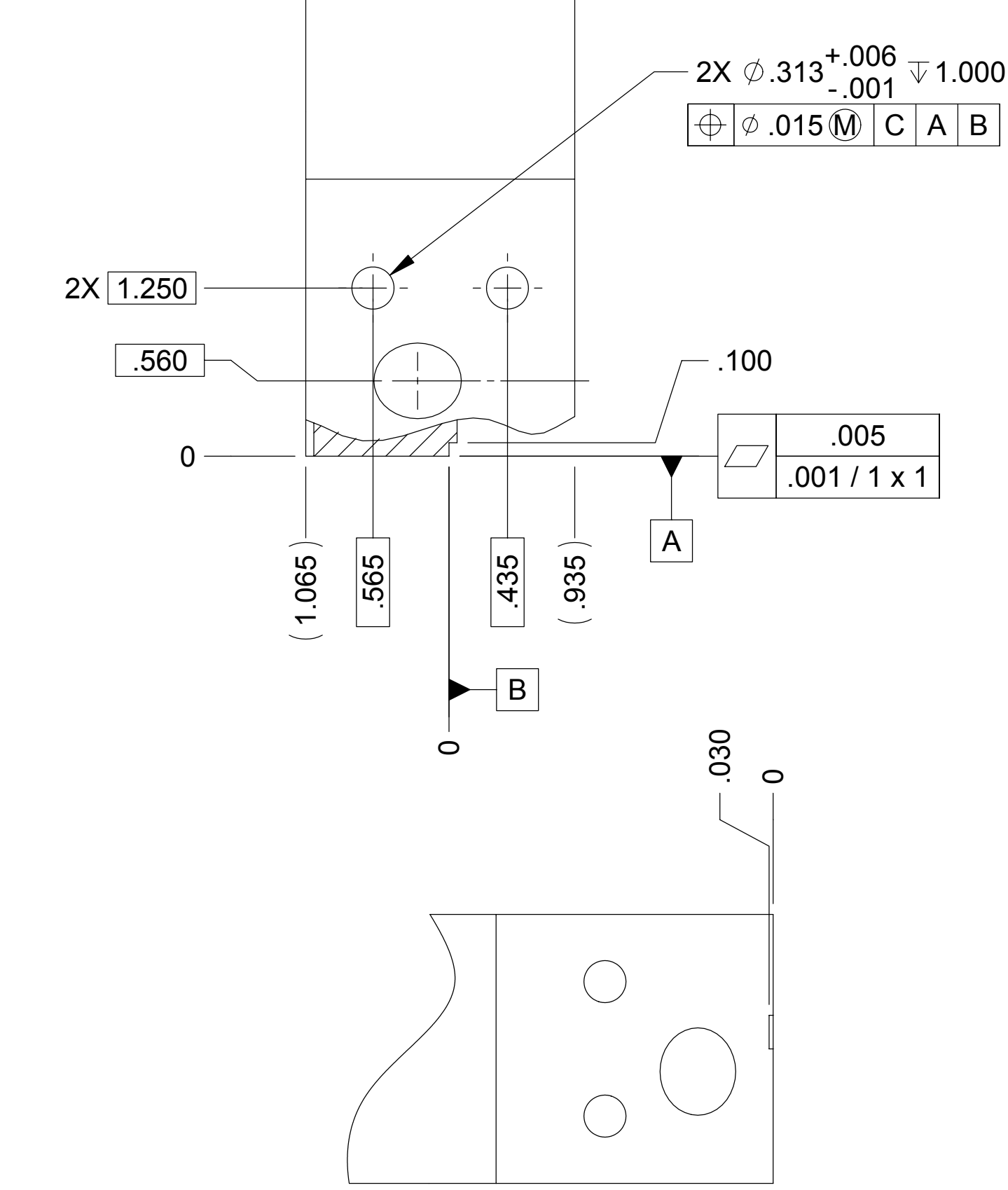
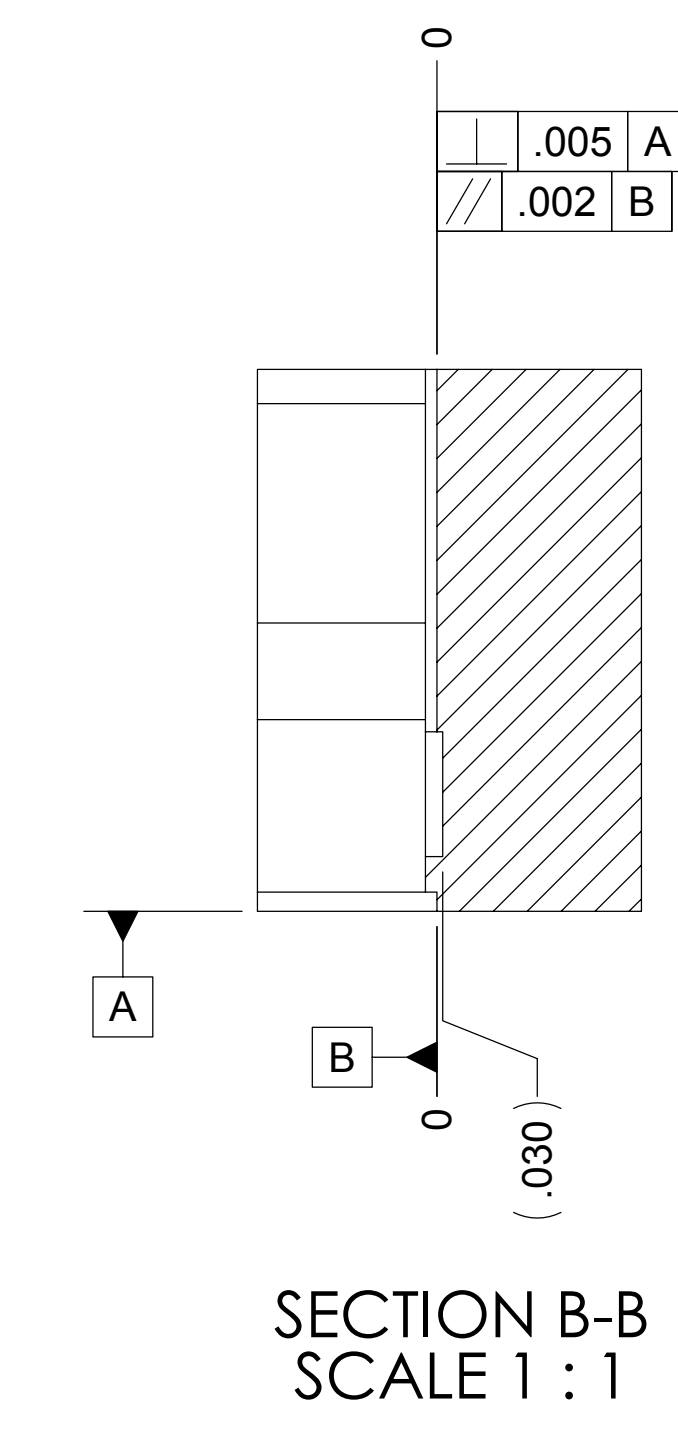
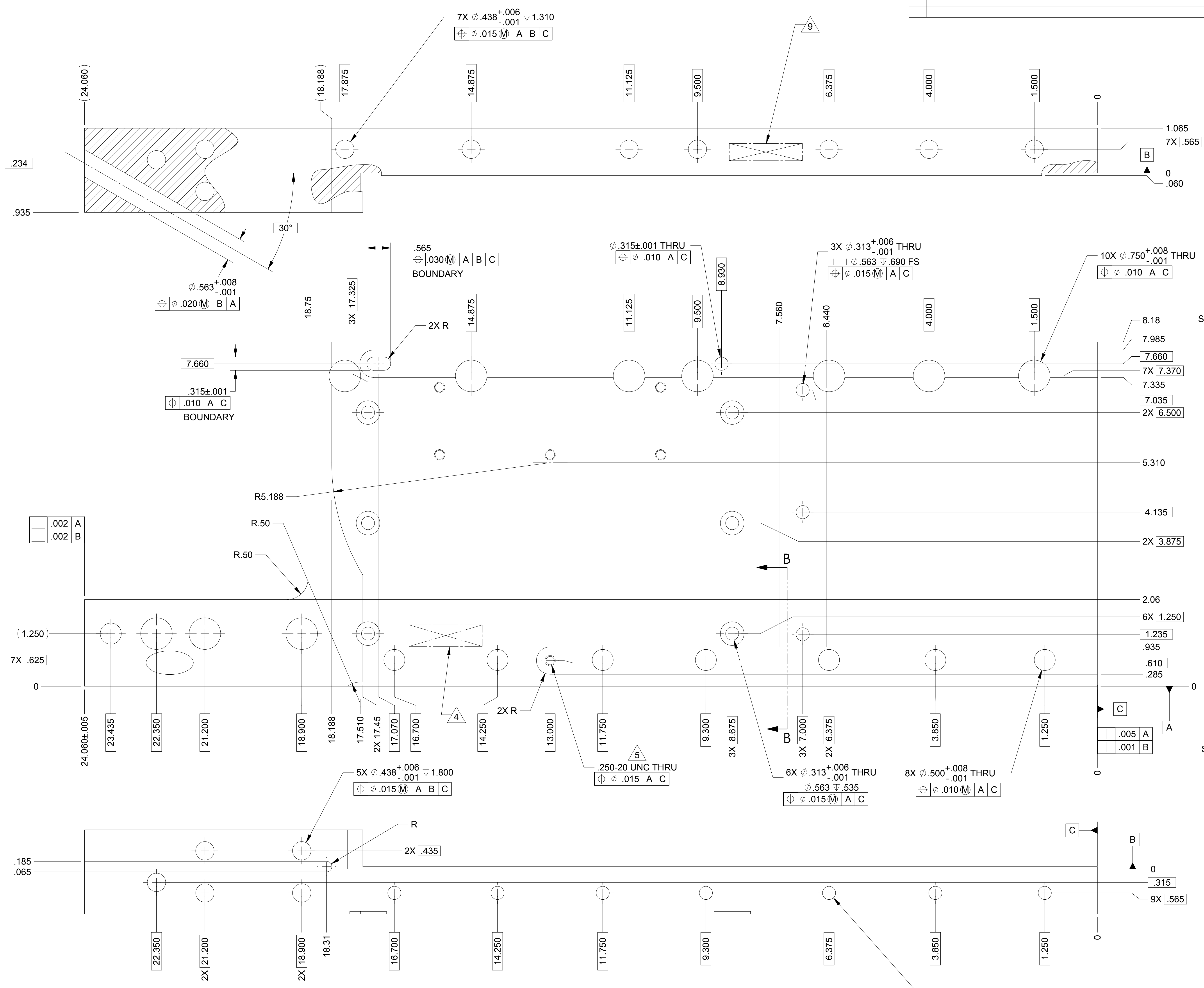
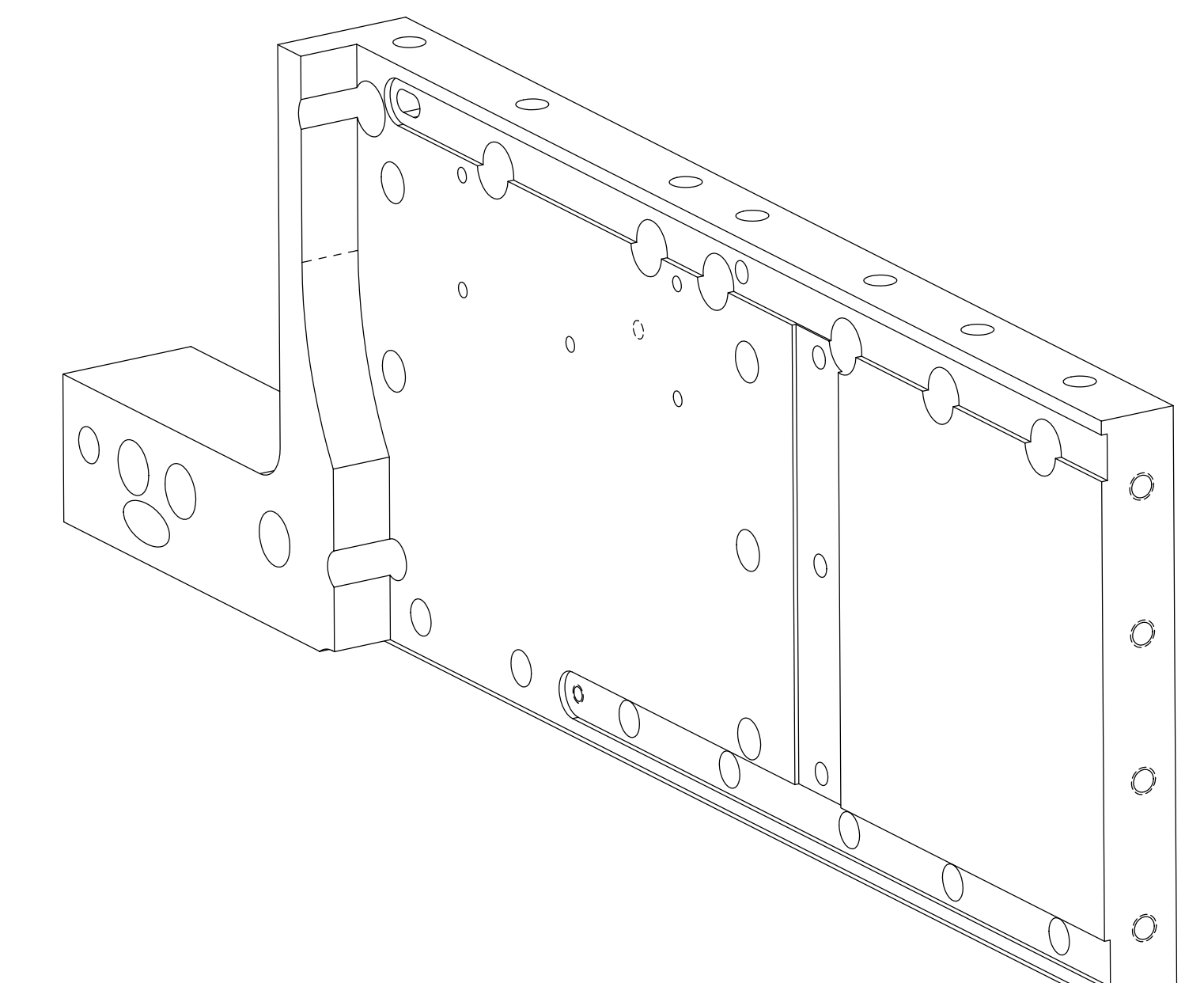


LTR		ZONE		REVISIONS										DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A				INITIAL RELEASE																				



- 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 NUMBER WITH 'P' EXTENSION 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.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 17.9 LBS.
 - MARK PART NUMBER WITH 'P' EXTENSION IN APPROXIMATE LOCATION SHOWN. USE ANY METHOD THAT WILL NOT RUB OFF OR SMUDGE UNDER NORMAL HANDLING. THIS MARKING DOES NOT NEGATE NOTE 7 AND WILL BE REMOVED DURING SUBSEQUENT OPERATIONS DEPICTED IN DRAWING 20007871.



