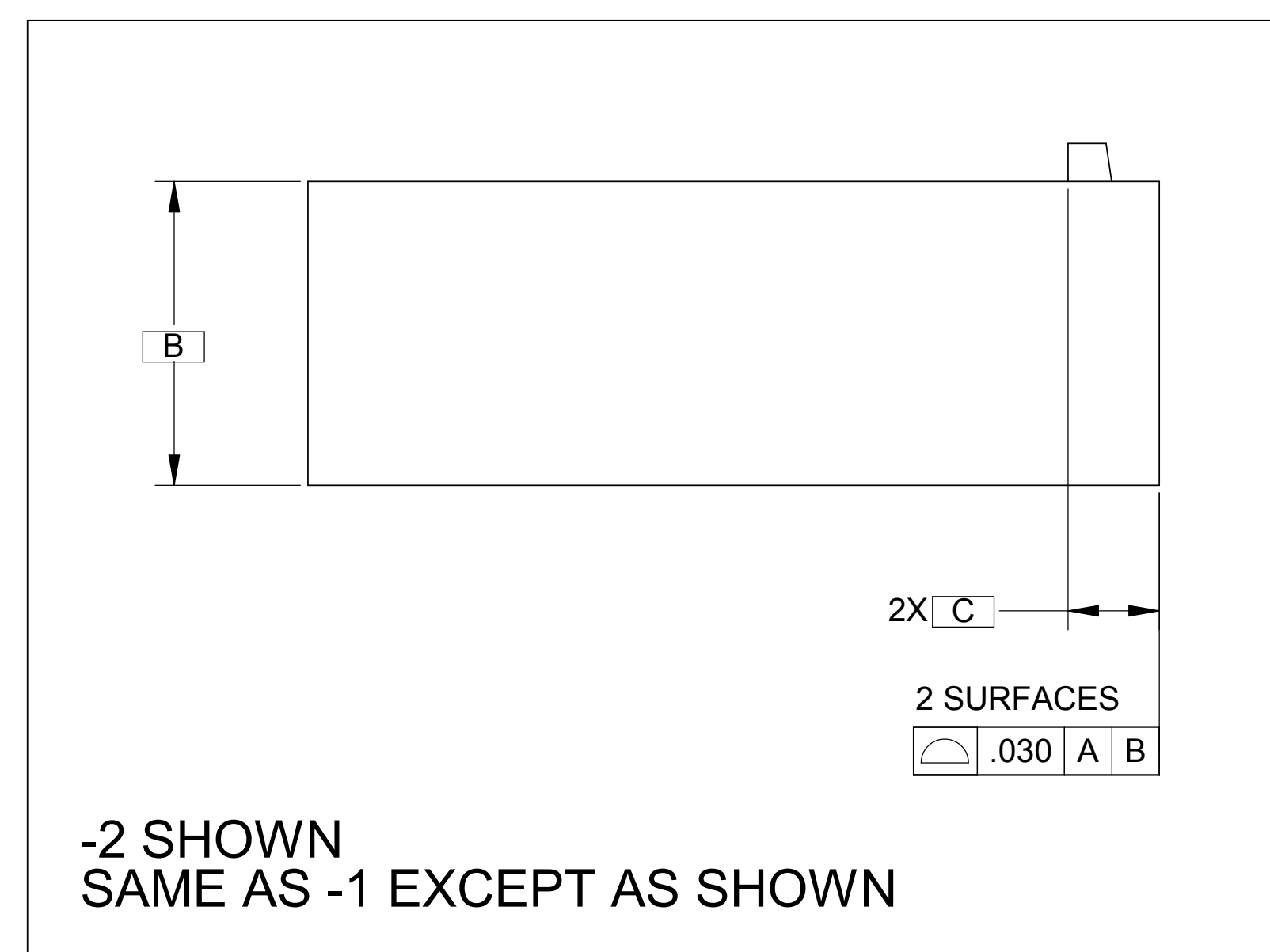
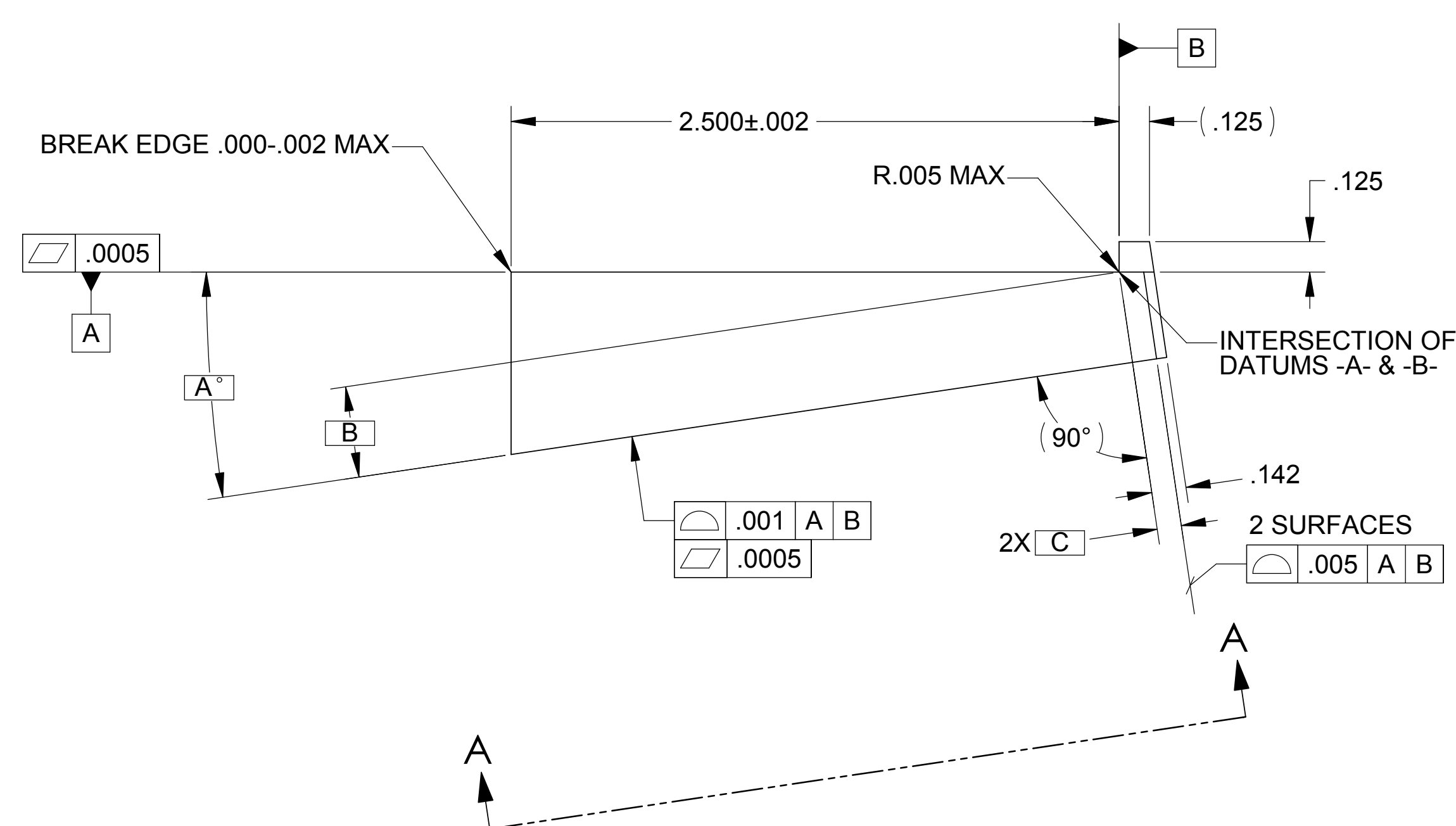
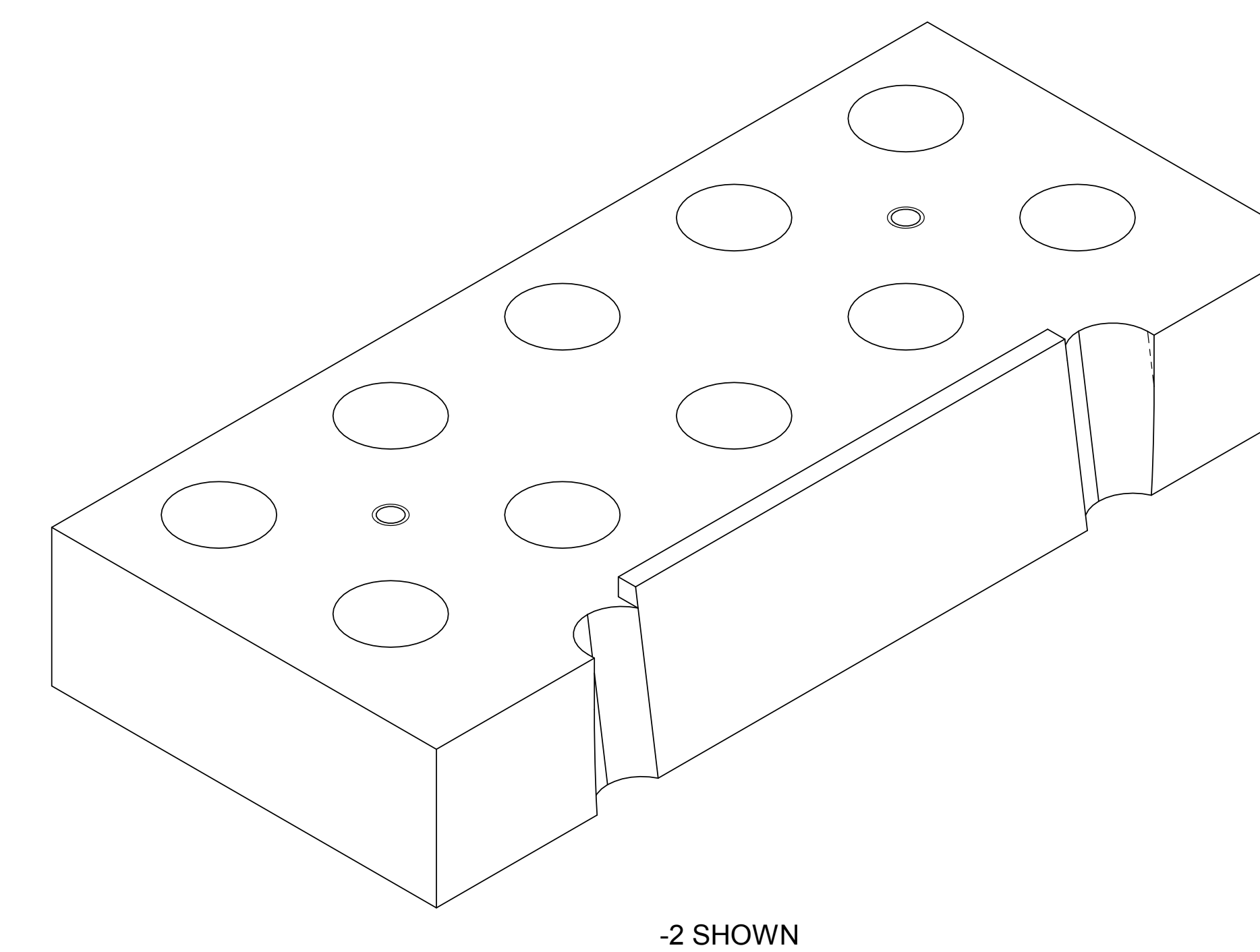
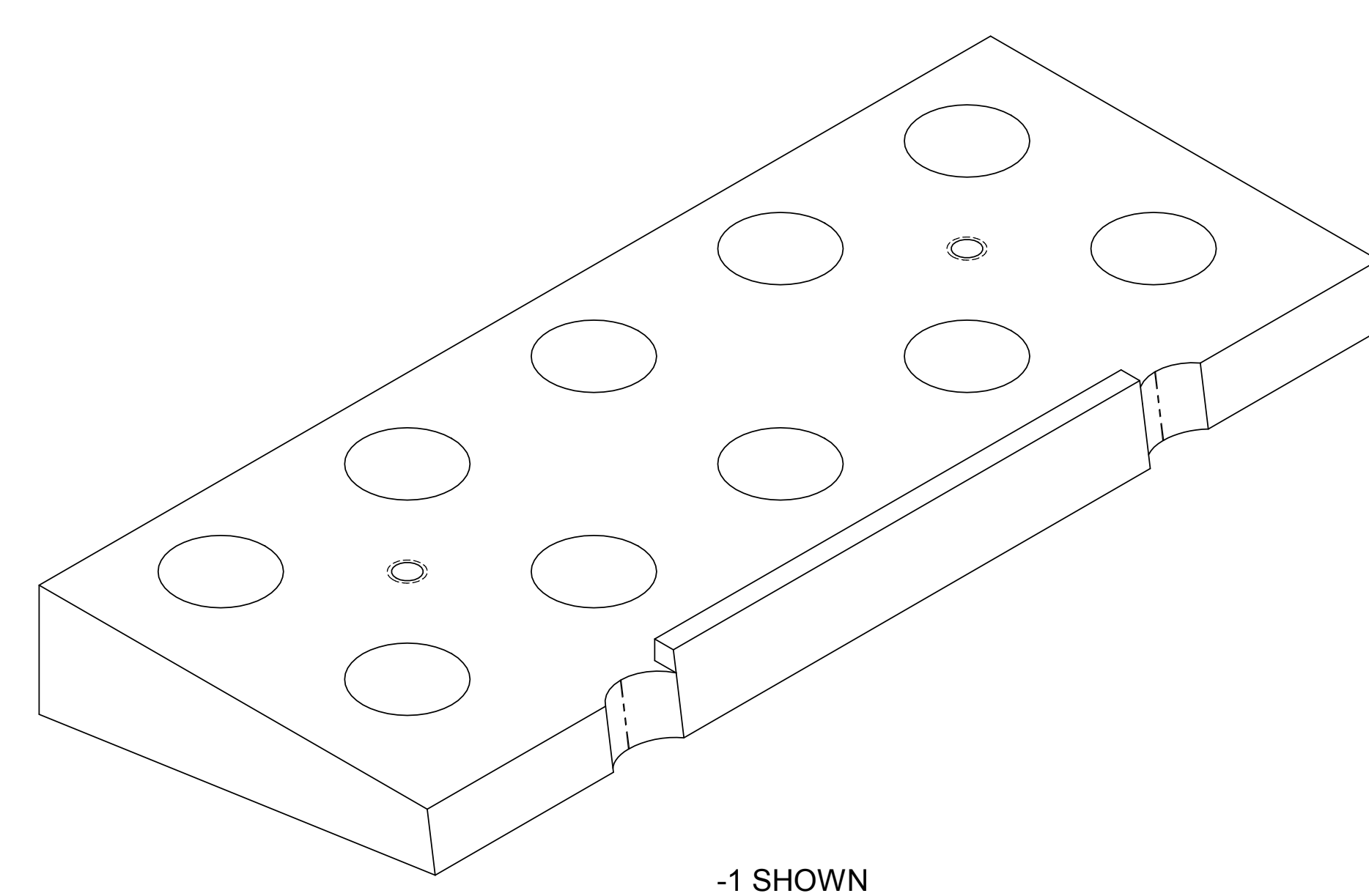
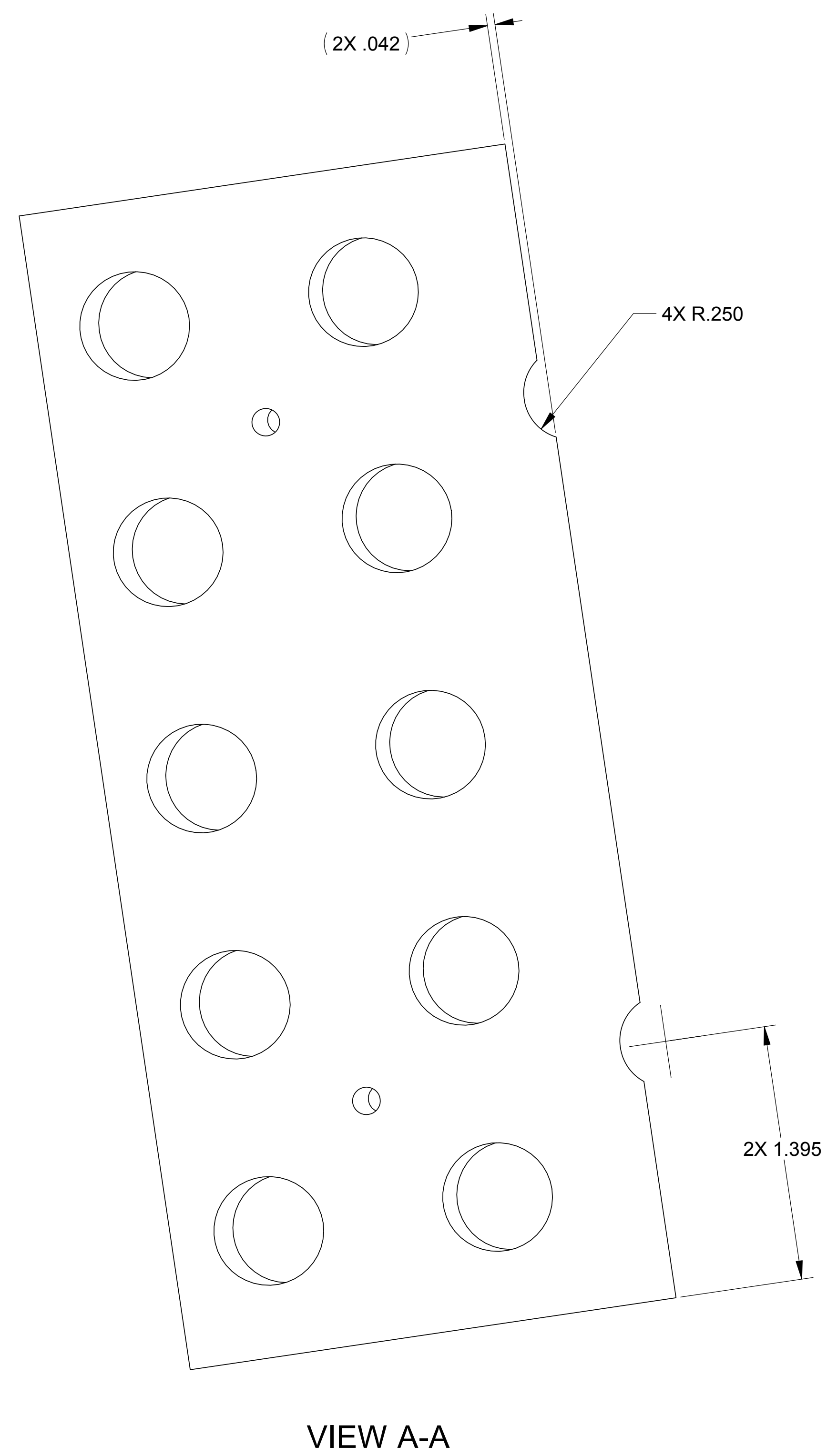
