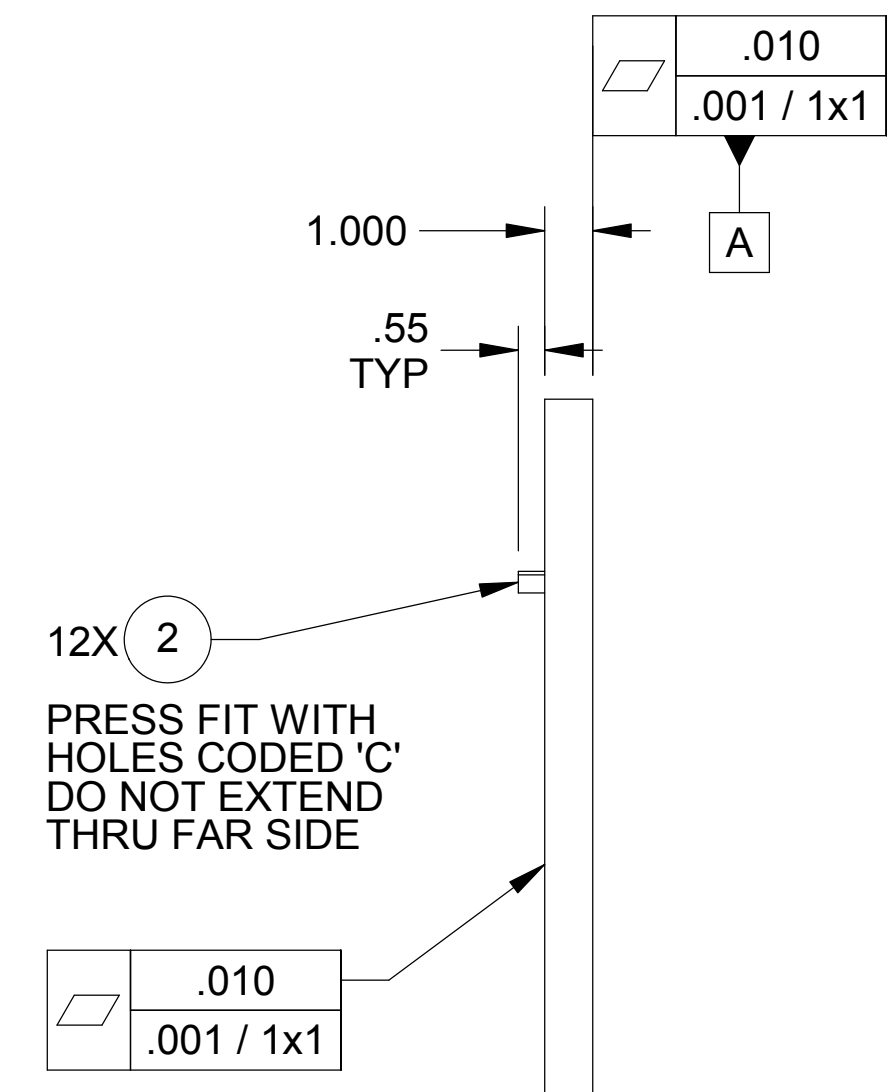
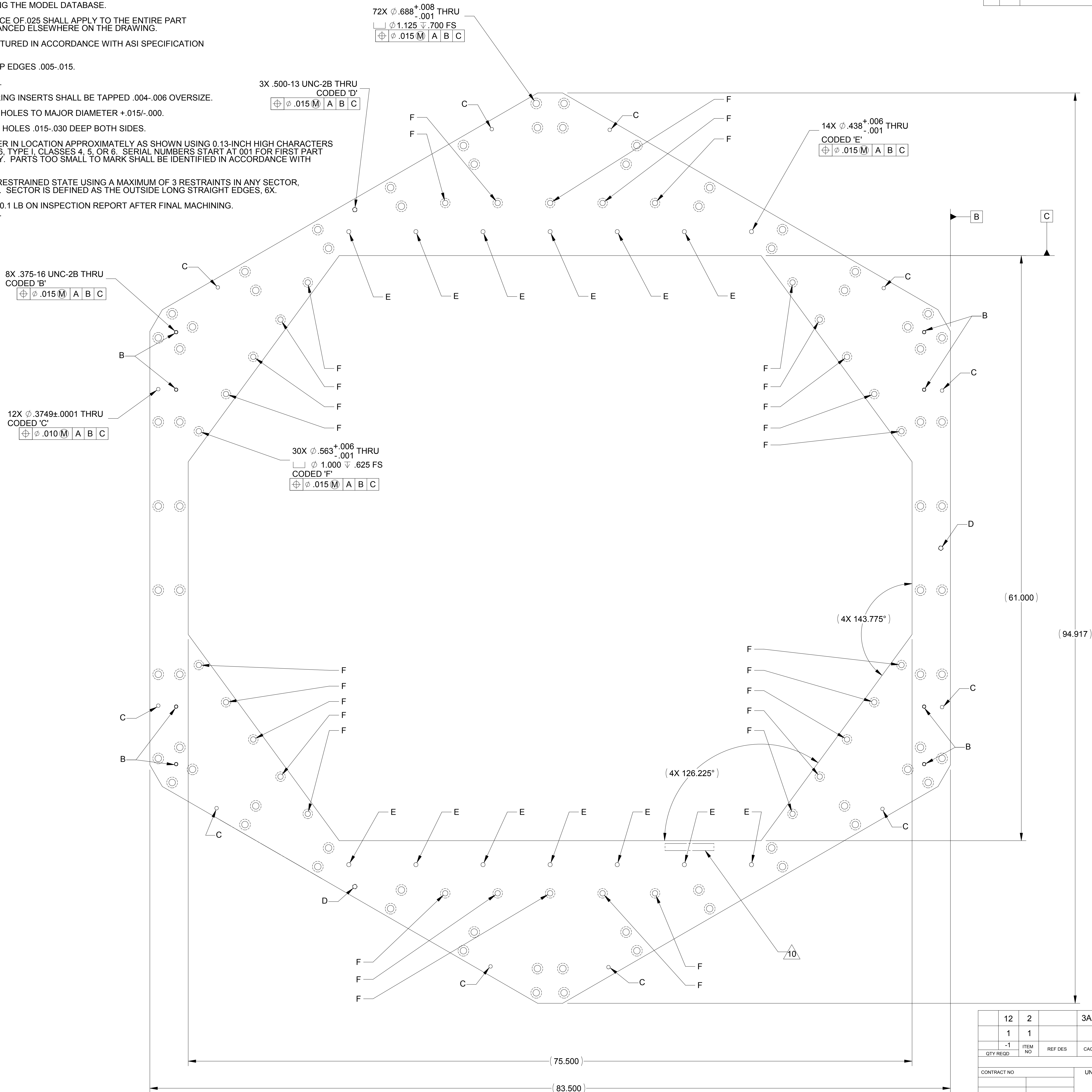


