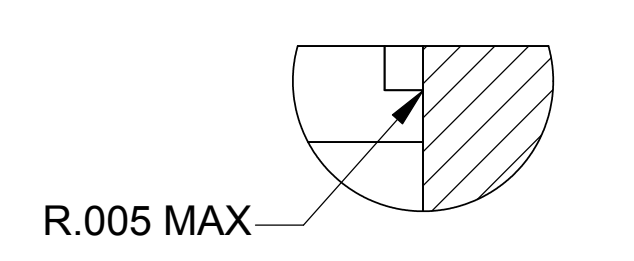
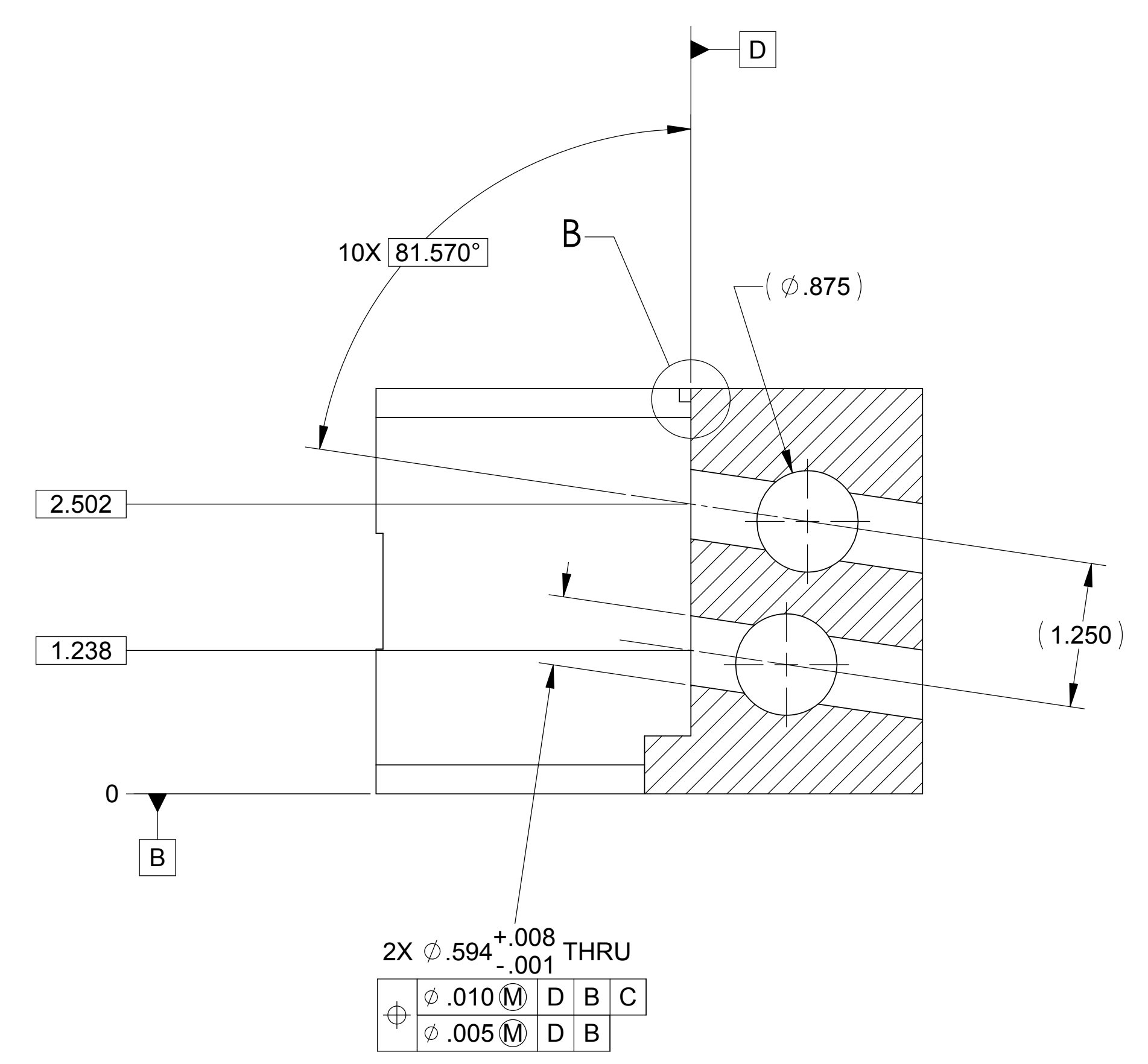
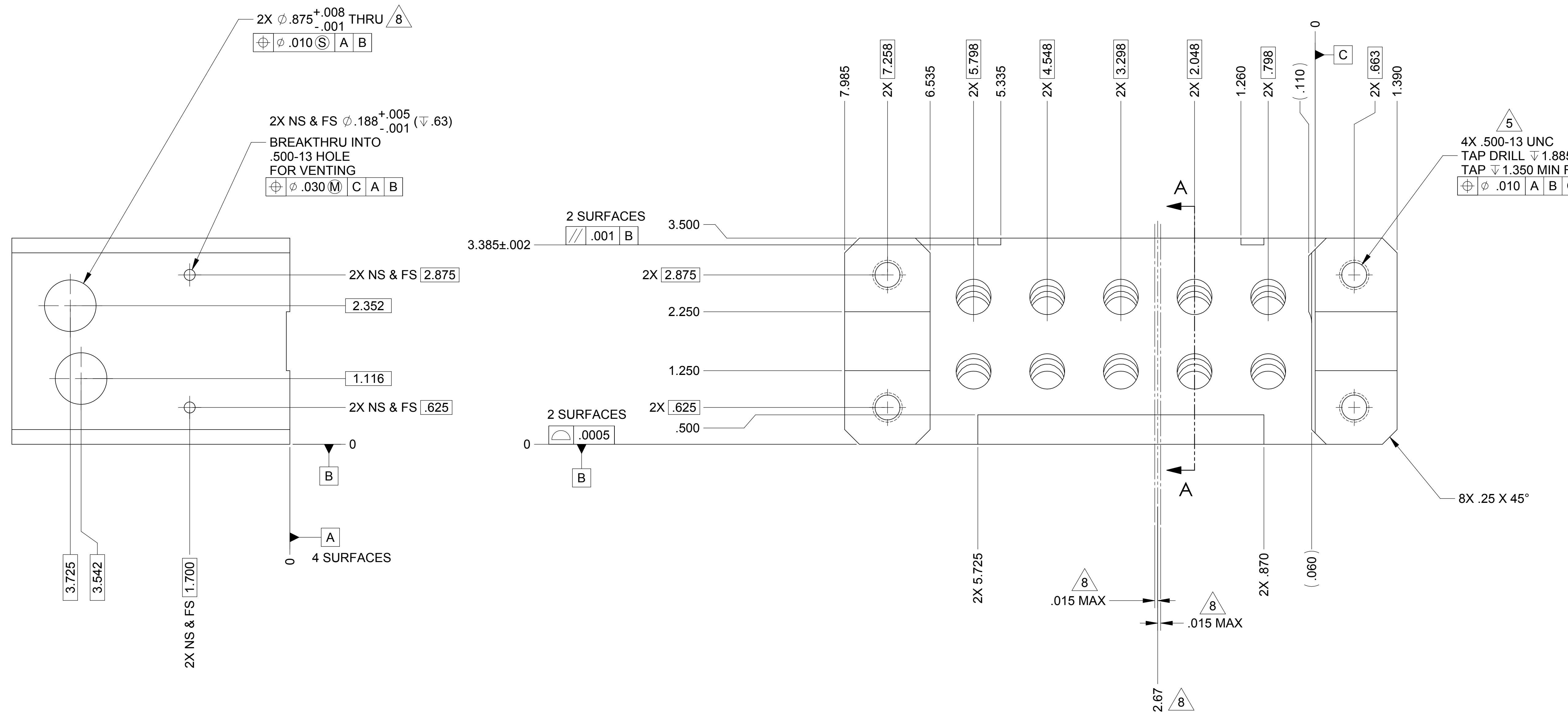
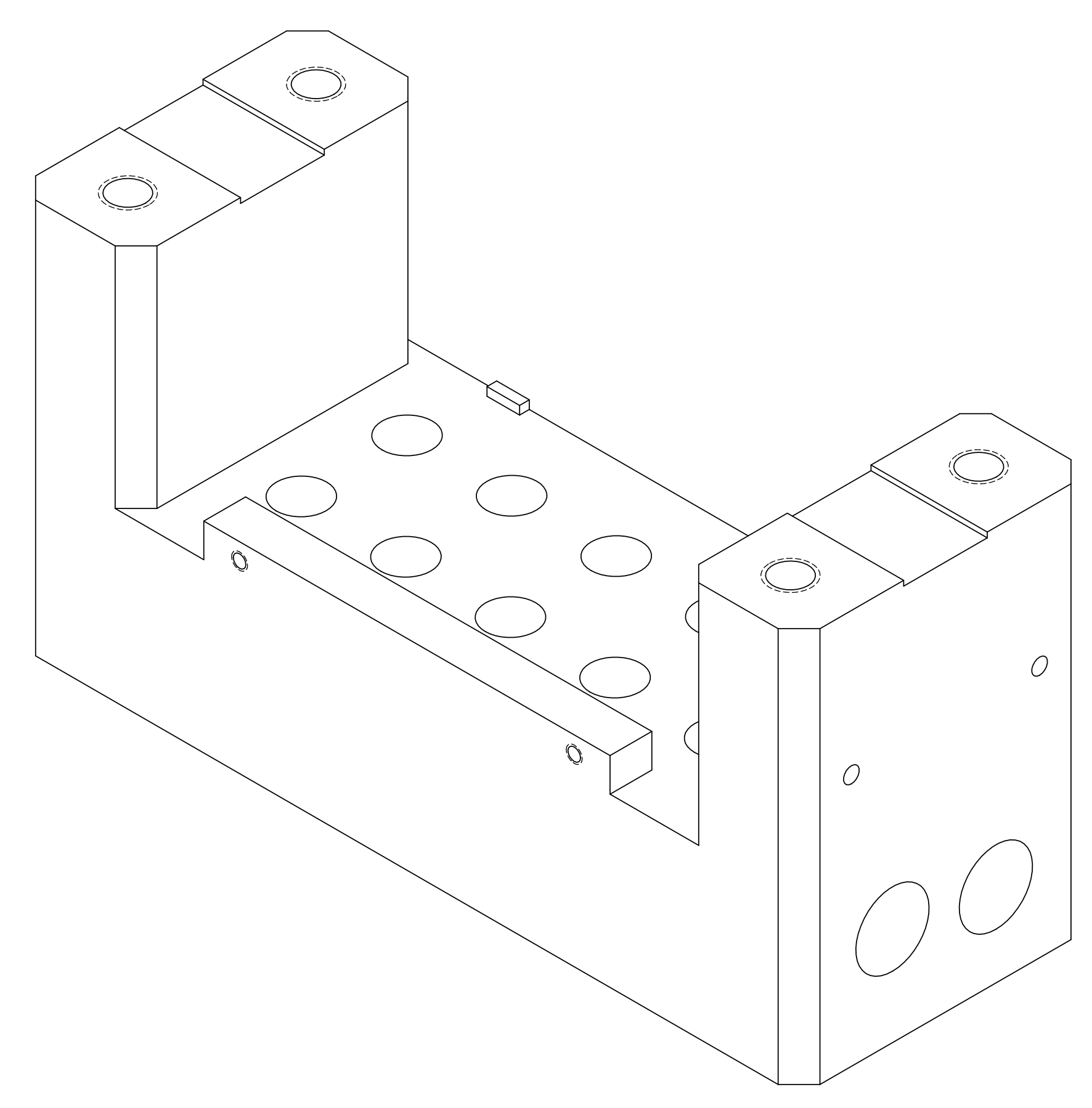
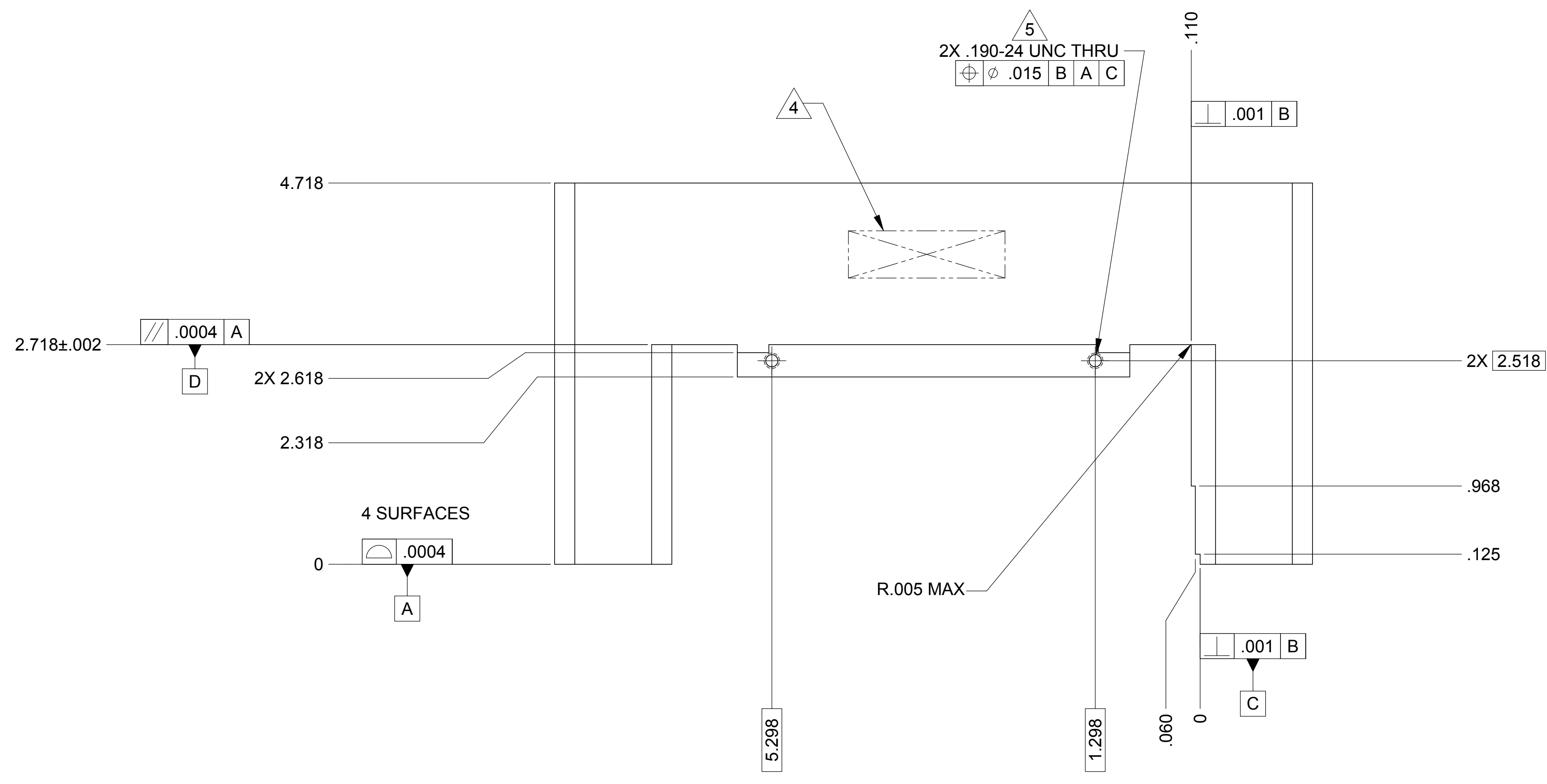


LTR		ZONE		REVISIONS									
				DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A				INITIAL RELEASE									



- 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.
 - 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.
 - 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/- .000.
 - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
 - PART MAY BE BORED FROM OPPOSITE SIDES. IF PART IS BORED FROM OPPOSITE SIDES .010 MIS-MATCH IS ALLOWABLE BUT MUST OCCUR WITHIN THE ZONE INDICATED.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 7.5 LBS.

QTY		REGD	ITEM NO	REF DES	CAGE NO	20007892-1	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		ANGLES		MACHINE FINISH	
		.XX ±.03		.XXX ±.010		±.12°		63		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994	
MATERIAL		AL 7075-T651		AMS-QQ-A-250/12		DWN		R.D.BILLING		07/26/04	
20007890		1388		20007890		1388		PROJ		1388	
NEXT ASSEMBLY		PROJECT CODE		APPLICATION		SIZE		CAGE CODE		REV	
						E		1KNU9		A	
						SCALE		1:1		UNCLASSIFIED SHEET 1 OF 1	

RELEASED
2/25/2005

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

STAGE 1-2 BLADE SPRING SADDLE
LIGO-D047892-A

20007892

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