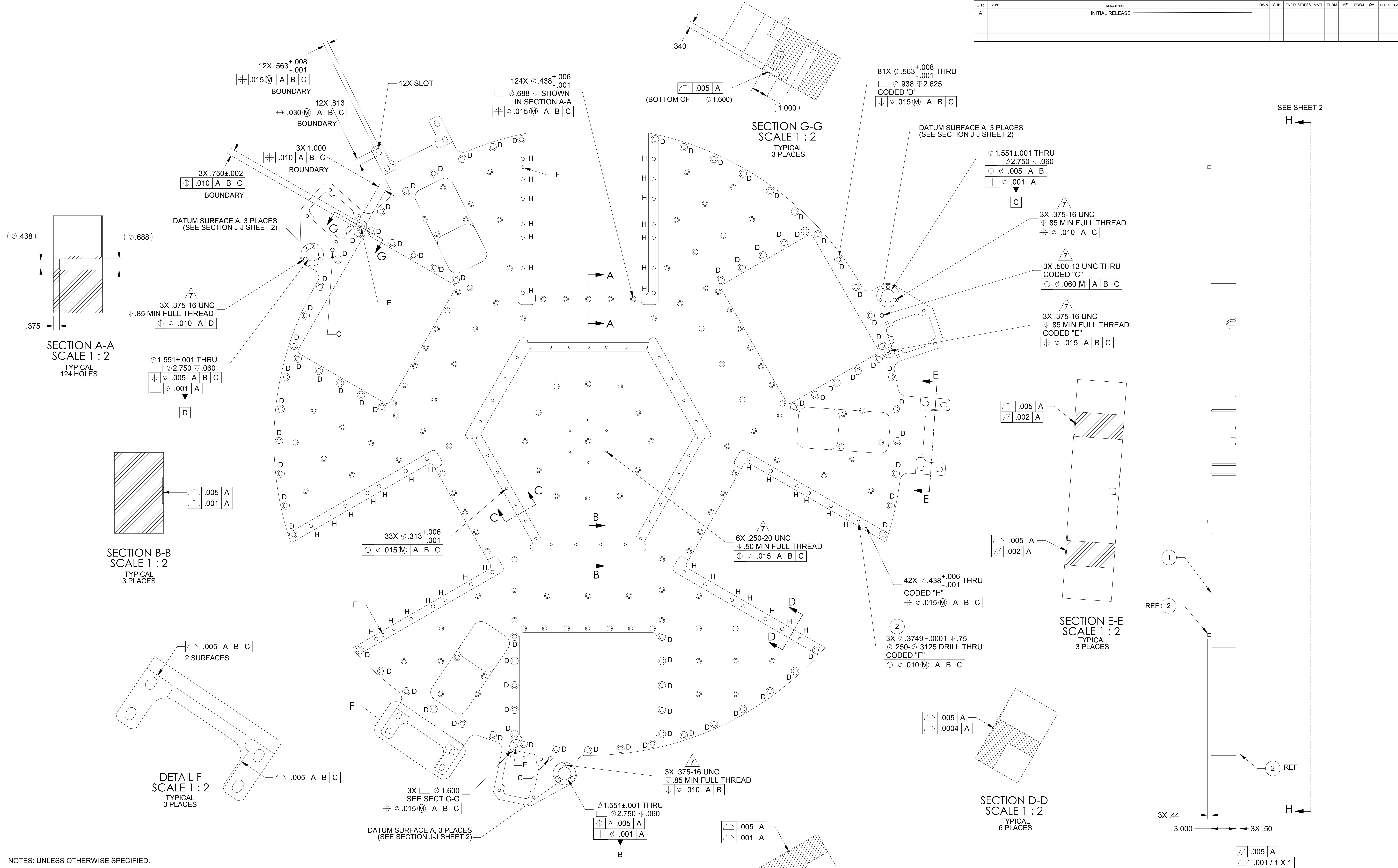


LTR		ZONE		DESCRIPTION		REVISIONS		DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A				INITIAL RELEASE													



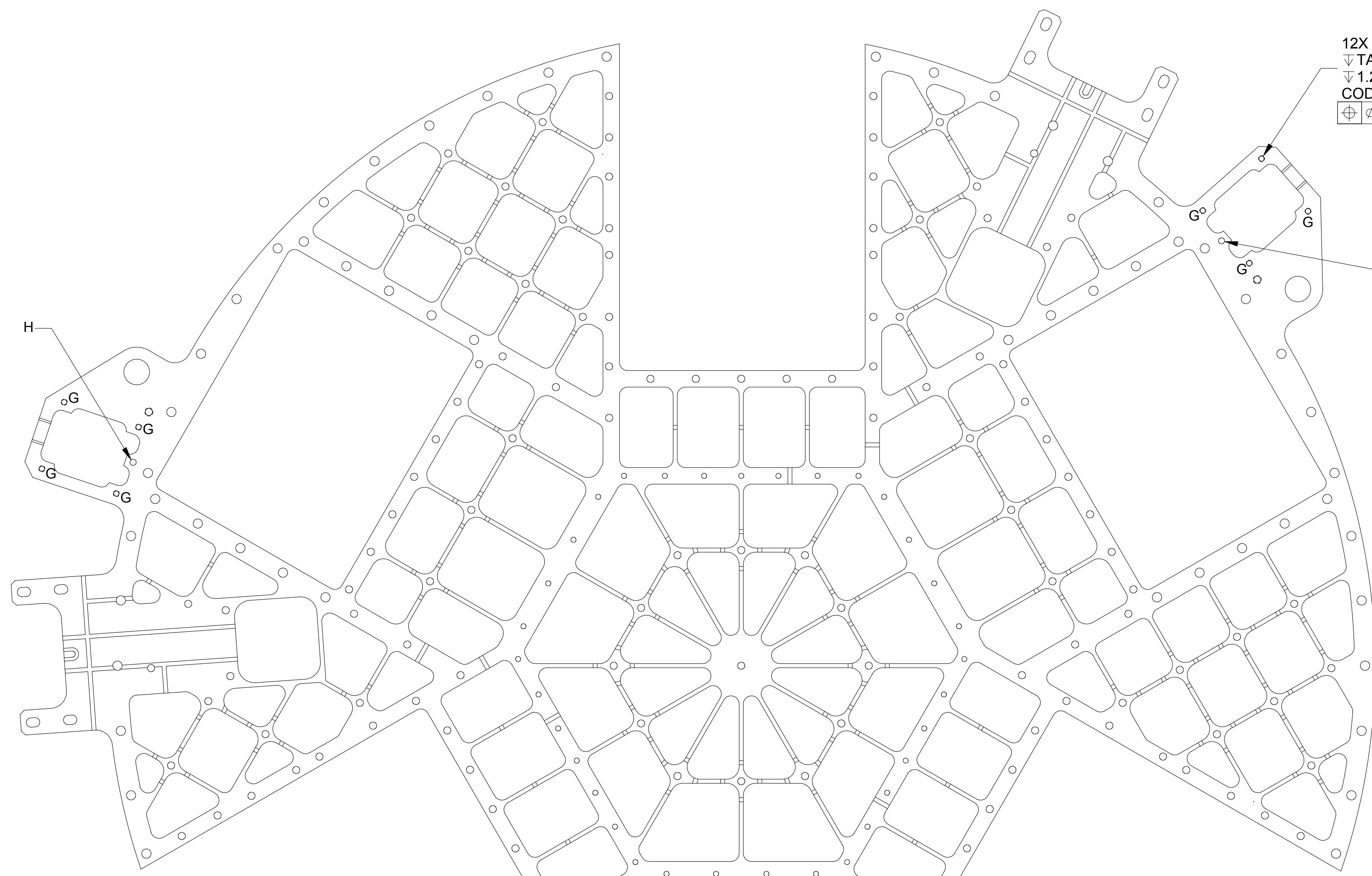
- NOTES: UNLESS OTHERWISE SPECIFIED.
1. THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE, THE MODEL DATABASE WILL TAKE PRECEDENCE.
 2. PART SHALL BE CHECKED USING THE MODEL DATABASE.
 3. A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
 4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
 5. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
 6. 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.
 8. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-0.00.
 9. 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 581.1 LBS.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
6	2			3A054	98380A624	PIN, Ø.3752 X 1.00L		McMASTER CARR	CRES
1	1			20007847-101		OPTICAL TABLE, LOWER		AMS-QQ-A-250/11	AL 6061-T651

