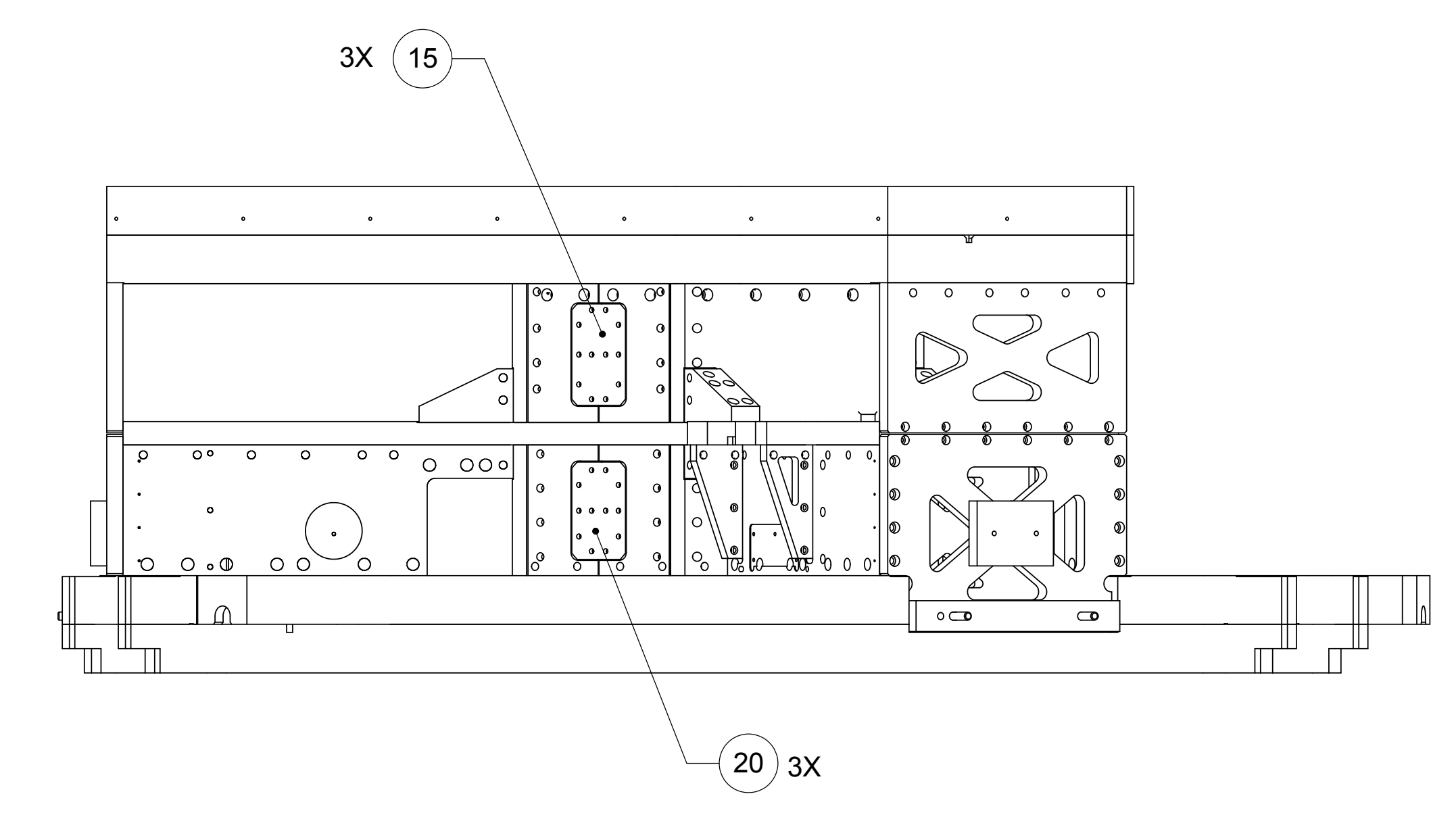
BOTTOM VIEW
ITEMS 27, 28, 29, 30 REMOVED FOR CLARITY
BASE PLATE (ITEM 26) SHOWN



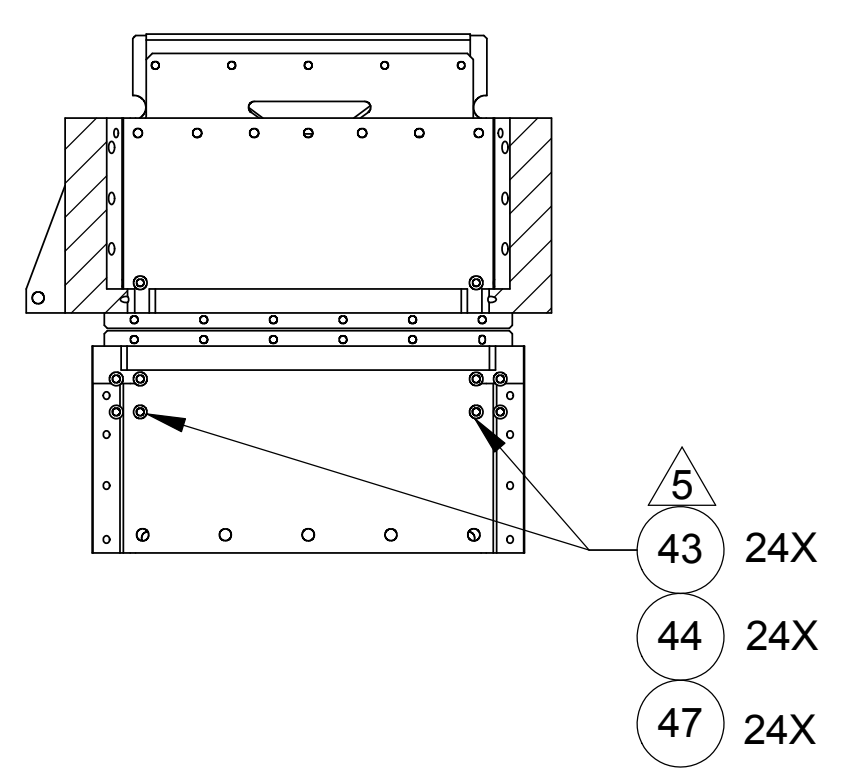