QTY		REGD	ITEM NO	REF DES	CAGE NO	20007852-1P	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
PARTS LIST											
CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES									
		TOLERANCES									
		DECIMALS ANGLES									
		.XX ±.03 .XXX ±.010 ±.12°									
		MACHINE FINISH 125									
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M-1994									
		MATERIAL									
		AL ALY 6061-T651 AMS-QQ-A-250/11									
20007871		1388									
NEXT ASSEMBLY		PROJECT CODE									
		APPLICATION									
FILE ATTACHMENTS		20007852_x_1									
		SCALE 1:2									
		SHEET 1 OF 2									

RELEASED
12/4/2005

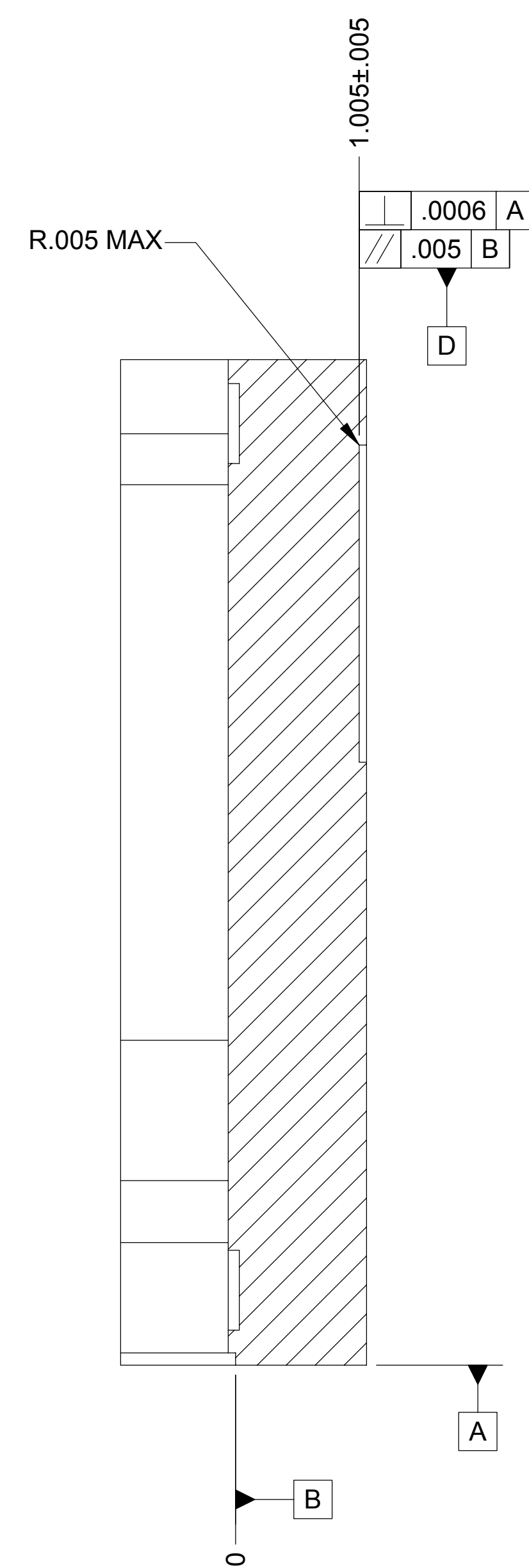
asi ALLIANCE SPACESYSTEMS, INC.
