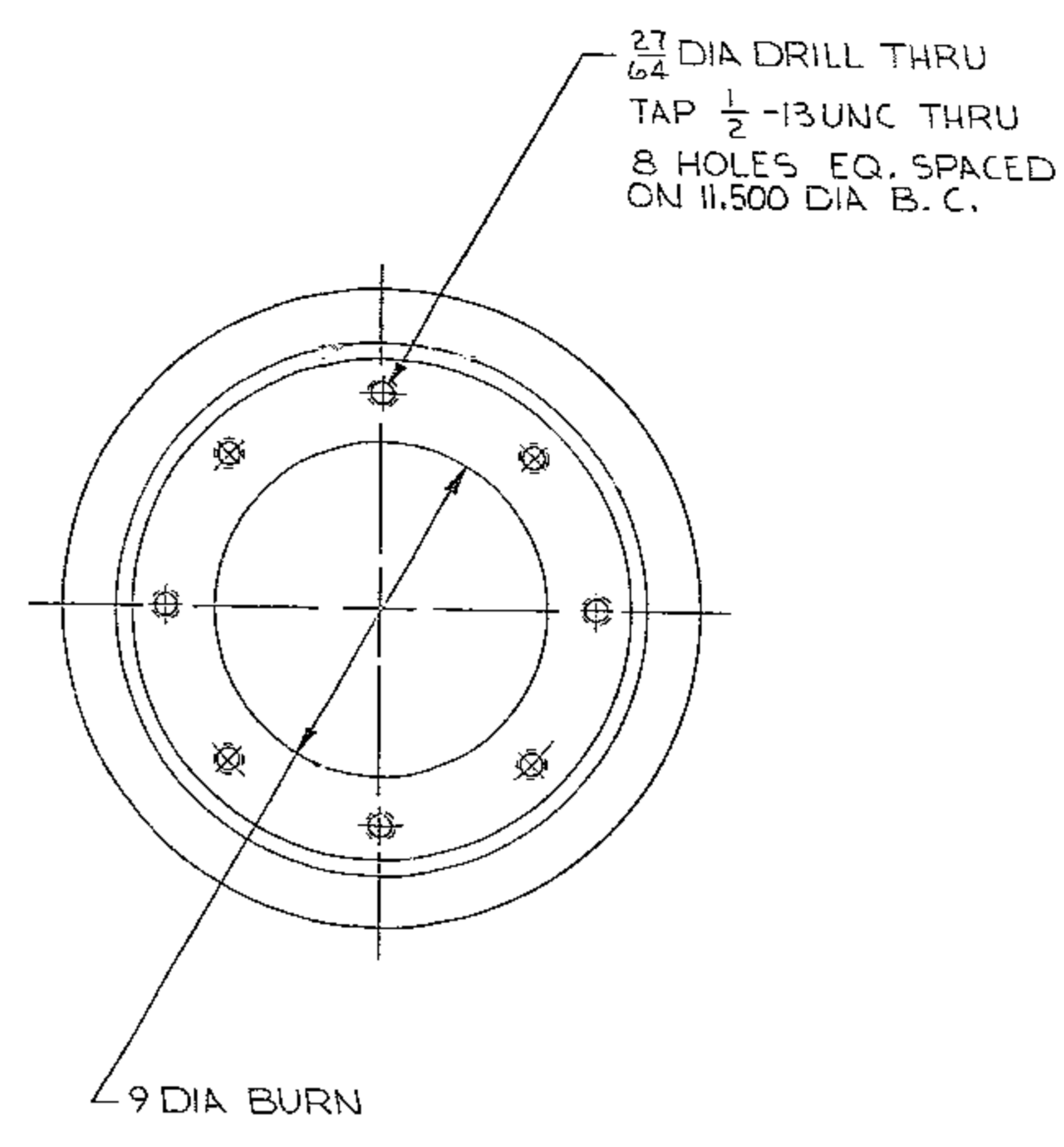
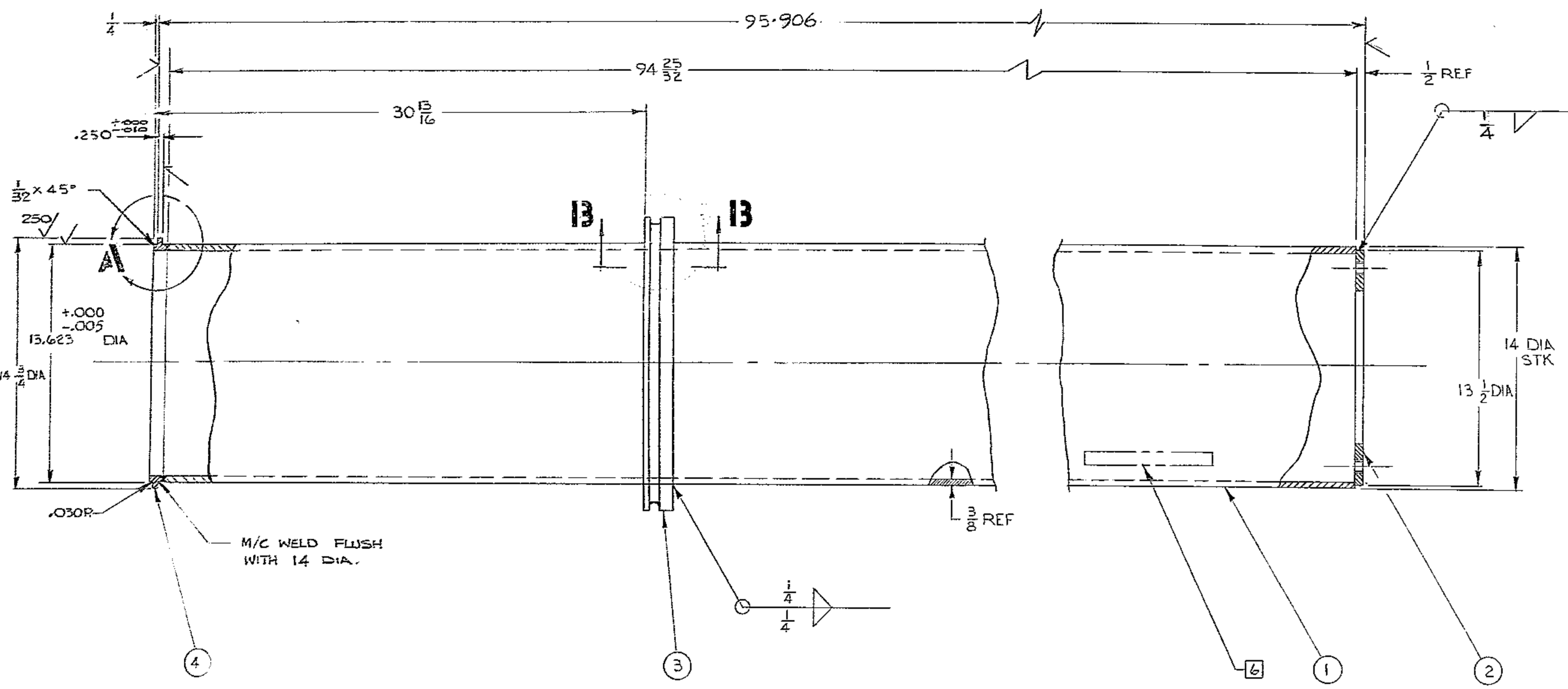
