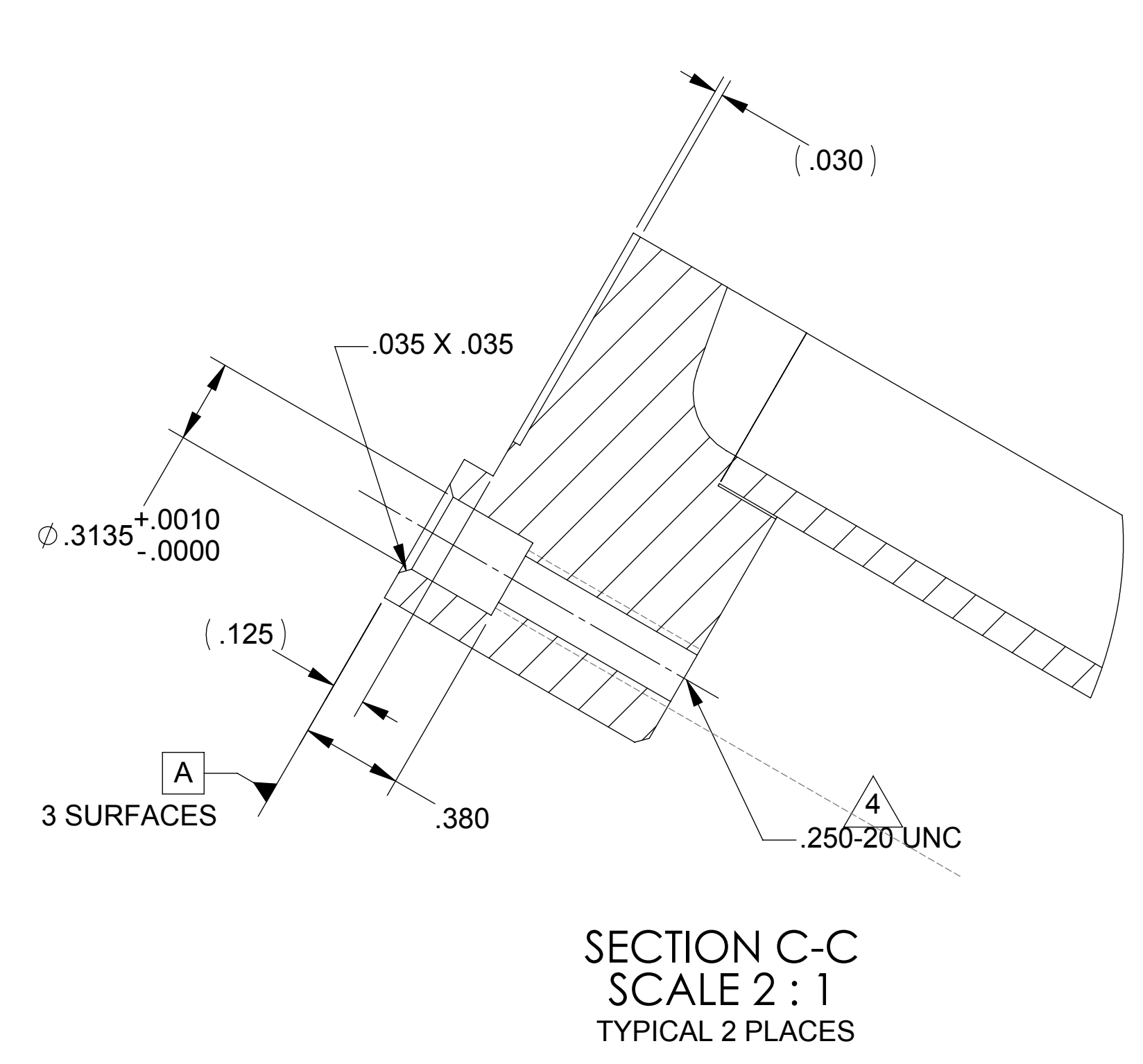
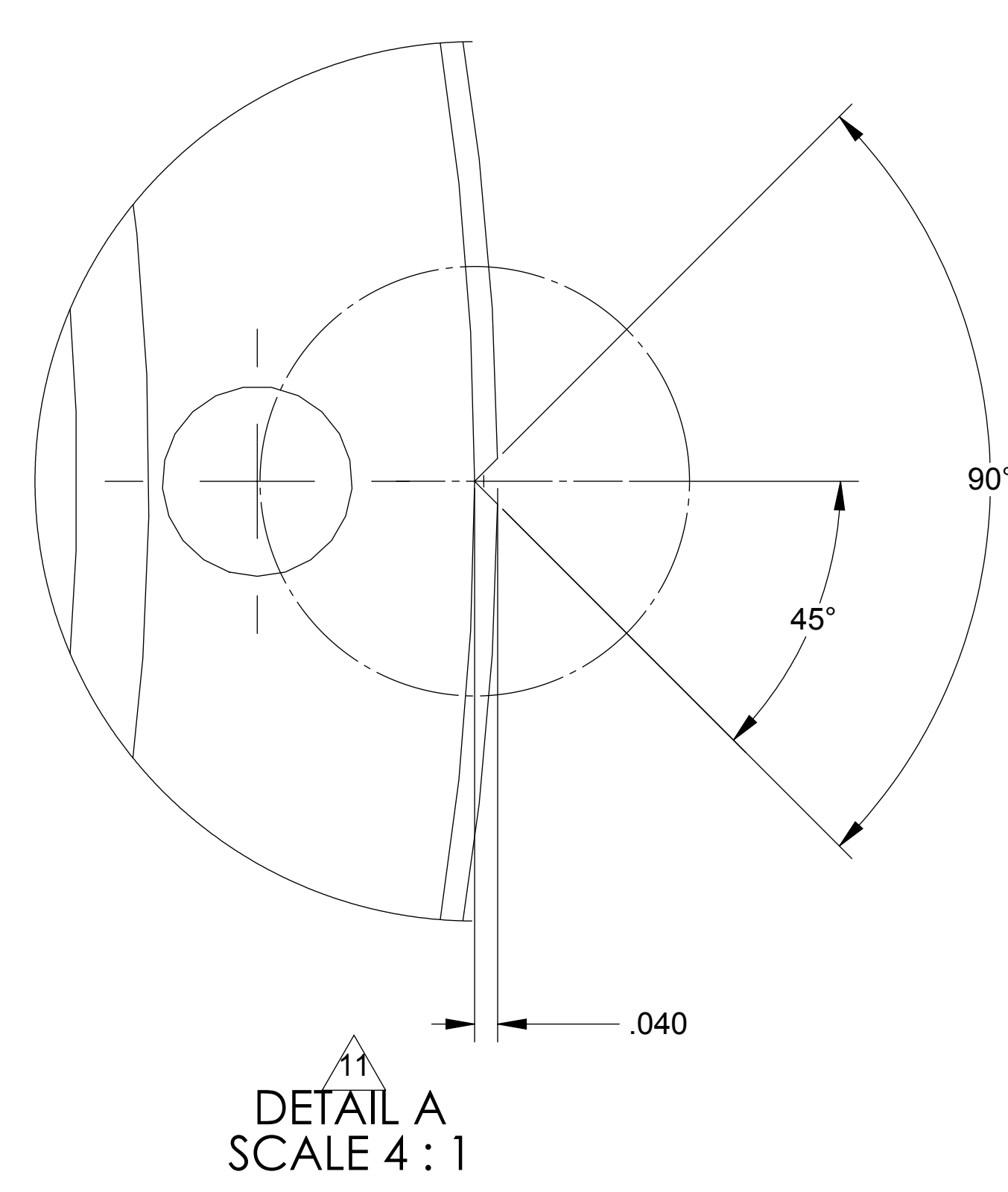
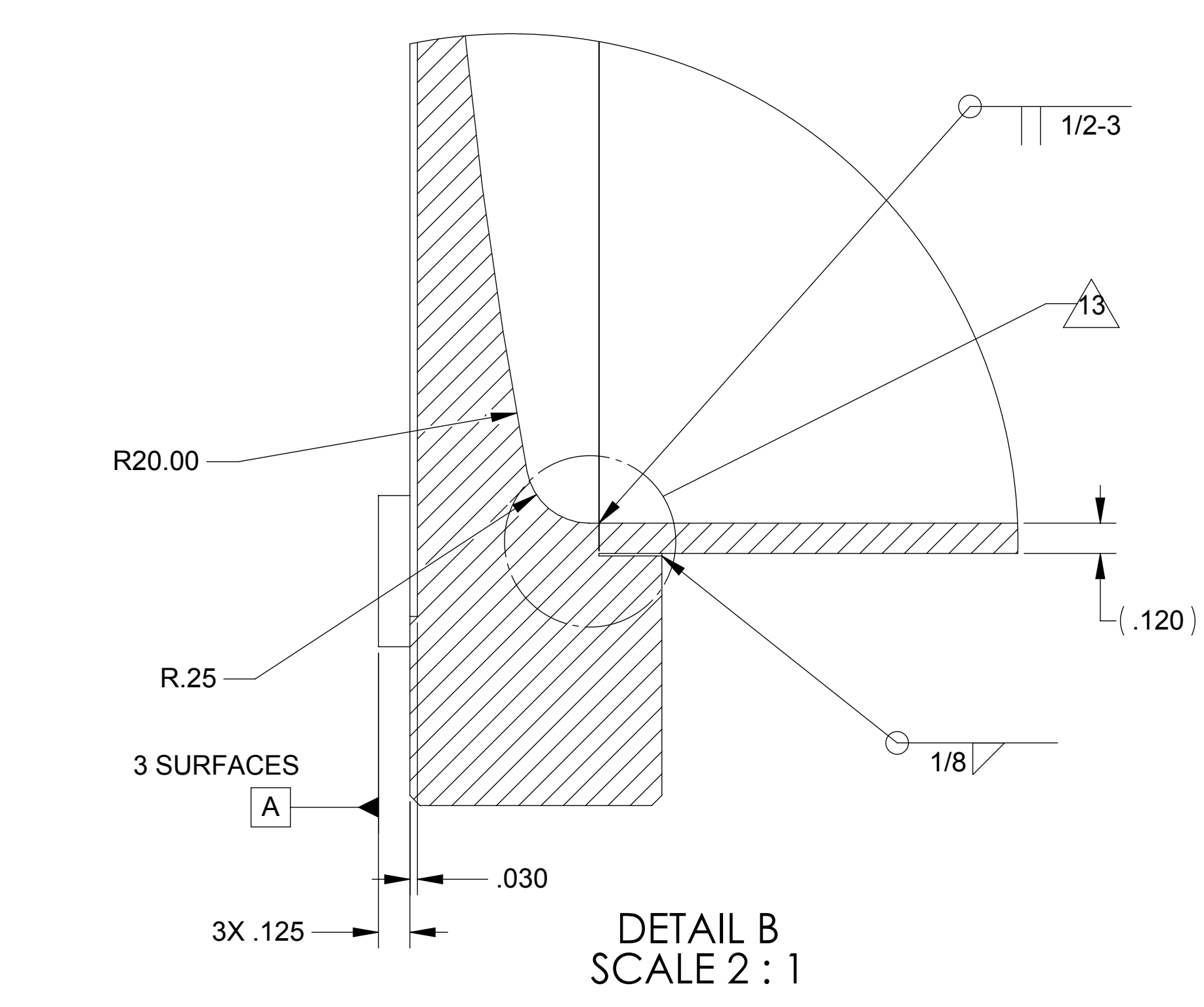
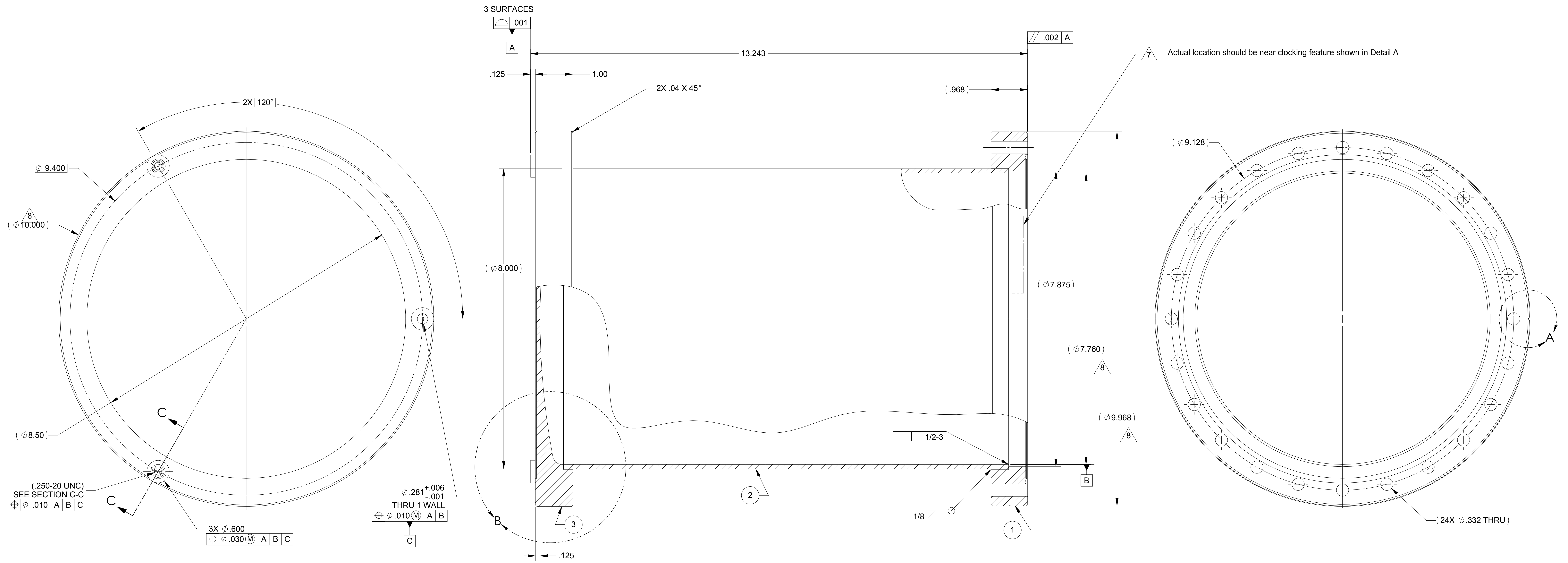


LTR		ZONE		REVISIONS										DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A				INITIAL RELEASE																				
minor changes to notes on 5/19/09- changed notes to satisfy LIGO rather than ASI procurement																								



- NOTES: UNLESS OTHERWISE SPECIFIED.
- 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.
  - COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/- .000.
  - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
  - WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE (VIBRATORY ACCEPTABLE) THE FOLLOWING INFORMATION AS SHOWN BELOW: LIGO P/N-REVISION-TYPE, FOLLOWED ON THE NEXT LINE BY "S/N-" AND A THREE DIGIT SERIAL NUMBER, STARTING AT 100, AND PROCEEDING CONSECUTIVELY. USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER.

- FEATURES THAT ARE REFERENCED OR UNDIMENSIONED ARE SPECIFIED BY THE MANUFACTURER.
- REFERENCE MATING PART DRAWING 20007813.
- ELECTROPOLISH TUBES PRIOR TO WELDING PER BEST COMMERCIAL PRACTICE.
- PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- ALL WELDS ARE GTAW.
- JOINT CONFIGURATION TO BE DETERMINED BY MANUFACTURER.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 29.7 LBS.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
1	3				20007812-103	TOP		CRES 304 PER ASTM A167	
1	2				20007812-102	TUBING, .120 WALL Ø 8.00	SST-800 (CRES 304)		
1	1				20007812-1	BASE, CF FLANGE 10.00	1000-800N (CRES 304)		

CONTRACT NO	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES	RELEASED 2/22/2005	ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103
	DECIMALS .XX ± .03 ANGLES XXX ± .010 ± 15°		
	MACHINE FINISH 125	DWN R.D.BILLING 02/23/04	CHAMBER, TOP MOUNT GS-13 SEISMOMETER LIGO-D047812-A
	DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994	PROJ ENGR STRS	SIZE E CAGE CODE 1KNU9
		CHK MATL	SCALE 1:1 UNCLASSIFIED SHEET 1 OF 1
		CONFIG PROJ	20007812
		ME QA	REV A

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