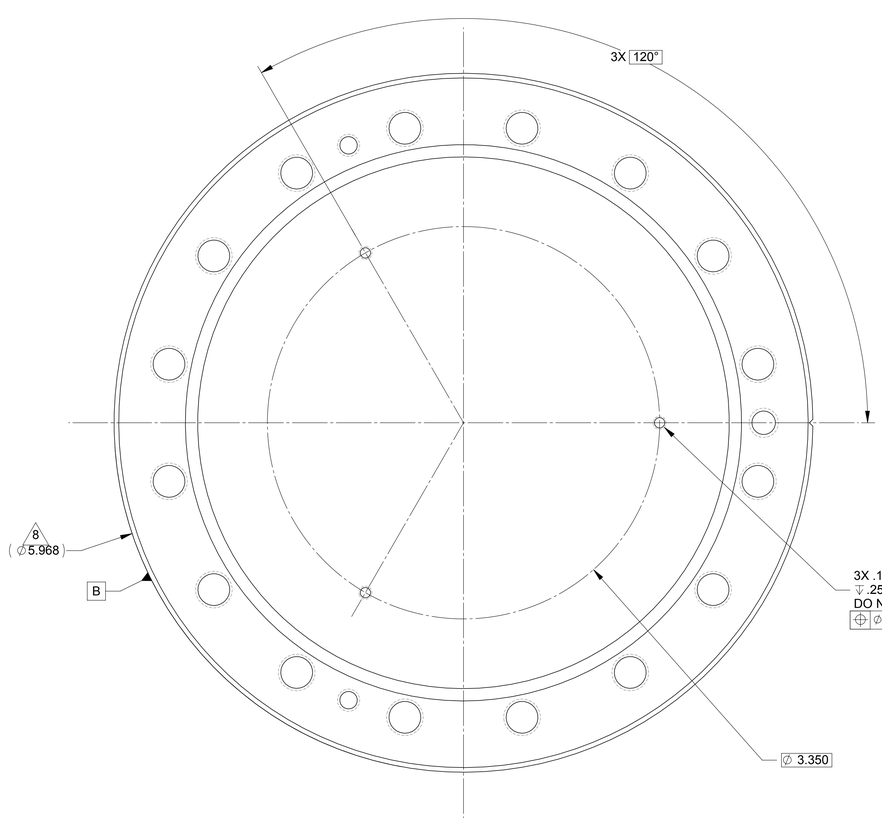
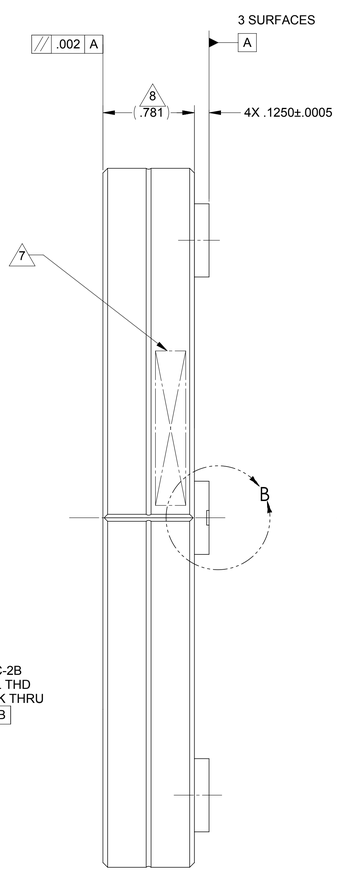
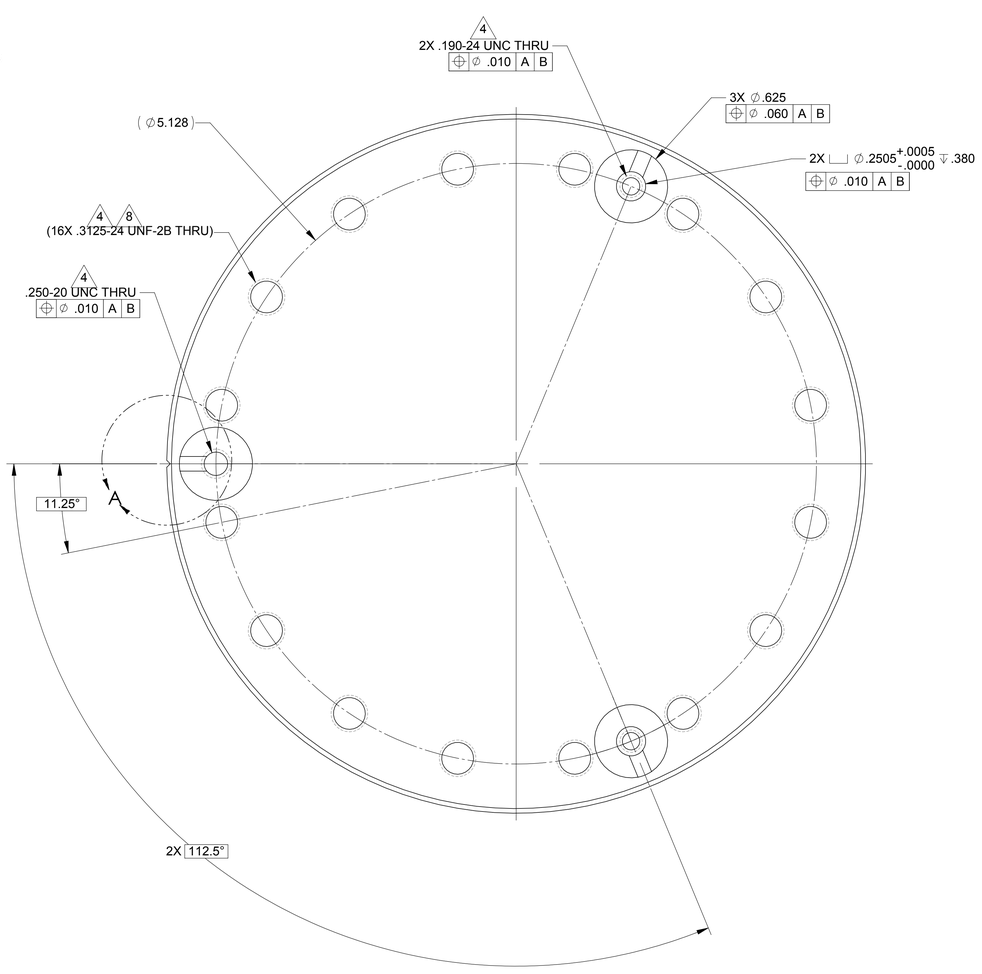
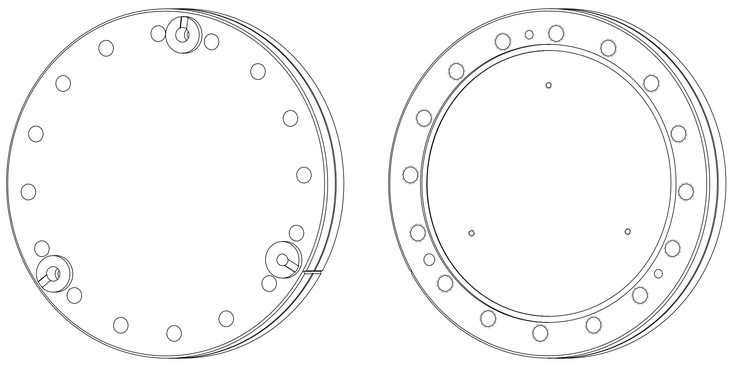
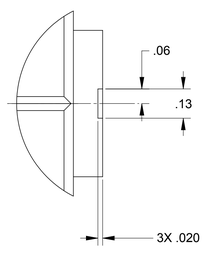
REVISIONS											
LTR	ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONFIG	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE										
		minor note changes from ASI referenced document to LIGO referenced document on 5/19/2009										