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
20007845	1388	DECIMALS	ANGLES	DWN	ENGR
		XX ±.03	XXX ±.010 ±1/2°	KEVIN J SPINK	06/28/04
		MACHINE FINISH	125	STRS	
		DO NOT SCALE DRAWING	INTERPRET DWG PER ASME Y14.5M	MATL	
		MATERIAL	SEE PARTS LIST	THRM	PROJ
		FILE ATTACHMENTS	20007847_x_1	ME	QA

SIZE	CAGE CODE	REV
E	1KNU9	20007847
SCALE 1:4		UNCLASSIFIED

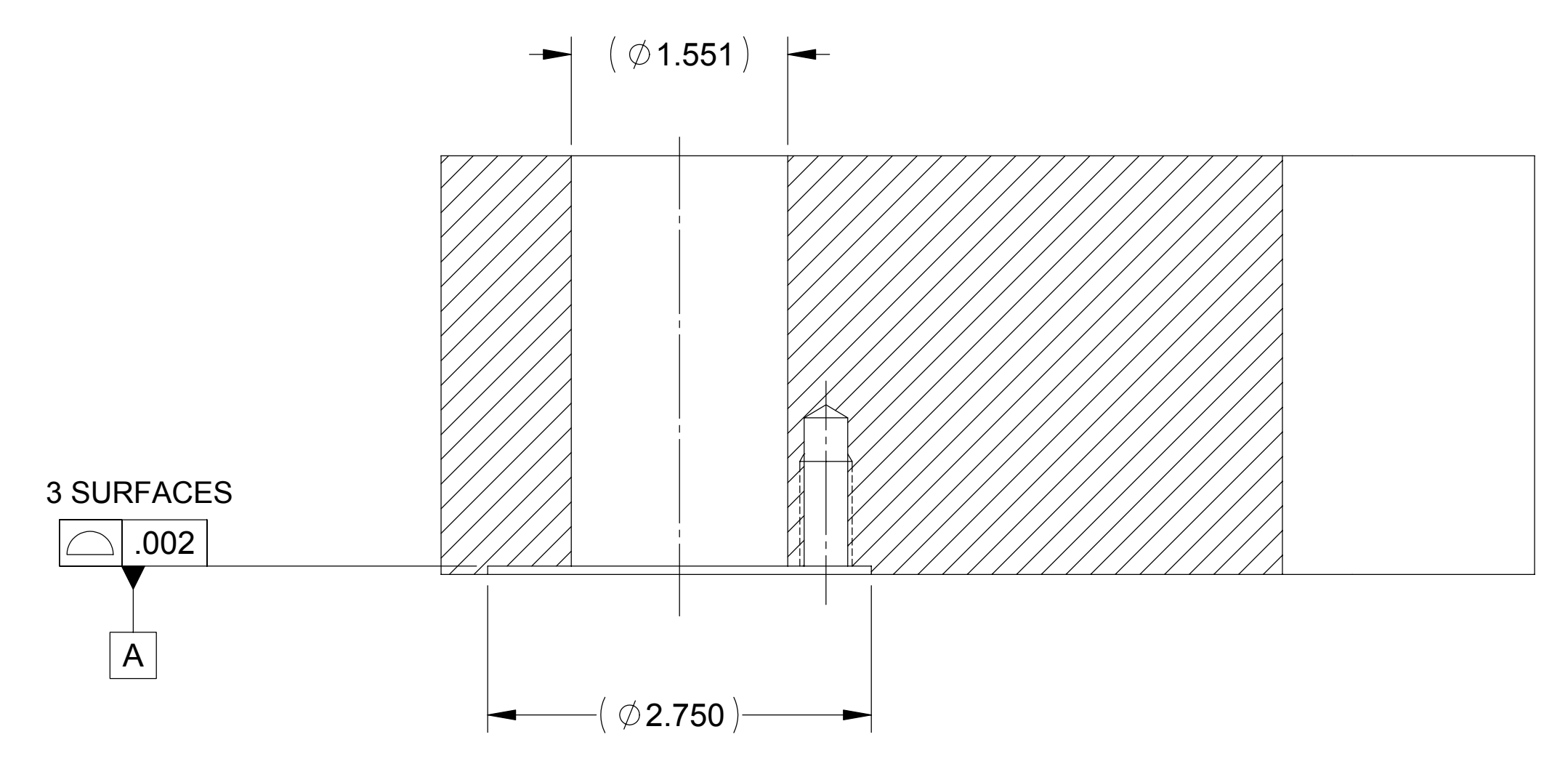
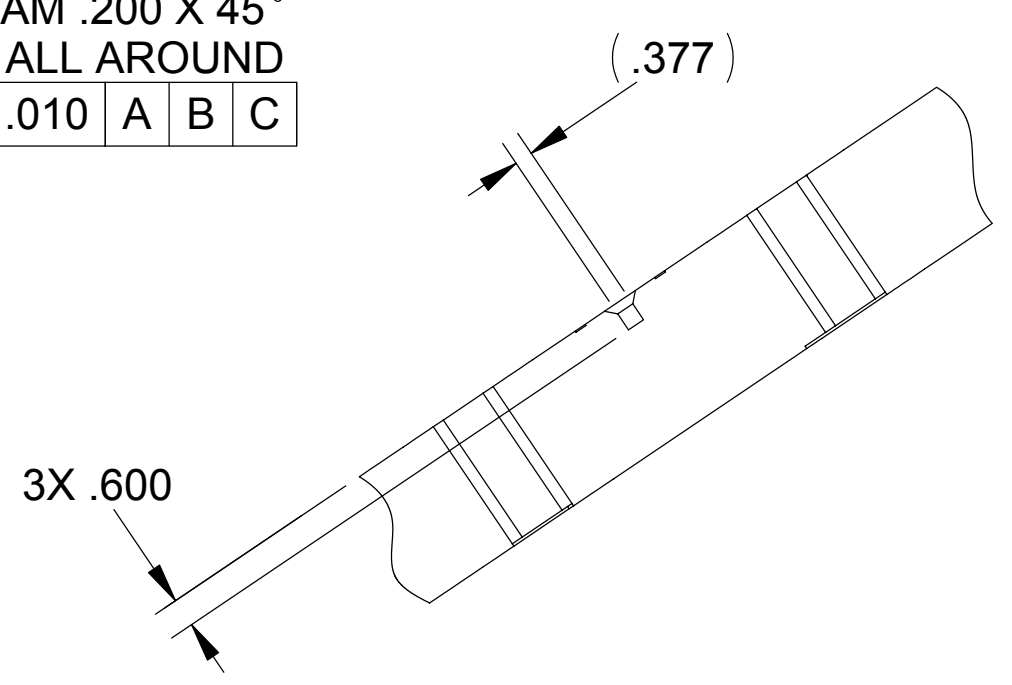


12X .375-16 UNC
TAP DRILL THRU
1.25 MIN FULL THREAD
CODED "G"
⊕ .015 M | A | B | C

2
3X $\phi .3749 \pm .0001$ $\nabla .75$
DRILL THRU $\phi .250 \pm .005$
CODED "H"
⊕ .015 | A | B | C

3X $.377 \pm .001$
CHAM .200 X 45°
ALL AROUND
⊕ .010 | A | B | C

VIEW H-H



SECTION J-J
SCALE 1 : 1