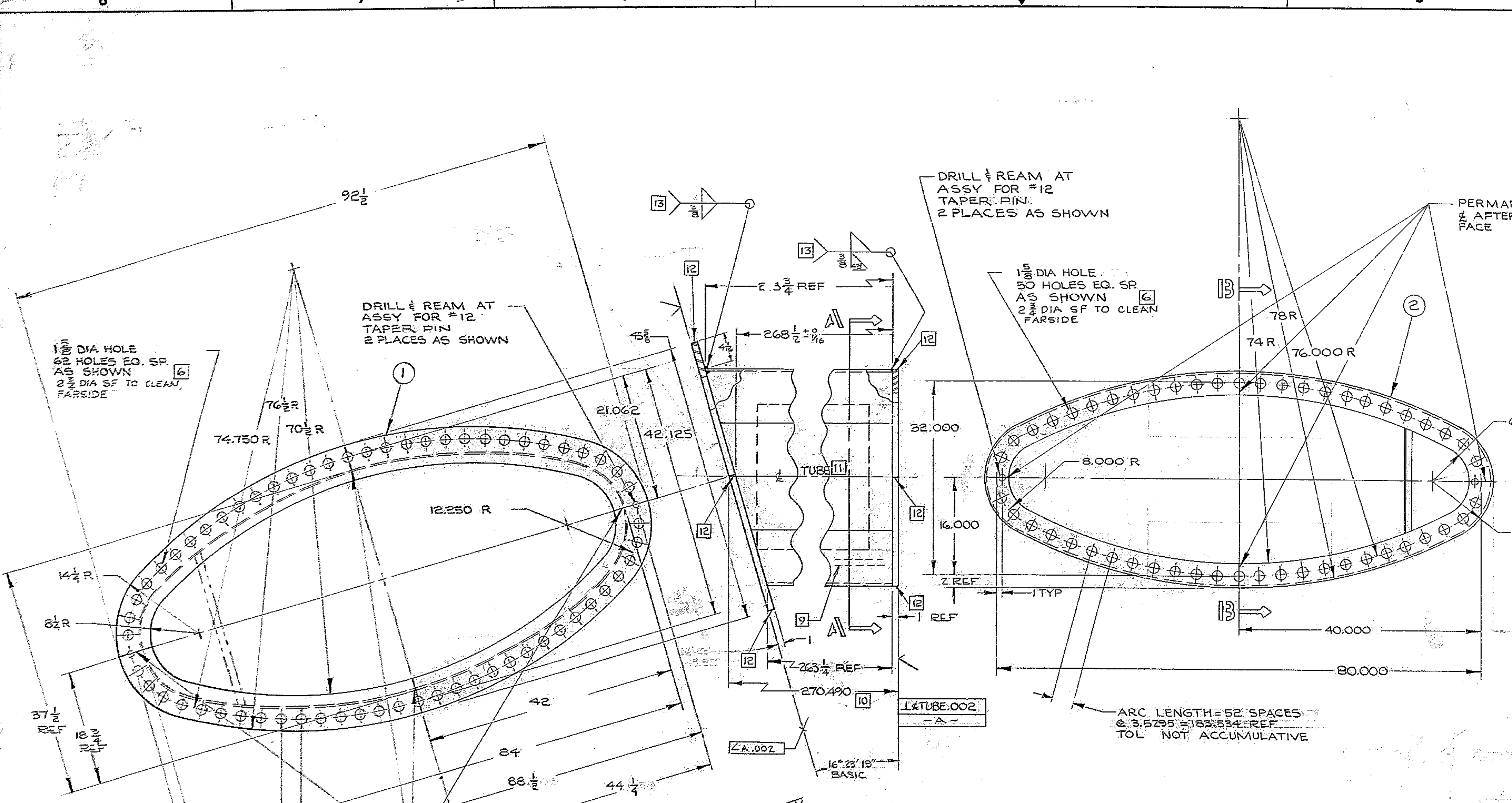


REVISIONS				
ZONE	LT#	DESCRIPTION	DATE	APPROVED
A	1	REVISED PER AURA APPD CONST. PRINT	18 APR 68	
B	1	CHANGED 10.404 68		
B	2	REMOVED 75°36'37" / 75°36'37" DIA.		
B	3	ADDED: [LA.002] 1 [FA.1] 3 14°23'18" BASIC	14 APR 68	
B	4	NOTE: 2 WAS W.G.C. SPEC 752		
B	5	NOTE: 3 ADDED "APPLY TO 70°F ± 5°F"		
C	1	CORRECTED APPROX HEAD ON 45° DIA DIM	15 APR 68	G.R.
C	2	16° 23'18" WAS 14° 23'18"		
D	1	ADDED: NOTE 13	11/14/68	
D	2	ADDED: 2 1/2" DIA SF TO CLEAN	11/14/68	
D	3	ADDED: .204 DRILL ... (NOMINAL)	11/14/68	
D	4	ADDED: ITEMS 9 & 10	11/14/68	
E	1	81 WAS 17 1/2" 170° WAS 1A1	12/17/68	
E	2	PIV WAS 21 LG. PIV WAS 120 LG.	12/17/68	

MATERIAL LIST				
PC.NO.	QTY	DESCRIPTION	MAT'L SPEC	ROUGH WT
1	1	R 93-11 1/2 x 1/4	STL ASTM A-36	42.1
2	1	R 84 1/2 x 1 1/2 x 3/4	STL ASTM A-36	249
3	2	R 274 x 3/8 x 7/16	STL ASTM A-212	2227
			-65, GR A	
4	2	ARC, 10 R x 272	STL ASTM A-53	614
		(PIPE 3/8 WALL x 18 1/2)	-65 TYPE E GR B	
5	1	"SKYWALK" (3.14)	COMM'L STL	11
		GRATING 24 x 24		
6	2	"SKYWALK" (3.14)	COMM'L STL	63
		GRATING 24 x 24		
7	2	BAR 1 1/2 x 3/8 x 26 1/2	STL ASTM A-36	42
8	4	ANGLE 1 1/2 x 1/2 x 24	STL ASTM A-36	3.0
9	AR	BOLT 1/4-20 x 3/4	COMM'L STL	
10	AR	WASHER 1 1/2 x 3/16	COMM'L STL	

ROUGH WT. TOTAL = 6655



- NOTES:
- FABRICATION TOLERANCES, EXCEPT AS NOTED
UP TO 10 INCHES ± 1/16
10 TO 50 INCHES ± 1/8
50 INCHES & OVER ± 1/4
 - WELD PER A.W.S. SPECIFICATION D1.0-66
