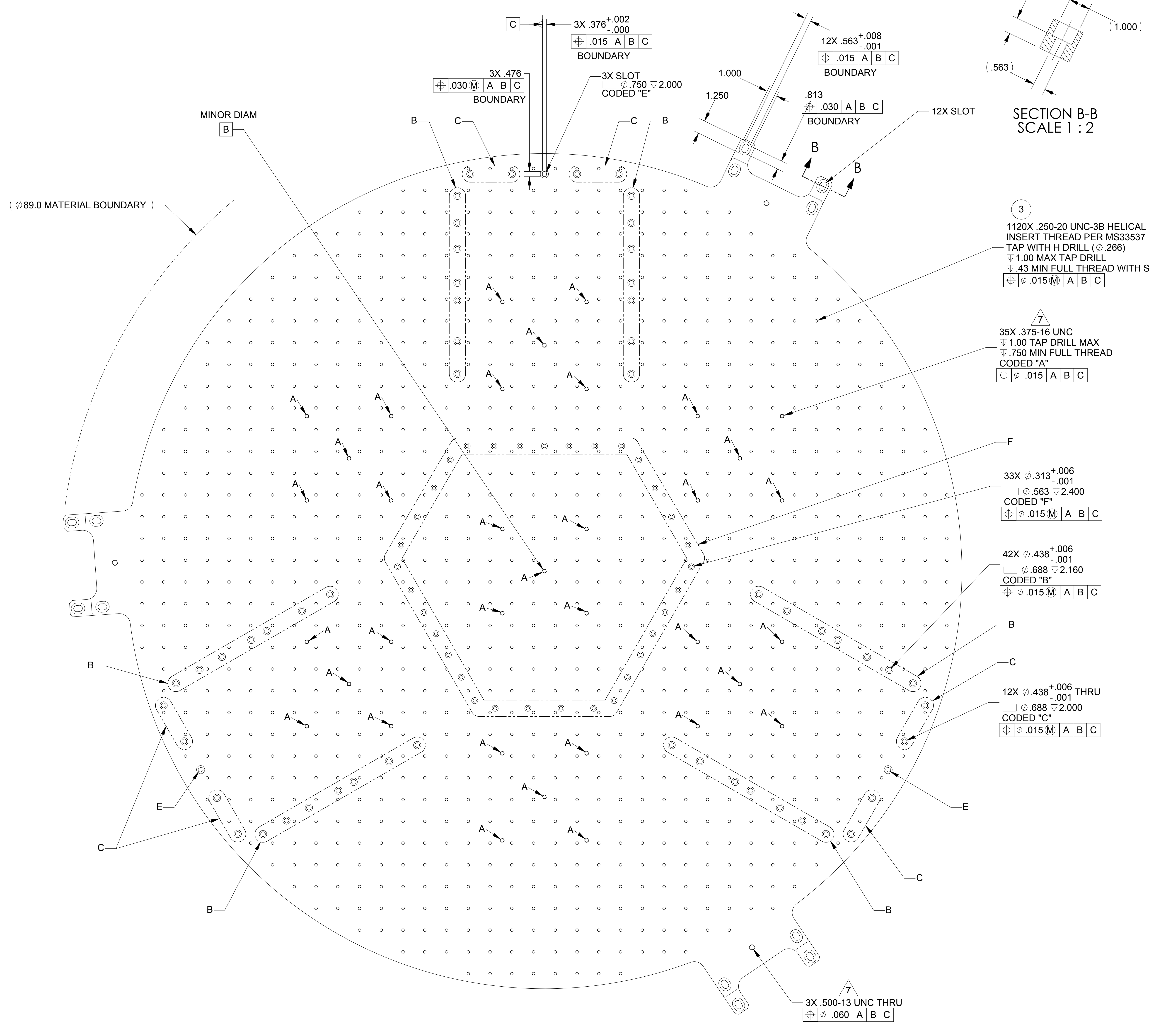


LTR		ZONE		REVISIONS									
				DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A				INITIAL RELEASE									



3
1120X .250-20 UNC-3B HELICAL COIL
INSERT THREAD PER MS33537
TAP WITH H DRILL (φ.266)
1.00 MAX TAP DRILL
.43 MIN FULL THREAD WITH STI TAP
φ.015 M A B C