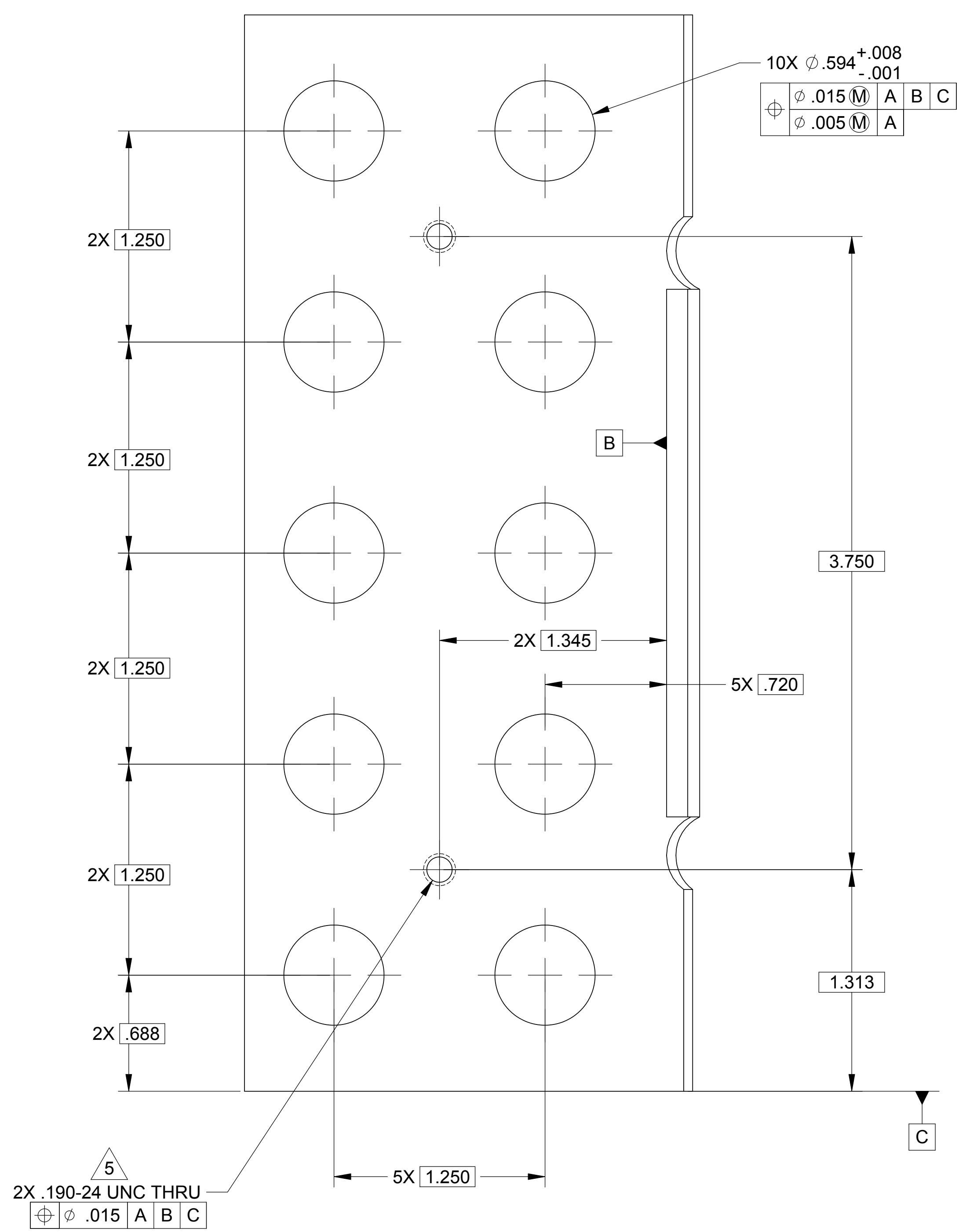
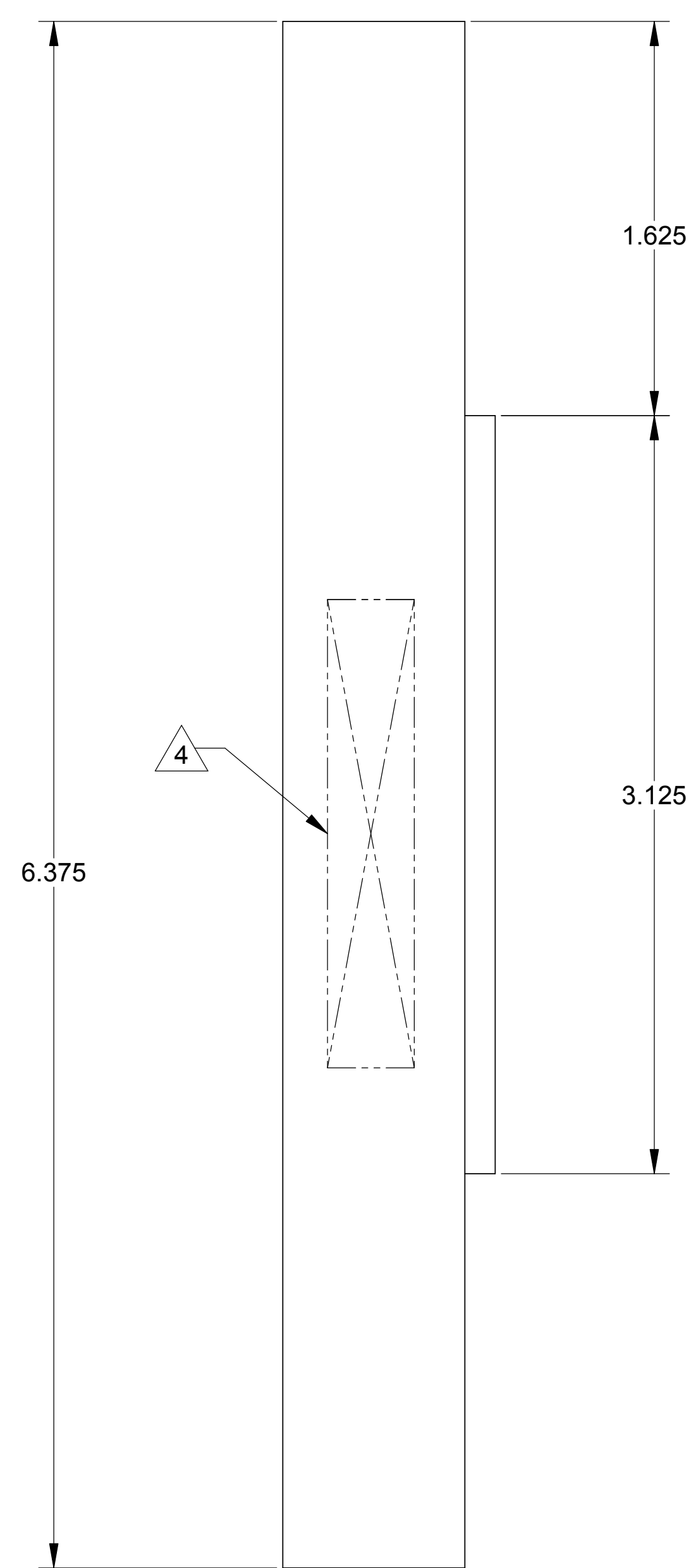


LTR		ZONE		REVISIONS									
NO.	DATE	BY	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE		
A													
INITIAL RELEASE													



