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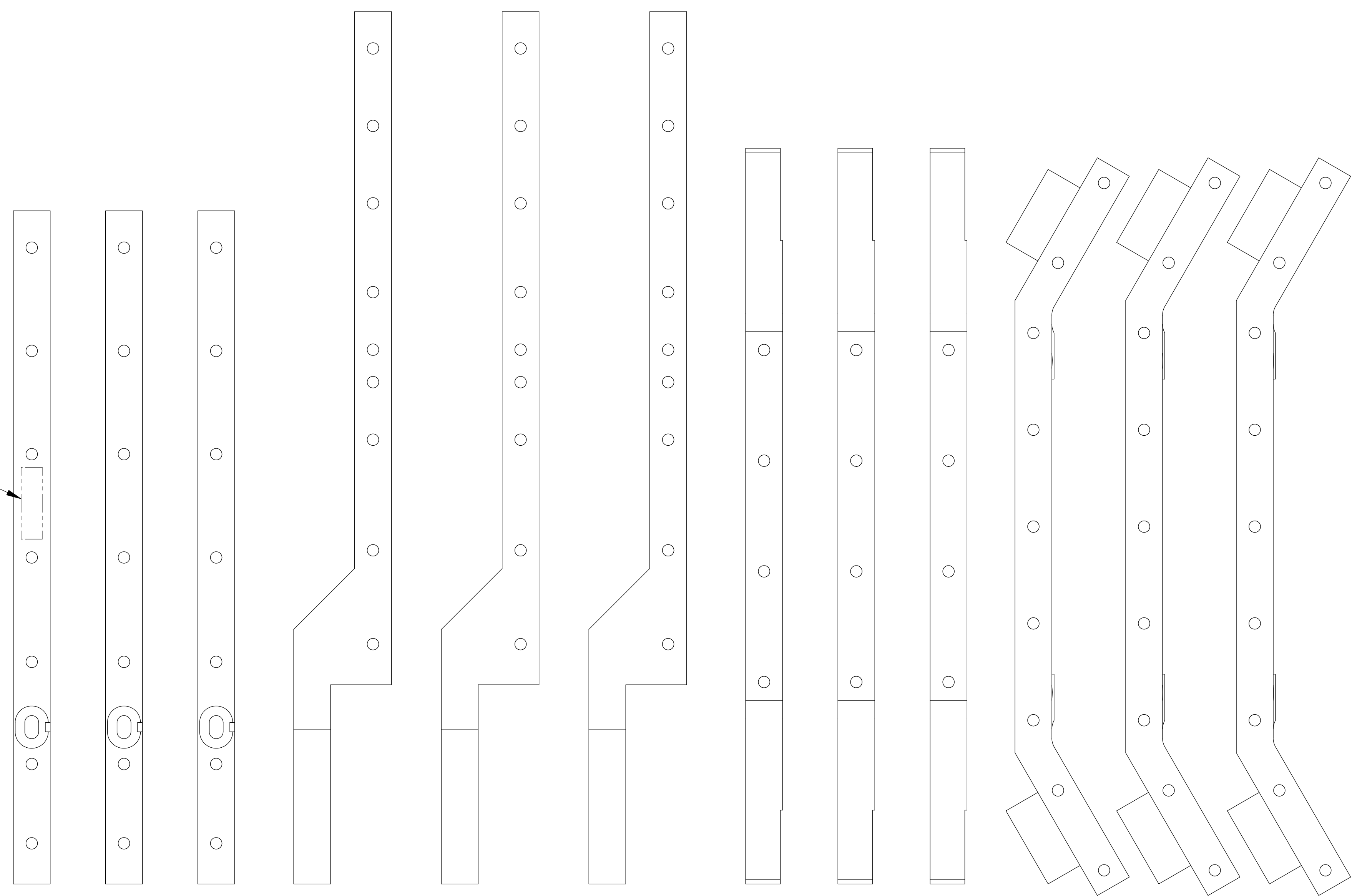
3

