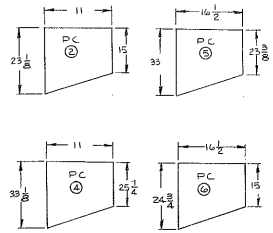
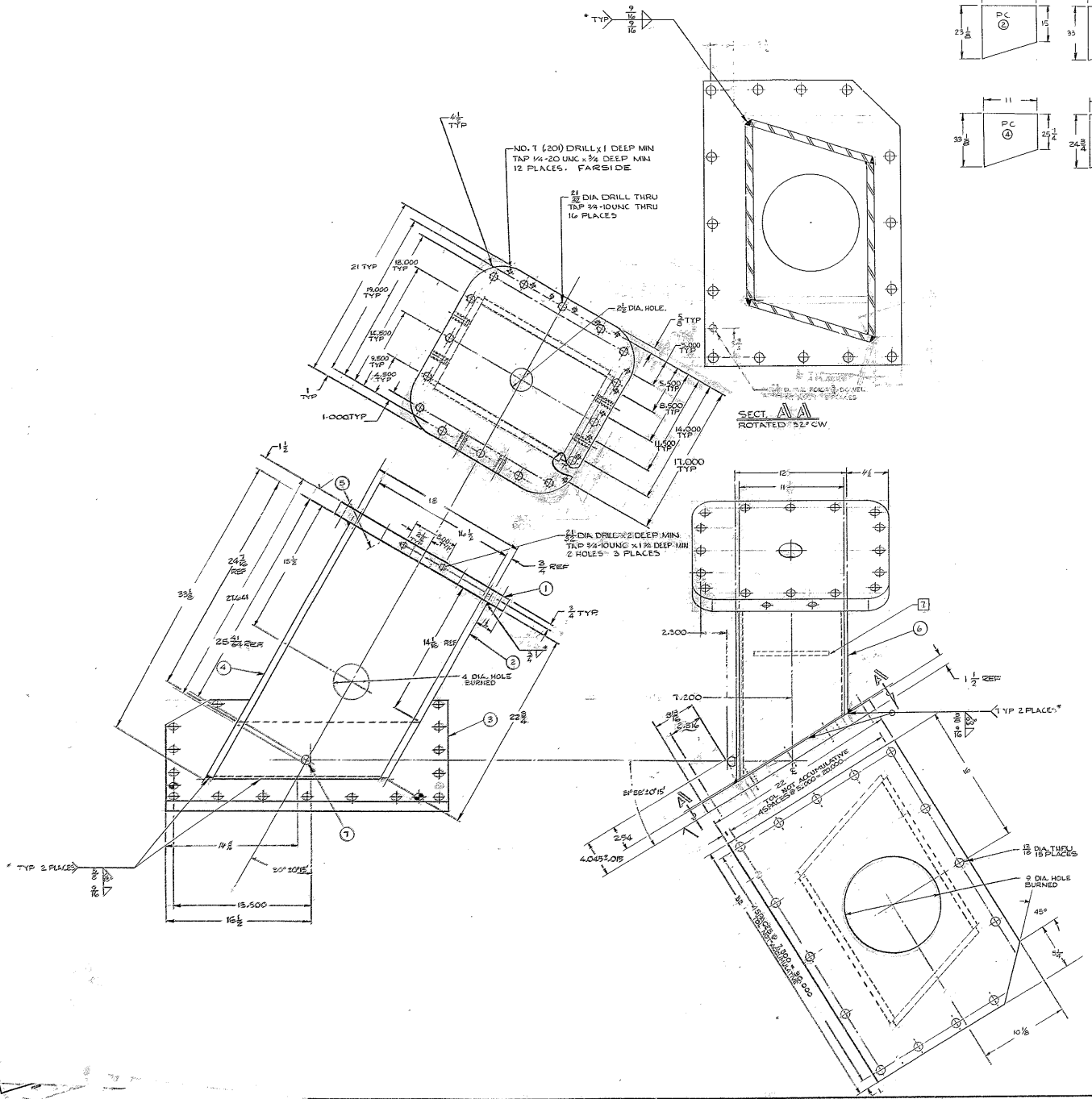
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	REVISED PER AURA APPD CONST PRINT	5-2-68	
	B	NOTE 8 ADDED & 4 HOLES	6-10-68	
E-1 C-6	C	DONE C-2 DIA WAS 2.06 DONE C-6 ⅝ WAS 5 5/32	7-10-68	
E-7	D	ADDED 14 3/4 DIM	29	
D-6	D	ADDED 1 1/4 DIM	29 Oct 68	
E-7	D	ADDED 4 1/2 DIM		
B-1	E	ADDED 16 1/2 DIM.	3/15/71	JW
C-5		ADDED 8 15/16 & 2.54 DIMS		
C-6		22 3/4 WAS 25 1/16, 14 1/16 WAS 15 9/16		
D-7		33 1/8 WAS 33 15/32, 24 7/16 WAS 25 51/32		
E-1		P/N 2 WAS R. 11 x 3/4 x 28 1/16		
E-1		P/N 3 WAS R. 22 x 1 1/2 x 32		
E-1		P/N 4 WAS R. 11 x 3/4 x 33 15/16		
E-1		P/N 5 WAS R. 16 1/2 x 3/4 x 33 15/16		
E-1		P/N 6 WAS R. 16 1/2 x 3/4 x 25 31/32		
GH5		CUTTING LAYOUT LENGTHS REVISED		
	F	DELETED DOWEL CALLOUT	7/1/70	LGS

