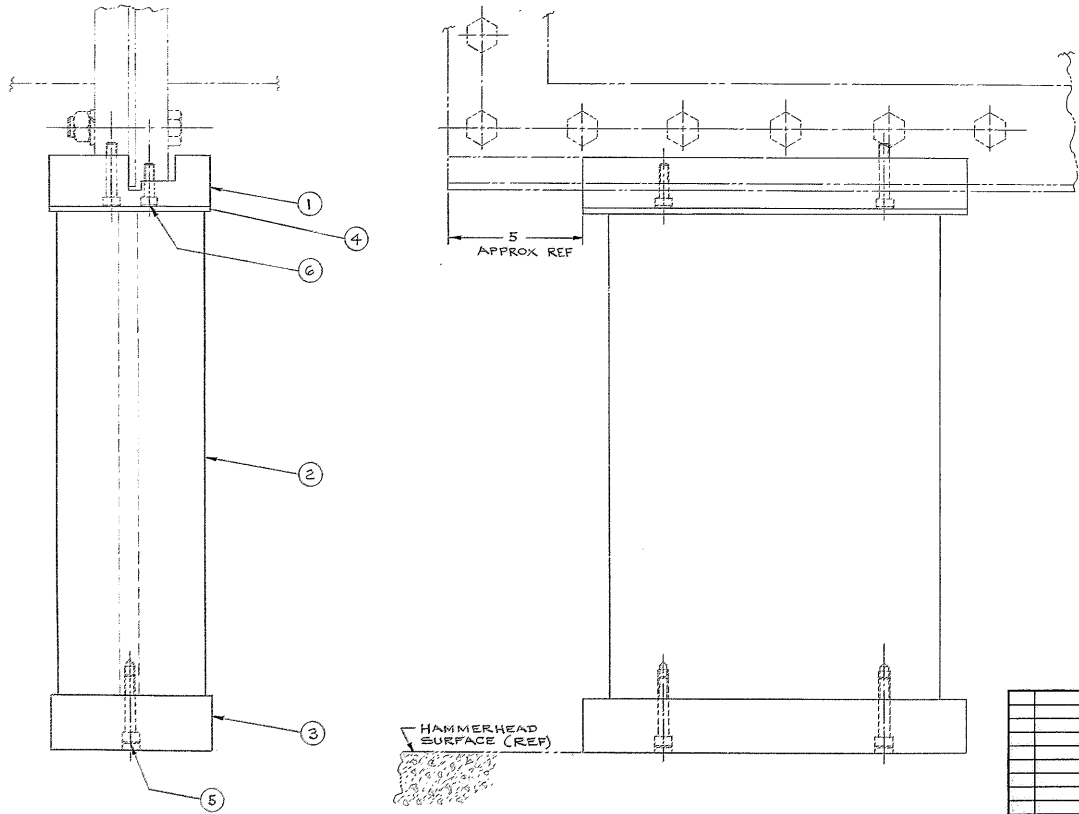
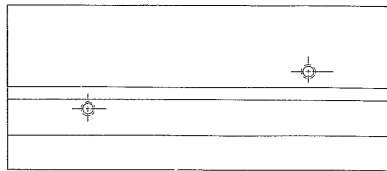


# BILL OF MATERIAL

ITEM	QTY	MATERIAL	DESCRIPTION	WEIGHT
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FOR BILL OF MATERIAL, SEE DWG 2150.150-A602