1250 Lincoln Ave., Suite 100
Pasadena, CA 91103

**PLATE, SIDE (GS-13)
STAGE 2
LIGO-D047852-A**

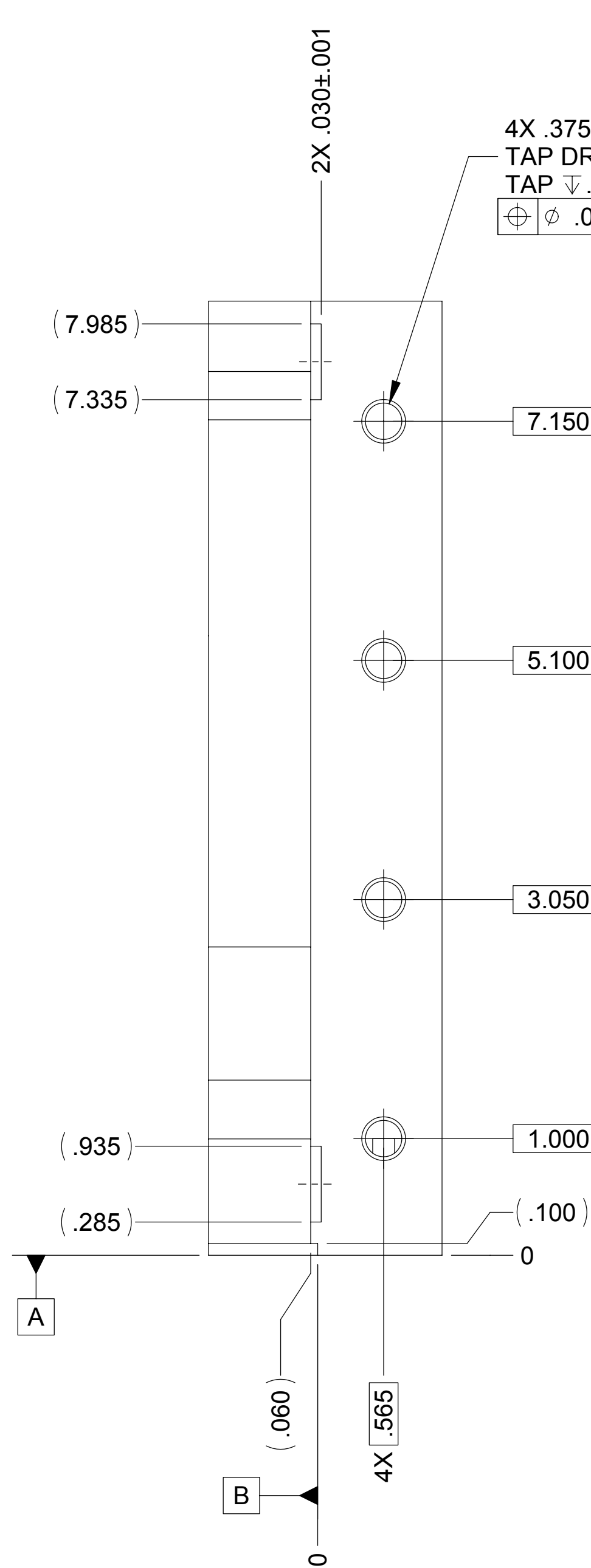
SIZE E CAGE CODE 1KNU9
20007852 REV A

8 7 6 5 4 3 2 1

