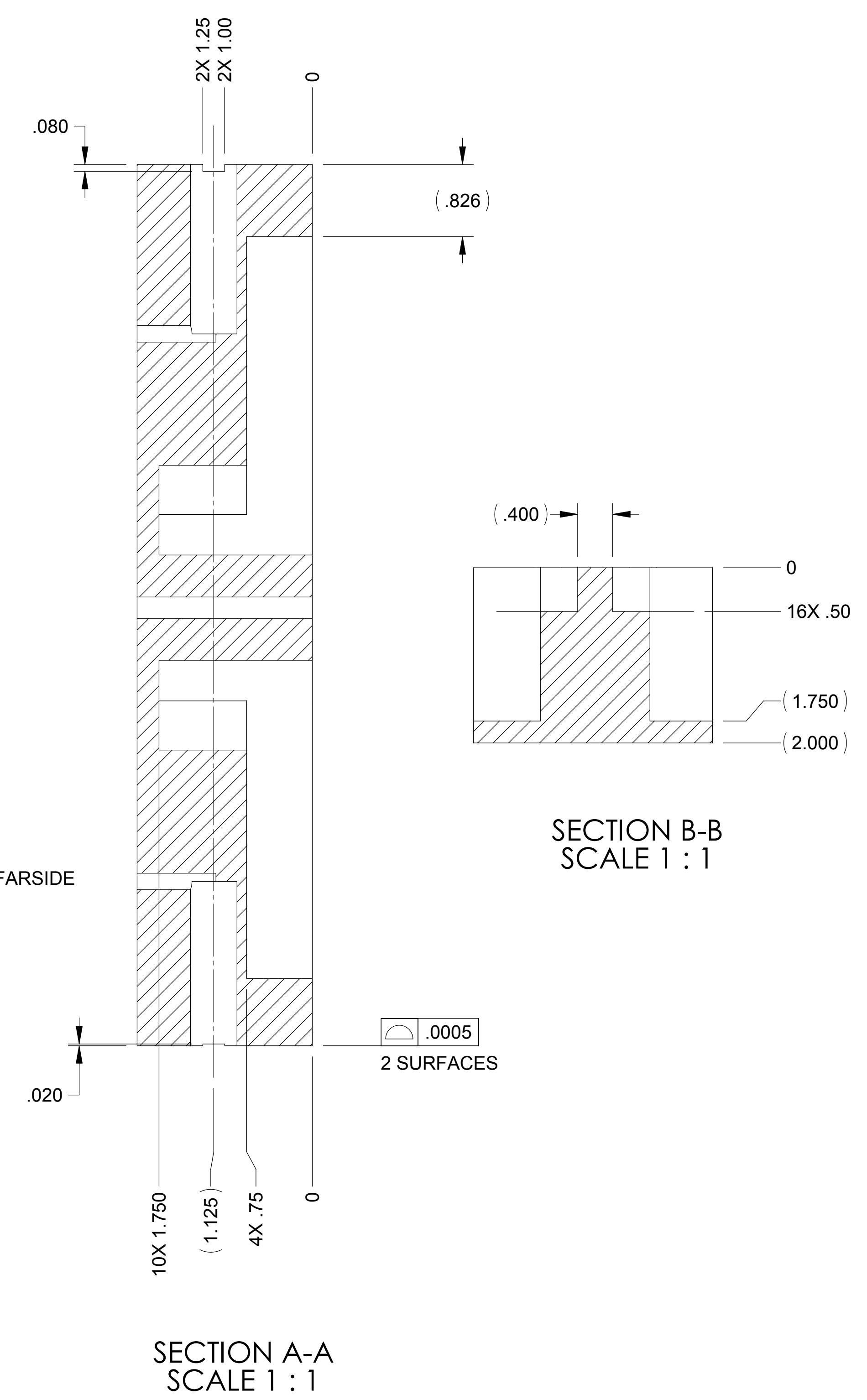