NOTES: UNLESS OTHERWISE SPECIFIED.

- 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.
- 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 RADI .003-.015.
- THREADED HOLES NOT REQUIRING INSERTS SHALL BE TAPPED .004-.006 OVERSIZE.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
- 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 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.
- PART MAY BE INSPECTED IN A RESTRAINED STATE USING A MAXIMUM OF 3 RESTRAINTS IN ANY SECTOR, LOCATIONS AT QA DISCRETION. SECTOR IS DEFINED AS THE OUTSIDE LONG STRAIGHT EDGES, 6X.
- RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 198.8 LB.

LTR		ZONE		REVISIONS									
				DWN	CHK	ENGR	STRESS	MATL	THRM	ME	PROJ	QA	RELEASE DATE
A				INITIAL RELEASE									



QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
12	2			3AO54	98380A618	PIN, 0.3752 X 1.50L		MCMASPER-CARR	CRES
1	1			20007951-101		PLATE, BOTTOM		AMS-QQ-A-250/11	AL 6061-T651
-1									

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
20007950	1388	DECIMALS .XX ± .03	ANGLES XXX ± .010 ± 12°	SEE PARTS LIST	SEE PARTS LIST
NEXT ASSEMBLY		MACHINE FINISH 125/		DWN KEVIN J SPINK 06/25/04	
APPLICATION		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994		PROJ ENGR STRS	
		MATERIAL		CHK MATL	
				CONFIG PROJ	
				ME QA	

SCALE 1:4	SIZE E	CAGE CODE 1KNU9	20007951	REV A
UNCLASSIFIED		SHEET 1 OF 1		

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