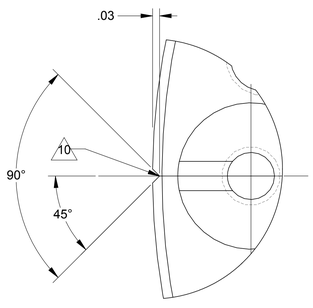








DETAIL B
SCALE 4 : 1
TYPICAL 3 PLACES



10
DETAIL A
SCALE 4 : 1
TYPICAL 3 PLACES

NOTES: UNLESS OTHERWISE SPECIFIED.

1. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
2. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
3. MACHINE FILLET RADII .003-.015.
4. 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.
5. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
6. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
7. WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE (VIBRATORY ACCEPTABLE) THE FOLLOWING INFORMATION AS SHOWN BELOW: LIGO P/N-REVISION-TYPE, FOLLOWED ON THE NEXT LINE BY "S/N-" AND A THREE DIGIT SERIAL NUMBER, STARTING AT 100, AND PROCEEDING CONSECUTIVELY. USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER.

   D047813-C-1 (SHEET 1), D047813-C-2 (SHEET 2)
   S/N-100 (EXAMPLE) S/N-101 (EXAMPLE)

8. FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO TO NOR-CAL PRODUCTS PART NUMBER 600-000NT.
9. REFERENCE MATING PART DRAWING 20007823.
10. PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURERS OPTION BUT SHALL BE LOCATED AS SPECIFIED.
11. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS 5.8 LBS.
12. NOTE 4 DOES NOT APPLY.

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

20007822-1

QTY REQD	ITEM NO	REF DES	CAGE NO	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 .XX ±.03 .XXX ±.010
ANGLES ±1/2°
MACHINE FINISH 63
DO NOT SCALE DRAWING
INTERPRET DWG PER ASME Y14.5M - 1994

MATERIAL
304 CRES - ARGON OXYGEN DECARBURIZATION PER ASTM-240

RELEASED
2/4/2005

DWN KJ SPINK 02/24/04
PROJ ENGR
CHK
CONFIG
ME
STRS
MATL
PROJ
QA

FILE ATTACHMENTS

20007790	1388
NEXT ASSEMBLY	PROJECT CODE
APPLICATION	

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

BASEPLATE, CF FLANGE L4-C SEISMOMETER LIGO-D047822-A

SIZE	CAGE CODE		REV
E	1KNU9	20007822	A

SCALE 2:1 | UNCLASSIFIED | SHEET 1 OF 1

REV 7/04