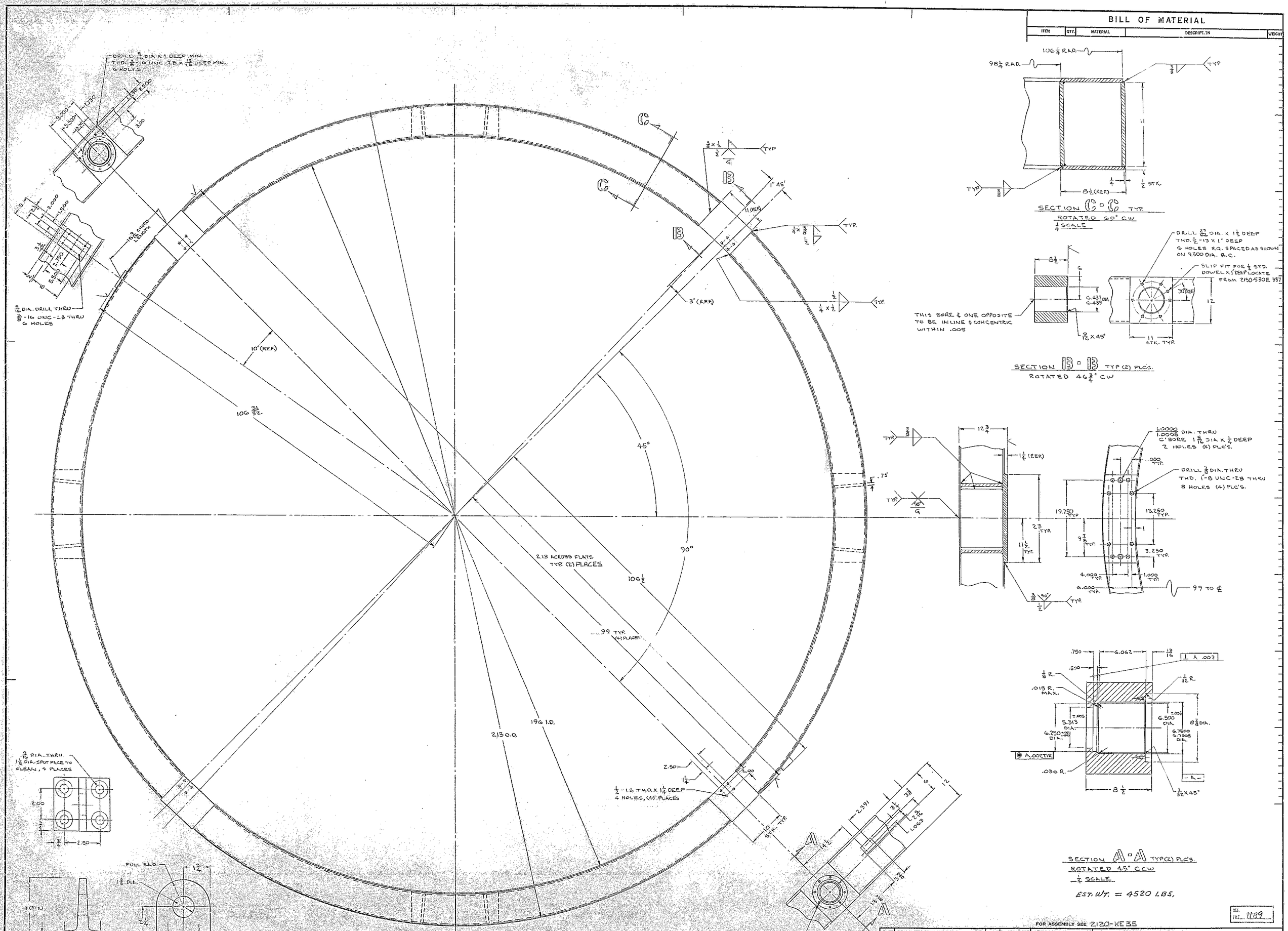
BILL OF MATERIAL
ITEM
QTY.
MATERIAL
DESCRIPTION
WEIGHT
DRILL 5/16 DIA X 1 DEEP MIN.
THD. 3/8-16 UNC-2B X 13/16 DEEP MIN.
