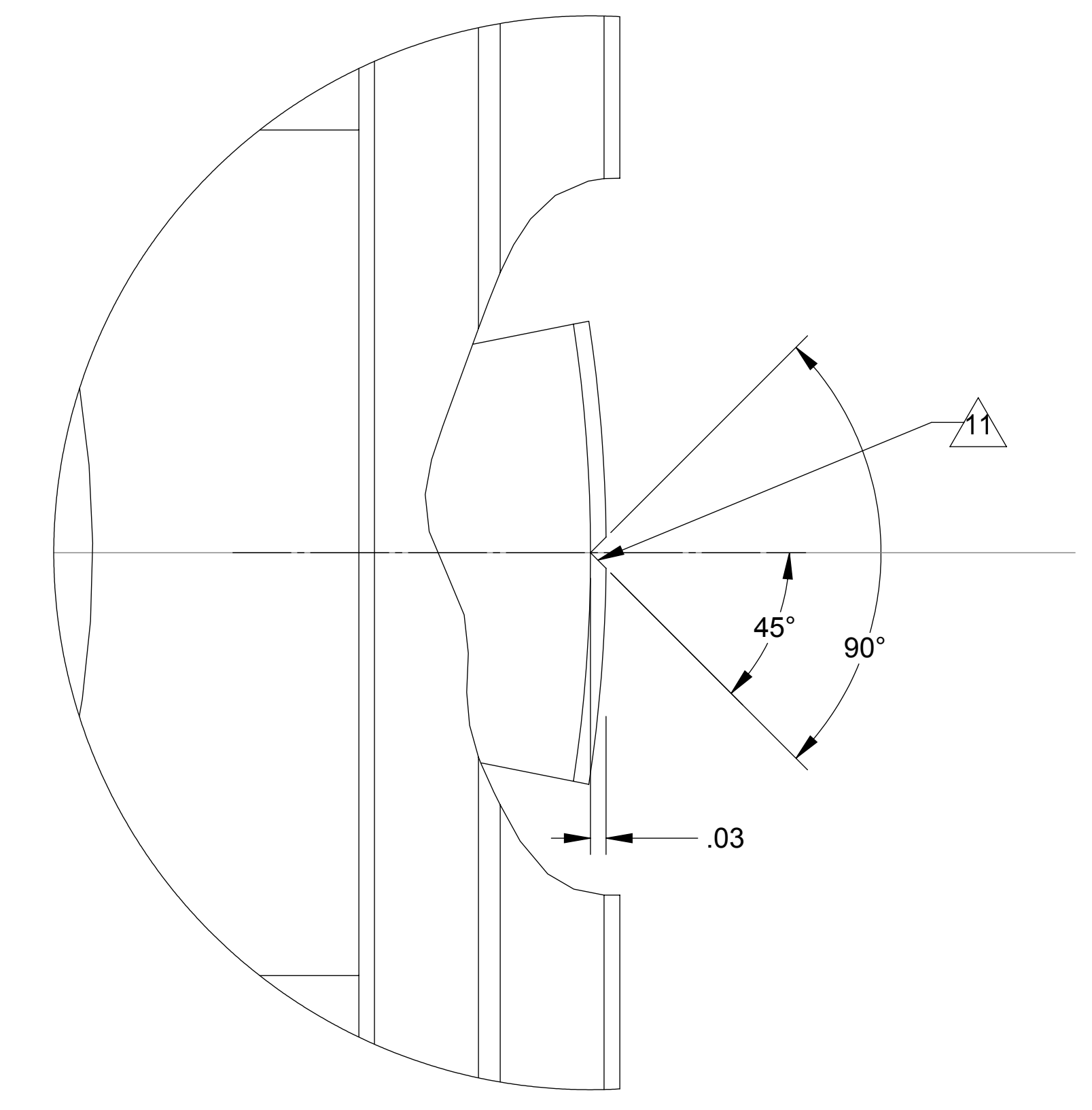
