

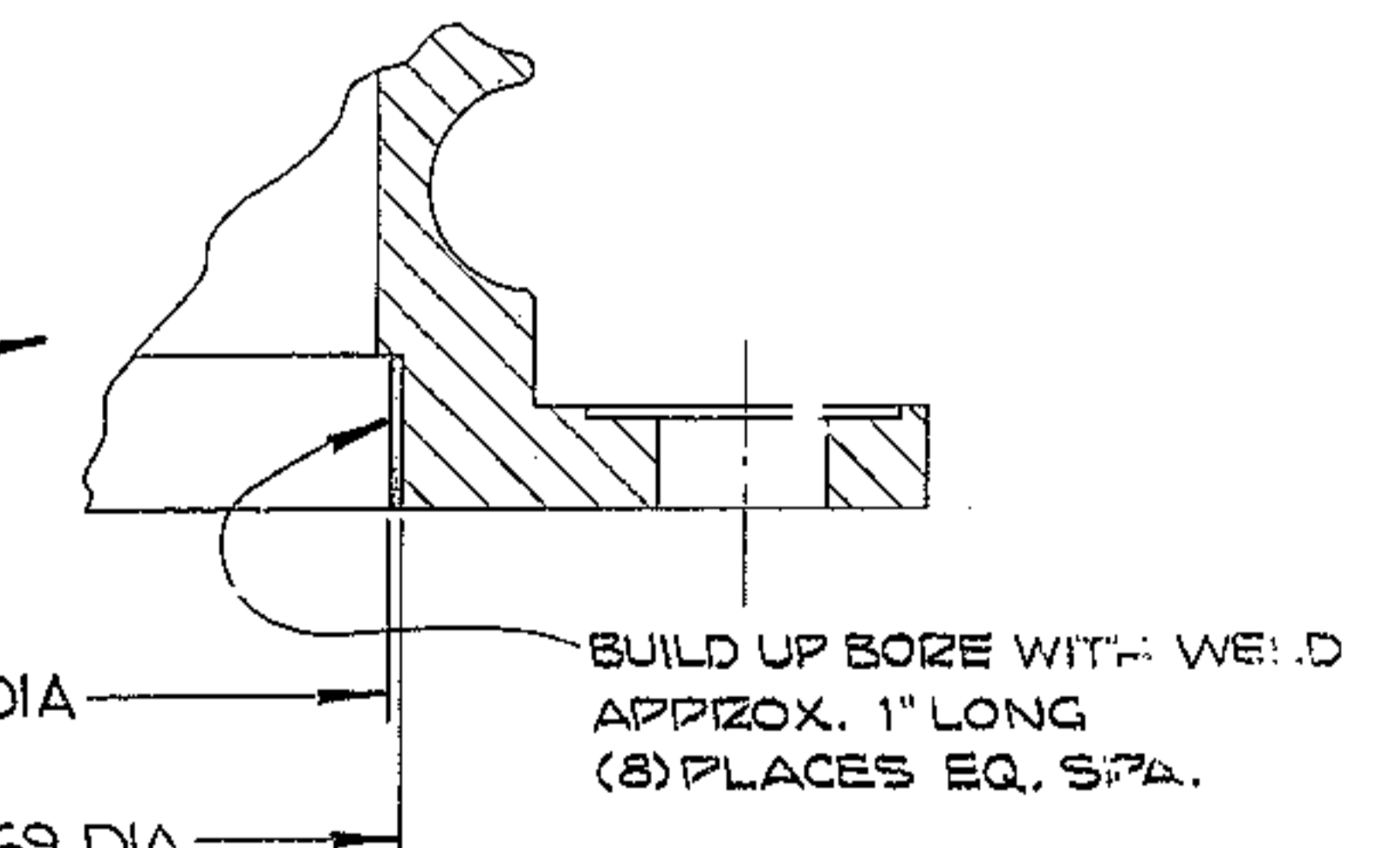
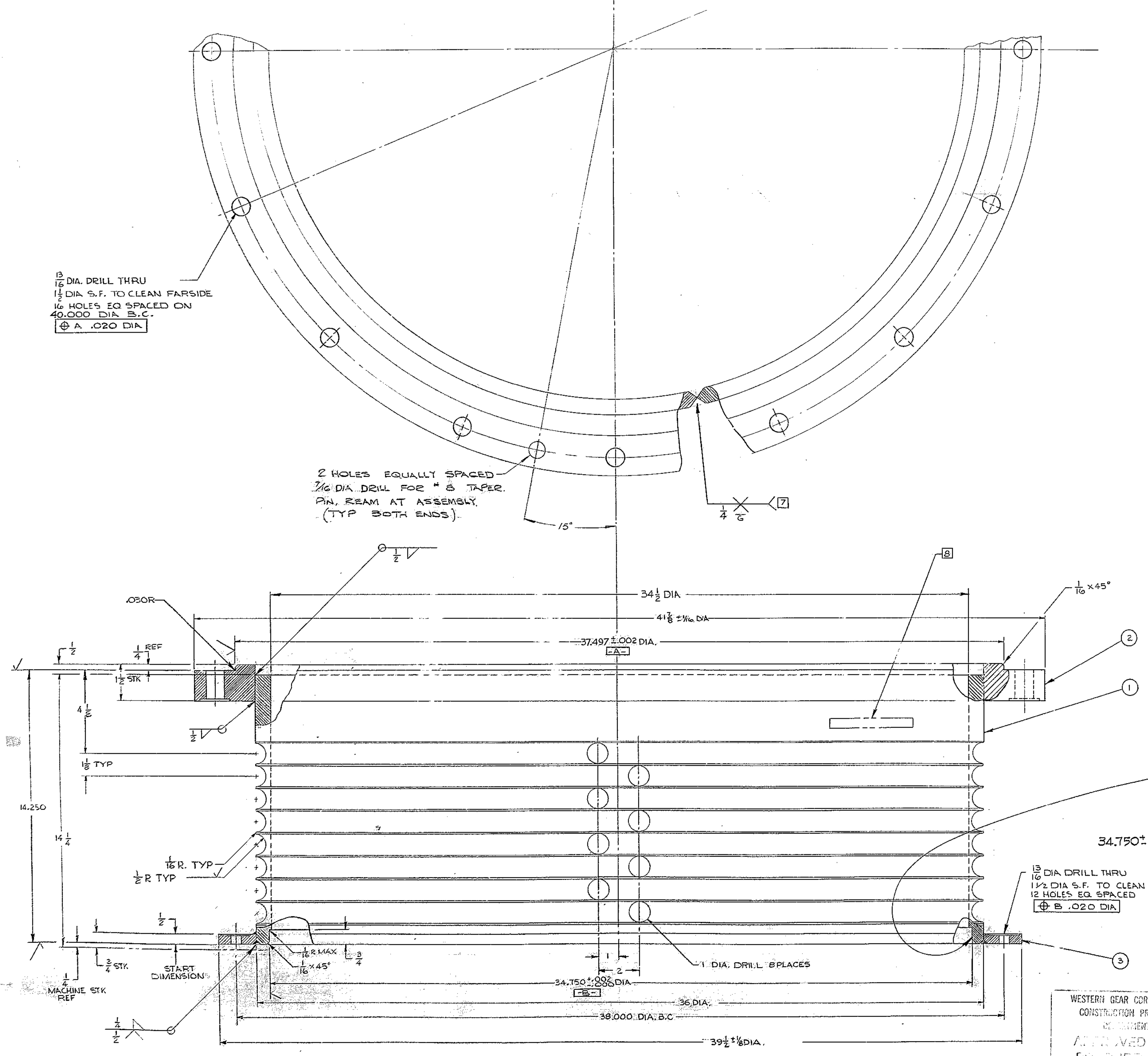
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
A		APPROVED PER A UEA APPROVED PART	4/14/68	
B		ADDED 'AS BUILT' S/N 2 FLANGE DETAIL	7/27/71	JWV
C		41 R WAS 42. 33 1/2 WAS 33 3/4	3/26/72	228

