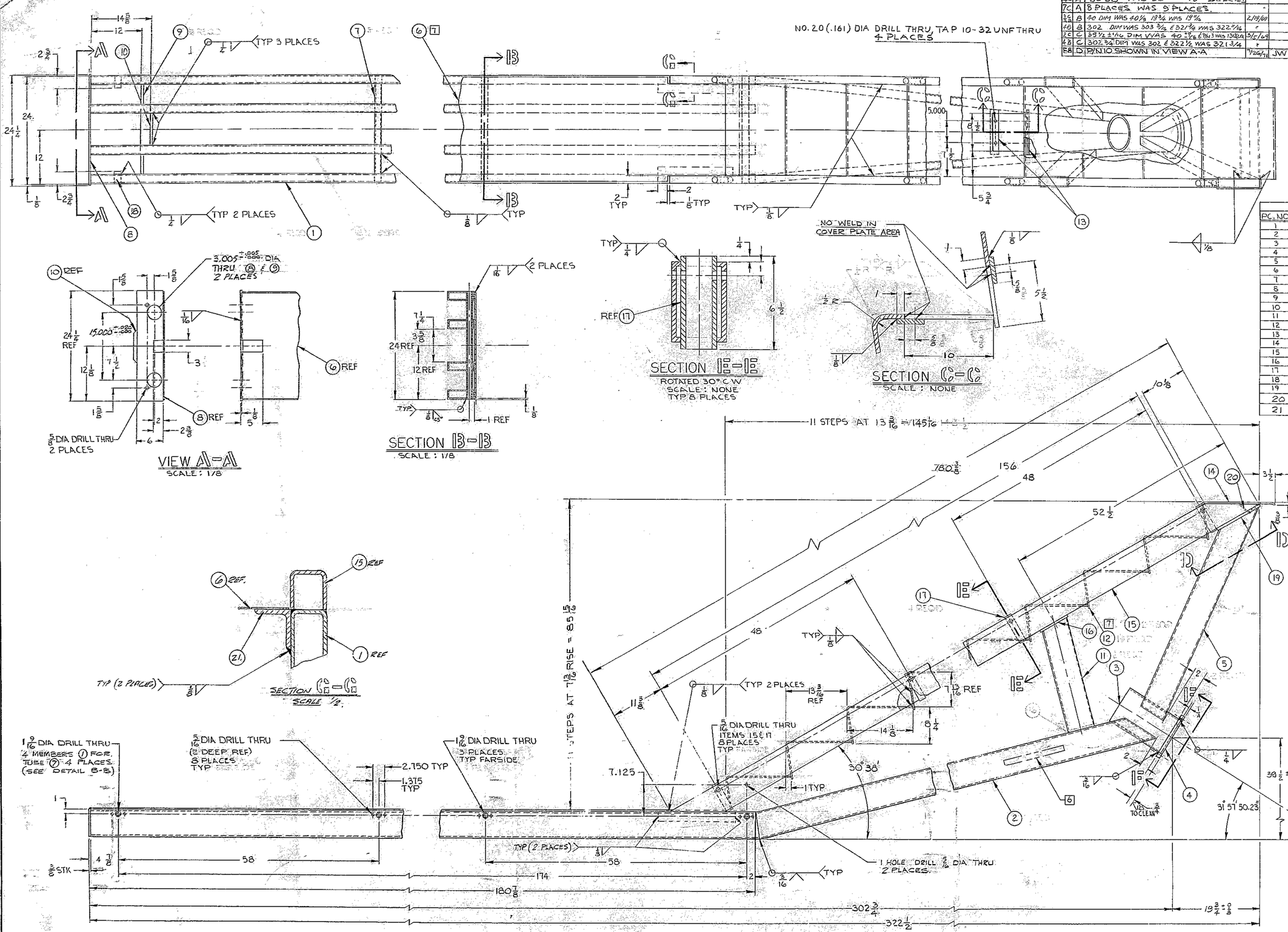
ZONE	LTR	REVISIONS DESCRIPTION	DATE	APPROVED
4C	A	30°38' WAS 30° 19° DELETED		
7C	A	8 PLACES WAS 9 PLACES.		
