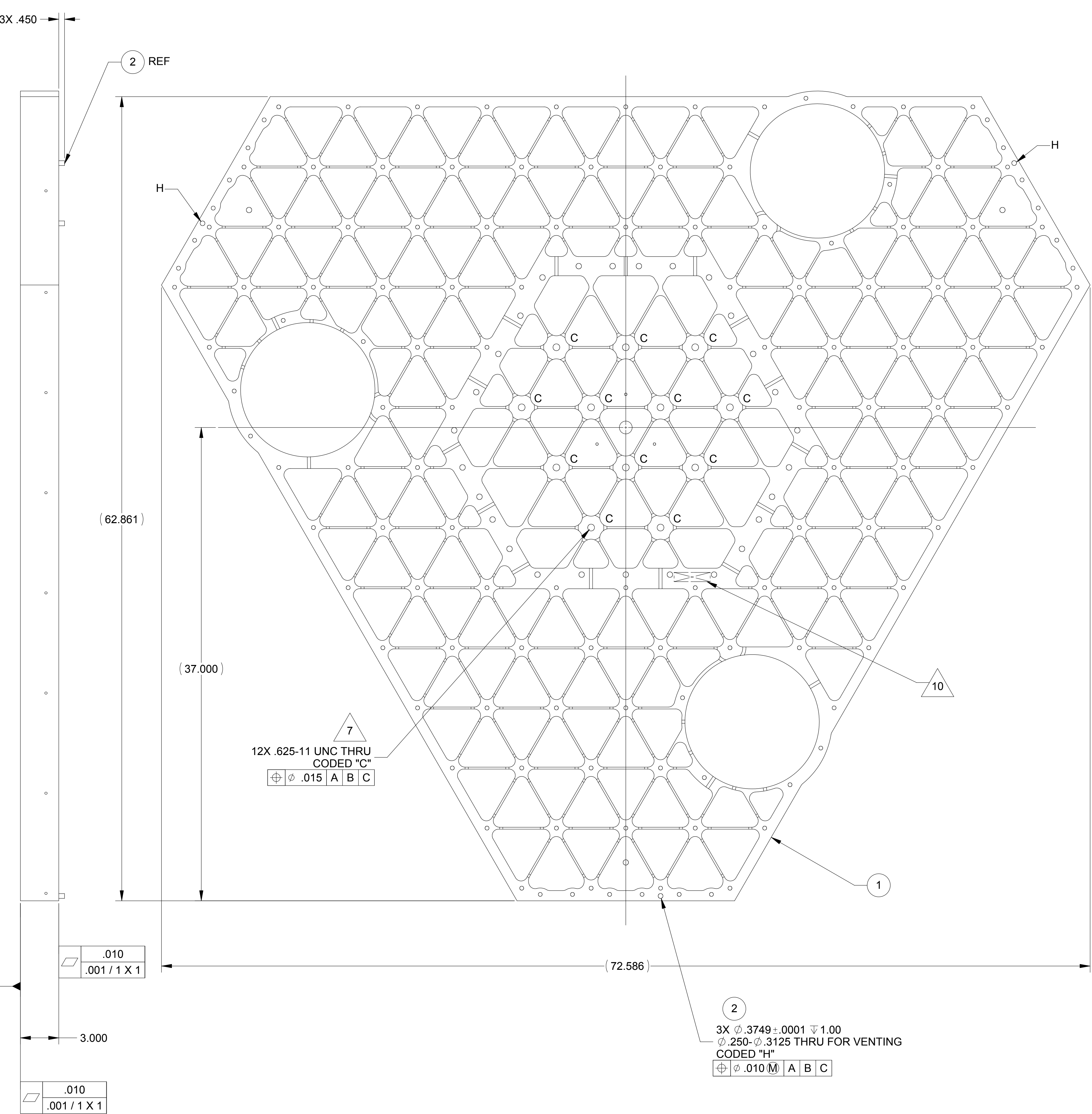
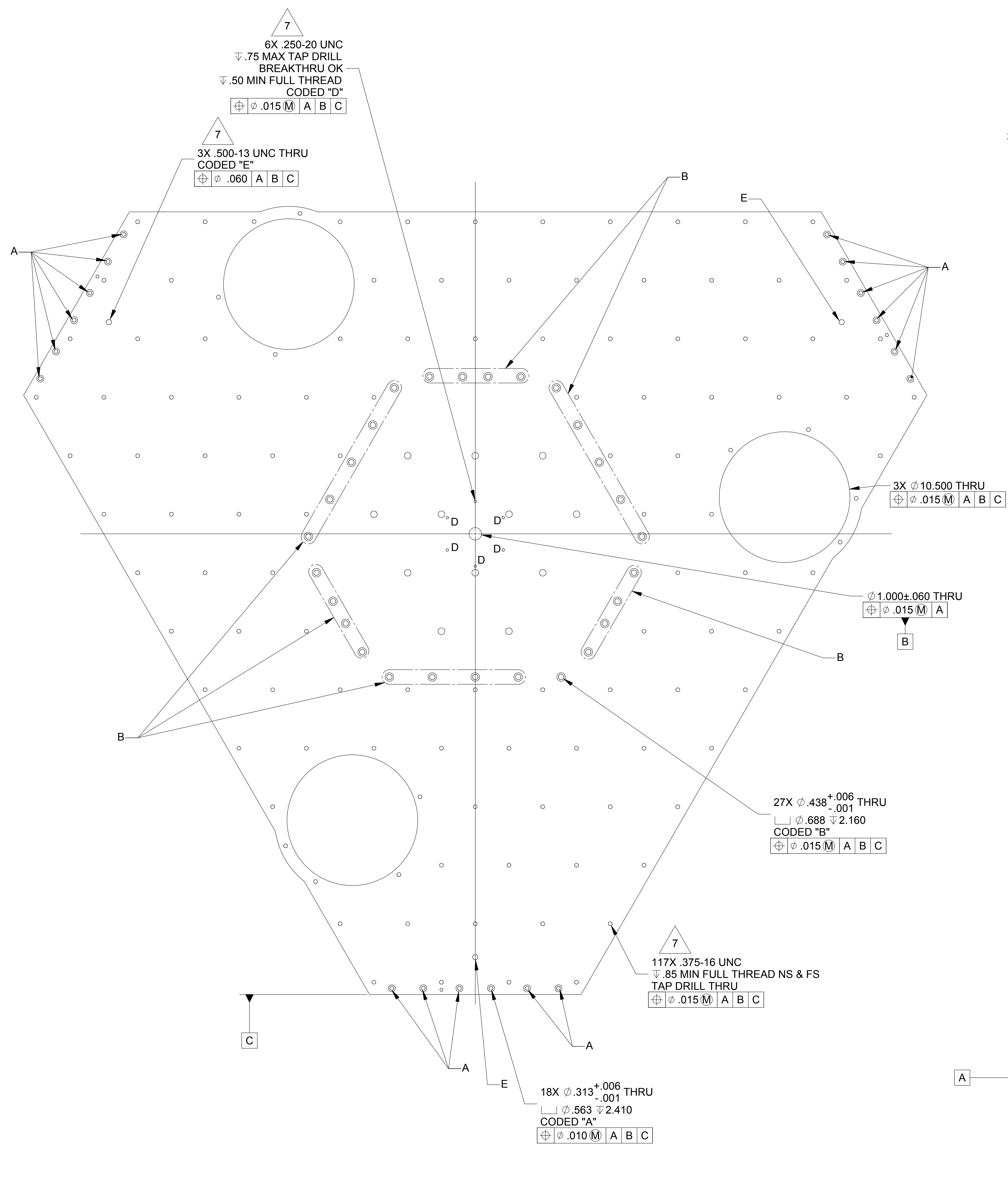


