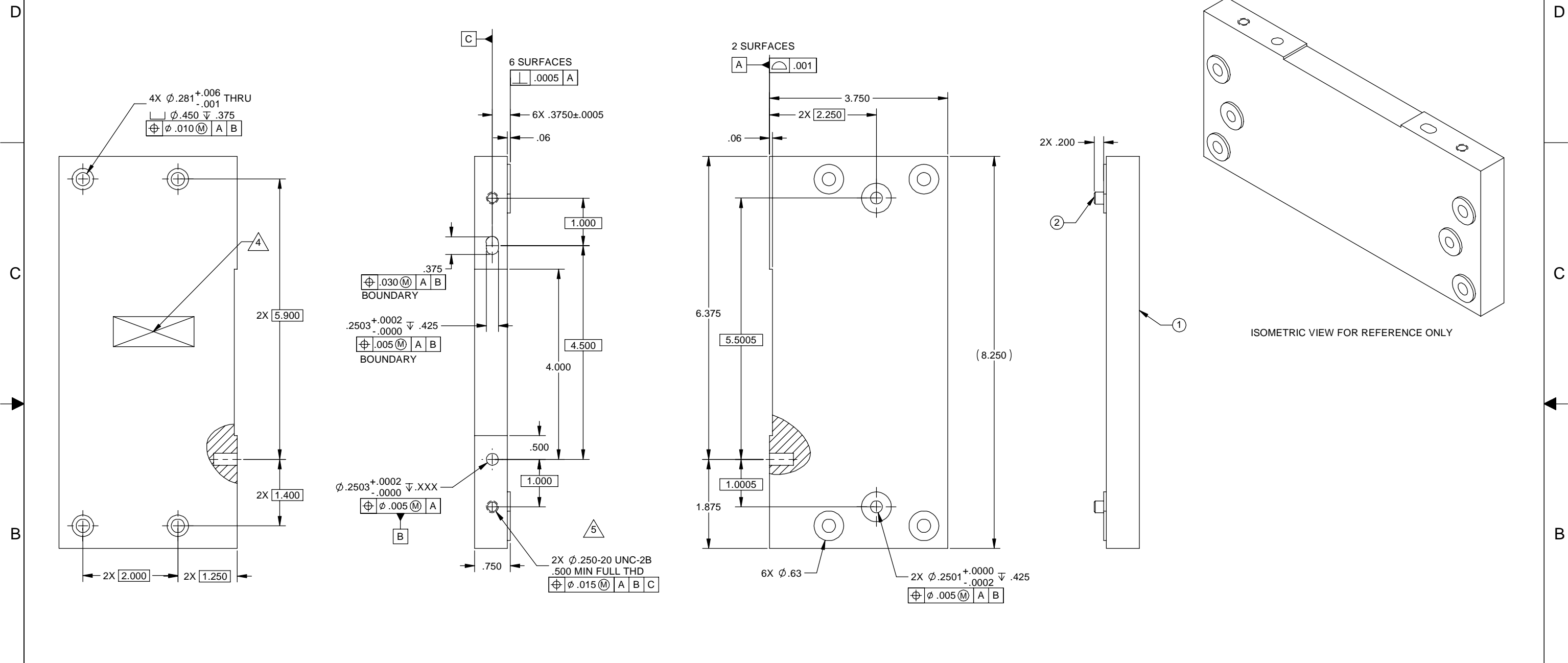


LTR		ZONE		DESCRIPTION		REVISIONS									
A				INITIAL RELEASE		DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE



- 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 $+.015/-0.000$.
 - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
2	2			McMASTER CARR P/N 98380A539	PIN, $\phi .250 \times .625 \text{ L}$		CRES	
1	1			2000XXXX-1	STAGE 0-1 VERT. ACTUATOR SETUP TOOLING FIELD SIDE			
-1								

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .XX $\pm .03$ ANGLES .XXX $\pm .010$ $\pm 1/2^\circ$ MACHINE FINISH 63		THIS DRAWING IS PRELIMINARY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS HERE.		ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
NEXT ASSEMBLY PROJECT CODE 1388		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		DWN J. LARAMEE 10/06/04 PROJ ENGR STRS CHK MATL CONFIG PROJ ME QA		STAGE 0-1 VERT ACTUATOR SETUP TOOLING, FIELD SIDE LIGO D04XXXX-A	
APPLICATION		MATERIAL AL 6061-T651 AMS-QQ-A-250/11		SIZE D CAGE CODE 1KNU9 SCALE 1:1		REV 0 D050344-00-D SHEET 1 OF 1	

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