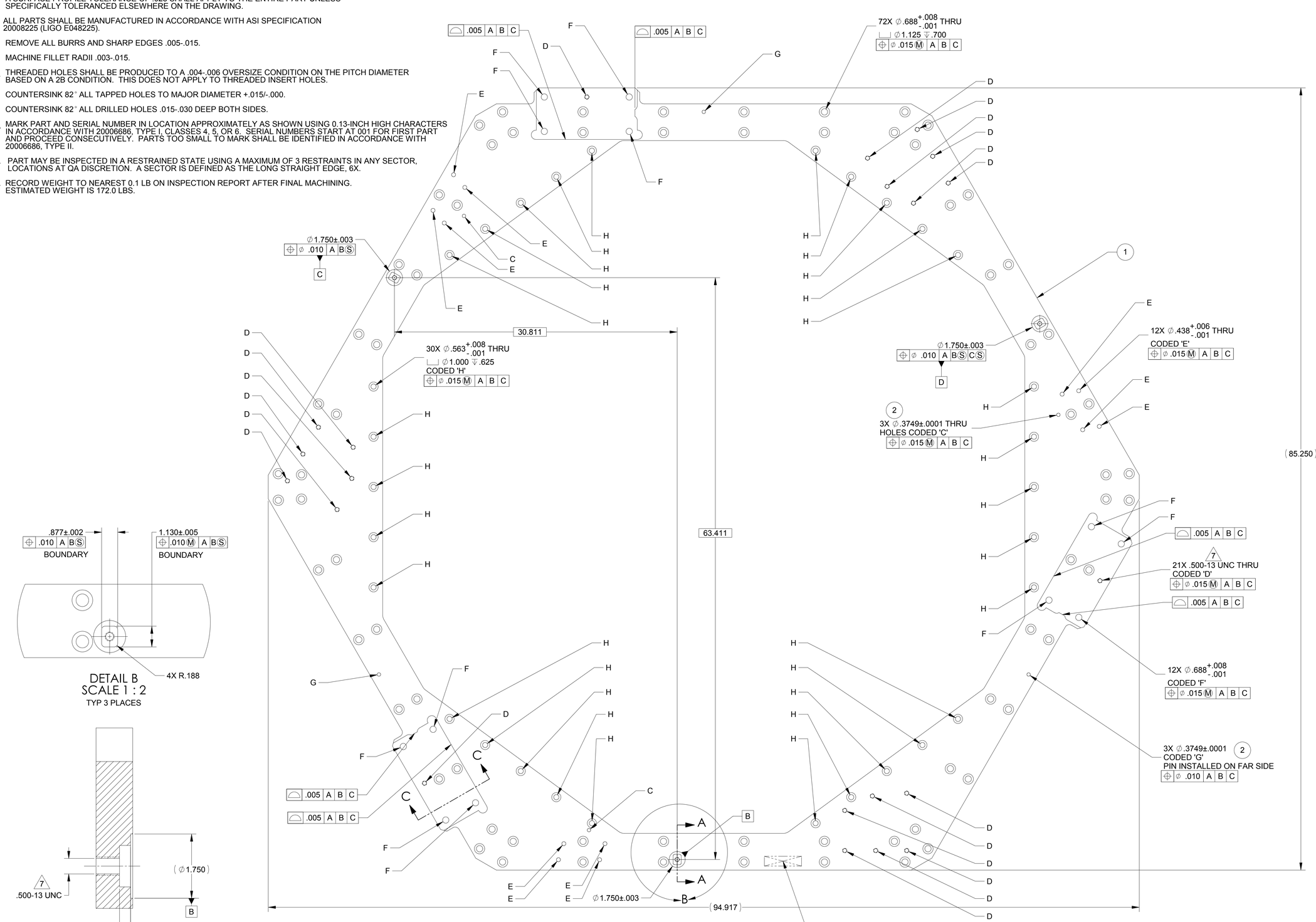
NOTES: UNLESS OTHERWISE SPECIFIED.

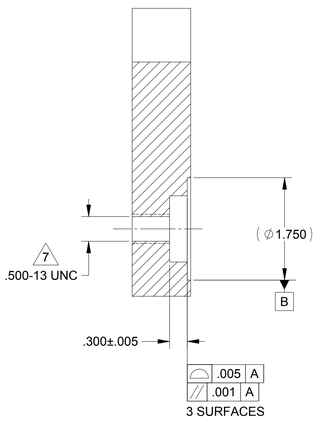
1. THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE MODEL DATABASE THE MODEL DATABASE WILL TAKE PRECEDENCE.
2. PART SHALL BE CHECKED USING THE MODEL DATABASE.
3. SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUM(S). A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
5. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
6. MACHINE FILLET RADII .003-.015.
7. 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.
8. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
9. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
10. 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.
11. PART MAY BE INSPECTED IN A RESTRAINED STATE USING A MAXIMUM OF 3 RESTRAINTS IN ANY SECTOR, LOCATIONS AT QA DISCRETION. A SECTOR IS DEFINED AS THE LONG STRAIGHT EDGE, 6X.
12. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 172.0 LBS.

REVISIONS

LTR	ZONE	DESCRIPTION	DWN	CHK	ENGR	STRESS	MATL	CONFIG	ME	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE	KJS	RDB	KS	DCW	DCW	RF	RM	AA	GD	9-14-04
B		ADDED RELIEF FEATURE DEPICTED IN SECTION VIEW C-C. REVISED NOTE 7 AND ADDED DELTA.	RF	RDB	KS	DCW	DCW	RF	RM	AA	GD	10-12-04
C		TITLE CHANGED TO REFLECT CURRENT REVISION LETTER	KJS									

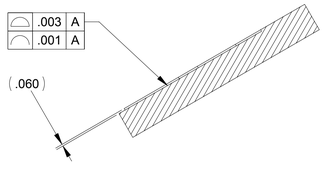


DETAIL B
SCALE 1 : 2
TYP 3 PLACES



3 SURFACES

SECTION A-A
SCALE 1 : 1
DATUM PADS
TYP 3 PLACES



SECTION C-C
SCALE 1 : 2
TYPICAL 3 PLACES

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
	6	2	3AO54	9838OA618	PIN, ∅.3752 X 1.5 L	MCMASTER-CARR	CRES	
	1	1		20007957-101	PLATE, TOP	AMS-QQ-A-250/11	AL 6061-T651	
	-1							

PARTS LIST

CONTRACT NO

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS XX ±.03 XXX ±.010
ANGLES ±1/2°
MACHINE FINISH 125
DO NOT SCALE DRAWING
INTERPRET DWG PER ASME Y14.5M, 1994
MATERIAL
SEE PARTS LIST

RELEASED
2/4/2005
THIS DRAWING IS RELEASED AND NOT UNDER CONFIGURATION CONTROL. DATE RELEASED SIGNATURE

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

DWN	KEVIN J SPINK	07/21/04	
PROJ ENGR		STRS	
CHK		MATL	
CONFIG		PROJ	
ME		QA	

TOP PLATE
STAGE 0
LIGO-D047957-C

SIZE	CAGE CODE		REV
E	1KNU9	20007957	C
SCALE 1:4	UNCLASSIFIED	SHEET 1 OF 1	

FILE ATTACHMENTS
20007957-1.x_t

NEXT ASSEMBLY	PROJECT CODE
20007950	1388

APPLICATION

REV 6/04

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