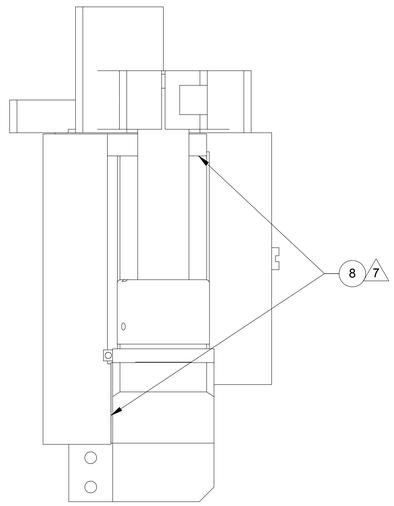
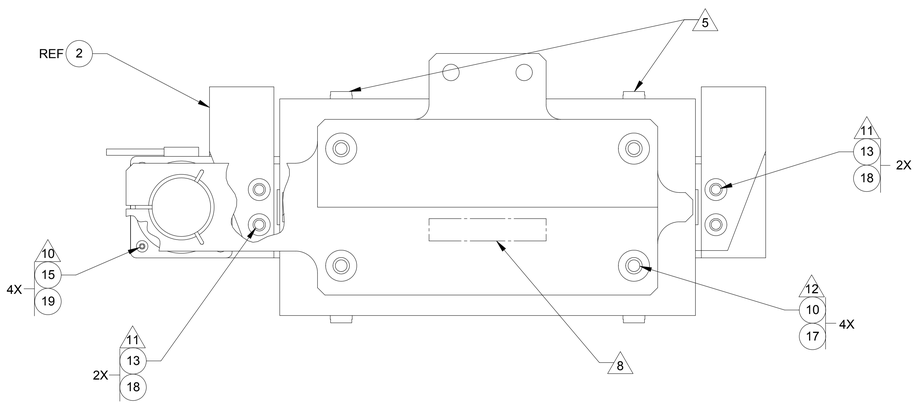
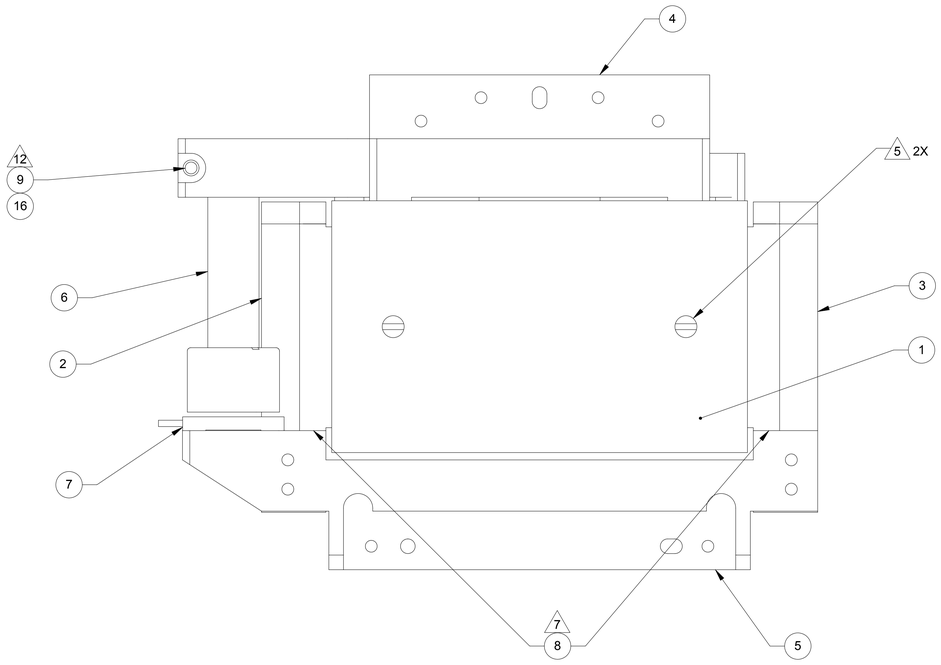
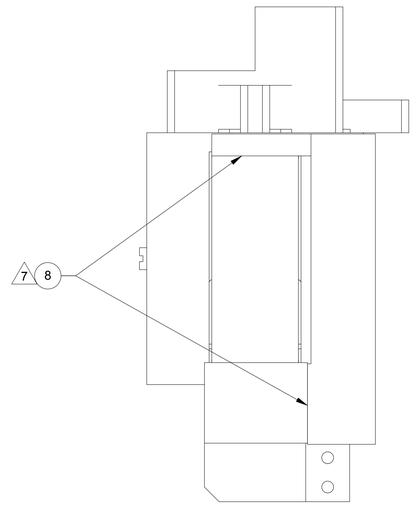
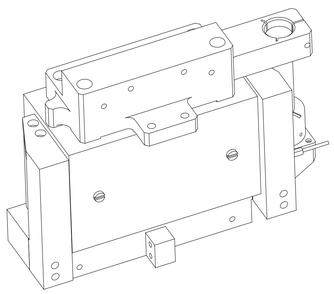
REVISIONS											
LTR	ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONFG	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE										

