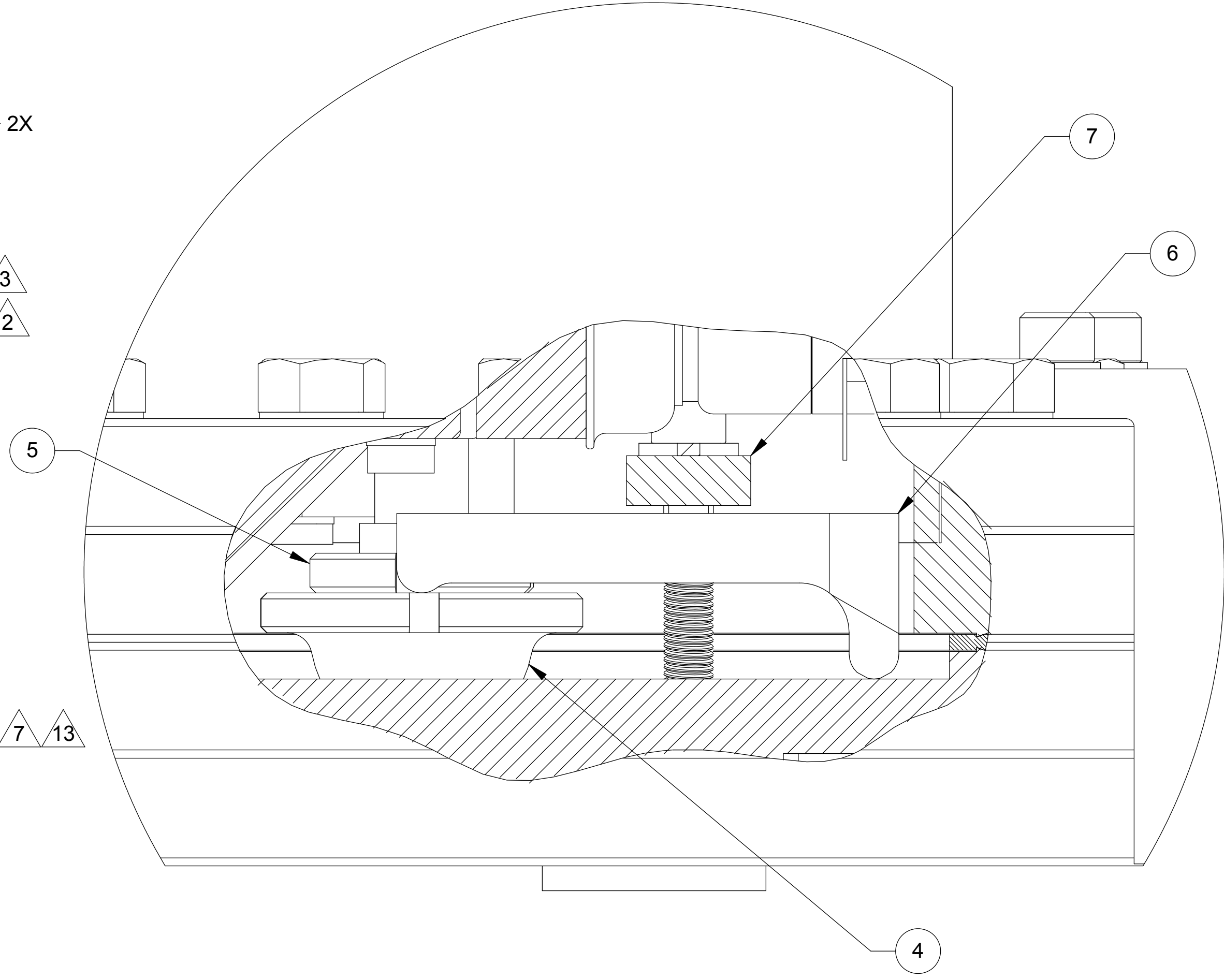