SECTION N-N
SCALE 1:6



SECTION J-J
SCALE 1:6



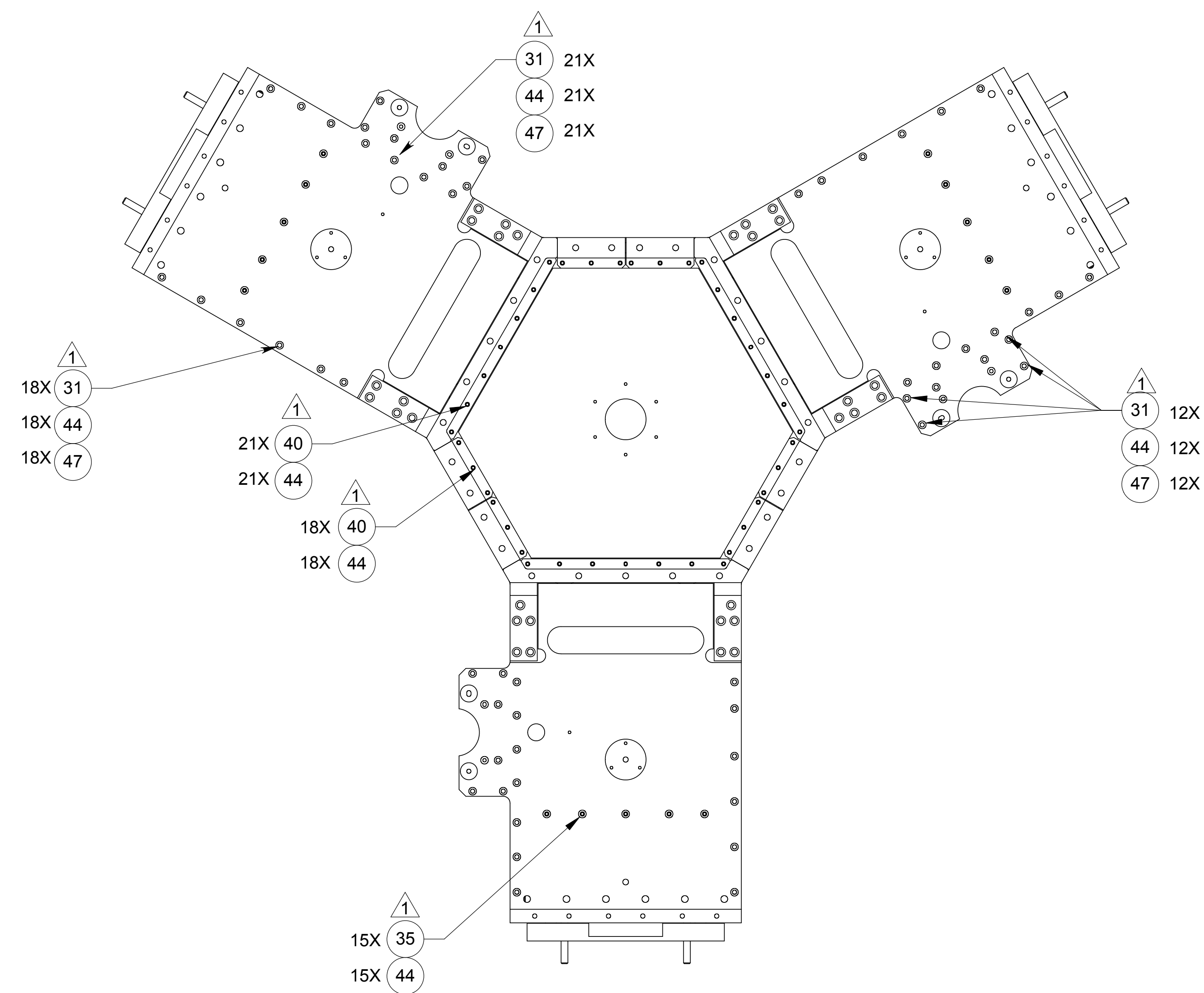
SECTION P-P
SCALE 1:6



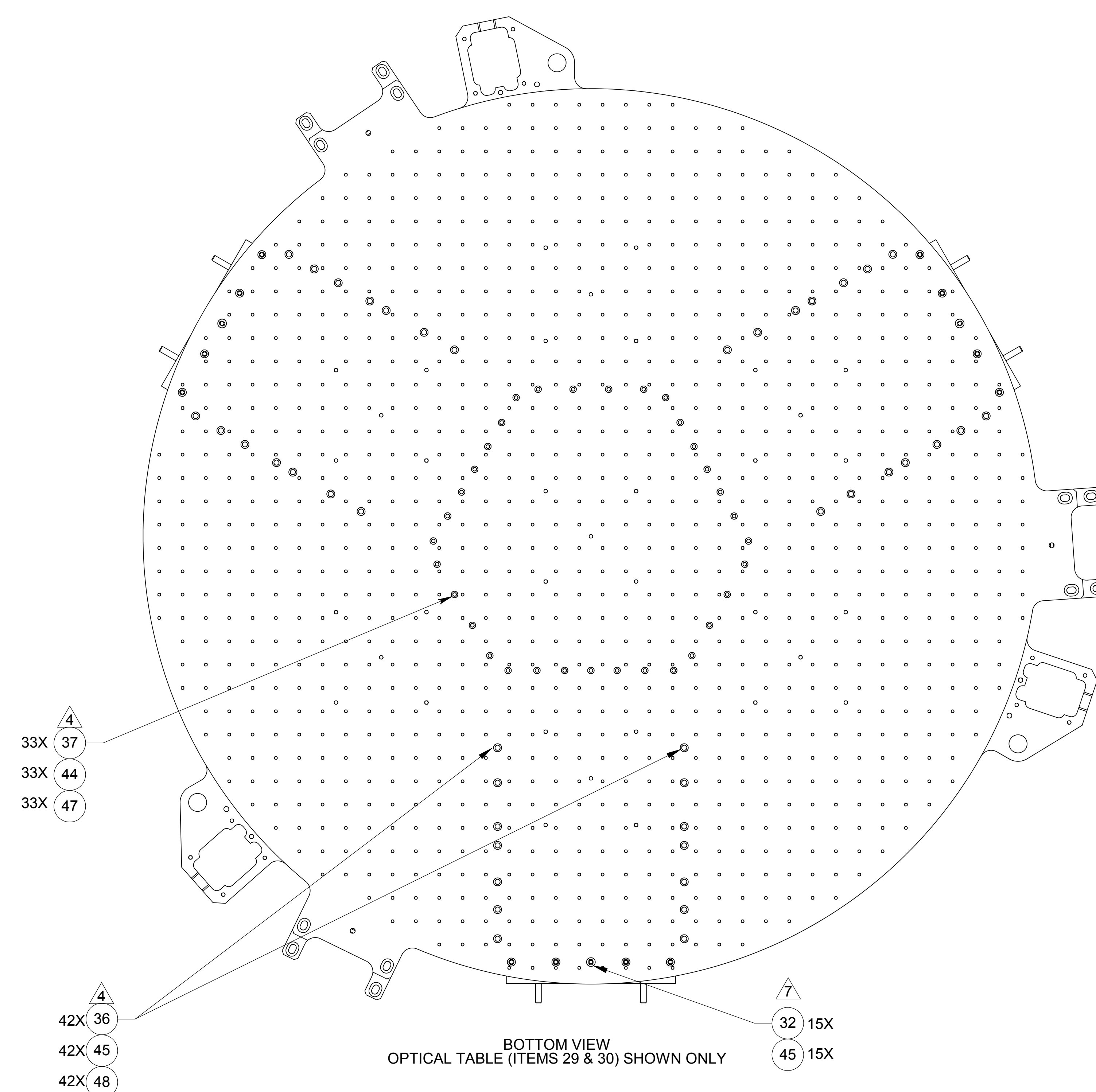
SECTION L-L
