



### BILL OF MATERIAL

ITEM	QTY	MATERIAL	DESCRIPTION	WEIGHT
FOR BILL OF MATERIAL, SEE DWG 2150.150-A702				

#### INSTALLATION NOTES

AFTER THE FRAME ASSEMBLY IS COMPLETED, INSTALL EACH STABILIZER ASSEMBLY IN THE FOLLOWING STEPS:

- STEP 1** - THOROUGHLY CLEAN THE BASE FRAME FLANGES OF ALL OILING AND REMOVE ALL BURRS FROM THE SURFACES THAT 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 LEAKAGES AND GAP. IF ONE OR THE OTHER OF THE SCREWS TENDS TO PULL THE ADAPTER OUT 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 TRUE SHIM (4) CAN BE PLACED WITH NO PROBLEMS. MARK OUTLINE OF BASE PLATE (3) ON FLOOR AND REMOVE THE ASSEMBLY.
- STEP 5** - THOROUGHLY CLEAN ALL SURFACES TO BE MATED. SPREAD "EPOXY-GLUED STEEL" EPOXY COMPOUND, 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 EPXY/COM 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 SET THE DIAL INDICATORS BEHIND EACH JACK LEFT SQUARELY AND TOGETHER THE BASE FRAME TO THE HEIGHT SPECIFIED BY ENGINEERING. MEASURE THE GAP ALL AROUND AND GRIND THE SHIMS (4) TO THE CORRECT DIMENSION.
- STEP 7** - RAISE THE JACKS AN ADDITIONAL AMOUNT (NOT TO EXCEED .010) TO PERMIT INSERTION OF THE SHIMS AND CHECK FOR FIT OF SHIM AT ALL POINTS. LOWER JACKS AND RECHECK SHIM FIT TO BE TIGHT ALL OVER.

5-BREAK SHARP EDGES .03

4-IDENTIFY BY \_\_\_\_\_ AT LOCATION \_\_\_\_\_ "MADE-IN-USA"

3-STAMP MATCH MARKS ON ALL MATING PARTS WHERE NECESSARY.

2-PROJECT DRAWINGS

1-FOR NEXT ASSY. SEE (2120-D51 REF)

NOTES:

TOLERANCES UNLESS OTHERWISE NOTED	
DECIMAL DIMENSIONS	±0.0008
FRACTIONAL DIMENSIONS UP TO 6/16	±0.0010
6/16 & OVER	±0.0015
ANGLES ±0°-30'	
ALL DIMENSIONS TO HOLE ±.0015 FINISH UNLESS OTHERWISE NOTED.	

KITT PEAK NATIONAL OBSERVATORY	
ASSOCIATION OF UNIVERSITIES FOR RESEARCH IN ASTRONOMY, INC.	
NATIONAL SCIENCE FOUNDATION	
150 INCH STELLAR TELESCOPE	REV 1198
SOUTH BASE SUPPORT STABILIZER ASSY	SCALE HALF
WEST-KPNO	PRINT ISSUED
DRAWING NO. 2150.150-D702	REV.

REV	DATE	BY	APP'D BY
1	11-14-75	J.S. WILLY	
2	12-27-75	J.S. WILLY	