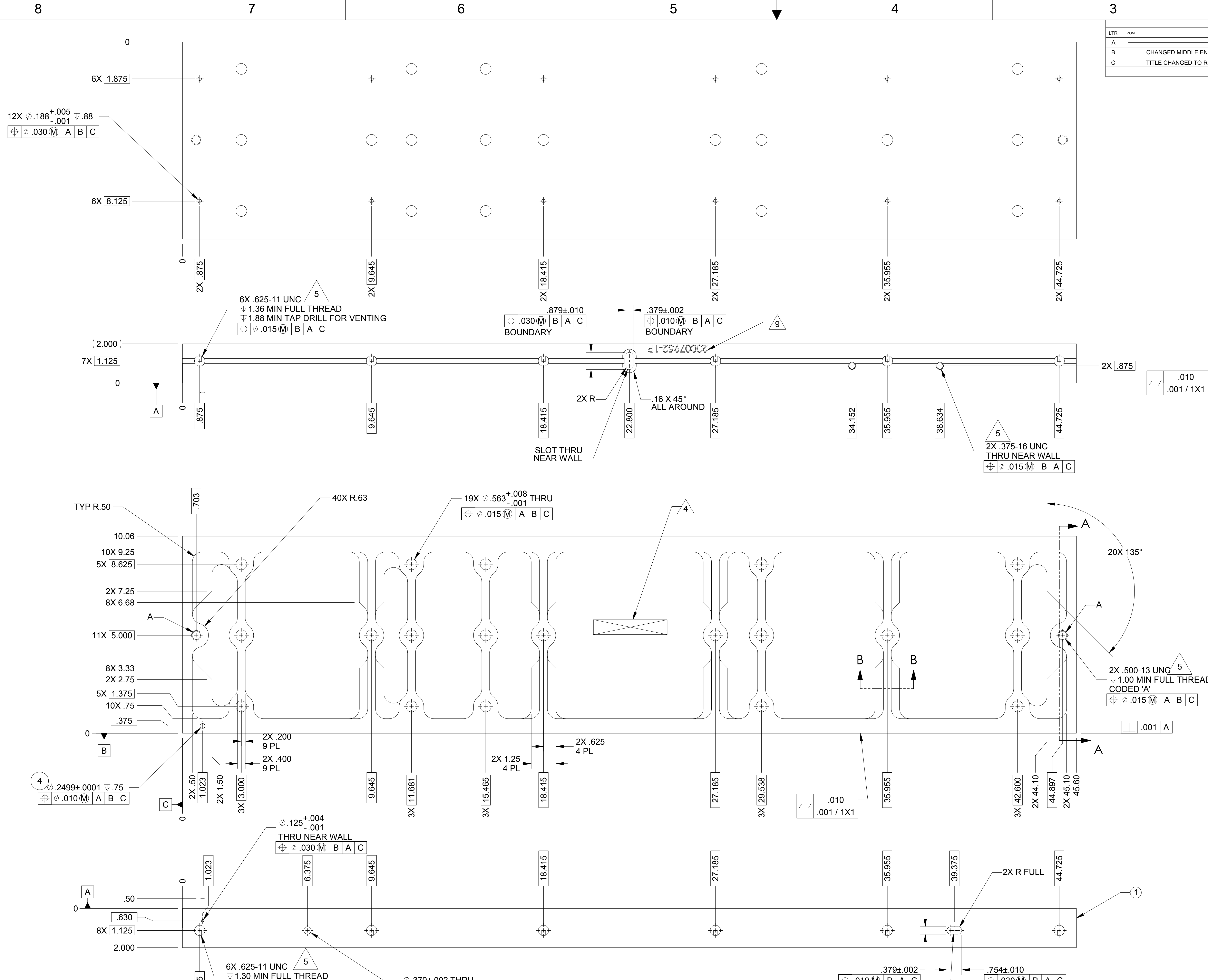