SCALE 1:6

NOTES: UNLESS OTHERWISE SPECIFIED

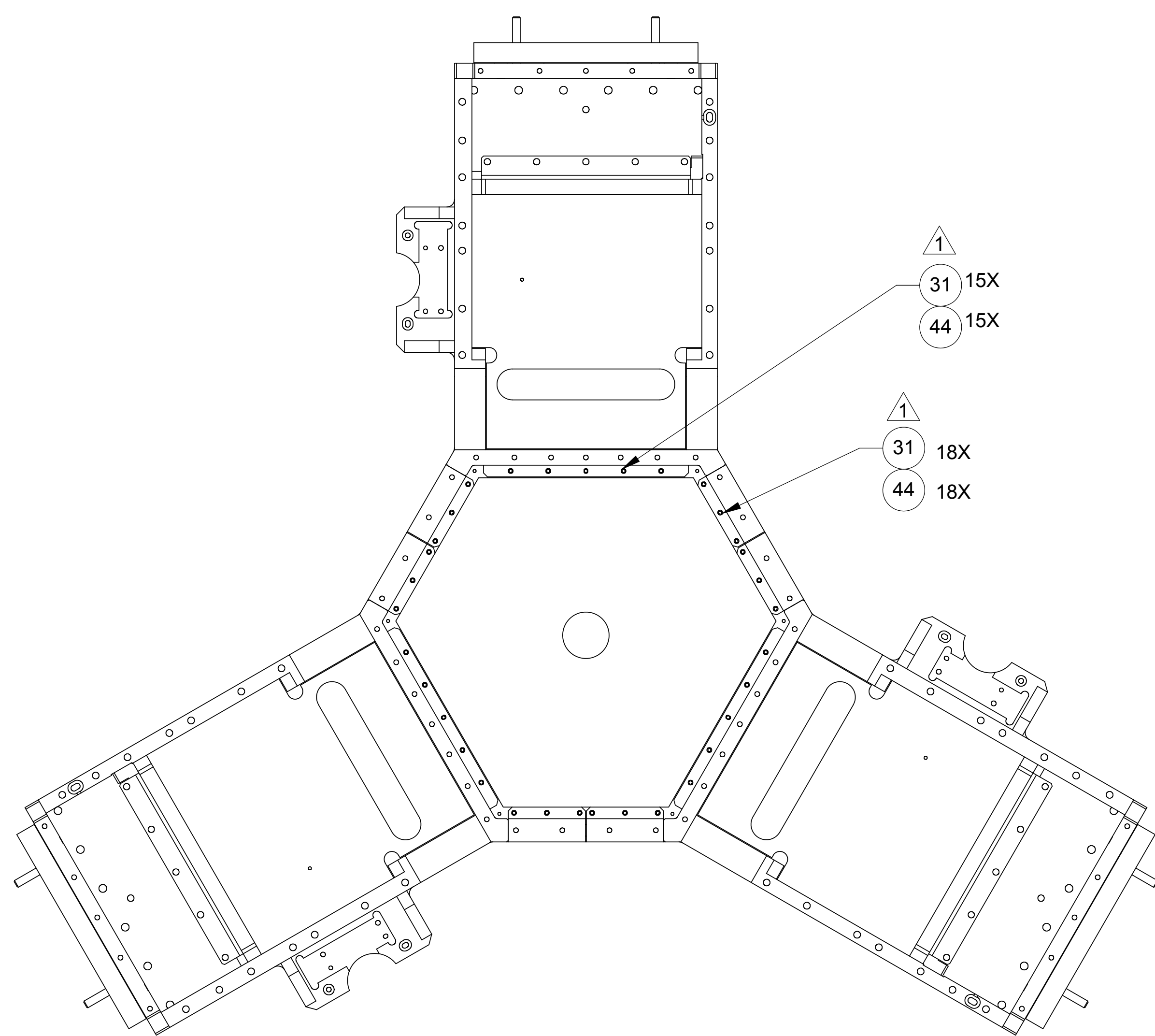
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EXPORT RESTRICTIONS MAY APPLY