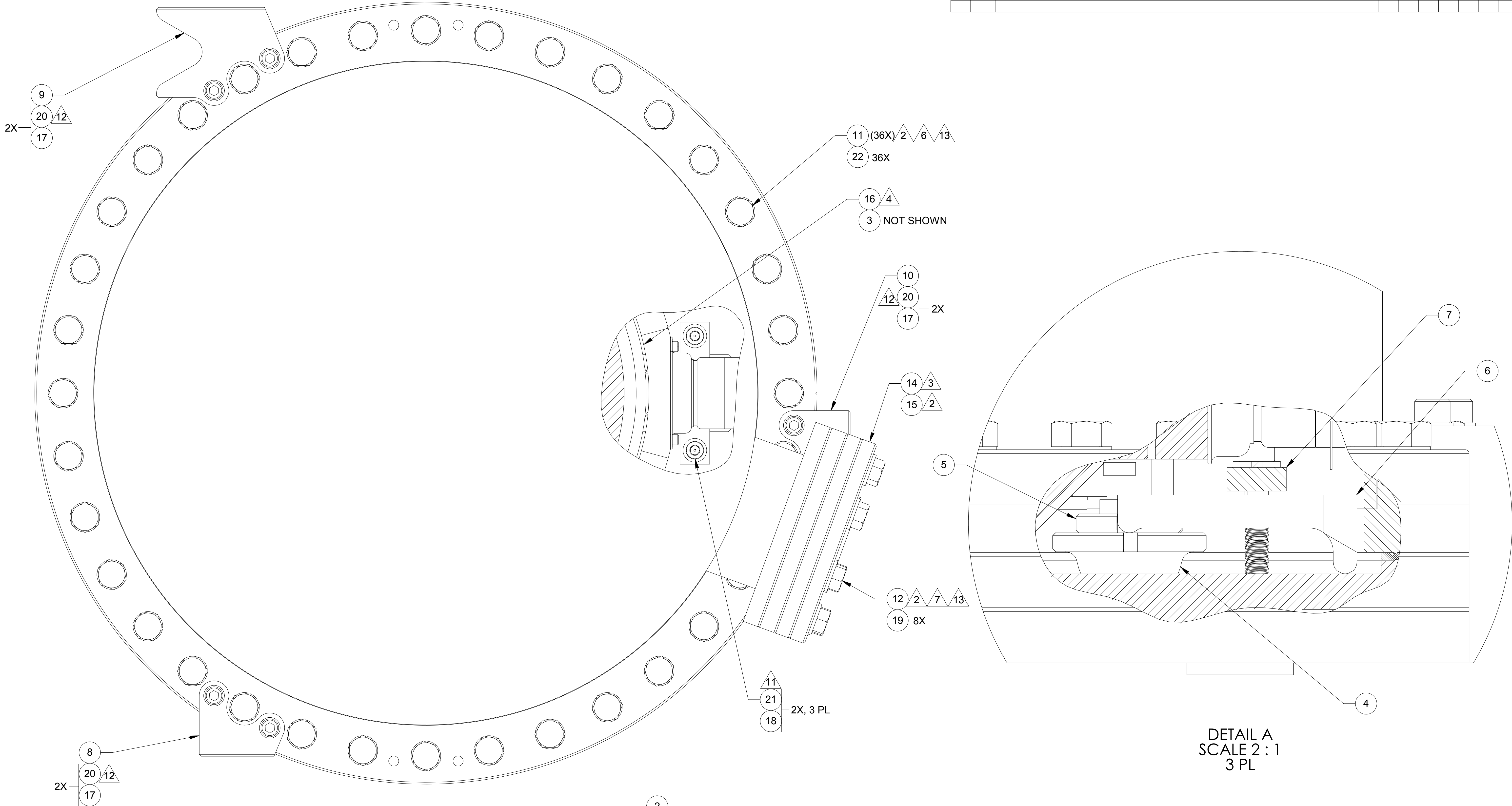