 - STRESS RELIEVE AFTER WELDING & BEFORE MACHINING PER W.G.C. SPECIFICATION 510
 - APPLY ONE COAT OF PRIME PAINT ALL OVER PER W.G.C. SPECIFICATION 511 IMMEDIATELY AFTER STRESS RELIEVING.
 - ALL SURFACES MARKED ✓ TO BE 175° EXCEPT AS NOTED.
 - THESE HOLES TO BE LOCATED USING A TEMPLATE WHICH IS TO BE USED FOR LOCATING CORRESPONDING HOLES ON MATING PART. OPTION: LOCATE HOLES FROM MATING PART.
 - TWO PARTS MAY BE CUT FROM ONE PIPE
 - ALL DIMENSIONS ARE IN INCHES & APPLY TO 70°F ± 5°F MARK PART NO. 2150.201E003
 - THIS DIMENSION IS TO BE SUCH THAT WHEN ALL SIX STRUTS ARE ASSEMBLED TO THE NORTH AND SOUTH JOURNALS A GAP OF NO MORE THAN .002 EXISTS BEFORE BOLTING
 - Ø OF TUBE IS A THEORETICAL Ø PASSING THRU PERMANENTLY MARKED Ø ON EDGES OF FLANGES
 - ESTABLISH Ø OF TUBE AND PERMANENTLY MARK ON EDGES OF FLANGES AS SHOWN 4 MARKS ON EACH FLANGE @ 90°
 - MAGNAFLUX INSPECT THESE WELDS

TEMPORARY ASSY: 2150.215E002 (WG.N102925)
NEXT ASSY: 2150.201E002 (W.G. N102907)

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 FRACTIONAL ± 1/32					
BREAK ALL SHARP EDGES					
MATERIAL					
SEE MAT'L LIST					
APPROVED					

WESTERN GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

STRUT, COUDÉ, EAST

SIZE: W.G. N102,908
CODE IDENT NO.: E 16603
2150.201E003

SCALE: 1/4" = 1" WT 1/2" = 1" LG 1/2" = 1" OF 1

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS
DEPARTMENT
APPROVED FOR
PROCUREMENT
DATE 12/20/68