LTR		ZONE		REVISIONS										DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE	
A				INITIAL RELEASE																				



- 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.
  - SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUM(S). A SURFACE PROFILE TOLERANCE OF .025 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.
  - 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 20006686, 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 20006686, TYPE II.
11. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 303.5 LBS.

3	2		3A054	98380A624	PIN, DOWEL Ø.3752 X 1.00 L	McMASTER CARR	CRES																				
1	1			20007848-101	KEEL PLATE	AMS-QQ-A-250/11	AL 6061-T651																				
-1	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE																			
PARTS LIST																											
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES																									
		DECIMALS .XX ±.03 ANGLES .XXX ±.010 ±12° MACHINE FINISH 125																									
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M																									
		MATERIAL SEE PARTS LIST																									
20007845		1388																									
NEXT ASSEMBLY		PROJECT CODE																									
APPLICATION																											
FILE ATTACHMENT		20007848.x_t																									
		<table border="1"> <tr> <td>DWN</td> <td>KEVIN J SPINK</td> <td>06/30/04</td> </tr> <tr> <td>PROJ ENGR</td> <td></td> <td></td> </tr> <tr> <td>STRS</td> <td></td> <td></td> </tr> <tr> <td>MATL</td> <td></td> <td></td> </tr> <tr> <td>ME</td> <td></td> <td></td> </tr> <tr> <td>QA</td> <td></td> <td></td> </tr> </table>								DWN	KEVIN J SPINK	06/30/04	PROJ ENGR			STRS			MATL			ME			QA		
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**asi** ALLIANCE SPACESYSTEMS, INC.  
1250 Lincoln Ave., Suite 100  
Pasadena, CA 91103

