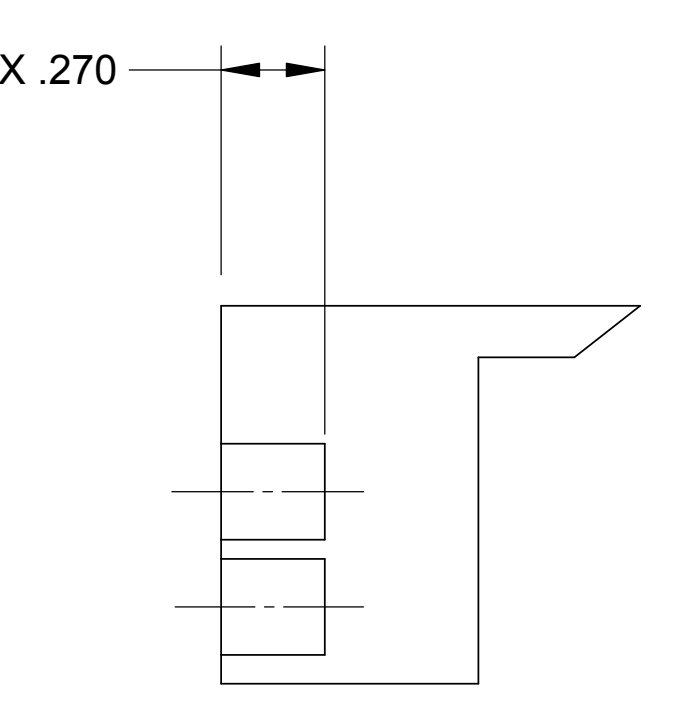
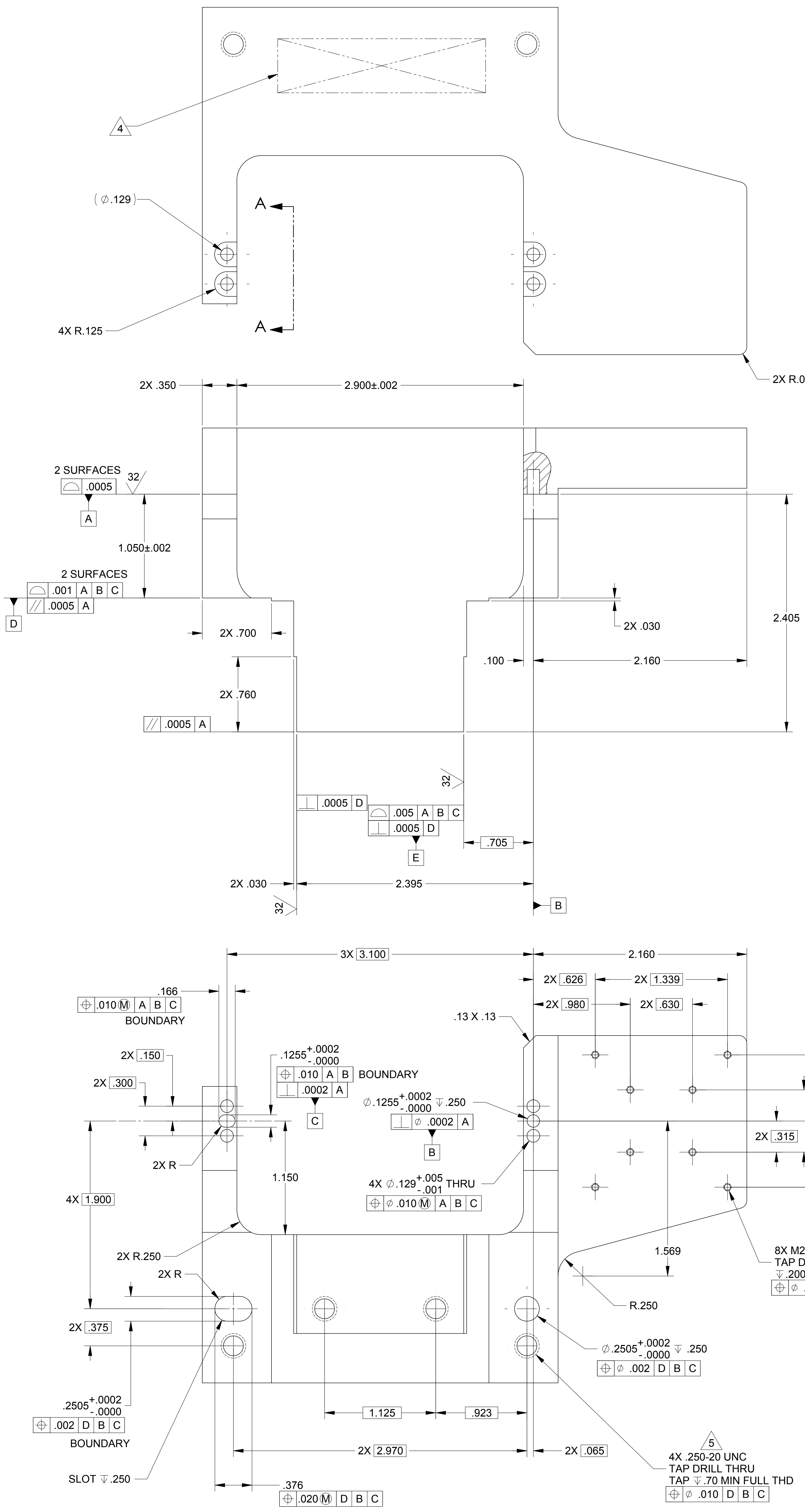
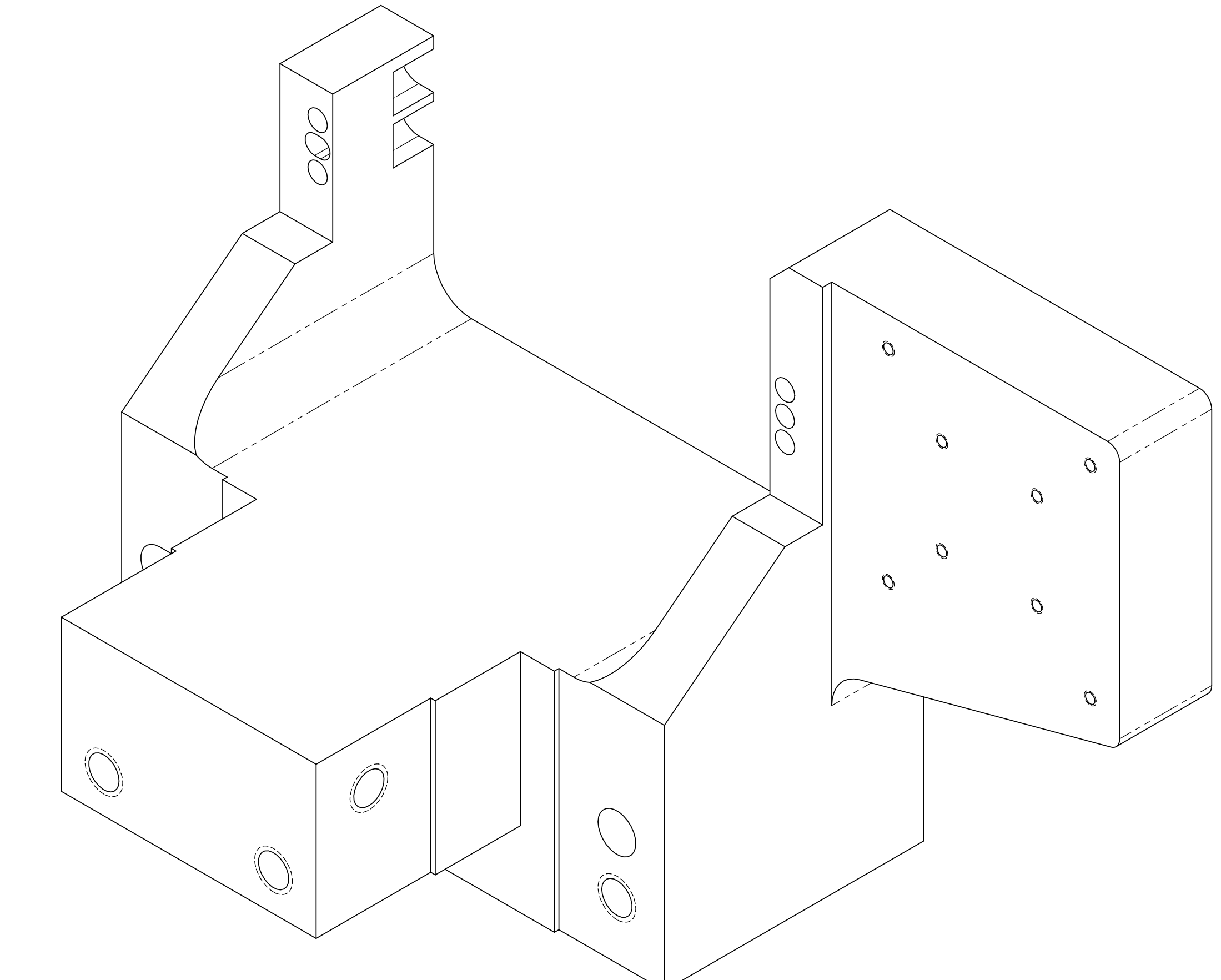


LTR		ZONE		REVISIONS									
NO.	DATE	BY	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE		
A											INITIAL RELEASE		
A											INITIAL RELEASE		
B	AG										.250-20 UNC HOLE TAP CALLOUT WAS: $\nabla$ 900 MIN. IS: THRU		



VIEW A-A  
TYPICAL 2 PLACES



- 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 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.
  - 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 OR M2 METRIC 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 1.5 LBS.

QTY REQD		ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
					20007918-1				
					PARTS LIST				
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			<p><b>RELEASED</b> 2/17/2005</p> <p>ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103</p>				
NEXT ASSEMBLY		MACHINE FINISH 125			<p>ADAPTOR, STAGE 1-2 VERTICAL COIL LIGO D047918-B</p>				
APPLICATION		MATERIAL			<p>AL 7075-7651 AMS-QQ-A-250/12</p>				
20007969		1388			<p>SIZE E CAGE CODE 1KNU9 SCALE 2:1</p>				
		20007918.x_1			<p>REV B UNCLASSIFIED SHEET 1 OF 1</p>				

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