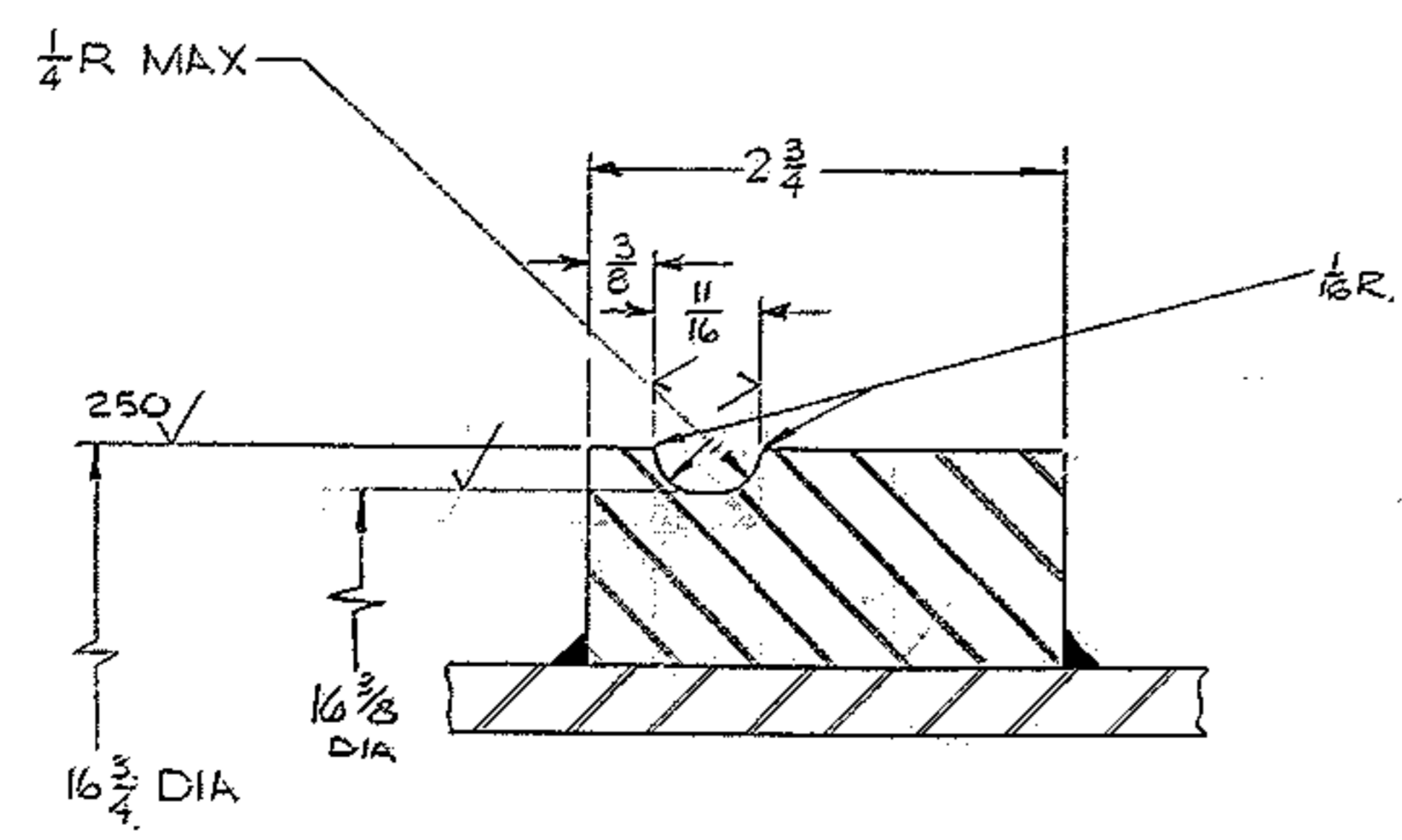
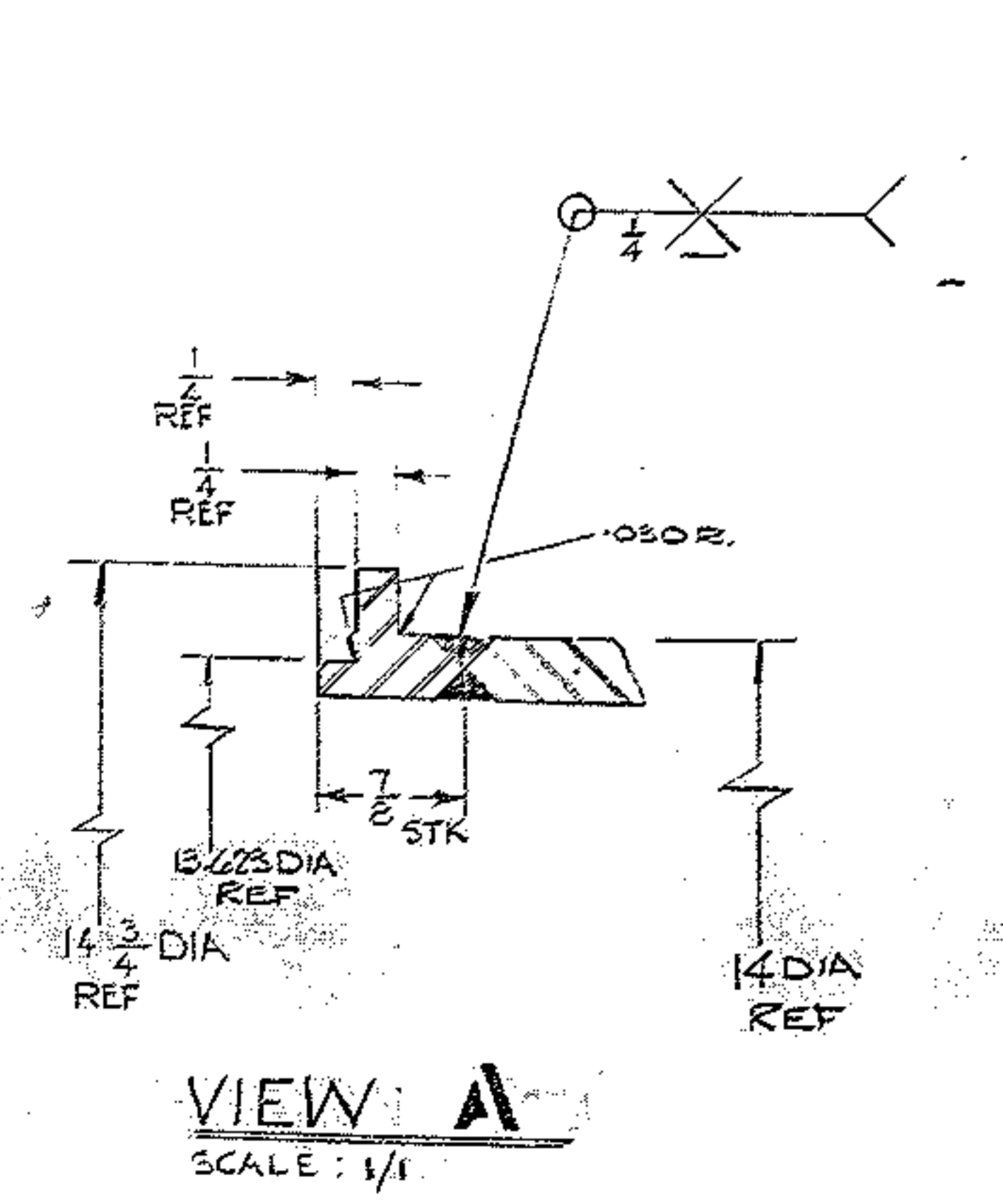


