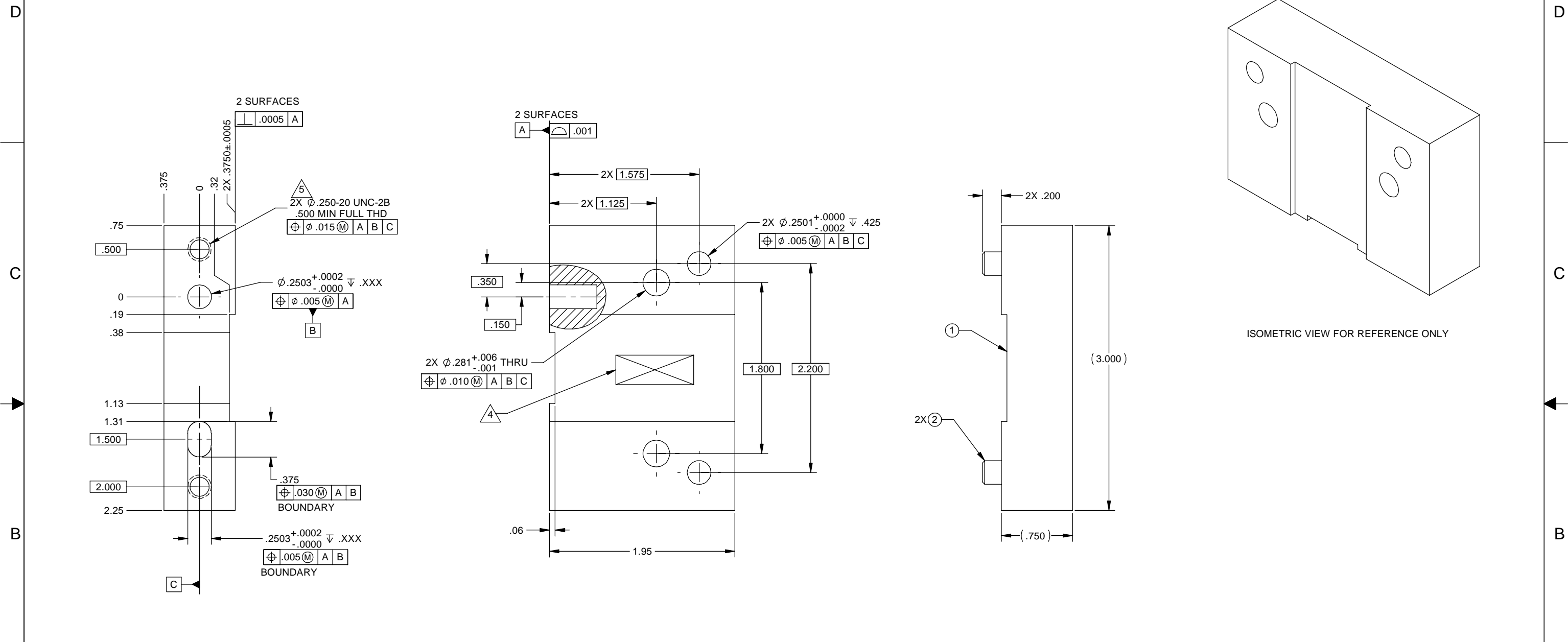


LTR		ZONE		DESCRIPTION		REVISIONS												
QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE	DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE
	A				INITIAL RELEASE													



- 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.

2	2			McMASTER CARR P/N 98380A539	PIN Ø.250 X .625 L			CRES	
1	1			2000XXXX-1	STAGE 1-2 HORI ACTUATOR SETUP TOOLING, COIL SIDE				
-1									

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		THIS DRAWING IS PRELIMINARY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS HERE.		ALLIANCE SPACESYSTEMS, INC.	
		DECIMALS	ANGLES	DWN	STRS	1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	
		XX ±.03	XXX ±.010	J. LARAMEE	10/07/04	STAGE 1-2 HORI ACTUATOR SETUP TOOLING, COIL SIDE	
		MACHINE FINISH 63		PROJ ENGR	STRS	LIGO D04XXXX-A	
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994		CHK	MATL	SIZE	CAGE CODE
				CONFIG	PROJ	D	1KNU9
				ME	QA	D050349-00-D	
						SCALE	2:1
						SHEET 1 OF 1	

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