6 HOLES
DIA. DRILL THRU
-16 UNC-2B THRU
6 HOLES
15.52 CHORD LENGTH
10° (REF)
106 31/32
45°
90°
2.13 ACROSS FLATS
TYP. (2) PLACES
106 1/2
.99 TYP. (4) PLACES
196 I.D.
213 O.D.
3" (REF)
1° 45'
11 (REF)
TYP.
1/2-13 THD X 1 1/4 DEEP
4 HOLES, (4) PLACES
DRILL 5/16 DIA X 1 DEEP MIN.
THD. 3/8-16 UNC-2B X 13/16 DEEP MIN.
8 HOLES EQ. SPACED ON
7.625 DIA. B.C. TYP (2) PLC'S.
.015 DIA
SECTION C-C TYP.
ROTATED 60° CW
1/4 SCALE
98 1/4 RAD.
106 1/4 RAD.
8 1/2 (REF)
1/4 STK.
1/2 STK.
DRILL 27/64 DIA. X 1 1/2 DEEP
THD. 1/2-13 X 1" DEEP
6 HOLES EQ. SPACED AS SHOWN
ON 9.500 DIA. B.C.
SLIP FIT FOR 1/2 STD.
DOWEL X 1" DEEP LOCATE
FROM 2150-530E 337
THIS BORE & ONE OPPOSITE
TO BE IN LINE & CONCENTRIC
WITHIN .005
6.437
6.439 DIA
9/16 X 45°
11 STK. TYP.
SECTION B-B TYP (2) PLC'S.
ROTATED 46 3/4° CW
4.0000 DIA. THRU
1.0008
C'BORE 1 9/16 DIA X 1/4 DEEP
2 HOLES (4) PLC'S.
DRILL 7/8 DIA. THRU
THD. 1-8 UNC-2B THRU
8 HOLES (4) PLC'S.
19.750 TYP
13.250 TYP.
3.250 TYP.
4.000 TYP.
1.000 TYP.
6.000 TYP.
99 TO ℄
12 3/4
1 1/4 (REF)
23 TYP.
11 1/2 TYP.
9 7/8 TYP.
SECTION A-A TYP (2) PLC'S.
ROTATED 45° CCW
1/4 SCALE
EST. WT. = 4520 LBS.
6.062
.750
.500
1/8 R.
.015 R. MAX.
5.313 DIA.
6.250 DIA.
6.500 DIA.
6.7500 DIA.
8 7/8 DIA.
.030 R.
8 1/2
1/32 R.
1/32 X 45°
A .002 TIR
.002
2.391
14 1/2
1.063
2.50
2.00
1 1/4
10 STK. TYP.
5/16 DIA. THRU
1 1/8 DIA. SPOT FACE TO
CLEAN, 4 PLACES
FULL RAD.
1 3/4
1 1/2 DIA.
2 1/4
4 (STK.)
1 1/2 (STK.)
LIFTING BRACKET
SCALE: 1/2 SIZE
(4) REQ'D.
MAT'L. STEEL TEE ASTM-A7 (4X4X1/2)
FOR ASSEMBLY SEE 2120-KE35
TOLERANCES UNLESS OTHERWISE NOTED
DECIMAL DIMENSIONS
.00 ±.010
.000 ±.002
FRACTIONAL DIMENSIONS
UP TO 18" ± 1/64
18" TO 30" ± 1/32
30" & OVER ± 1/16
BREAK SHARP EDGES
ALL SURFACES 125 TO HAVE FINISH UNLESS OTHERWISE NOTED.
A
DRAWING REVISED FROM 2120 KE127
ADDED LIFTING BRACKET
LET.
REVISION
ECR
DATE
BY
KITT PEAK NATIONAL OBSERVATORY
OPERATED BY THE
ASSOCIATION OF UNIVERSITIES FOR RESEARCH IN ASTRONOMY, INC.
UNDER CONTRACT WITH
NATIONAL SCIENCE FOUNDATION
150 INCH STELLAR TELESCOPE
NAME
LAYOUT OF REVISED UPPER RING GIRDER WELDMENT
SCALE 1/8 & NOTED
PRINT ISSUED
DRAWN BY
DATE
APPROVED BY
DATE
DRAWING NUMBER
2120 -E127
REV.
A
TUCSON TOOL DESIGN