| REVISIONS | | DWN | CHK | P-ENG | CONF | STRS | MATL | ME | PROJ | QA | RELEASE DATE |
|-----------|--|-----|-----|-------|------|------|------|-----|------|-----|--------------|
| A | INITIAL RELEASE | KS | RDB | KSS | REF | DCW | DCW | RJM | AA | GAD | 04/09/13 |
| B | CHANGED MIDDLE END HOLE FROM THRU HOLE TO TAPPED, CODED 'A', ZONE D3 | REF | RDB | KSS | REF | DCW | DCW | RJM | AA | GAD | 10-05-04 |
| C | TITLE CHANGED TO REFLECT CURRENT REVISION LETTER | KJS | | | | | | | | | |



- 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.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT PER DASH NUMBER IS: 20007952-1P=35.6 LBS, 20007952-2P=35.7 LBS, 20007952-3P=35.7 LBS
 - MARK PART NUMBER AND DASH NUMBER WITH THE LETTER P AFTER THE DASH NUMBER IN APPROXIMATE LOCATION SHOWN. USE ANY METHOD THAT WILL NOT RUB OFF OR SMUDGE UNDER NORMAL HANDLING. THIS MARKING DOES NOT NEGATE NOTE 4 AND WILL BE REMOVED DURING SUBSEQUENT OPERATION DEPICTED IN DRAWING 20007960.
 - 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.