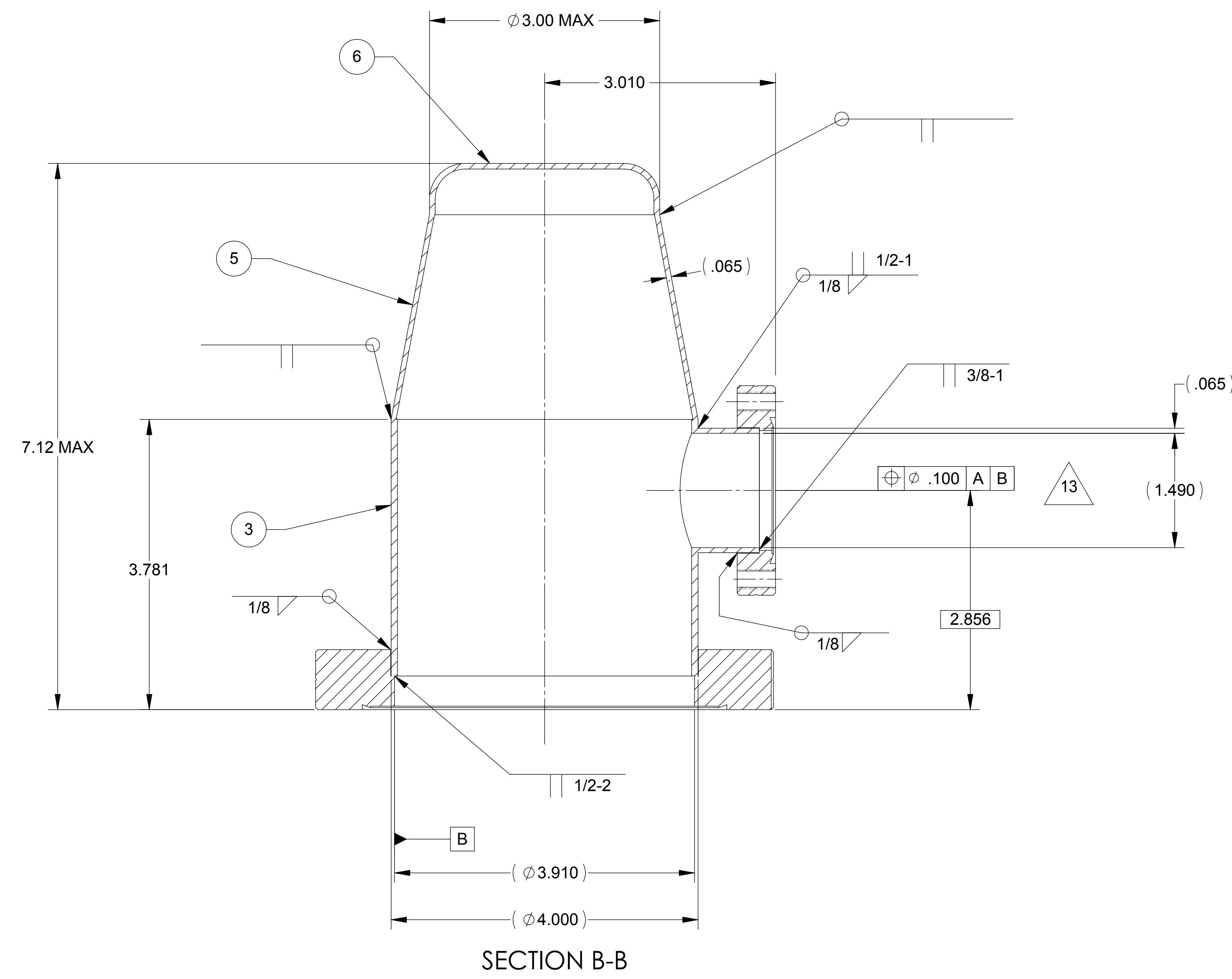
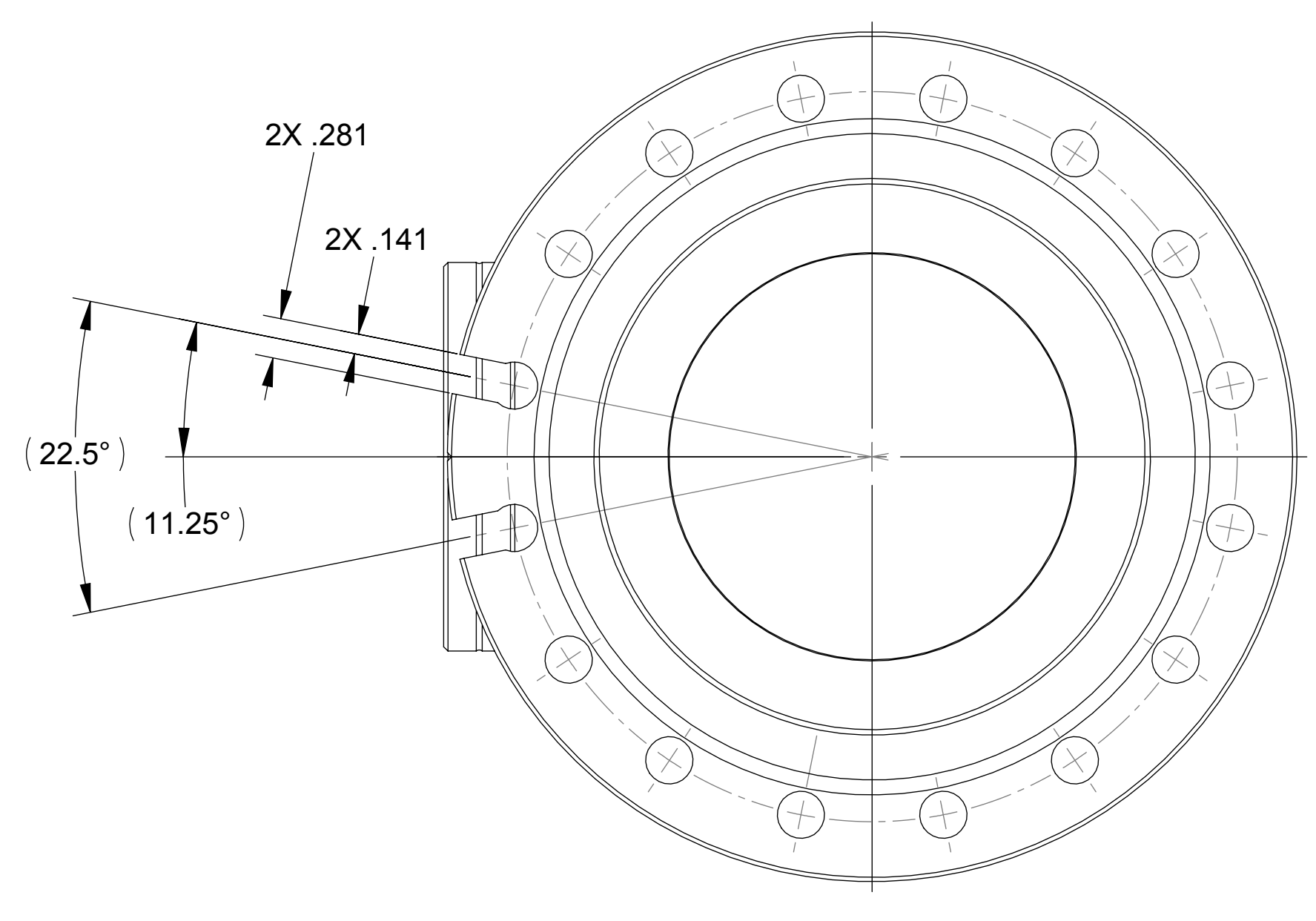
