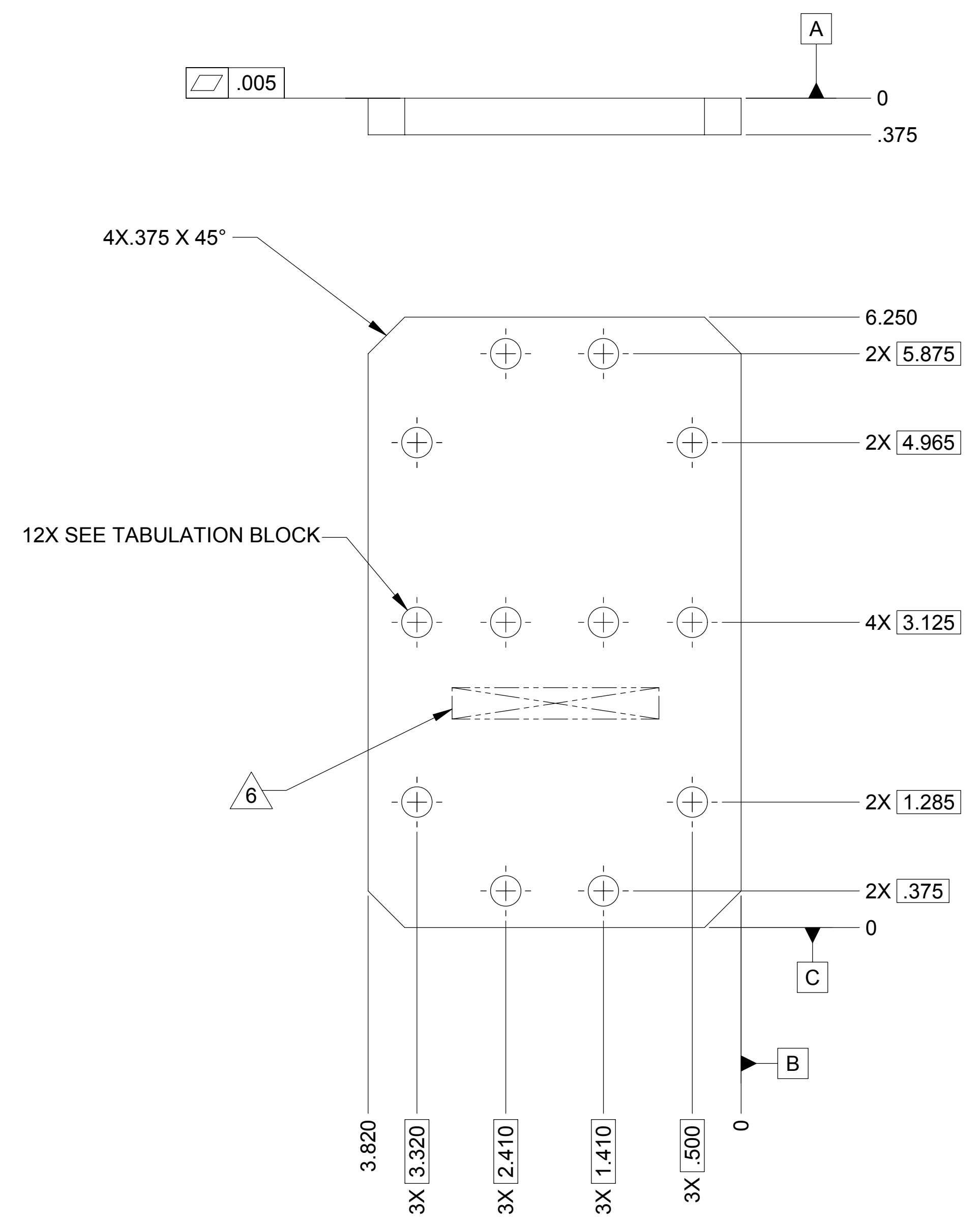


LTR		ZONE		REVISIONS										
				DESCRIPTION	DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A				INITIAL RELEASE										

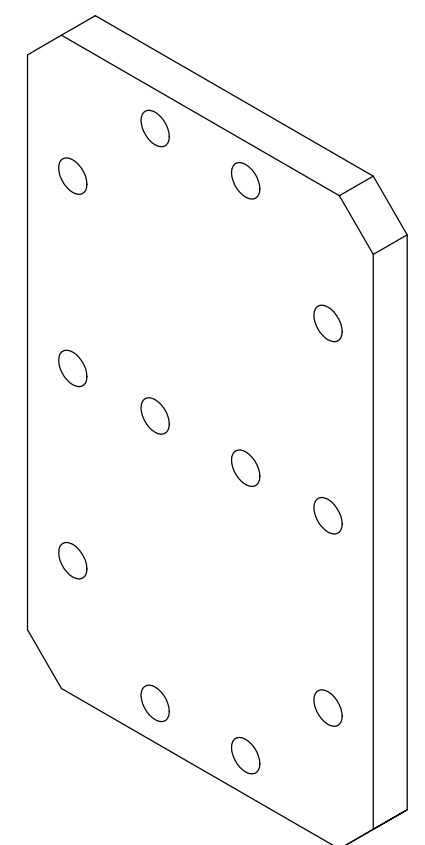
-1 SHOWN



HOLE TABULATION BLOCK		
DASH NO.	HOLE SIZE	POSITIONAL TOLERANCE
-1	$\phi .313 +.006/-0.01$ THRU	$\oplus \phi .015$ (M) A B C
-2	$\triangle 8$.250-20 UNC THRU	$\oplus \phi .015$ A B C

NOTES: UNLESS OTHERWISE SPECIFIED.

- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
- REMOVE ALL BURRS AND SHARP EDGES .005-.015.
- MACHINE FILLET RADII .003-.015.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY 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 THEN PROCEED CONSECUTIVELY. PARTS TOO SMALL TO MARK SHALL BE IDENTIFIED IN ACCORDANCE WITH 20006686, TYPE II.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 0.8 LBS.
- 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.



20007858-2	SPLICE, THREADED
20007858-1	SPLICE, THRU

QTY REQD	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 .XXX ±.010 ANGLES ± 1/2°																						
				MACHINE FINISH 125 ✓																						
				DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M																						
				MATERIAL AL ALY 6061-T651 AMS QQ-A-250/11																						
20007845 1388				<table border="1"> <tr> <td>DWN</td> <td>N. BRAZEAU</td> <td>07/01/04</td> </tr> <tr> <td>PROJ ENGR</td> <td></td> <td></td> </tr> <tr> <td>CHK</td> <td></td> <td></td> </tr> <tr> <td>MATL</td> <td></td> <td></td> </tr> <tr> <td>CONFIG</td> <td>PROJ</td> <td></td> </tr> <tr> <td>ME</td> <td>QA</td> <td></td> </tr> </table>					DWN	N. BRAZEAU	07/01/04	PROJ ENGR			CHK			MATL			CONFIG	PROJ		ME	QA	
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asi ALLIANCE SPACESYSTEMS, INC.
1250 Lincoln Ave., Suite 100
Pasadena, CA 91103

**HEX WALL SPLICE, KEEL
STAGE 2
LIGO-D047858-A**

20007858

THIS DOCUMENT MAY CONTAIN ITAR CONTROLLED INFORMATION AND/OR COMMERCE CONTROLLED INFORMATION EXPORT RESTRICTIONS MAY APPLY

FILE ATTACHMENTS	
	20007858-1.x_t
	20007858-2.x_t

RELEASED
1/24/2005