| REVISIONS |     |   |         |          |
|-----------|-----|---|---------|----------|
| ZONE      | LTR | DESCRIPTION                               | DATE    | APPROVED |
| A         |     | APPROVED PER AREA APPROVED PER JET        | 8-14-68 |          |
| B5        | B   | 1/4 GROOVE DEPTH DELETED 1/4 DIA WAS STAY |         |          |
| B         | B   | 1/8 DIA 16 3/8 DIA ADDED 13.625 DIA WAS   |         |          |
| G2        | B   | 13.625 DIA                                |         |          |



| MATERIAL LIST  |     |                                       |                       |       |     |
|----------------|-----|---------------------------------------|-----------------------|-------|-----|
| P.C. NO.       | QTY | DESCRIPTION                           | MAT'L & SPEC          | ROUGH | WT. |
| 1              | 1   | PIPE 14 DIA x 3/8 W x 3/8 S           | STL WELDED PIPE OR EQ | 432   |     |
| 2              | 1   | RE 13 1/2 DIA x 9 I.D. x 3/8 THK      | STL ASTM A 316        | 14    |     |
| 3              | 1   | RE 16 3/4 DIA x 14 I.D. x 3/8 THK     | STL ASTM A 316        | 51    |     |
| 4              | 1   | RE 14 3/4 DIA x 13 1/4 I.D. x 3/8 THK | STL ASTM A 316        | 3     |     |
| TOTAL ROUGH WT |     |                                       |                       | =     | 508 |