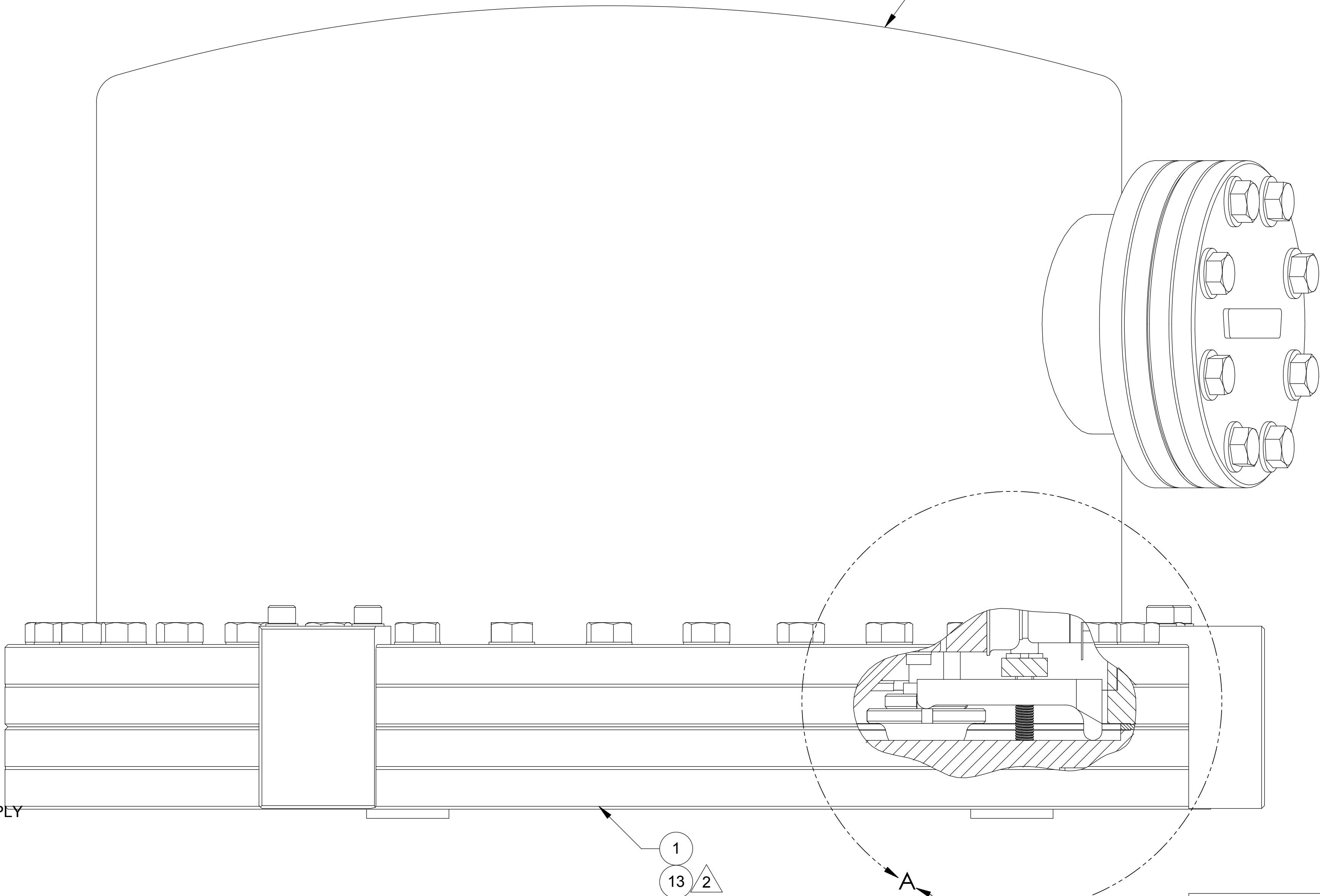