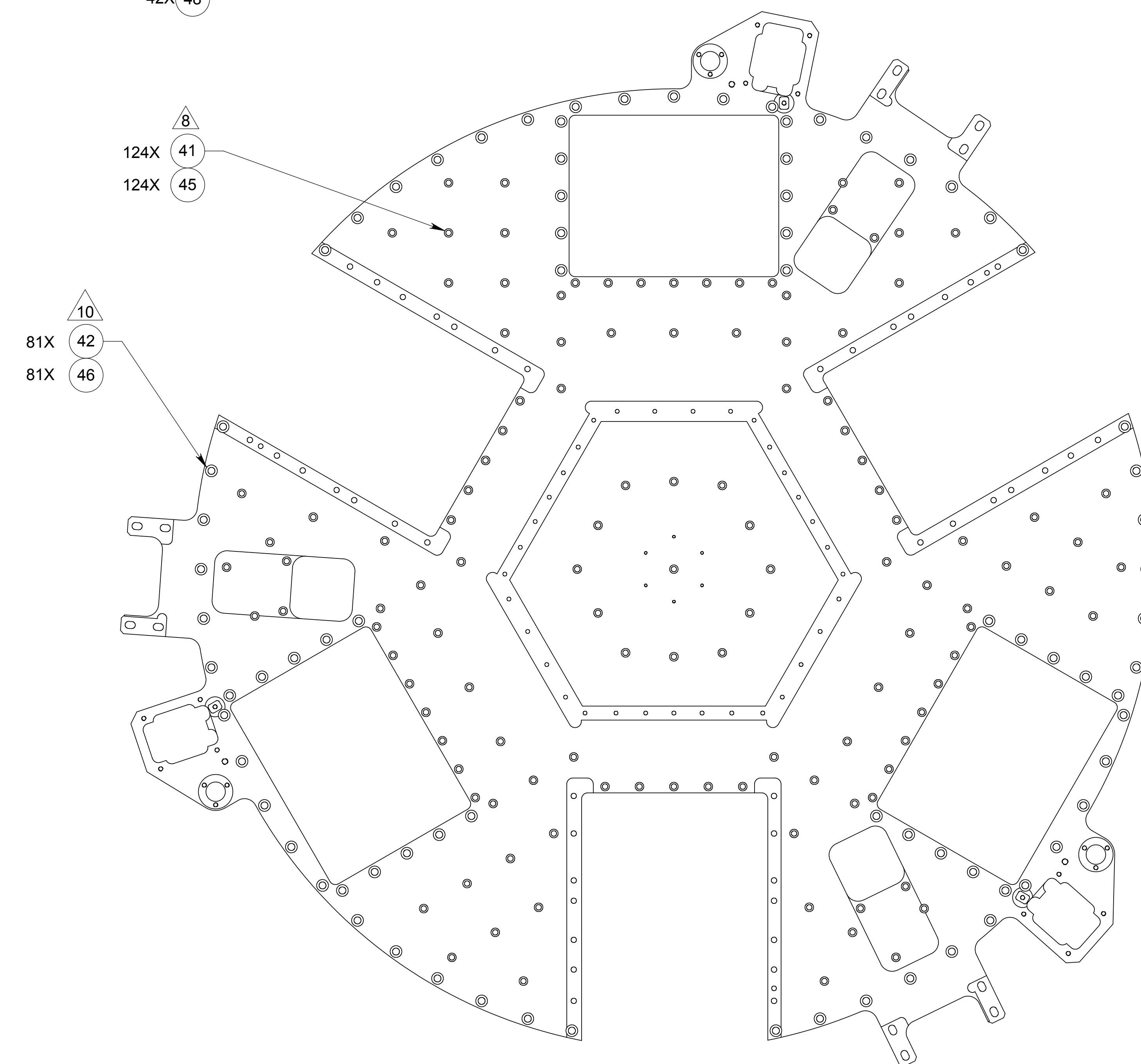
TOP VIEW
KEEL PLATE (ITEMS 27 & 28) & OPTICAL TABLE (ITEMS 29 & 30) NOT SHOWN



BOTTOM VIEW
OPTICAL TABLE (ITEMS 29 & 30) SHOWN ONLY



BOTTOM VIEW