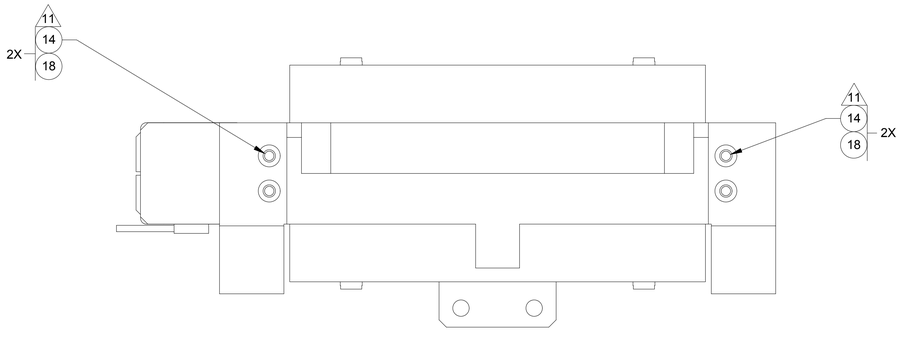


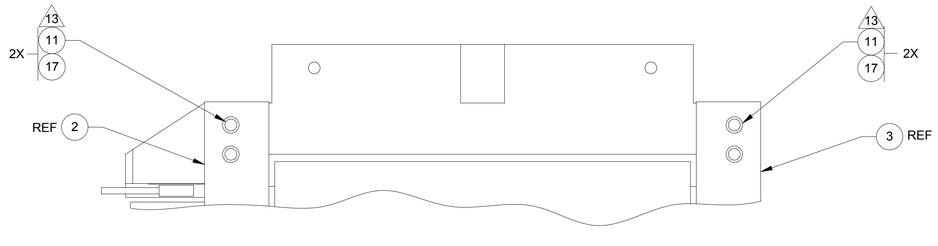












NOTES: UNLESS OTHERWISE SPECIFIED.

1. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
2. SOURCE OF SUPPLY: PLANNING SYSTEMS INCORPORATED MELBOURNE, FLORIDA 32901
3. SOURCE OF SUPPLY: ADE TECNOLOGIES NEWTON, MARYLAND 02466
4. SOURCE OF SUPPLY: U-C COMPONENTS, INC MORGAN HILL, CALIFORNIA 95037
5. REMOVE SHIPPING SCREWS PRIOR TO TEST AND OPERATION.
6. ALUMINUM ALLOY FOIL, ANNEALED, .001 INCH THICK, CONFORMING TO ASTM B 479-00.
7. APPLY FOIL TO FAYING SURFACES OF ITEMS 3, 1 AND 5, AND 2, 1 AND 5.
8. MARK ASSY AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING .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.
9. BOLT TORQUING PROCEDURE SHALL ENSURE THAT THE SPECIFIED TORQUE IS APPLIED WITHIN A TOLERANCE OF +5% / -10%.
10. TORQUE: 1.5 IN LBS.
11. TORQUE: 30 IN LBS.
12. TORQUE: 60 IN LBS.
13. TORQUE: 168 IN LBS.
14. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL ASSEMBLY. ESTIMATED WEIGHT IS: 45.1 LBS.
15. ALL SCREWS SHALL BE SILVER PLATED. DIMENSIONAL TOLERANCES PER UNC/UNF-2A APPLY AFTER PLATING.

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

		QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
4		4	19			MFWV-02	WASHER, FLAT, VENTED	.086 ID, .197 OD, .012 THK	18-8 CRES	
4		8	18			WFV-10	WASHER, FLAT, VENTED	.195 ID, .354 OD, .032 THK	18-8 CRES	
4		8	17			WFV-25	WASHER, FLAT, VENTED	.255 ID, .468 OD, .032 THK	18-8 CRES	
		1	16			NA620C-416	WASHER, FLAT	.255 ID, .468 OD, .063 THK	18-8 CRES	
4		4	15			MP-206-A	SCREW, PAN HD, VENTED	M2 X 0.4 X 6MM	18-8 CRES	
4		4	14			C-1008-A	SCREW, SHC, VENTED	.190-32 UNF X .500 L	18-8 CRES	
4		4	13			C-1006-A	SCREW, SHC, VENTED	.190-32 UNF X .375 L	18-8 CRES	
			12							
4		4	11			C-286-2028-NA	SCREW, SHC	.250-20 UNC X 1.750 L	A286 CRES	
4		4	10			C-2016-A	SCREW, SHC, VENTED	.250-20 UNC X 1.000 L	18-8 CRES	
4		1	9			C-2012-NA	SCREW, SHC	.250-20 UNF X .750 L	18-8 CRES	
		AR	8				FOIL, .001 IN THK (6)	ASTM B 479-00	1100 AL ALLOY	
3		1	7			033968-01	SENSOR, ADE 20MM			
		1	6			20007912-1	DISPLACEMENT SENSOR TARGET ASSY			
		1	5			20007910-1	ADAPTER, HORIZ.,COIL			
		1	4			20007908-1	ADAPTER, FIELD			
		1	3			20007977-2	THERMAL BAR, RIGHT			
		1	2			20007977-1	THERMAL BAR, LEFT			
2		1	1			0487-LIGO-D210-050904-SCS	ACTUATOR			

PARTS LIST

CONTRACT NO	
20007970	1388
NEXT ASSEMBLY	PROJECT CODE
APPLICATION	

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

MATERIAL
SEE PARTS LIST

FILE ATTACHMENTS
20007966.x_t

RELEASED 3/4/2005
THIS DRAWING IS RELEASED ONLY AND NOT UNDER CONFIGURATION CONTROL UNLESS A DATE IS LISTED

DWN	KEVIN J SPINK	12/02/04	
PROJ ENGR		STRS	
CHK		MATL	
CONFIG		PROJ	
ME		QA	

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

STAGE 0-1 HORIZONTAL ACTUATOR ASSEMBLY LIGO D047966-A

SIZE	CAGE CODE		REV
E	1KNU9	20007966	A
SCALE 1:1	UNCLASSIFIED	SHEET 1 OF 1	

REV 7/04