LTR	ZONE	DESCRIPTION	REVISIONS													
			DWN	CHK	P-ENG	CONF	ME	STRS	MATL	PROJ	QA	RELEASE DATE				
A		INITIAL RELEASE														



DETAIL A
SCALE 2 : 1
3 PL



QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
5		36	22		WFV-38	WASHER, FLAT, VENTED	380 ID, .625 OD, .032 THK	18-8 CRES	
5		6	21		C-2824-NA	SCREW, SHC	.250-28 UNF X 1.500L	18-8 CRES	
5		6	20		C-2012-A	SCREW, SHC, VENTED	.250-20 UNC X .750L	18-8 CRES	
5		8	19		WFV-31	WASHER, FLAT, VENTED	328 ID, .562 OD, .032 THK	18-8 CRES	
5		6	18		NAS620L-416	WASHER, FLAT	.255 ID, .468 OD, .032 THK	18-8 CRES	
5		6	17		WFV-25	WASHER, FLAT, VENTED	.255 ID, .468 OD, .032 THK	18-8 CRES	
4		1	16		STS-2	STS-2 SEISMOMETER			
2		1	15		G-338	GASKET, 4.50 OFHC			
3		1	14		100220	FLANGE, CONNECTOR FEED	Ø4.5, 25 PIN		
2		1	13		G-1650	GASKET, 16.50 OFHC			
13	2	1	12		B-450T-12-2P	KIT, .3125-24 BOLTS, FLAT WASHERS			
13	2	1	11		B-1650T	KIT, .375-24 BOLTS, FLAT WASHERS			
1		1	10		20007985-1	CAM FLAT			
1		1	9		20007983-1	CONCAVE, LOCATOR, REAR			
1		1	8		20007982-1	FLAT, LOCATOR			
3		3	7		20007794-1	CROSSBAR, KINEMATIC FOOT			
3		3	6		20007793-1	CLAMP, KINEMATIC FOOT			
3		3	5		20007792-1	NUT, JAM			
3		3	4		20007791-1	FOOT, KINEMATIC			
1		1	3		20007808-1	HARNES			
1		1	2		20007795-1	CHAMBER, SIDE PORT			
1		1	1		20007796-1	BASEPLATE			

- NOTES: UNLESS OTHERWISE SPECIFIED.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
 - SOURCE OF SUPPLY: NOR-CAL PRODUCTS INC. YREKA, CALIFORNIA 96097
 - SOURCE OF SUPPLY: ACCUGLASS PRODUCTS INC. SAN FERNANDO, CALIFORNIA 91340
 - SOURCE OF SUPPLY: QUANTERRA, INC. HARVARD, MASSACHUSETTS 01451 AS SPECIFIED BY LIGO.
 - SOURCE OF SUPPLY: U-C COMPONENTS MORGAN HILL, CALIFORNIA 95037
 - TORQUE (DETERMINED BY SUPPLIER): 345 IN. LBS.
 - TORQUE (DETERMINED BY SUPPLIER): 190 IN. LBS.
 - ALIGN MARKS PRIOR TO INSTALLING ITEM 12
 - MARK ASSY AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.13-INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006886, TYPE I, CLASSES 4, 5, OR 6. SERIAL NUMBERS START AT 001 FOR FIRST PART AND PROCEED CONSECUTIVELY.
 - BOLT TORQUING PROCEDURE SHALL ENSURE THAT THE SPECIFIED TORQUE IS APPLIED WITHIN A TOLERANCE OF +5% / -10%.
 - TORQUE: 68 OZ IN.
 - TORQUE: 60 IN LBS.
 - DISCARD FLAT WASHERS SUPPLIED WITH KIT.
 - ALL SCREWS SHALL BE SILVER PLATED. DIMENSIONAL TOLERANCES PER UNC/UNF-2A APPLY AFTER PLATING.
 - RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL ASSEMBLY. ESTIMATED WEIGHT IS: 113.5 LBS.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES: DECIMALS .XX ±.03 ANGLES XXX ±.010 ±12°
MACHINE FINISH V
DO NOT SCALE DRAWING INTERPRET DWG PER ASME Y14.5M - 1994

RELEASED 3/4/2005

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

STS-2 SEISMOMETER POD ASSEMBLY
LIGO D047790-A

20007970 1388
NEXT ASSEMBLY PROJECT CODE
APPLICATION

SCALE 1:1

UNCLASSIFIED SHEET 1 OF 1