KEEL PLATE (ITEMS 27 & 28) & OPTICAL TABLE (ITEMS 29 & 30) NOT SHOWN



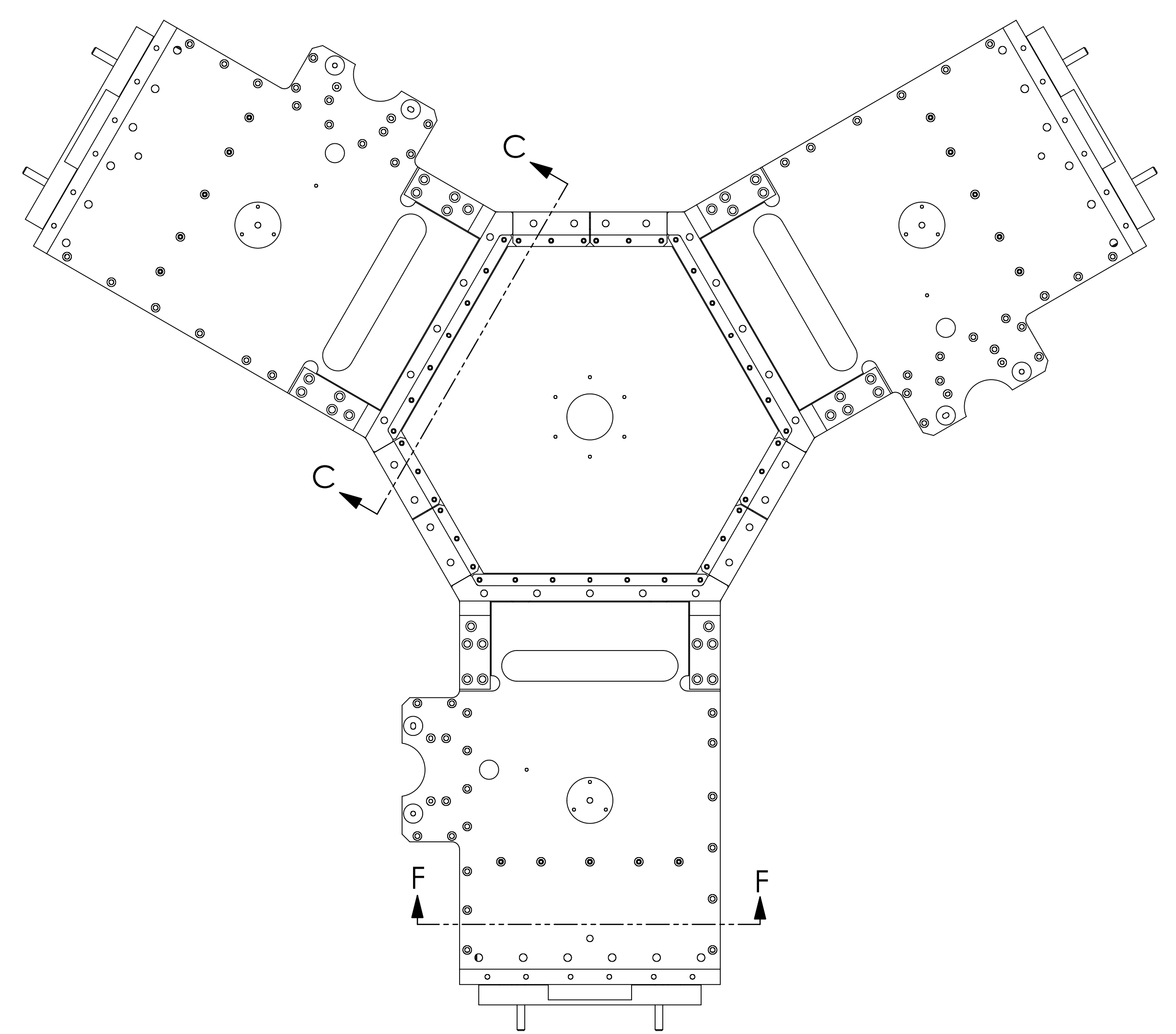
TOP VIEW
OPTICAL TABLE (ITEMS 29 & 30) SHOWN ONLY

NOTES: UNLESS OTHERWISE SPECIFIED

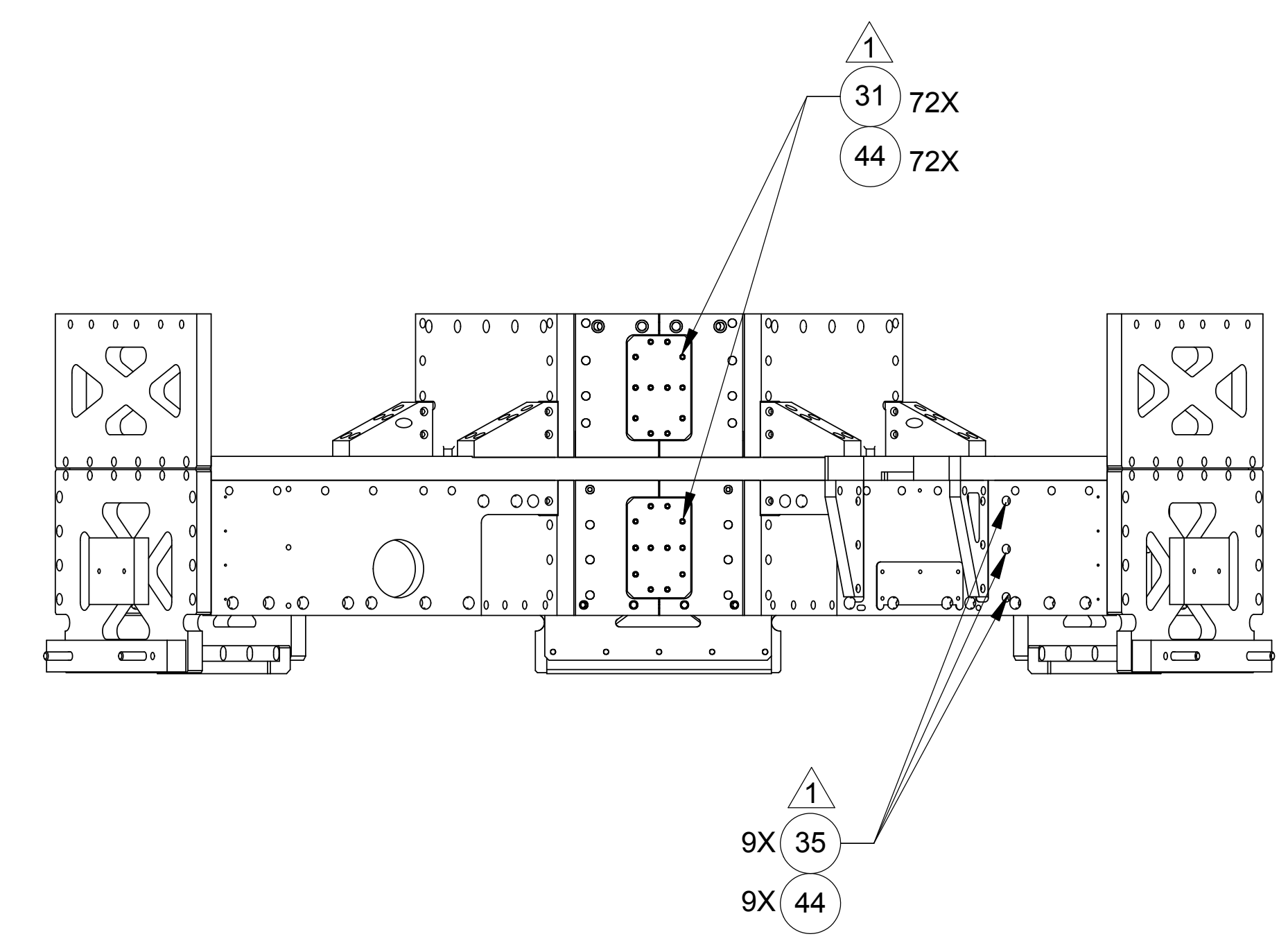