MATERIAL LIST					
PC. NO.	QTY	DESCRIPTION	MAT'L & SPEC	ROUGH WT	
1	1	R 14 1/2 x 3/4 x 113 1/8	STL ASTM A36	343	
2	1	R 42 O.D. x 36 I.D. x 1 1/2	STL ASTM A36	156	
3	1	R 39 3/4 O.D. x 36 I.D. x 3/4	STL ASTM A36	41	
				TOTAL ROUGH WT = 540	

1/8 DIA. DRILL THRU  
 1/2 DIA S.F. TO CLEAN FAR SIDE  
 1/16 HOLES EQ SPACED ON  
 40.000 DIA B.C.  
 ⊕ A .020 DIA.

2 HOLES EQUALLY SPACED  
 3/16 DIA. DRILL FOR # 8 TAPER  
 PIN, BEAM AT ASSEMBLY  
 (TYP BOTH ENDS)

- 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 WGC SPECIFICATION 752 APP T1
  - STRESS RELIEVE AFTER WELDING & BEFORE MACHINING PER WGC SPECIFICATION 510 APP T1
  - ALL DIMENSIONS ARE IN INCHES.
  - APPLY ONE COAT OF PRIMER PAINT ALL OVER PER WGC SPECIFICATION 511 IMMEDIATELY AFTER STRESS RELIEVING AND CLEANING.
  - ALL SURFACES MARKED ✓ TO BE ✓ EXCEPT AS NOTED.
  - ITEM ① TO BE ROLLED & BUTT WELDED AS SHOWN.
  - STAMP PART NO. 2150.210E.005 APPROX WHERE SHOWN.



"AS BUILT" S/N 2  
 SCALE 1/1

WESTERN GEAR CORPORATION  
 CONSTRUCTION PROJECTS  
 DEPARTMENT  
 APPROVED FOR  
 PROCUREMENT  
 DATE 8-12-68

NEXT ASSY: 2150.210E.002 (WGN 102833)				
FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL
LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED				
ANGULAR = ± 1°				
LINEAR:				
X = ± .01	XXX = ± .010			
XX = ± .03	FRACTIONAL = ± 1/32			
CHECK <i>Steve Russo</i> 11/26/68				
BREAK ALL SHARP EDGES				
MATERIAL				
SEE MAT'L LIST				
LIST OF MATERIAL (LM)				
150 INCH STELLAR TELESCOPE MOUNTING				
DRAWN L. JOHNSON 3-2-68				
ENGR				
WGN102964				
APPROVED				
HEAVY MACHINERY DIVISION EVERETT, WASHINGTON				
TUBE, WRAP-UP, POLAR AXLE ASSEMBLY				
SIZE	CODE IDENT NO.	REV		
E 16603	2150.210E.005	C		
SCALE 1/2	WT 410	LB	SHEET 1 OF 1	