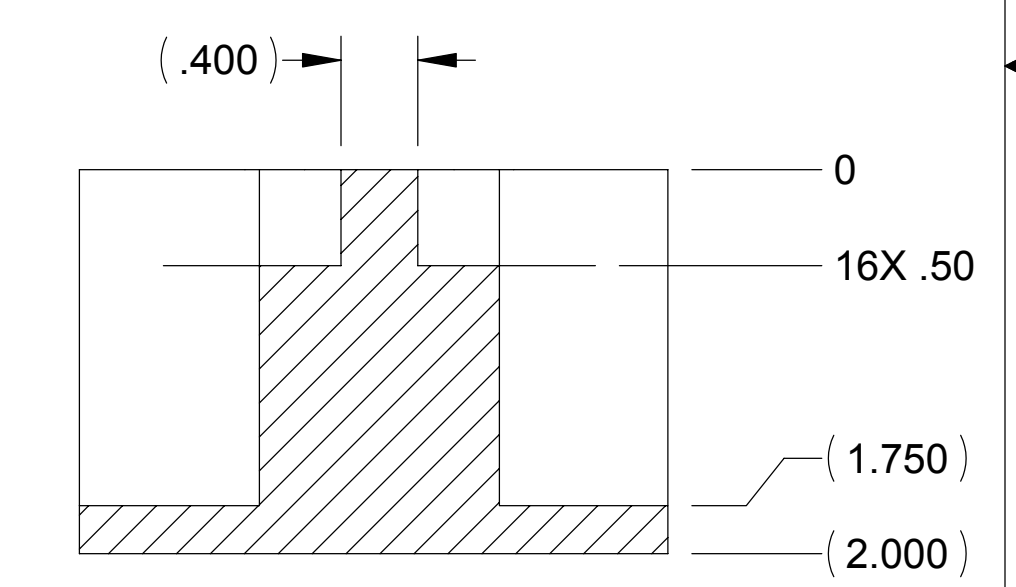
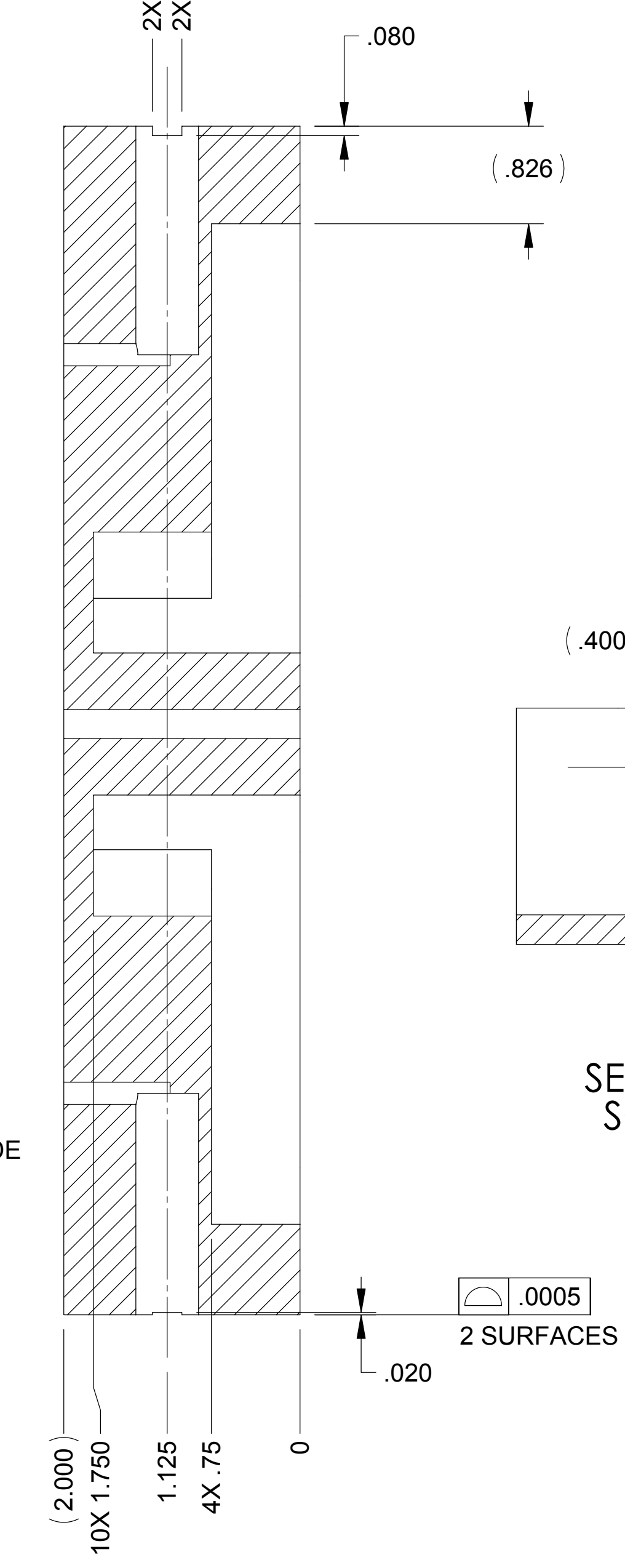