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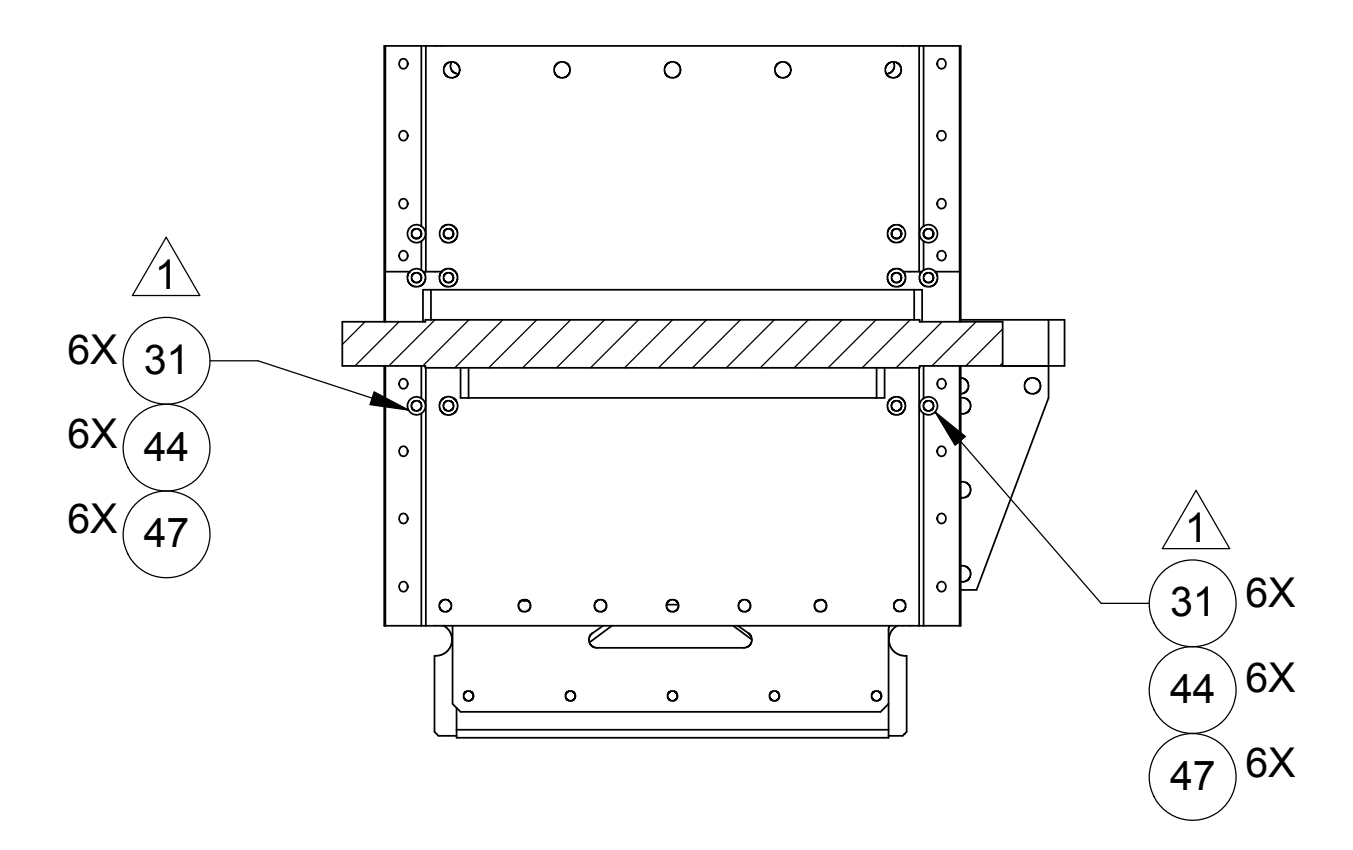
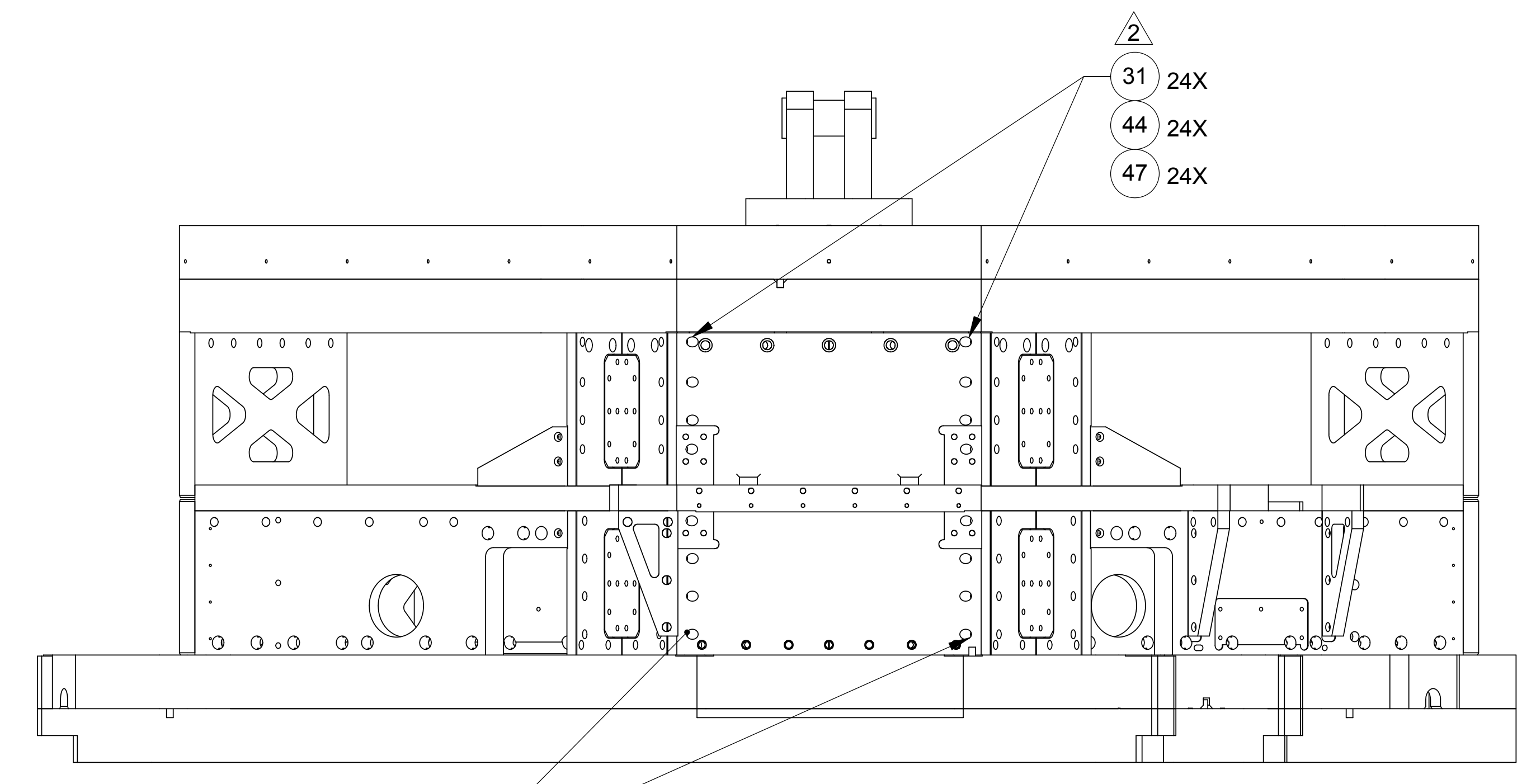
SIZE E CAGE CODE 1KNU9 REV A
SCALE 1:6 UNCLASSIFIED SHEET 3 OF 5
20007845