- INSTALLATION NOTES**  
 AFTER BASE FRAME ASSEMBLY IS COMPLETED, INSTALL EACH STABILIZER ASSEMBLY IN THE FOLLOWING STEPS:
- STEP 1** - THOROUGHLY CLEAN THE BASE FRAME FLANGES OF ALL DIRT AND REMOVE ALL BURRS FROM THE SURFACES THEY WILL BE MATED.
  - STEP 2** - PLACE THE ADAPTER (1) AGAINST THE FLANGES LOCATED FROM THE OUTBOARD FLANGE LEGS TO THE DIMENSION SHOWN. DRILL AND TAP LOCATED FROM THE ADAPTER (1) FOR THE TWO HOLDING SCREWS (5) & (6).
  - STEP 3** - PLACE THE ADAPTER (1) AND BOLT IN PLACE WITH SCREWS (5) AND (6) AND CHECK LEVELNESS AND GAP. IF ONE OR THE OTHER OF THE SCREWS TENDS TO PULL THE ADAPTER OFF OF LEVEL IN THE N-S DIRECTION, SHIM WITH A THIN SHIM NOT OVER 3/4 O.D. ON THE SCREW.
  - STEP 4** - SET THE ASSEMBLY OF THE BASE PLATE (3) AND SUPPORT POST (2) IN LINE WITH THE ADAPTER (1) ABOVE AND CHECK FOR SQUARENESS AND THAT SHIM (4) CAN BE PLACED WITH NO PROBLEMS. MARK OUTLINE OF BASE PLATE (3) ON FLOOR AND REMOVE THE ASSEMBLY. THOROUGHLY CLEAN ALL SURFACES TO BE MATED. SPREAD "BONDON- LIQUID STEEL" EPOXY CEMENT, APPROXIMATELY 1/16" THICK, ON MATING SURFACE OF ADAPTER (1) AND OUTLINE OF BASE PLATE (3) MARKED ON FLOOR. MOUNT ADAPTER TO FLANGES AND SET SUPPORT ASSEMBLY FIRMLY IN CORRECT POSITIONS. LET EPOXY SET AS REQUIRED TO ACHIEVE FULL STRENGTH WITHOUT DISTURBING.
  - REPEAT STEPS 1 THRU 5 FOR THE OPPOSITE SIDE OF THE FRAME BEFORE CONTINUING WITH STEP 6.
  - STEP 6** - PLACE JACKS TO FLANGES JUST OUTBOARD OF THE ENDS OF THE ADAPTER (1) ON BOTH THE EAST AND WEST SIDES OF THE BASE FRAME AND USING DIAL INDICATORS RESIDE EACH JACK LIFT EQUALLY AND TOGETHER THE BASE FRAME TO THE HEIGHT SPECIFIED BY ENGINEERING. MEASURE THE GAP ALL AROUND AND GRIND THE SHIMS (4) TO THE CORRECT THICKNESS.
  - STEP 7** - RAISE THE JACKS AN ADDITIONAL AMOUNT (NOT TO EXCEED .010) TO FURTHER TIGHTEN UP THE SHIMS AND CHECK FOR FIT OF SHIM AT ALL POINTS. LOWER JACKS AND RECHECK SHIM FIT TO BE TIGHT ALL OVER.

BREAK SHARP EDGES .03  
 IDENTIFY BY \_\_\_\_\_ AT LOCATION  "AURA" MADE IN USA  
 STAMP MATCH MARKS ON ALL MATING PARTS WHERE NECESSARY.  
 DRAWING: \_\_\_\_\_  
 FOR NEXT ASSY, SEE (2120-DS1 REF)

**NOTES:**

**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 DRAWING NUMBER 1158  
 NAME SOUTH BASE SUPPORT STABILIZER ASSY SCALE HALF  
 EAST KPNO PRINT ISSUED

DATE: 12-17-72  
 DRAWN BY: J. J. ...  
 CHECKED BY: ...  
 APPROVED BY: ...  
 DATE: 12-17-72

REV	DESCRIPTION	DATE	BY

**TOLERANCES UNLESS OTHERWISE NOTED**

DECIMAL DIMENSIONS .0001  
 FRACTIONAL DIMENSIONS UP TO 1/16 1/64  
 5/8 & OVER 1/16

UNLESS OTHERWISE NOTED TO HAVE FINISH UNLESS OTHERWISE NOTED.