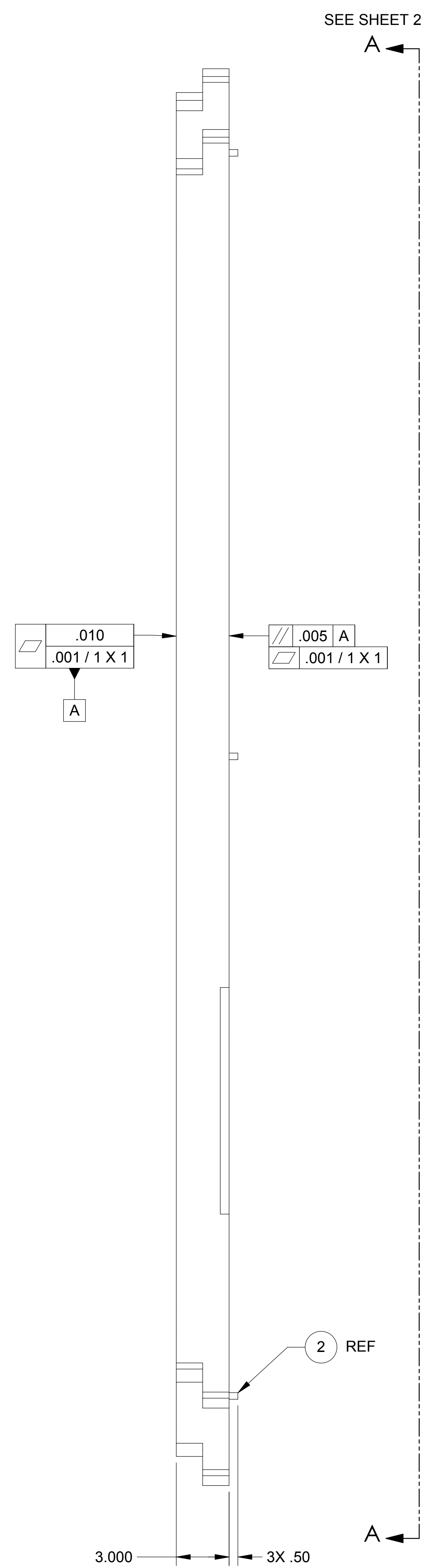
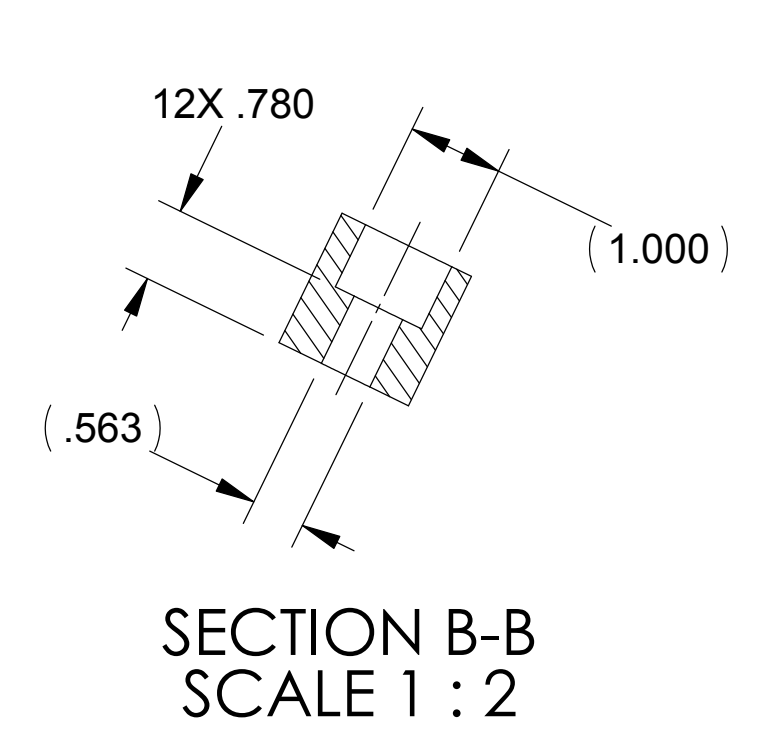
7
35X .375-16 UNC
1.00 TAP DRILL MAX
.750 MIN FULL THREAD
CODED "A"
φ.015 A B C

F
33X φ.313^{+0.006}_{-.001}
φ.563 2.400
CODED "E"
φ.015 M A B C

42X φ.438^{+0.006}_{-.001}
φ.688 2.160
CODED "B"
φ.015 M A B C

B
C
12X φ.438^{+0.006}_{-.001} THRU
φ.688 2.000
CODED "C"
φ.015 M A B C

7
3X .500-13 UNC THRU
φ.060 A B C



NOTES: UNLESS OTHERWISE SPECIFIED.

- THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE, THE MODEL DATABASE WILL TAKE PRECEDENCE.
- PART SHALL BE CHECKED USING THE MODEL DATABASE.
- A SURFACE PROFILE TOLERANCE OF .014 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
- 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.
- 7 THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION. THIS DOES NOT APPLY TO THREADED INSERT HOLES.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-0.000.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.

10. MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.13 INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006886, TYPE I, CLASSES 4, 5, OR 6. SERIAL NUMBERS START AT 001 FOR FIRST PART AND PROCEED CONSECUTIVELY. PARTS TOO SMALL TO MARK SHALL BE IDENTIFIED IN ACCORDANCE WITH 20006886, TYPE II.
11. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 1,019.0 LBS.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
1120	3		3LKZ8	1185-4EN375	INSERT, .250-20 X .375 L	EMHART	NITRONIC 60		
3	2		3A054	98380A624	PIN, φ.3752 X 1.00L	MC MASTER CARR	CRES		
1	1			20007846-101	OPTICAL TABLE	AMS-QQ-A-250/11	AL 6061-T651		

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
20007870	1388	DECIMALS	ANGLES	DWN	KEVIN J SPINK 06/25/04
		XX ±.03	XXX ±.010 ±12°	PROJ ENGR	STRS
		MACHINE FINISH 125		CHK	MATL
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M		CONFIG	PROJ
		MATERIAL		ME	QA
		SEE PARTS LIST		SCALE	1:4

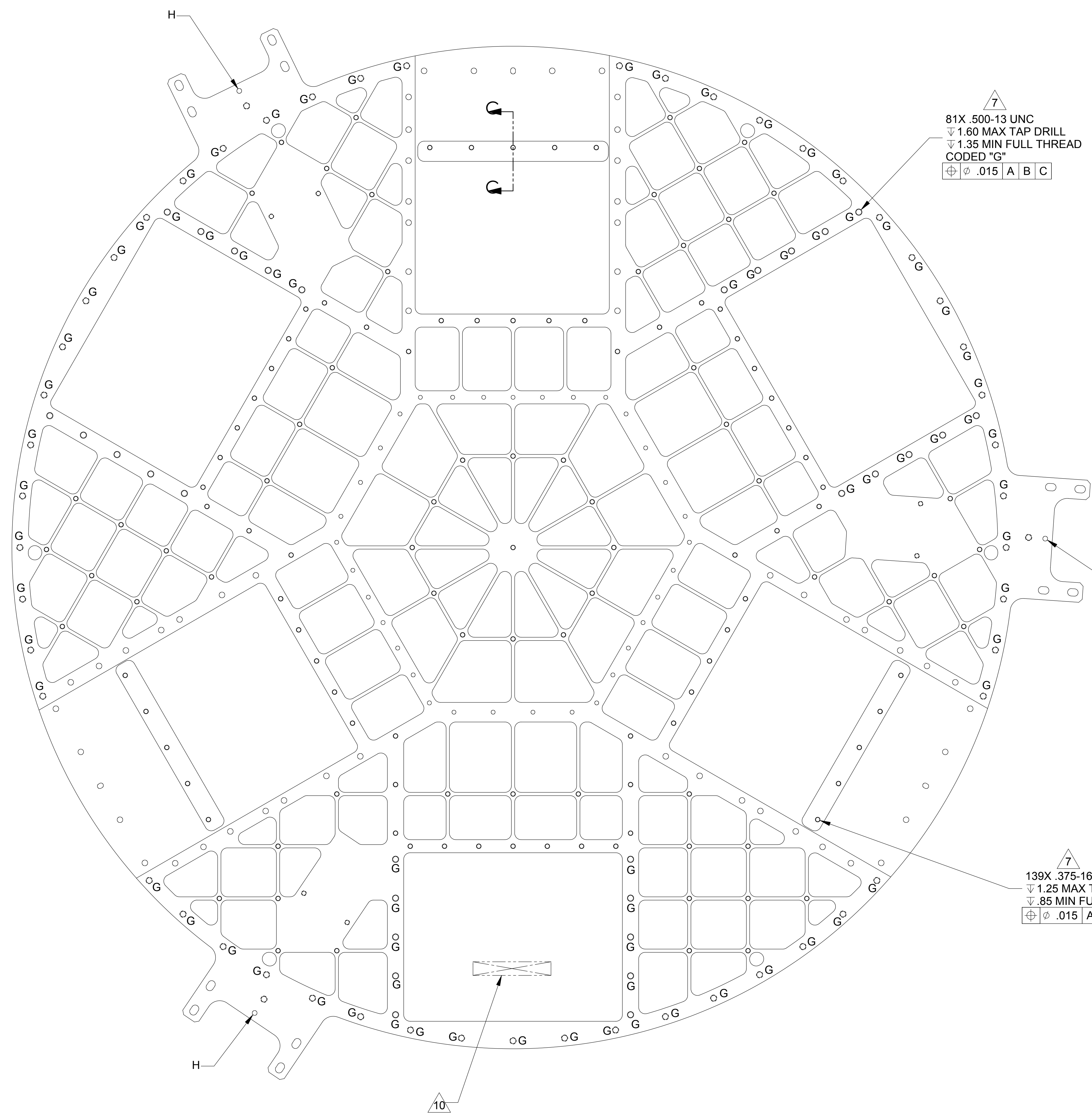
20007846_x_1	20007846	1388	20007846	REV A
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THIS DOCUMENT MAY CONTAIN ITAR CONTROLLED INFORMATION AND/OR COMMERCE CONTROLLED INFORMATION EXPORT RESTRICTIONS MAY APPLY

