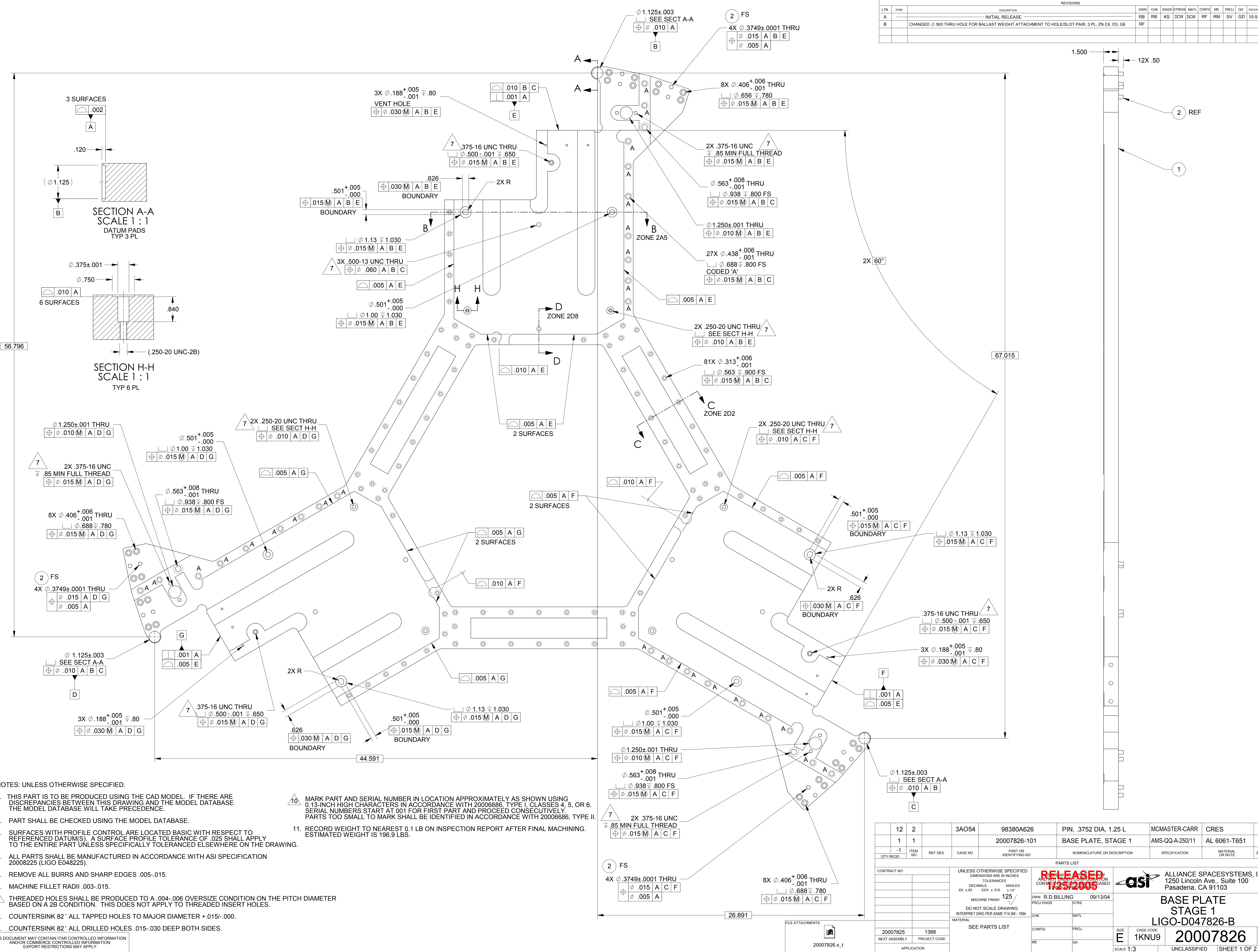


REVISIONS		DWN	CHK	ENGR	STRESS	MATL	CONFIG	ME	PROJ	QA	RELEASE DATE
A	INITIAL RELEASE	RB	RB	KS	DCW	DCW	RF	RM	SV	GD	10-5-2004
B	CHANGED Ø.563 THRU HOLE FOR BALLAST WEIGHT ATTACHMENT TO HOLE/SLOT PAIR, 3 PL, 2Z C6, D3, G6	RF									



- 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/-0.00.
 - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
 - 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.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 196.9 LBS.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
12	2			3AO54	98380A626	PIN, .3752 DIA, 1.25 L	MCMASPER-CARR	CRES	
1	1			20007826-101		BASE PLATE, STAGE 1	AMS-QQ-A-250/11	AL 6061-T651	

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
20007825	1388	TOLERANCES	DECIMALS	ANGLES	MACHINE FINISH
		.XX ± .03	.XXX ± .010	± 15°	125/
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994			
		MATERIAL	SEE PARTS LIST		

