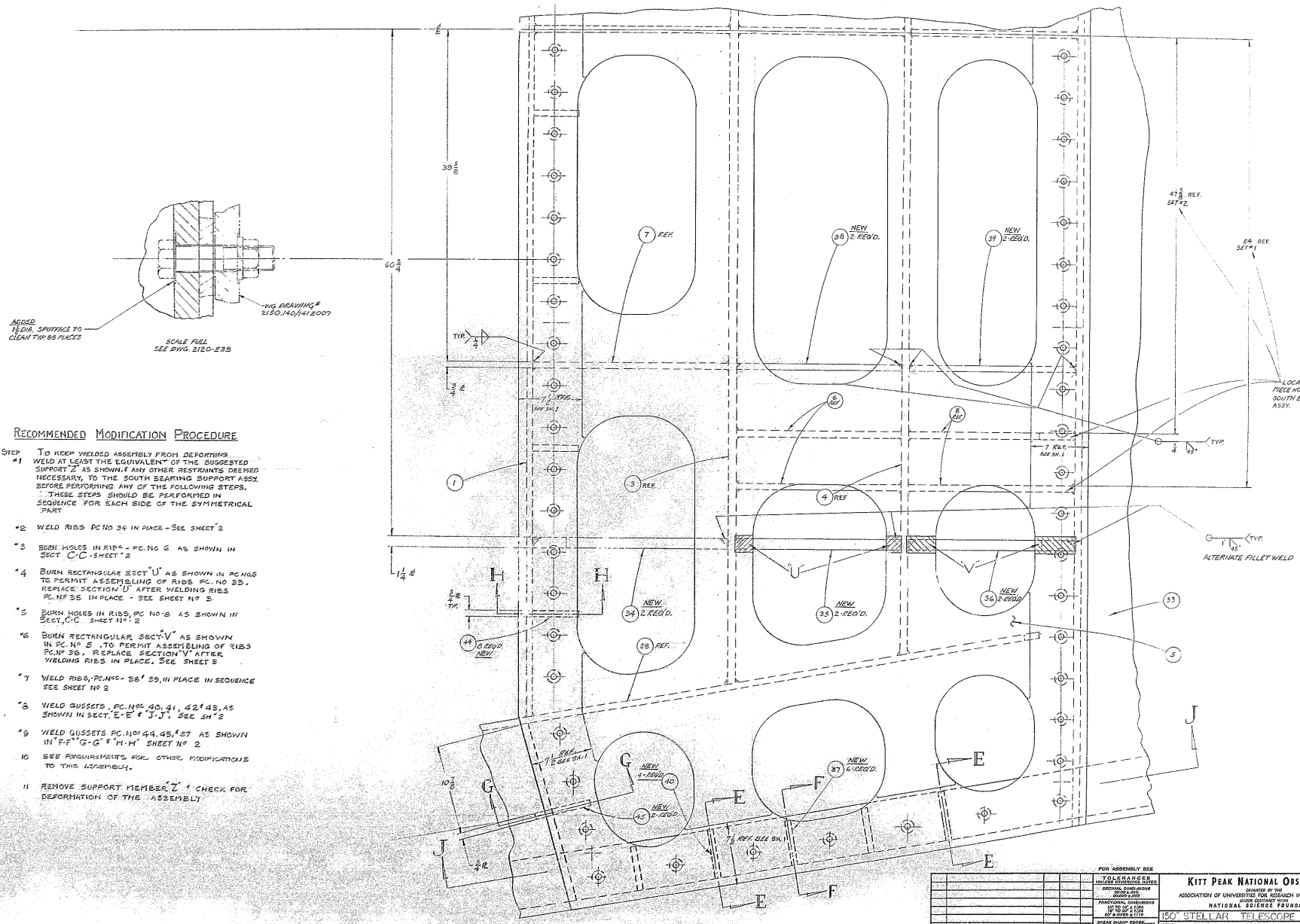
BILL OF MATERIAL				
ITEM	QTY.	MATERIAL	DESCRIPTION	WEIGHT



RECOMMENDED MODIFICATION PROCEDURE

STEP #1 TO KEEP WELDED ASSEMBLY FROM DEFORMING WELD AT LEAST THE EQUIVALENT OF THE SUGGESTED SUPPORT "Z" AS SHOWN & ANY OTHER RESTRAINTS DEEMED NECESSARY, TO THE SOUTH BEARING SUPPORT ASSY. BEFORE PERFORMING ANY OF THE FOLLOWING STEPS. THESE STEPS SHOULD BE PERFORMED IN SEQUENCE FOR EACH SIDE OF THE SYMMETRICAL PART

#2 WELD RIBS PC NO 34 IN PLACE - SEE SHEET 2

#3 BURN HOLES IN RIBS - PC. NO 6 AS SHOWN IN SECT C-C - SHEET 2

#4 BURN RECTANGULAR SECT "U" AS SHOWN IN PC. NO 5 TO PERMIT ASSEMBLING OF RIBS PC. NO 35, REPLACE SECTION "U" AFTER WELDING RIBS PC. Nº 35 IN PLACE - SEE SHEET Nº 3.

#5 BURN HOLES IN RIBS, PC NO 8 AS SHOWN IN SECT, C-C SHEET Nº 2

#6 BURN RECTANGULAR SECT "V" AS SHOWN IN PC. Nº 5 . TO PERMIT ASSEMBLING OF RIBS PC. Nº 36, REPLACE SECTION "V" AFTER WELDING RIBS IN PLACE. SEE SHEET 5

#7 WELD RIBS, PC. Nos 38 & 39, IN PLACE IN SEQUENCE SEE SHEET Nº 2

#8 WELD GUSSETS, PC. Nos 40, 41, 42 & 43, AS SHOWN IN SECT. "E-E" & "J-J". SEE SH. 2

#9 WELD GUSSETS PC. Nos 44, 45, & 37 AS SHOWN IN "F-F" "G-G" & "H-H" SHEET Nº 2

10 SEE REQUIREMENTS FOR OTHER MODIFICATIONS TO THIS ASSEMBLY.

11 REMOVE SUPPORT MEMBER "Z" & CHECK FOR DEFORMATION OF THE ASSEMBLY

SECTION -A-A

LET.	REVISION	ECN	DATE	BY

FOR ALL REVISIONS SEE SH. 1

FOR ASSEMBLY SEE

TOLERANCES UNLESS OTHERWISE NOTED
DECIMAL DIMENSIONS ±0.005 ±0.015
FRACTIONAL DIMENSIONS UP TO 10" ± 1/64 10" TO 60" ± 1/32 60" & OVER ± 1/16
BREAK SHARP EDGES
ALL SURFACES TO HAVE 125 FINISH UNLESS OTHERWISE NOTED

KITT PEAK NATIONAL OBSERVATORY
OPERATED BY THE ASSOCIATION OF UNIVERSITIES FOR RESEARCH IN ASTRONOMY, INC. UNDER CONTRACT WITH NATIONAL SCIENCE FOUNDATION

150" STELLAR TELESCOPE			
NAME	LAYOUT OF REVISIONS TO SOUTH BEARING SUPPT. ASSY.		
DRAWN BY	DATE	APPROVED BY	DATE
CHECKED BY	DATE	APPROVED BY	DATE
CHECKED BY	DATE	APPROVED BY	DATE
DRAWING NUMBER	2120-E68		
SCALE	1/2" = 1"		
PRINT ISSUED			
REV.			