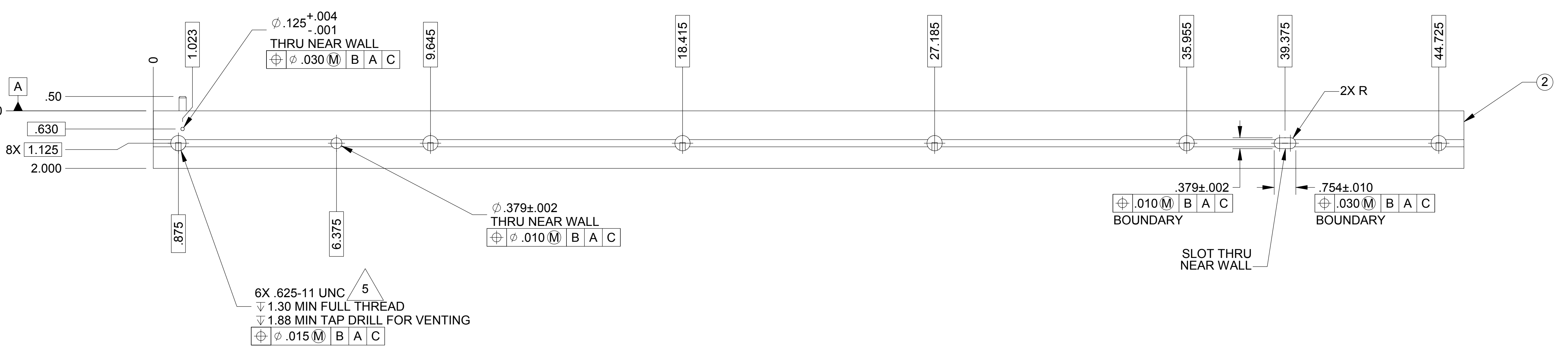
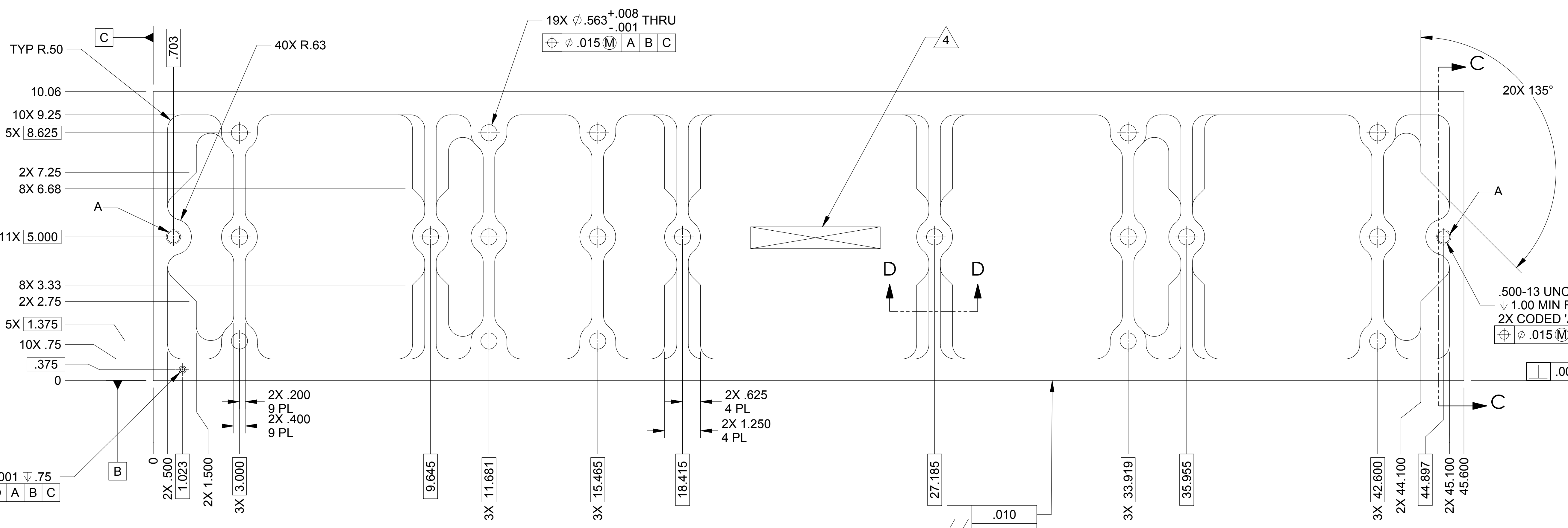