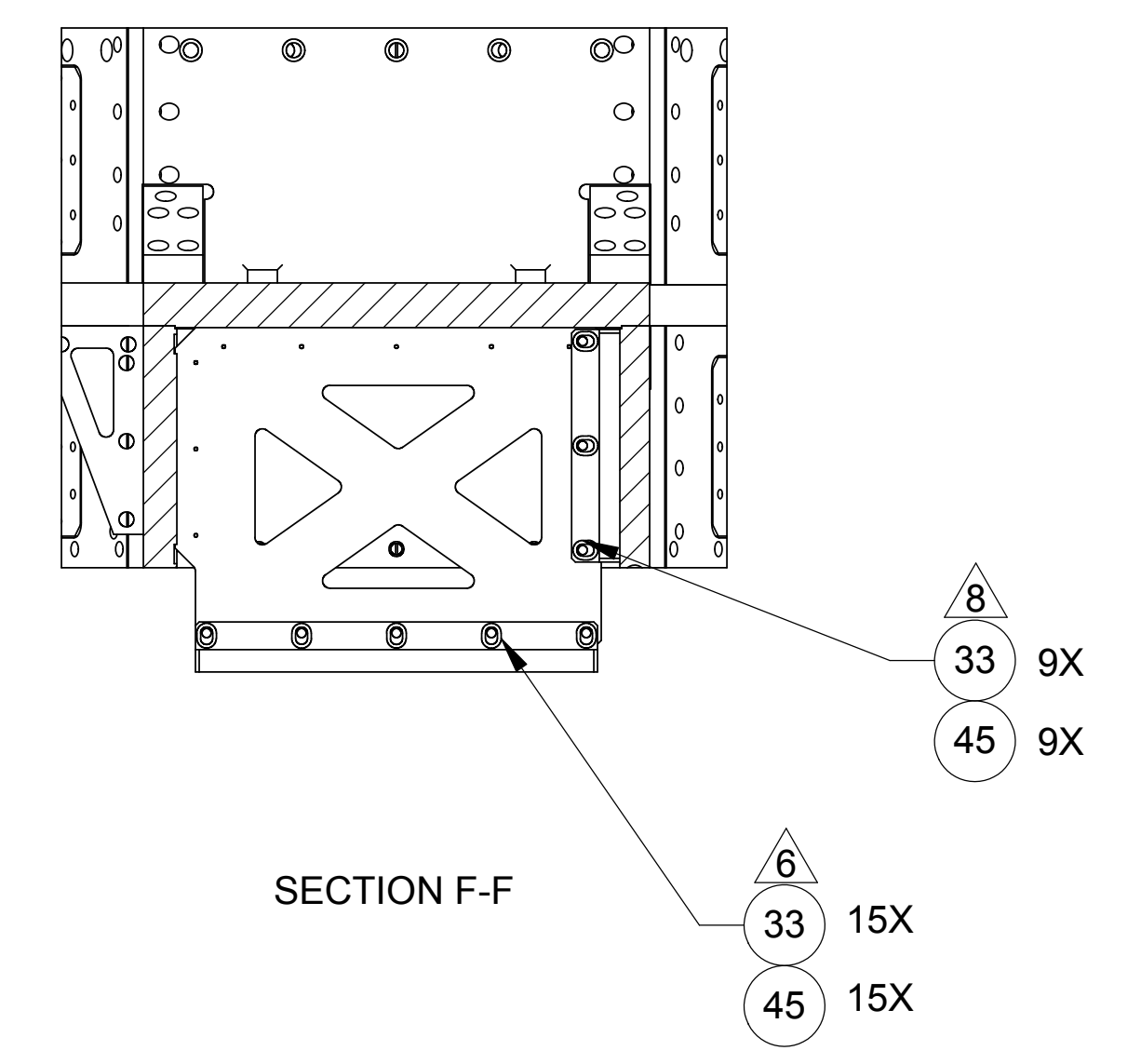
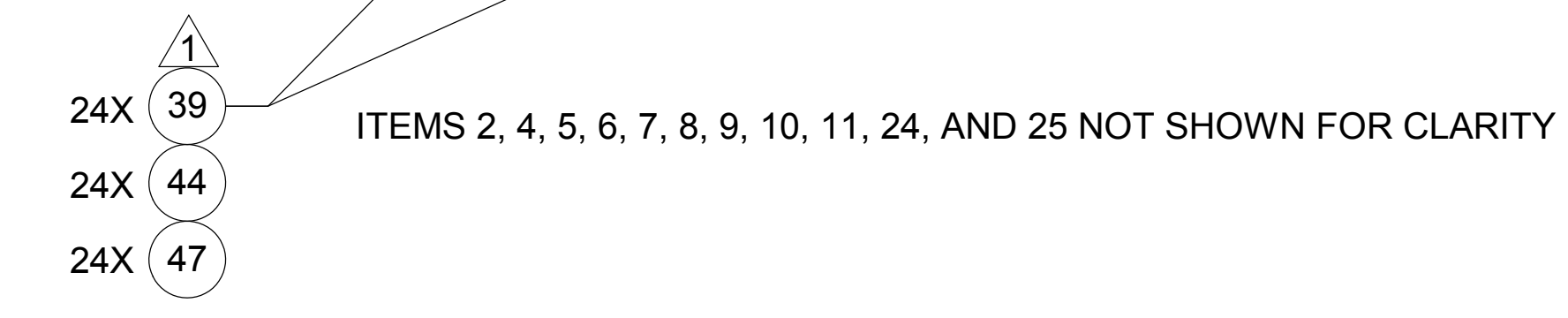
KEEL PLATE (ITEMS 27 & 28) & OPTICAL TABLE (ITEMS 29 & 30) NOT SHOWN