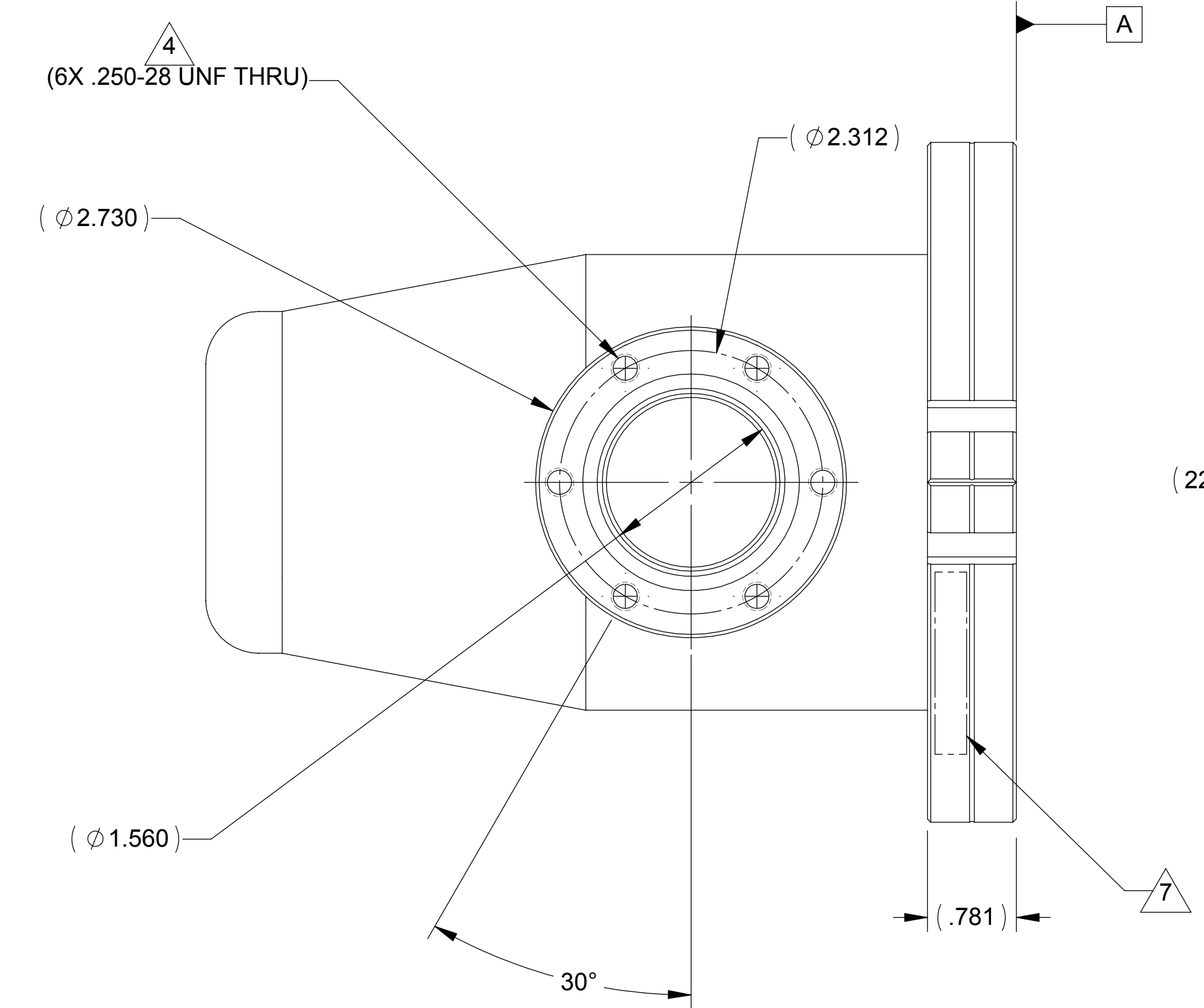