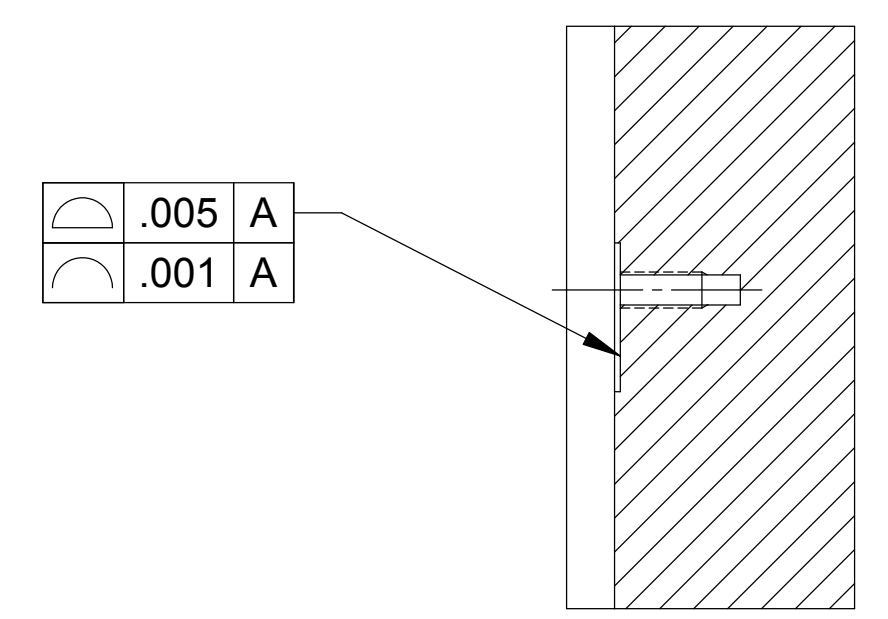
asi ALLIANCE SPACESTRONG SYSTEMS, INC.
1250 Lincoln Ave., Suite 100
Pasadena, CA 91103

UPPER OPTICAL TABLE
STAGE 2
LIGO-D047846-A

20007846
UNCLASSIFIED SHEET 1 OF 2



7
81X .500-13 UNC
▽1.60 MAX TAP DRILL
▽1.35 MIN FULL THREAD
CODED "G"
⊕⊖ .015 A B C



SECTION C-C
SCALE 1 : 2
TYPICAL 3 PLACES

2
3X ⌀.3749±.0001 ▽.75
CODED "H"
(SEE SHEET 1 FOR PIN
PROTRUSION DETAIL)
⊕⊖ .010 A B C

7
139X .375-16 UNC
▽1.25 MAX TAP DRILL
▽.85 MIN FULL THREAD
⊕⊖ .015 A B C

10

VIEW A-A