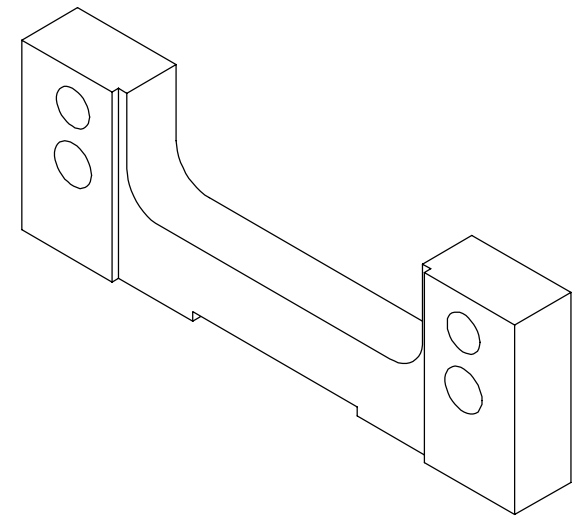
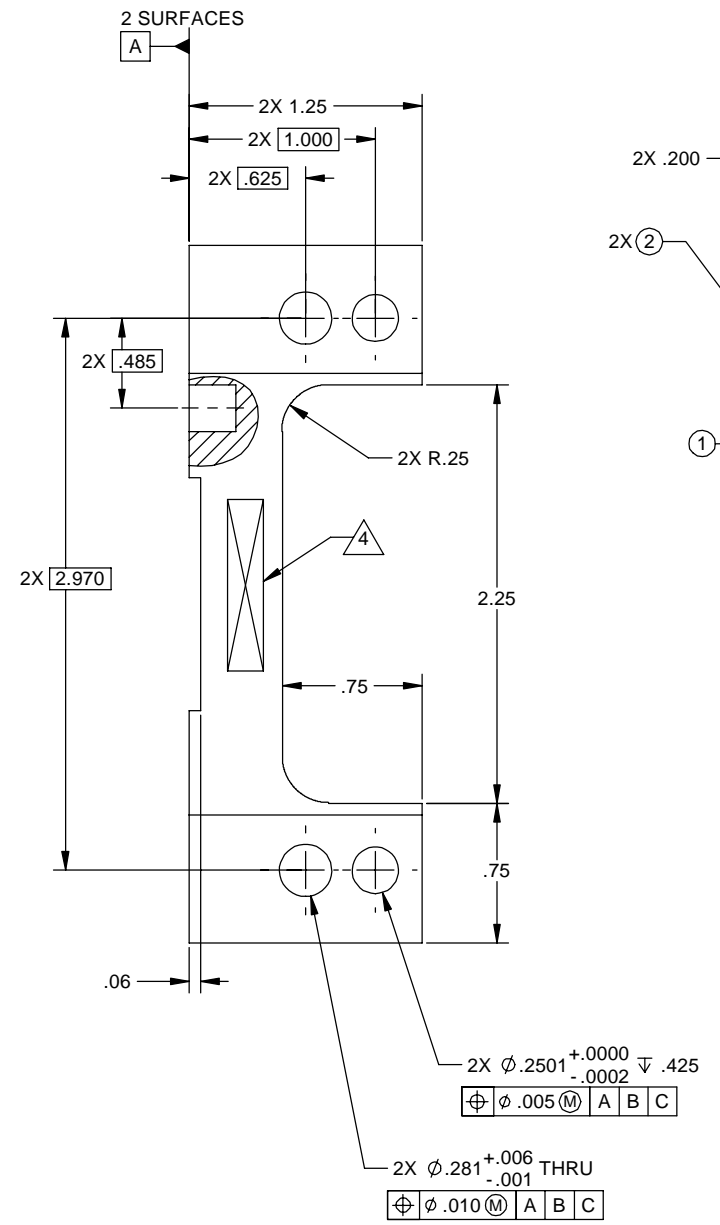
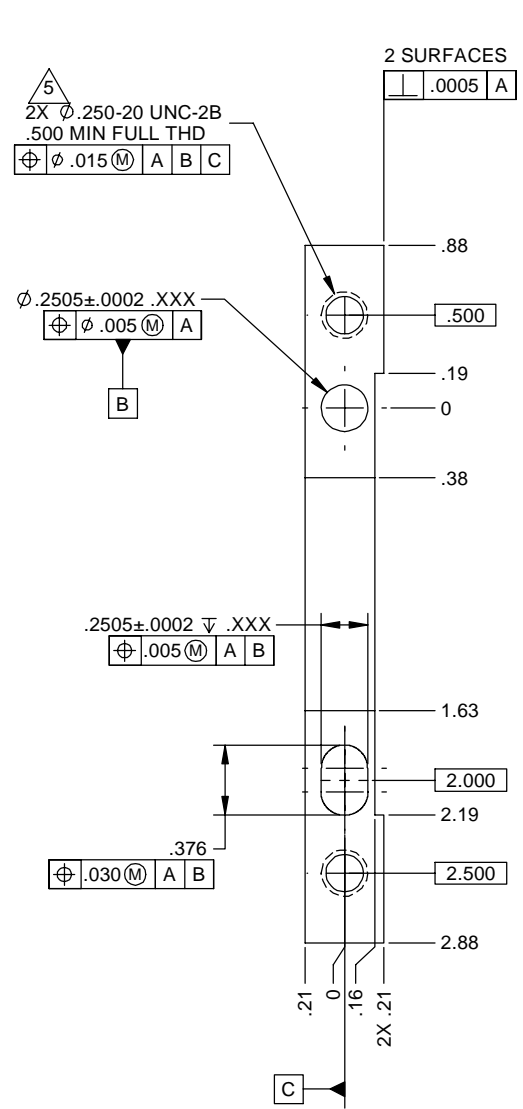


REVISIONS												
LTR	ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE										



ISOMETRIC VIEW FOR REFERENCE ONLY

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 98380A537	PIN Ø.250 X .500 L		CRES	
1	1			2000XXX-1	STAGE 1-2 VERT ACTUATOR SETUP TOOLING, COIL SIDE			
-1								
QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .XX ±.03 .XXX ±.010 ANGLES ±1/2° 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		DWN J. LARAMEE 10/07/04 PROJ ENGR STRS CHK MATL CONFIG PROJ ME QA		STAGE 1-2 VERT ACTUATOR SETUP TOOLING, COIL SIDE LIGO D04XXXX-A	
APPLICATION		MATERIAL AL 6061-T651 AMS-QQ-250/11		SIZE D CAGE CODE 1KNU9 SCALE 2:1		REV 0 D050353-00-D SHEET 1 OF 1	

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