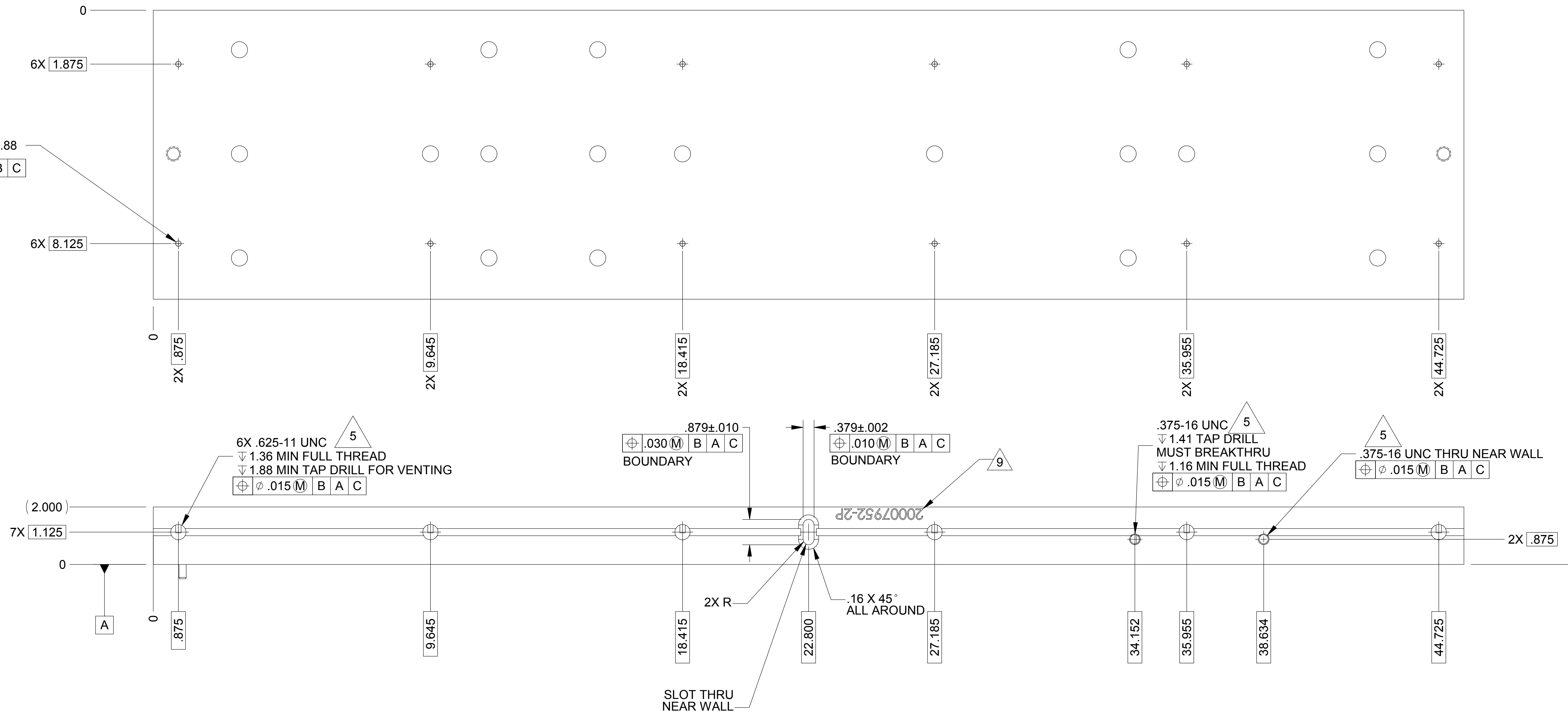
**-1 SHOWN
-2 SEE SHEET 2
-3 SEE SHEET 3**