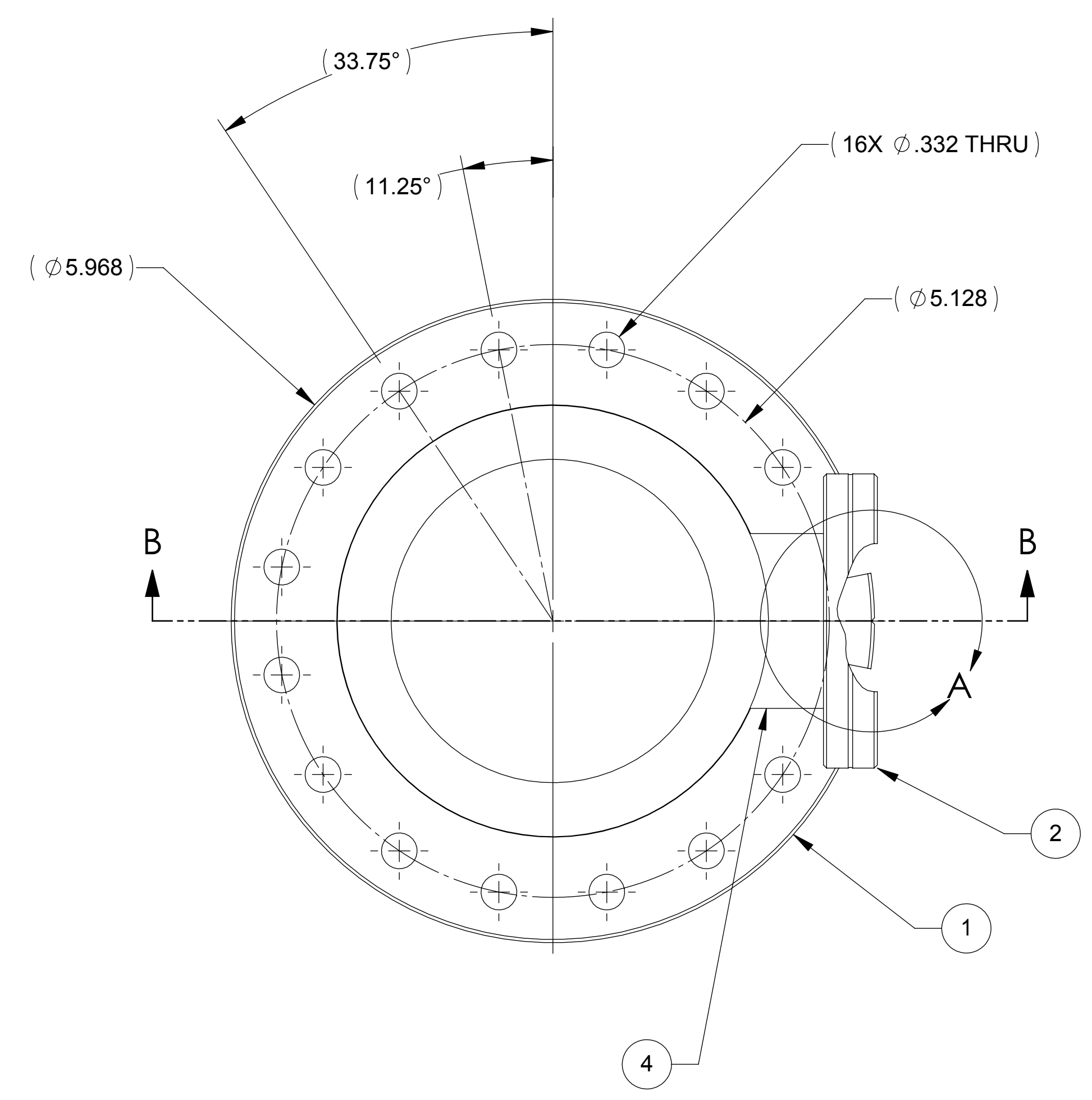