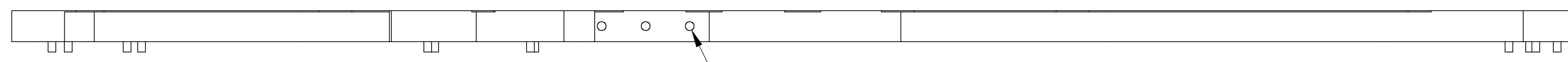
RELEASED 12/5/2005

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

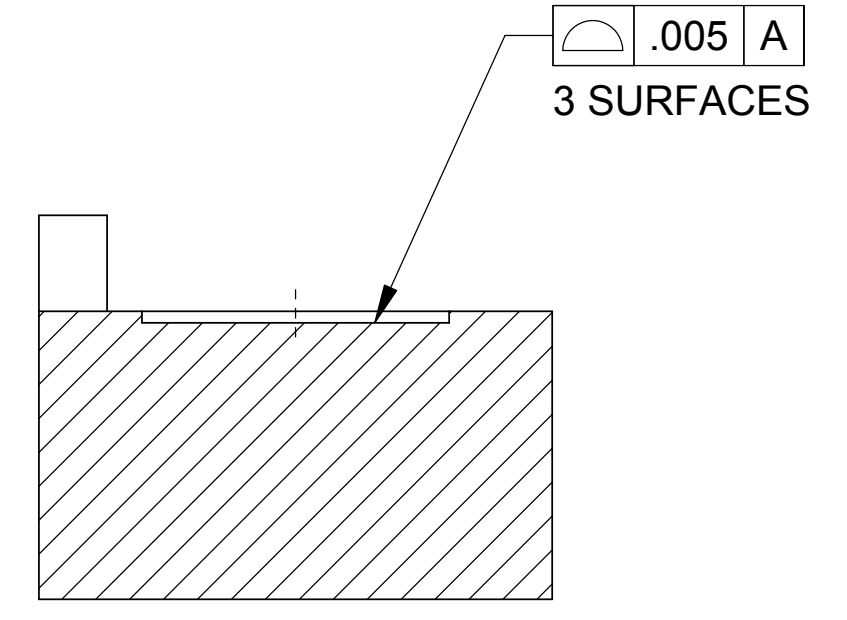
BASE PLATE STAGE 1 LIGO-D047826-B

REV B

SCALE 1:3 UNCLASSIFIED SHEET 1 OF 2



3X .500-13 UNC
▽ 1.35 MIN FULL THREAD
⊕ .015 M | E | A | B

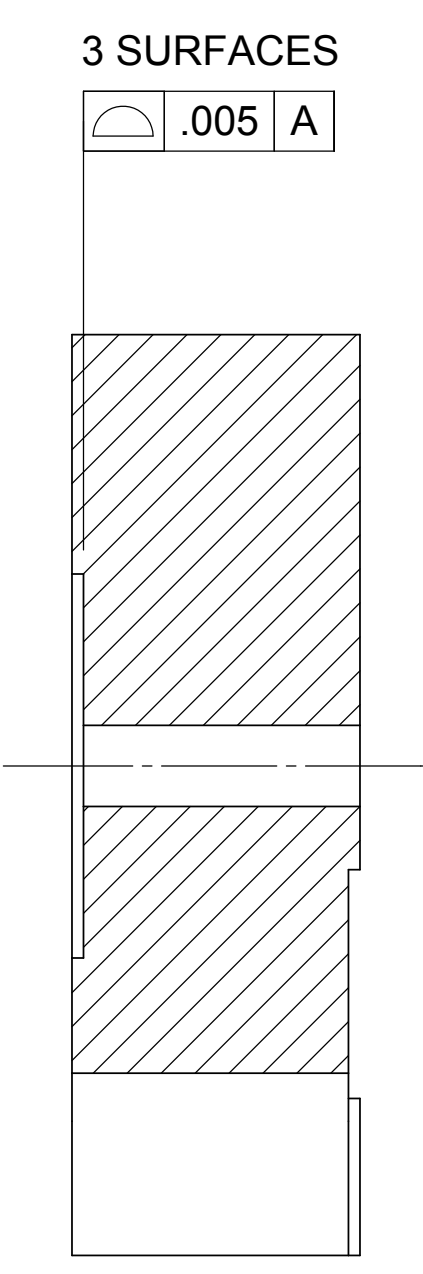


SECTION J-J
SCALE 1:1
BACK SIDE
DATUM PADS
3 PL

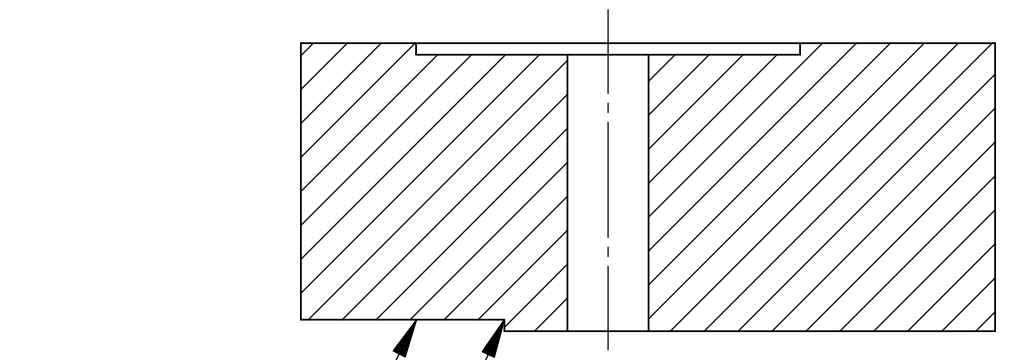
3X \perp ϕ 1.600 ± .030
▽ SEE SECT J-J