| QTY | REGD | -2P | -1P | ITEM NO | REF DES | CAGE NO | PART OR IDENTIFYING NO | NOMENCLATURE OR DESCRIPTION | SPECIFICATION | MATERIAL OR NOTE | ZONE |
|-----|------|-----|-----|---------|---------|---------|------------------------|-----------------------------|-----------------|------------------|--------------|
| 1 | 1 | 1 | 4 | | | 3A054 | 98380A624 | PIN, Ø.3752 X 1.00L | | MCMASTER-CARR | CRES |
| 1 | | | 3 | | | | 20007952-103 | OUTER WALL, STEP3 | AMS-QQ-A-250/12 | | AL 7075-T651 |
| 1 | | | 2 | | | | 20007952-102 | OUTER WALL, STEP2 | AMS-QQ-A-250/12 | | AL 7075-T651 |
| | | | 1 | 1 | | | 20007952-101 | OUTER WALL, STEP1 | AMS-QQ-A-250/12 | | AL 7075-T651 |

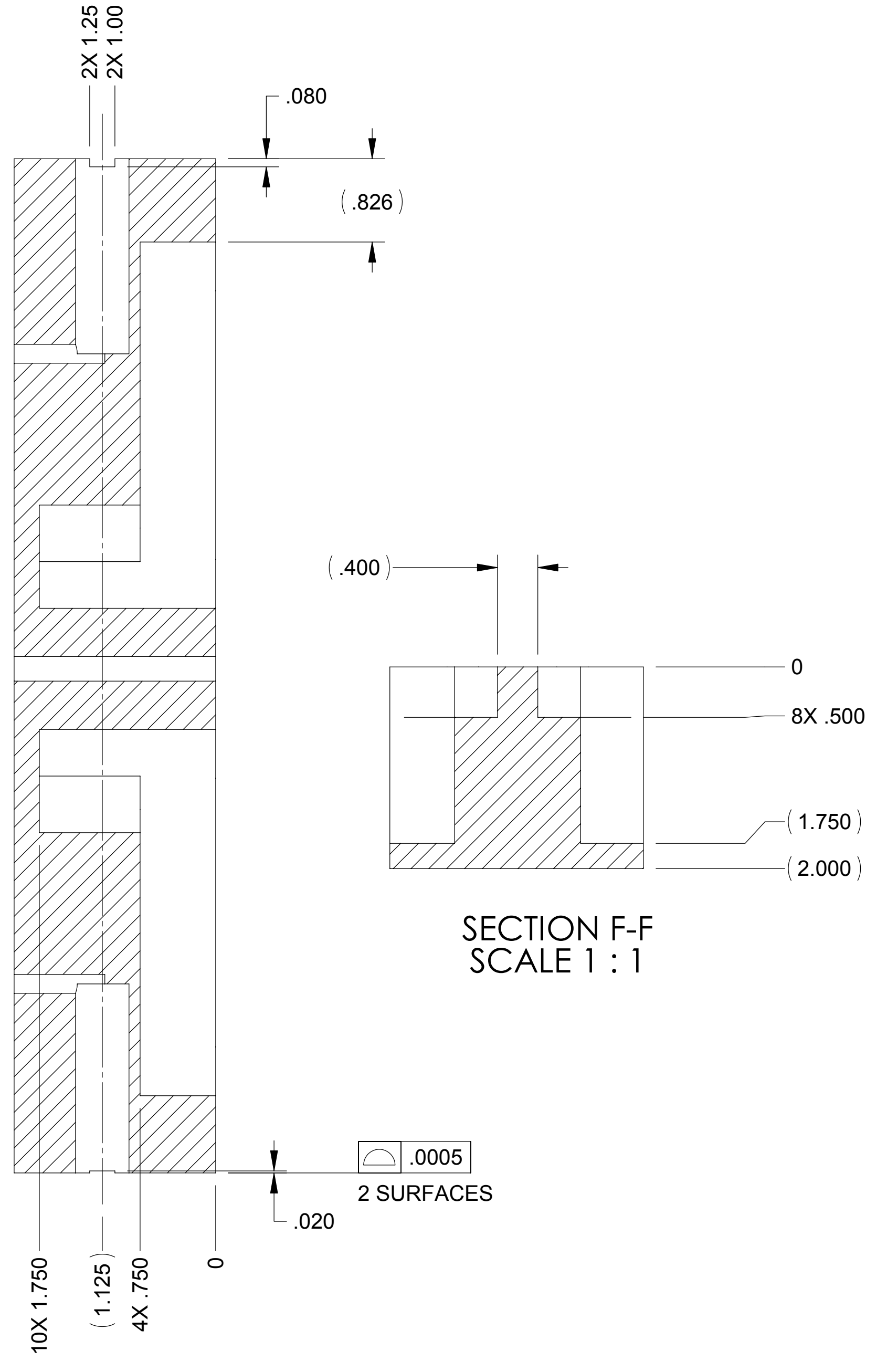
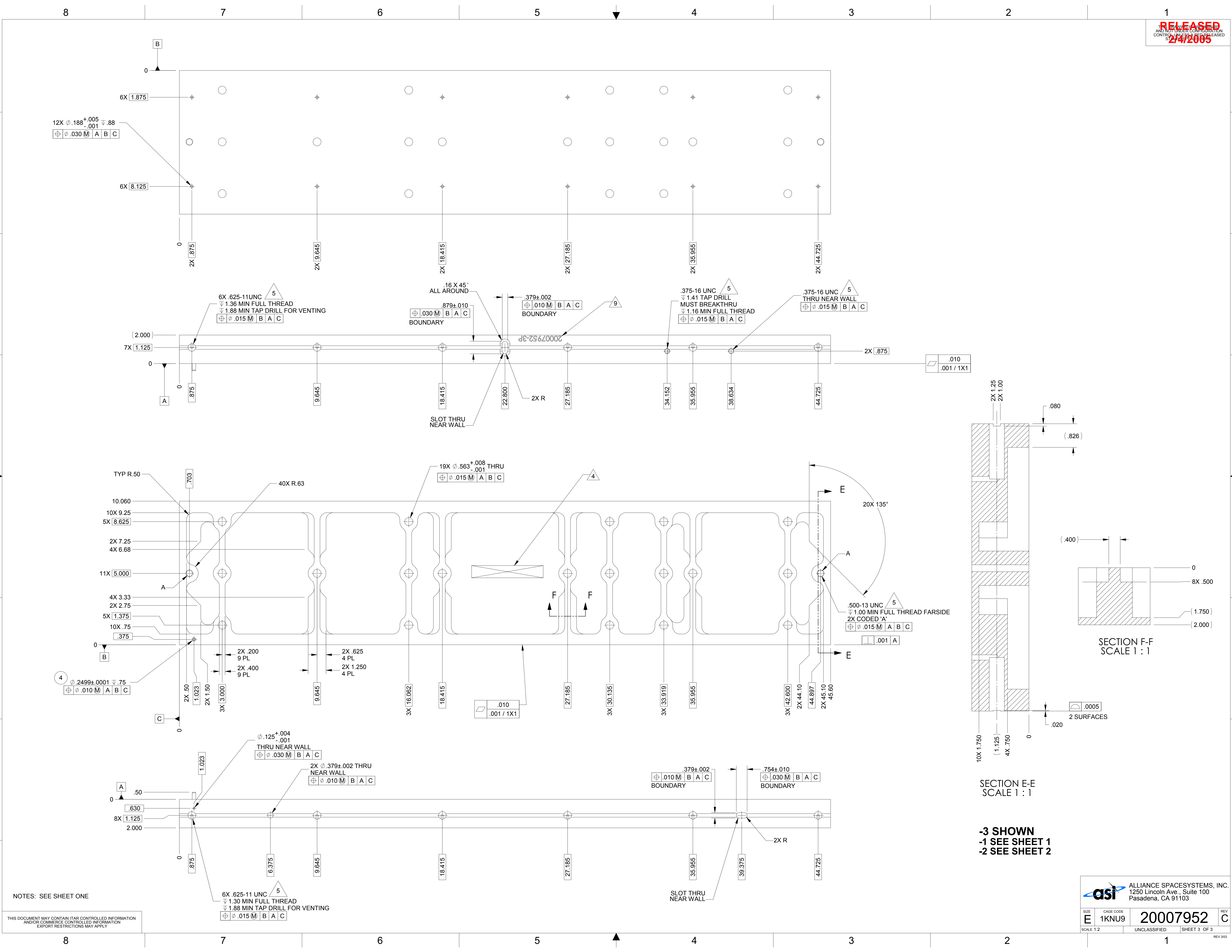
| | | | | | | | |
|-----------------|--|--|--|-------------------|--|--|--|
| CONTRACT NO | | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES | | | | ALLIANCE SPACESYSTEMS, INC. | |
| 20007960 | | DECIMALS ANGLES .XX ±.03 .XXX ±.010 ±.12° | | | | 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103 | |