VIEW A
SCALE 1:8



SECTION C-C

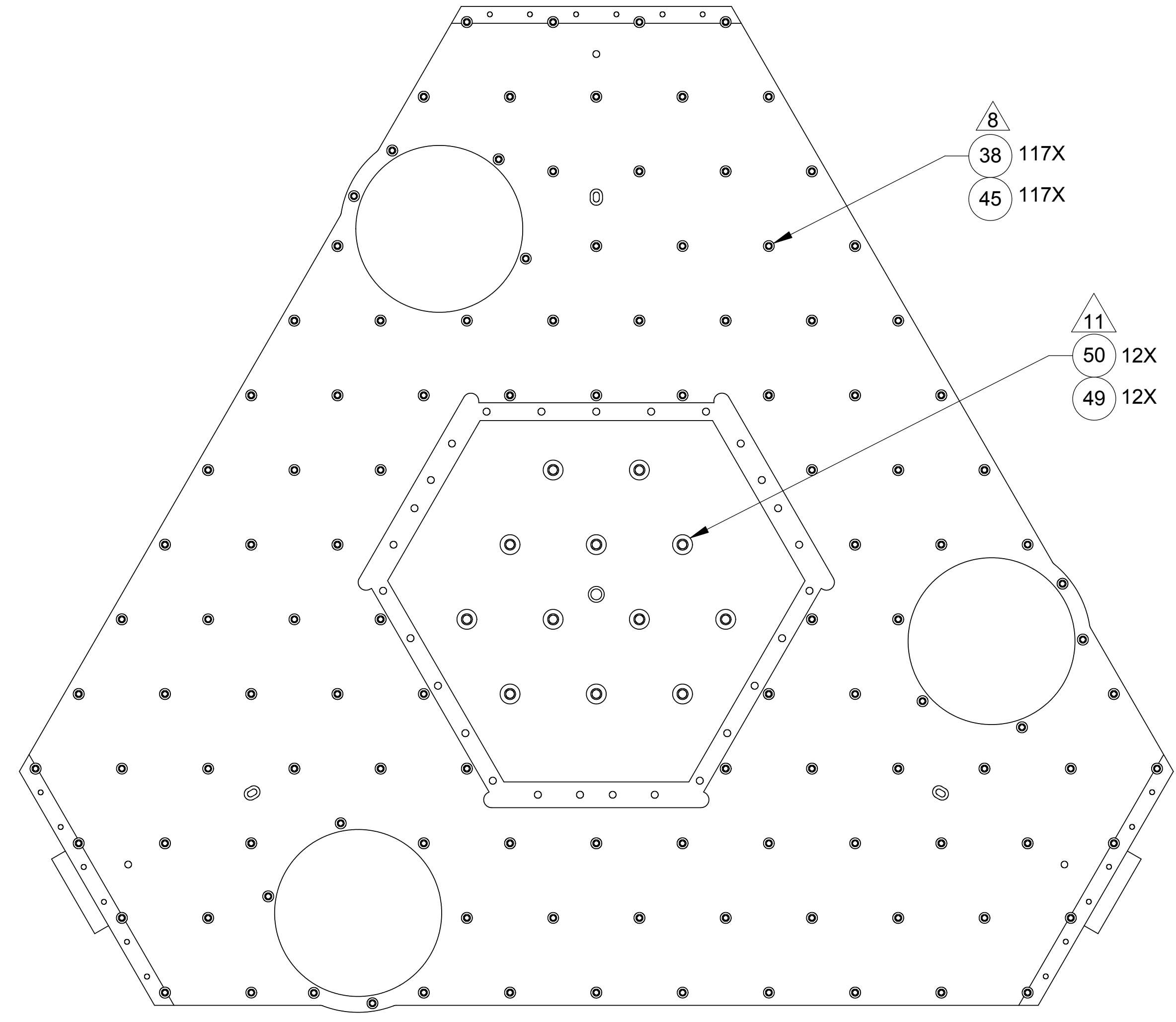
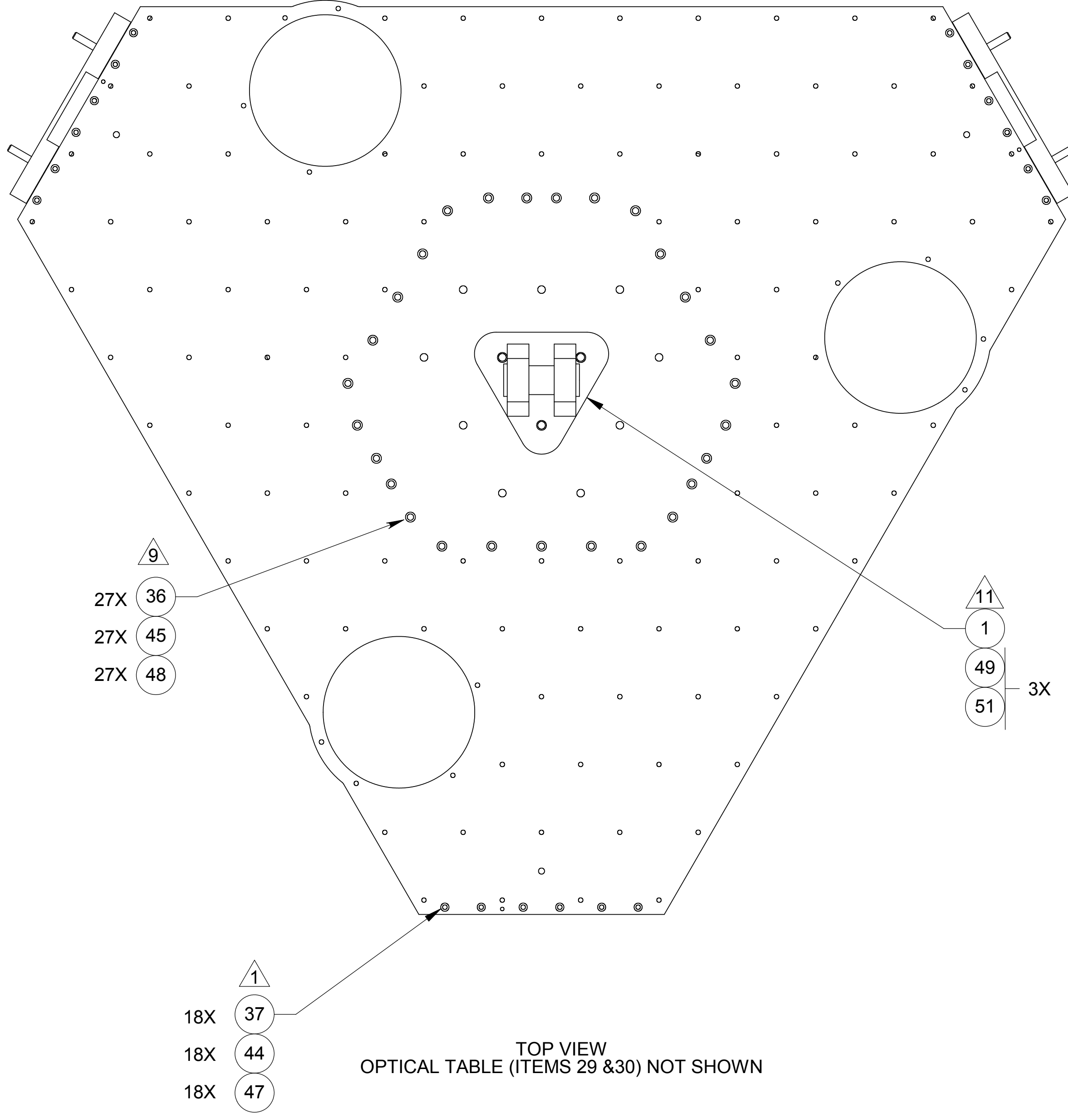


SECTION F-F

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SIZE E	CAGE CODE 1KNU9	REV A
SCALE 1:6		UNCLASSIFIED
SHEET 4 OF 5		REV 303



NOTES: UNLESS OTHERWISE SPECIFIED

BOTTOM VIEW
KEEL PLATES (ITEMS 27 & 28) SHOWN ONLY

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SIZE E	CAGE CODE 1KNU9	20007845	REV A
SCALE 1:6		UNCLASSIFIED	SHEET 5 OF 5