2

1

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

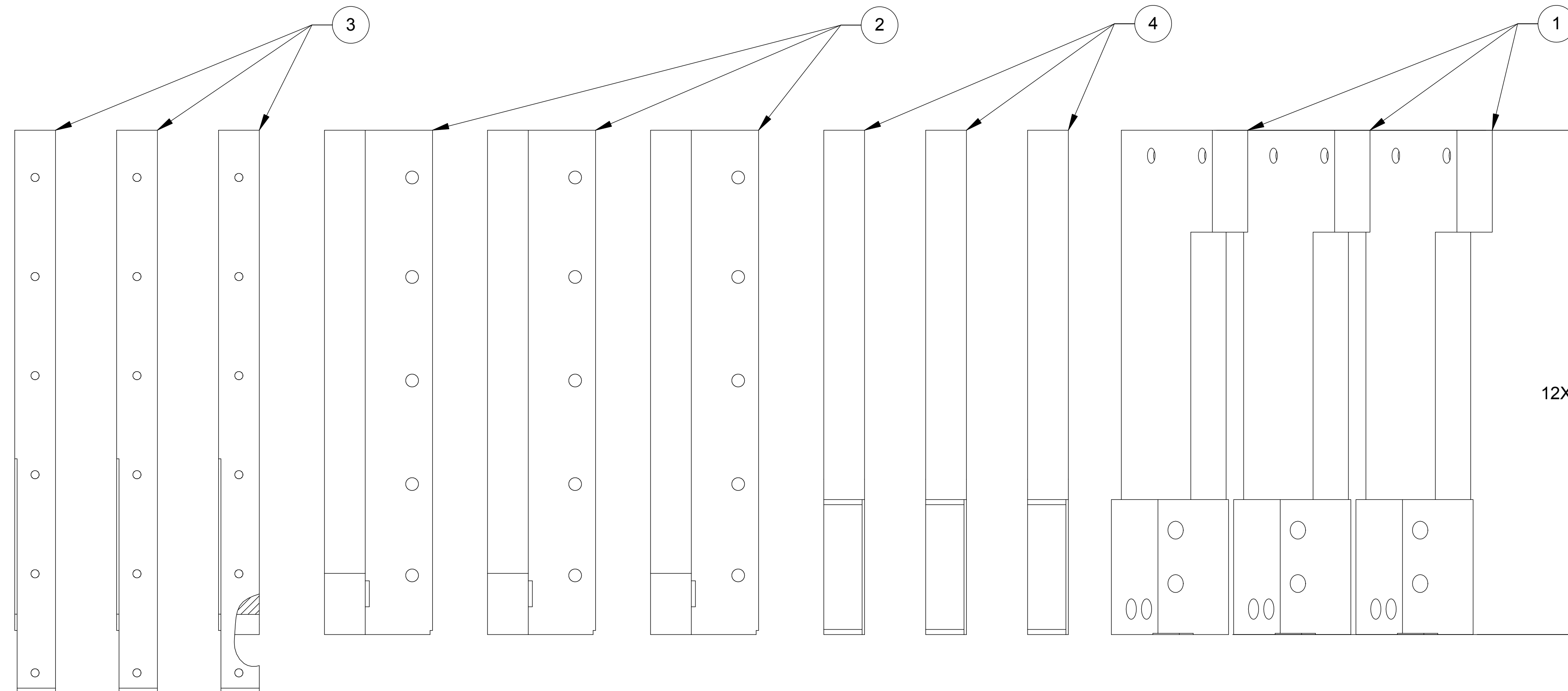
3  
12 PARTS



12 SURFACES  
(ACROSS ALL PARTS)  
A .001 A

12X 12.370±.005

18 SURFACES  
A .001 A



NOTES: UNLESS OTHERWISE SPECIFIED.

1. THIS DOCUMENT CONTROLS FINAL HEIGHT OF STAGE 1 STRUCTURE WALLS.
2. PARTS SHALL NOT BE MARKED WITH THIS DOCUMENT NUMBER.
3. SURFACE TO BE MACHINED IS MARKED WITH THE PART NUMBER, DASH NUMBER, AND THE LETTER "P". FOR EXAMPLE: 20007828-1P. THIS MARKING WILL BE REMOVED DURING THE MACHINING PROCESS. NO FURTHER MARKING IS REQUIRED.
4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
5. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
6. MACHINE FILLET RADII .003-.015.
7. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/- .000.
8. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.

QTY	REGD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
		3	4		20007830-1P	HEX MIDWALL			
		3	3		20007829-1P	SIDE PLATE, L4-C INTFC			
		3	2		20007828-1P	SIDE PLATE, FLEXURE ROD			
		3	1		20007827-1P	ANGLED HEX WALL			

CONTRACT NO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PARTS LIST	
		DECIMALS	ANGLES	DATE	BY
		XX ±.03	XXX ±.010 ±1/2°	01/14/05	KEVIN J SPINK
		MACHINE FINISH	125/	PROJ ENGR	STRS
		DO NOT SCALE DRAWING	INTERPRET DWG PER ASME Y14.5M - 1994	CHK	MATL
		MATERIAL	SEE PARTS LIST	CONFIG	PROJ
		APPLICATION		ME	QA

20007825	1388	SIZE	E	CAGE CODE	1KNU9	SCALE	1:2
20007838 Final Machine Cut Walls.x_1		UNCLASSIFIED		20007838			

RELEASED  
2/17/2005

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

FINAL CUT - WALL HEIGHT  
STAGE 1  
LIGO D-047838-A

20007838  
SHEET 1 OF 1

8

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6

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REV 704