| NEXT ASSEMBLY | | MACHINE FINISH | | DWN KEVIN J SPINK | | 07/13/04 | |
| 20007952-1P.X-1 | | 125 | | PROJ ENGR | | STRS | |
| 20007952-2P | | DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994 | | CHK | | MAIL | |
| 20007952-3P.X-1 | | MATERIAL | | CONFIG | | PROJ | |
| APPLICATION | | SEE PARTS LIST | | ME | | QA | |
| | | SIZE | | CAGE CODE | | REV | |
| | | E | | 1KNU9 | | 20007952 | |
| | | SCALE 1:2 | | UNCLASSIFIED | | SHEET 1 OF 3 | |

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12X $\phi .188^{+.005}_{-.001}$ $\nabla .88$
 $\oplus \phi .015 \overline{M}$ | A | B | C



-2 SHOWN
-1 SEE SHEET 1
-3 SEE SHEET 3



SECTION E-E
SCALE 1:1

SECTION F-F
SCALE 1:1

-3 SHOWN
-1 SEE SHEET 1
-2 SEE SHEET 2

NOTES: SEE SHEET ONE

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AND/OR COMMERCE CONTROLLED INFORMATION
EXPORT RESTRICTIONS MAY APPLY

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

| | | |
|-----------|--------------------|--------------|
| SIZE E | CAGE CODE 1KNU9 | REV C |
| SCALE 1:2 | | UNCLASSIFIED |
| 20007952 | | SHEET 3 OF 3 |

REV 303