CUTTING LAYOUT





MATERIAL LIST				
PC NO.	QTY.	DESCRIPTION	MATERIAL & SPEC.	ROUGH WT
1	1	R. 21 x 1 3/4 x 21	STL ASTM A-36	219
2	1	R. 11 x 3/4 x 33 1/8		54
3	1	R. 22 x 1 3/4 x 32		300
4	1	R. 11 x 3/4 x 33 1/8		80
5	1	R. 16 1/2 x 3/4 x 33		117
6	1	R. 16 1/2 x 3/4 x 24 3/4	STL ASTM A36	91
7	1	TOOLING BALL	AMER. CYCL. BUSH NO. AD 26680	—

NOTES:
1. FABRICATION TOLLERANCES: EXCEPT AS NOTED
   UP TO 10 INCHES ± 1/16 INCH
   UP TO 30 INCHES ± 1/8 INCH
   30 INCHES & OVER ± 1/4 INCH
2. WELD PER W.G.C. SPECIFICATION 752.
3. STRESS RELIEVE AFTER WELDING & BEFORE MACHINING PER W.G.C. SPECIFICATION 510.
4. APPLY ONE COAT OF PRIMER PAINT ALL OVER PER W.G.C. SPECIFICATION 511 IMMEDIATELY AFTER STRESS RELIEVING AND CLEANING.
5. SURFACES MARKED √ TO BE 125√ EXCEPT AS NOTED.
6. ALL DIMENSIONS ARE IN INCHES.

7 STAMP PART NO. 2150.120E103 APPROX WHERE SHOWN.

8. MAGNETIC PARTICLE INSPECTION:
   ALL WELDS MARKED THUS ✱ MUST BE 100% INSPECTED.
   WELDS MARKED THUS ± MUST BE 50% MINIMUM INSPECTED.
   ALL OTHERS MUST BE VISUALLY INSPECTED PER W.G.C. SPEC. # 761 PAR 11

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS DEPARTMENT
APPROVED FOR PROCUREMENT
DATE 1/6/69

NEXT ASSY: 2150.120E102 WGN 102860

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
		LIST OF MATERIAL (LM)			

LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED
ANGULAR = ± 1°
LINEAR:
X = ± .1 XXX = ± .010
XX = ± .03 FRACTIONAL = ± 1/32
BREAK ALL SHARP EDGES
MATERIAL: SEE MATL LIST

150 IN. STELLAR TELESCOPE MOUNTING

WESTERN GEAR CORPORATION — HEAVY MACHINERY DIVISION, EVERETT, WASHINGTON

DRAWN L. JOHNSON
CHECK
ENGR

HOUSING, RIGHT HAND
SOUTH HYDROSTATIC BEARING

WGN 102859

APPROVED

SIZE E | CODE IDENT NO. 16603 | 2150-120 E 103 | REV —

SCALE 1/4 | WT 829 LB | SHEET 1 OF

111 Inl. 1155