- 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 .005-.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.
  - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 2.4 LBS.
  - TABLE SHOWS PARAMETRIC VALUES FOR NOMINAL AND UNCUT SHIM. NOMINAL VALUES FOR DIMENSIONS A, B, AND C SUBJECT TO CHANGE AFTER FIRST INSTALLATION AND PERFORMANCE EVALUATION.

-1 SHOWN

-2 SHOWN  
SAME AS -1 EXCEPT AS SHOWN

CONFIG	A°	B	C
-1	8.430	3.750	0.100
-2	0.000	1.000	0.300

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
				20007895-2		SHIM, UNCUT			
				20007895-1		SHIM, CUT			

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
		DECIMALS	ANGLES	PROJ ENGR	STRS
		XX ± .03	XXX ± .010 ± 1/2°	DWN	R.D.BILLING
		MACHINE FINISH 125/		07/23/04	
		DO NOT SCALE DRAWING			
		INTERPRET DWG PER ASME Y14.5M - 1994			
		MATERIAL			
		CRES 303 FORGING PER AMS A473			
		20007890	1388		
		NEXT ASSEMBLY PROJECT CODE			
		APPLICATION			

SCALE	CAGE CODE	REV
2:1	1KNU9	A

STAGE	SHIM, BLADE SPRING	LIGO-D047895-A
1-2		

SCALE	UNCLASSIFIED	SHEET 1 OF 1
2:1		