LTR		ZONE		REVISIONS										DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE	
A				INITIAL RELEASE																				
minor note changes- ligo doc references rather than ASI doc references on 5-19-09																								



DETAIL A
SCALE 4:1

NOTES: UNLESS OTHERWISE SPECIFIED.

- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E048225.
- REMOVE ALL BURRS AND SHARP EDGES .005-.015.
- MACHINE FILLET RADII .003-.015.
- THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/- .000.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- 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.
- FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO THE APPROPRIATE NOR-CAL PRODUCTS PART NUMBERS LISTED IN THE PARTS LIST.
- REFERENCE MATING PART DRAWING 20007822.
- ELECTROPOLISH TUBES PRIOR TO WELDING PER BEST COMMERCIAL PRACTICE.
- PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- ALL WELDS ARE GTAW.
- APPLIES PRIOR TO WELDING.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	NorCal part No.	MATERIAL OR NOTE	ZONE
1		6			20007823-106	CAP, END	G-2W-300	(CRES 304)	
1		5			20007823-105	REDUCER, ϕ 4.00 TO ϕ 2.50 X .065 WALL	B-31W-400-250	(CRES 304)	
1		4			20007823-104	TUBE, ϕ 1.62 X .065 WALL	SST-162	(CRES 304)	
1		3			20007823-103	TUBE, ϕ 4.00 X .083 WALL	SST-400	(CRES 304)	
1		2			20007823-102	PORT, CF FLANGE ϕ 2.75	275-162N	(CRES 304)	
1		1			20007823-101	BASE, CF FLANGE ϕ 6.00	600-400N	(CRES 304)	

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		PARTS LIST	
		DECIMALS: .XX ± .03 ANGLES: XXX ± 010 ± 12°		RELEASED 2/22/2005	
		MACHINE FINISH 125/		DWN KEVIN J SPINK 02/24/04	
		DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994		PROJ ENGR STRS	
		MATERIAL		CHK MATL	
		SEE PARTS LIST		CONFIG PROJ	
20007820 1388				ME QA	
NEXT ASSEMBLY PROJECT CODE				SIZE E	
APPLICATION				CAGE CODE 1KNU9	
				SCALE 1:1	
				UNCLASSIFIED SHEET 1 OF 1	

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Pasadena, CA 91103

**CHAMBER, SIDE PORT
L4-C SEISMOMETER
LIGO-D047823-A**

20007823 REV A

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