**KEEL PLATE - UPPER  
STAGE 2  
LIGO D047848-A**

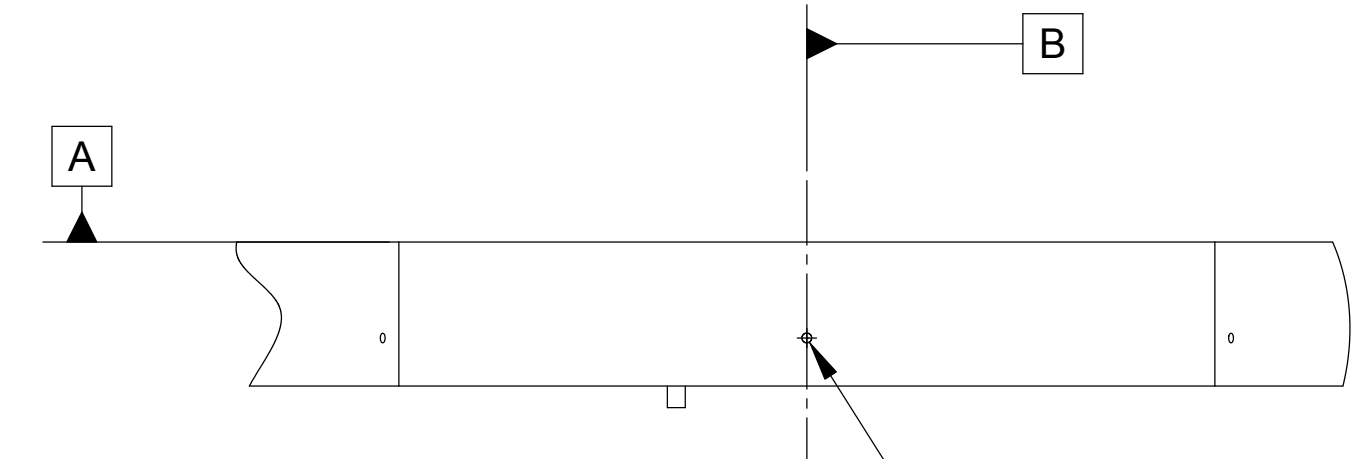
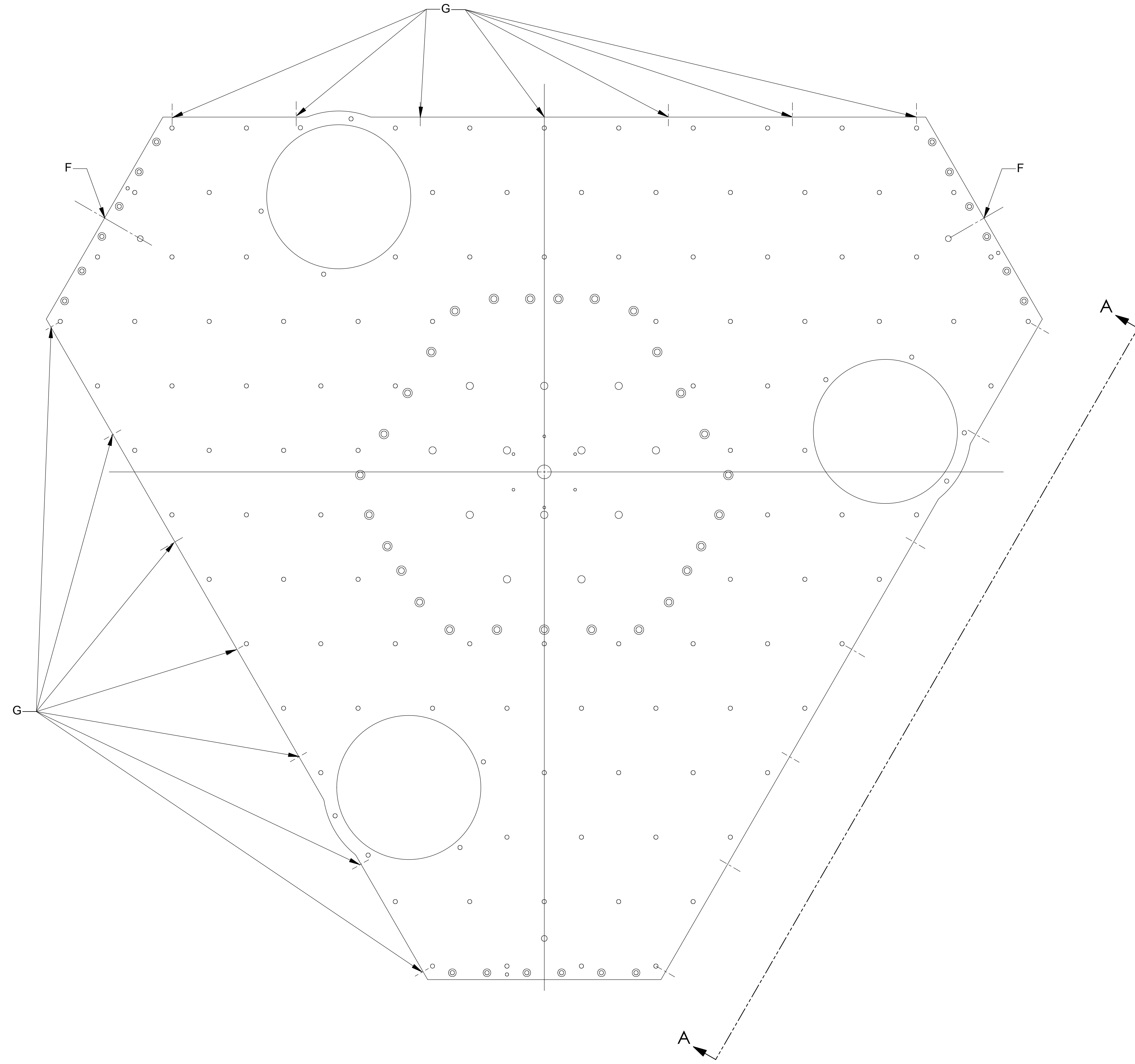
SCALE 1:4