- NOTES:
- ALL DIMENSIONS ARE IN INCHES.
  - FABRICATION TOLERANCE, EXCEPT AS NOTED  
UP TO 10 INCHES ± 1/16  
10 TO 50 INCHES ± 1/8  
50 INCHES AND OVER ± 1/4
  - WELD PER W.G.C. SPECIFICATION T52. APPT1
  - STRESS RELIEF AFTER WELDING AND BEFORE MACHINING PER W.G.C. SPECIFICATION 510.
  - APPLY ONE (1) COAT PRIME PAINT ALL OVER PER W.G.C. SPECIFICATION 511 IMMEDIATELY AFTER STRESS RELIEF AND CLEANING
  - STAMP PART NO. 2150.210E 008 APPROX WHERE SHOWN.
  - UNLESS OTHERWISE NOTED ALL SURFACES MARKED ✓ TO BE 125/.



**SECTION 13-13**  
SCALE: 1/1  
GROOVE MAY BE MACHINED BEFORE WELDING

WESTERN GEAR CORPORATION  
CONSTRUCTION PROJECTS  
DRAWN FOR  
PROCUREMENT  
DATE: 8-14-68

NEXT ASSY: 2150.210E 002 (W.G.N 102833) REF. FILE: 1165

| FIND NO.   | PART NO. | DESCRIPTION   | QTY | MATERIAL                           | CODE IDENT |
|--|----------|---|-----|------------------------------------|------------|
| LIST OF MATERIAL (LM)  |          |   |     |                                    |            |
| LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED                |          | 150 INCH STELLAR TELESCOPE MOUNTING                                   |     |                                    |            |
| ANGULAR = ± 1°   |          | WESTERN GEAR CORPORATION HEAVY MACHINERY DIVISION EVERETT, WASHINGTON |     |                                    |            |
| LINEAR: X = ± .1 XXX = ± .010 XX = ± .03 FRACTIONAL = ± 1/32 |          | DRAWN R ORR FEB 68  |     | TUBE COUDE 5 - POLAR AXLE ASSEMBLY |            |
| BREAK ALL SHARP EDGES  |          | CHECK SEVE Raso APPROD ENGR   |     | SEE MAT'L LIST                     |            |
| MATERIAL   |          | W.G.N 102 950   |     | SIZE CODE IDENT NO. REV            |            |
| APPROVED   |          | E 16603   |     | 2150.210E 008                      |            |
| SCALE: 1/1   |          | 493   |     | LB SHEET 1 OF 1                    |            |