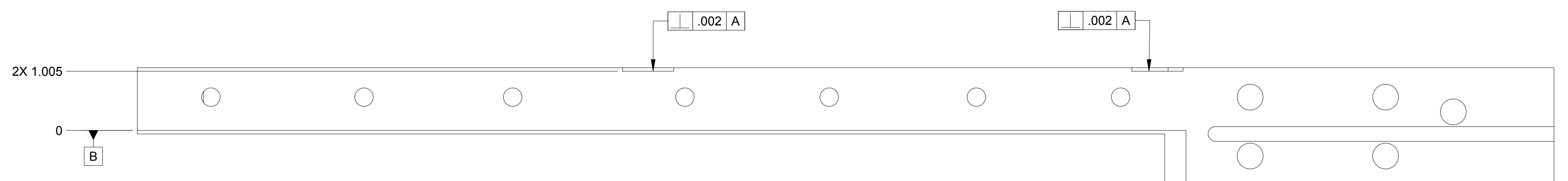
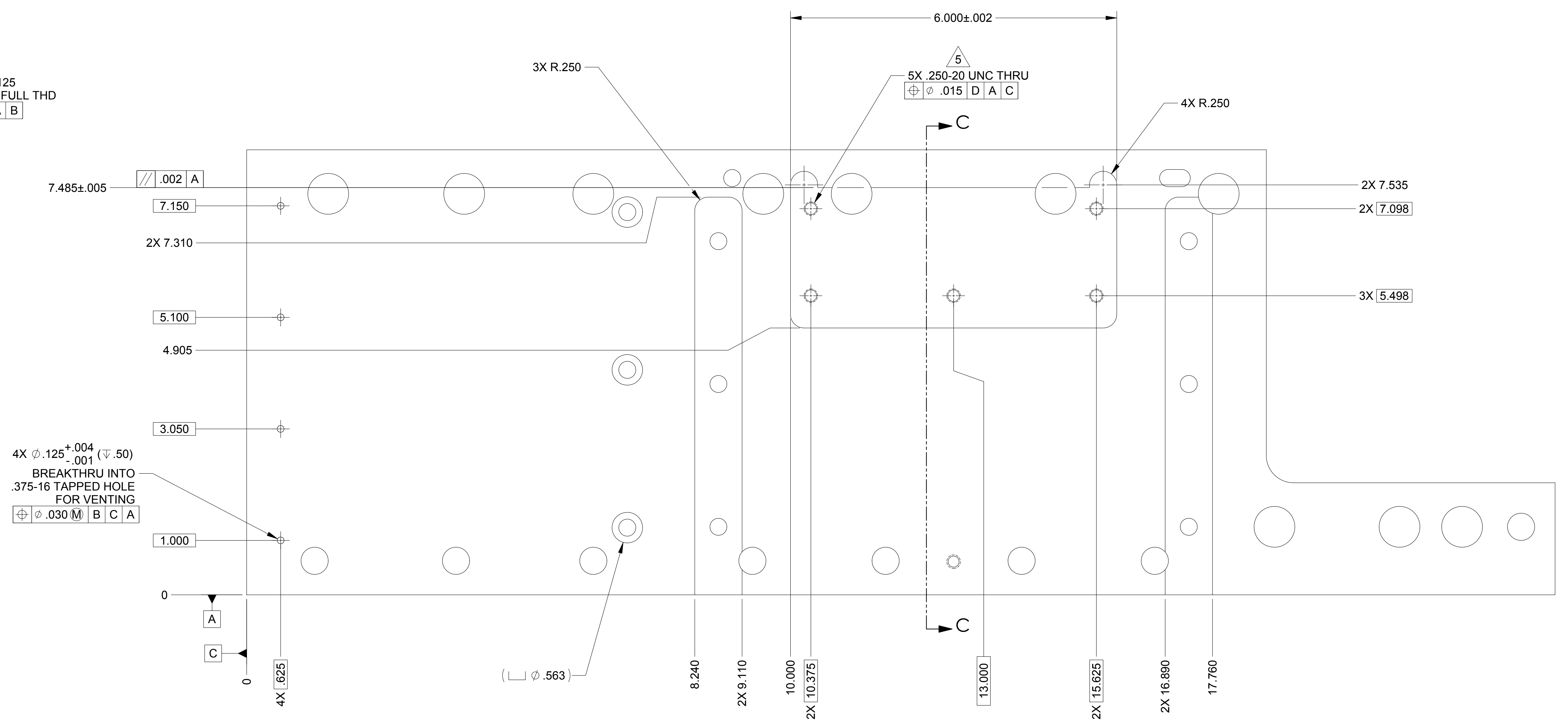
H
G
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SECTION C-C



VIEW A-A



8 7 6 5 4 3 2 1