UNCLASSIFIED SHEET 1 OF 2

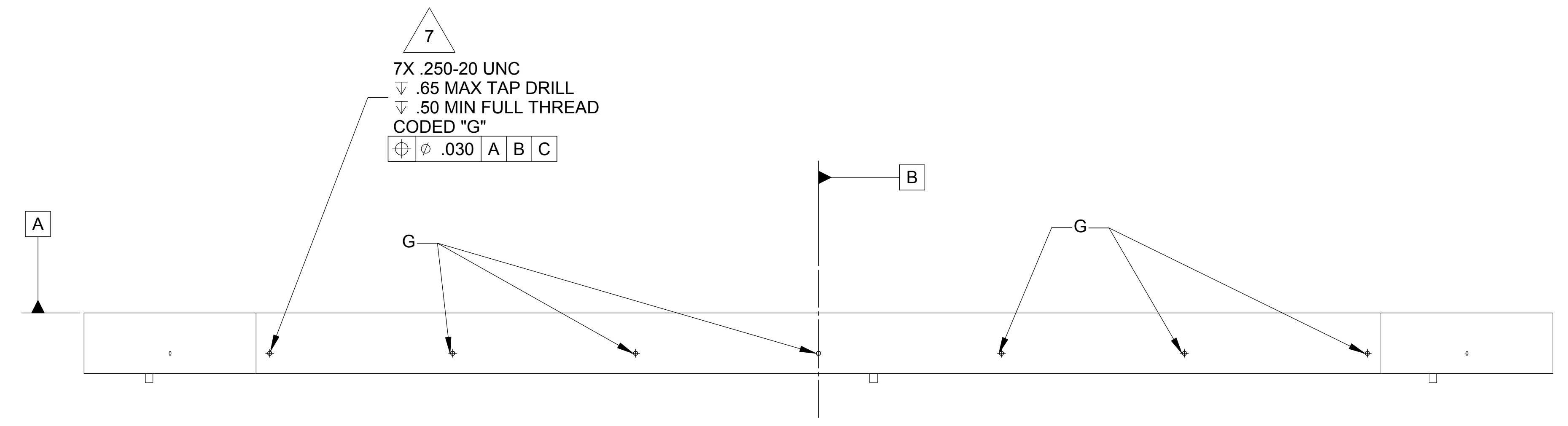
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8 7 6 5 4 3 2 1

H G F E D C B A



7  
3X .250-20 UNC  
▽.65 MAX TAP DRILL  
▽.50 MIN FULL THREAD  
CODED "F"  
⊕⊖ .030 | A | B | C



VIEW A-A  
TYPICAL 3 PLACES  
ROTATED CW 60°

7  
7X .250-20 UNC  
▽.65 MAX TAP DRILL  
▽.50 MIN FULL THREAD  
CODED "G"  
⊕⊖ .030 | A | B | C

NOTES: SEE SHEET ONE

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EXPORT RESTRICTIONS MAY APPLY

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SIZE	CAGE CODE	REV
E	1KNU9	20007848
SCALE 1:4	UNCLASSIFIED	SHEET 2 OF 2

8 7 6 5 4 3 2 1

A B C D E F G H