⊕ .030 M | A | B | C

3X .500-13 UNC
▽ .75 MIN FULL THREAD
⊕ .015 M | A | B | C

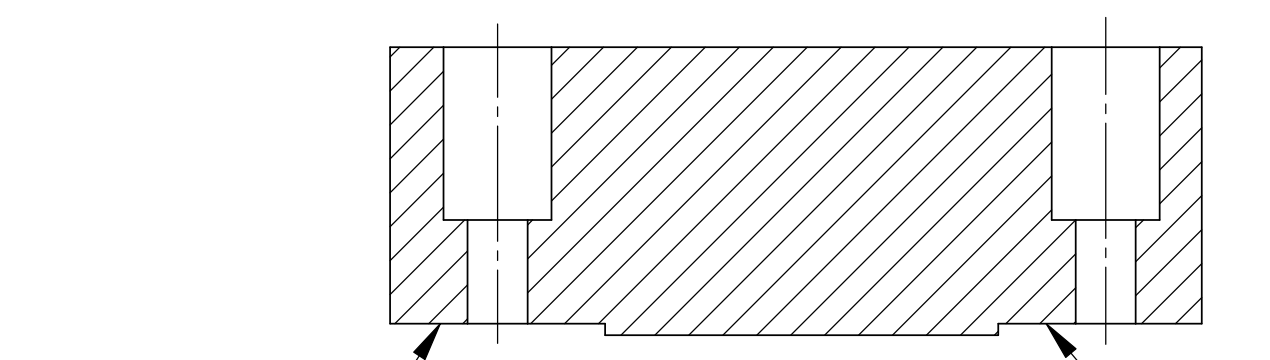
3X \perp ϕ 2.00
▽ SEE SECT K-K
⊕ .030 M | A | B | C



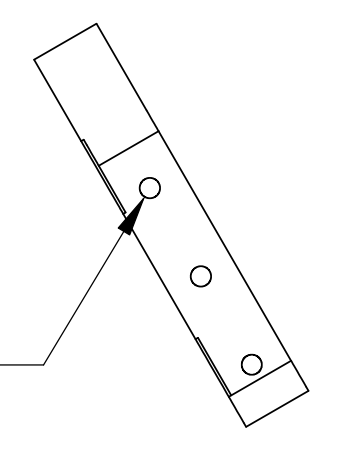
SECTION K-K
SCALE 1:1
TYP 3 PL



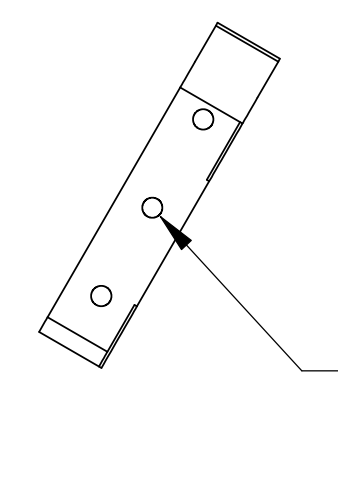
SECTION D-D
SCALE 1:1
ZONE 1F5
TYP 3 PL



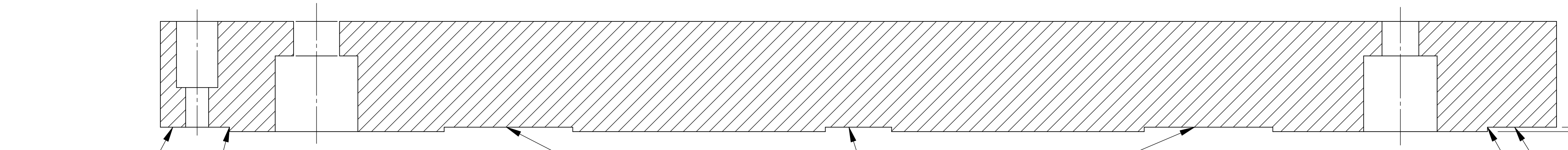
SECTION C-C
SCALE 1:1
ZONE 1E4
TYP 3 PL



VIEW E-E



VIEW F-F



SECTION B-B
SCALE 1:1
ZONE 1G4
TYP 3 PL