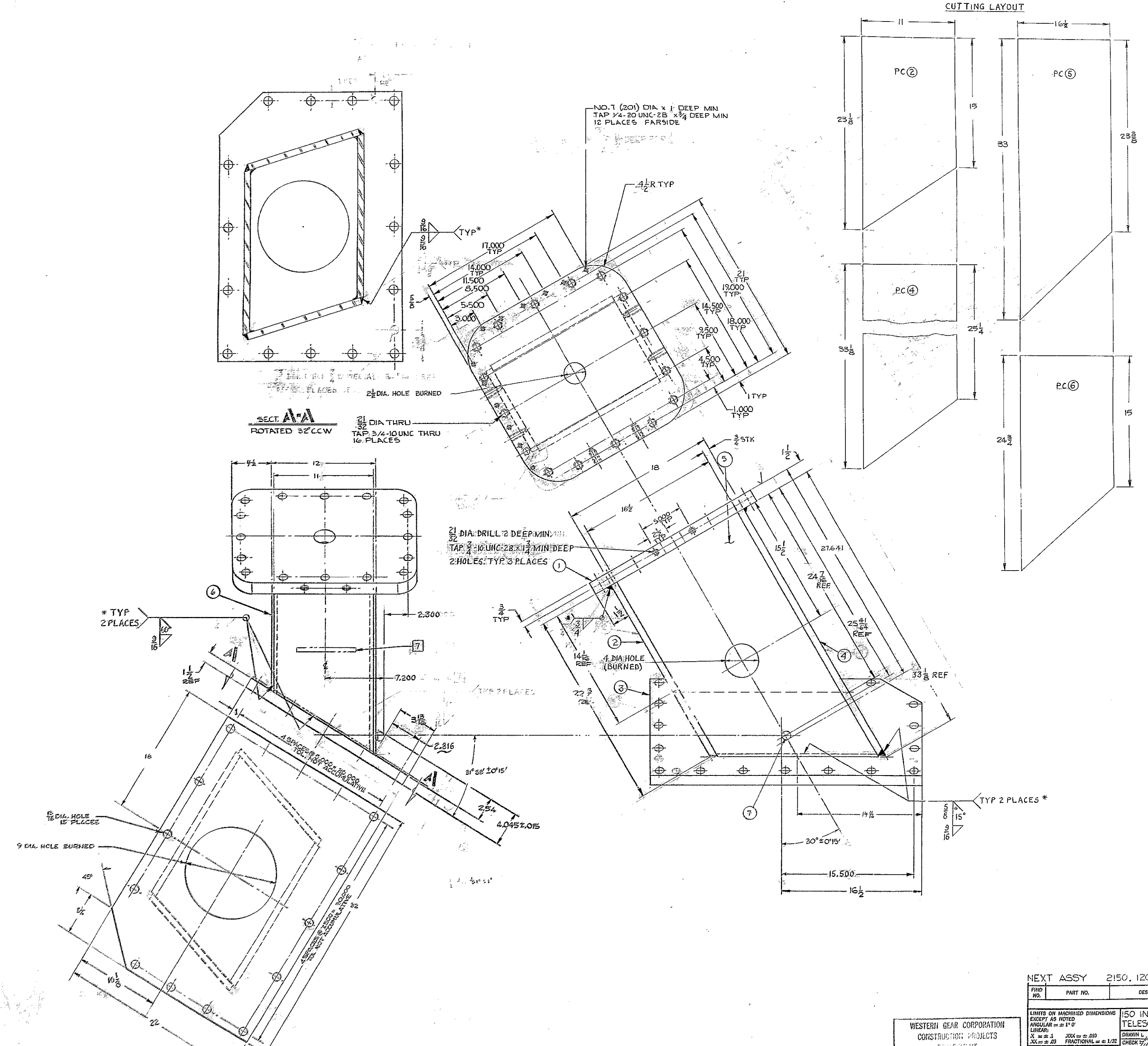

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	REVISED PER AURA APPROVED CONST PRINT.	5/3/68	
	B	ADDED NOTE 8 & "*" MARKS	6/30/68	
	C	ZONE C6 - 2.816 WAS 3.816 / ZONE C7 - 4 5/32 WAS 3 5/32	5 JULY 68	
C-3 D-5 E-7	D D D	ADDED 14 11/16 ADDED 1 1/2 ADDED 4 1/2	29 Oct 68	
B-3 D-5 D-3 C-5 F-1 F-1 F-1 F-1 F-1	E	ADDED 16 1/2 DIM. 14 1/16 WAS 15 9/16, 22 3/4 WAS 23 1/16 33 1/8 WAS 33 15/32, 24 7/16 WAS 25 31/32 ADDED 3 13/16 & 2.54 DIMS P/N 3 WAS PL 22 x 1 1/2 x 32 P/N 2 WAS PL 11 x 3/4 x 23 1/16 P/N 4 WAS PL 11 x 3/4 x 33 15/16 P/N 5 WAS PL 16 1/2 x 3/4 x 33 15/16 P/N 6 WAS PL 16 1/2 x 3/4 x 25 31/32 CUTTING LAYOUT LENGTHS REVISED	3/15/71	W
	F	DELETED DOWEL CALLOUT	3/15/73	LRS

MATERIAL LIST				
PC NO	QTY	DESCRIPTION	MATERIAL & SPEC	ROUGH WT
1	1	PL 21 x 1 3/4 x 21	STL ASTM A-36	219
2	1	PL 11 x 3/4 x 23 1/8	↑	54
3	1	PL 22 x 1 3/4 x 32		300
4	1	PL 11 x 3/4 x 33 1/8		80
5	1	PL 16 1/2 x 3/4 x 33	↓	117
6	1	PL 16 1/2 x 3/4 x 24 3/4	STL ASTM A36	91
7	1	TOOLING BALL	AMER DRILL BUSH NO. AD26840	—

NOTES:
1. FABRICATION TOLLERANCES EXCEPT AS NOTED
   UP TO 10 INCHES ± 1/16 INCH
   UP TO 50 INCHES ± 1/8 INCH
   50 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. 120E203 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. #751 PAR 11

REF FILE 1155

NEXT ASSY 2150. 120E 202 WGN 102864

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT

LIST OF MATERIAL (LM)

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS
DEPARTMENT
APPROVED FOR PROCUREMENT
DATE 5/3/68

LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED
ANGULAR = ± 1° 0'
LINEAR:
.X = ± .1 .XXX = ± .010
.XX = ± .03 FRACTIONAL = ± 1/32
BREAK ALL SHARP EDGES
MATERIAL
SEE MATERIAL LIST

150 IN STELLAR TELESCOPE MOUNTING
DRAWN L. JOHNSON
CHECK 3-16-68
ENGR
WGN102861
APPROVED

WESTERN GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

HOUSING, LEFT HAND SOUTH HYDROSTATIC BEARING

SIZE E | CODE IDENT NO. 16603 | 2150.120E 203 | REV F
SCALE 1/4 | WT 829 LB | SHEET 1 OF 1