3G 3H	B	40 DIM WAS 40 1/8 19 3/4 WAS 19 9/16	2/19/69	
4B	B	302 DIM WAS 303 3/4 & 321 3/4 WAS 322 9/16	"	
2C	C	38 1/2 ± 1/16 DIM WAS 40 ± 3/16 & 6 7/8 WAS 13 11/16	3/6/69	
4B	C	302 3/4 DIM WAS 302 & 322 1/2 WAS 321 3/4		
E8	D	P/N 10 SHOWN IN VIEW A-A	7/26/71	JW
		PC# 2 1 8 2 3/4 WA[illegible] PC# 2 3 1/2 WAS 121 1/2	9/17/68	
M/L	A	PC# 4 WAS R 11 [illegible] PC# 5 52 1/2		
M/L	A	WAS 52 PC# 6 [illegible] WAS 174 3/16		
M/L	A	PC# 11 32 1/2 WAS 3[illegible] PC# 12 & 14 WERE		
M/L	A	16 GA (.0747) PC[illegible] 3/8 WAS 182 1/4		
M/L	A	PC# 16 WAS QT 7 4 [illegible] 3/8 x 7		
M/L	A	PC# 18, 20 & 21 AD[illegible]		
4F	A	1 WAS 3/4, 1/2 R WAS 1/4 [illegible] 3/4		
3F	A	5 1/2 WAS 6 1/2 1 WA[illegible]		
4G	A	NO WELD IN COVER PLATE AREA ADDED		
4F	A	13 3/16 = 14 5/16 WAS 13 1/2 = 42 1/2		
	A	VARIOUS WELDING SYMBOLS CHANGED		
8F	A	15.000 +.020 -.000 WAS 7 1/2 2 PLACES)		
7G	A	3.005 +.005 -.000 WAS 3 1/4		
3E	A	180 3/8 ADDED 15G WAS 158 42 WAS 49		
M/L	A	PC# 10 WAS R 7 1/4 x 1/2 x 4		
4C	A	1 HOLE 5/16 DIA THRU (2 PLACES) ADDED		
2C	A	13 1/16 WAS 13 1/2 40 1/8 WAS 42		
4C	A	13 3/16 WAS 13 1/2 14 1/8 WAS 14 7/16		
5C	A	11 3/8 WAS 12 1/2 1 8 1/4 WAS 8 1/2		

MATERIAL LIST

PC. NO.	QTY	DESCRIPTION	MATL & SPEC	ROUGH WT
1	4	TUBE 2 x 6 x 3/16 WALL x 182 3/4	STL AISI MT 1010	142
2	2	TUBE 2 x 6 x 3/16 WALL x 131 1/4	STL AISI MT 1010	94
3	1	TUBE 8 1/2 O.D. x 3/8 WALL x 13 1/2	STL AISI MT 1015	37
4	1	PL 11 O.D. x 3/8 x 8 1/2 I.D.	STL ASTM A36	9 1/2
5	2	TUBE 2 x 6 x 3/16 WALL x 51 1/2	STL AISI MT 1010	40
6	1	SHT 14 GA (.0141) 23 3/4 x 178 5/8	STL AISI C1010 (C.R)	90
7	3	TUBE 1 1/2 O.D. x .109 WALL x 24	STL AISI MT 1015	3
8	1	PL 6 x 3/8 x 24 1/4	STL ASTM A36	15
9	2	PL 4 3/8 x 1/2 x 6	STL ASTM A36	4
10	1	.250-.240 x .035	WGD 107423	6
11	2	TUBE 2 x 6 x 3/16 WALL x 32 1/4	STL AISI MT 1010	20
12	10	SHT 10 GA (.1345) x 20 x 22 1/8	STL AISI C1010 (C.R)	10
13	2	PL 2 x 1/4 x 10	STL ASTM A36	1.5
14	1	SHT 10 GA (.1345) x 24 x 25 3/4	STL AISI C1010 (C.R)	13
15	2	TUBE 2 x 6 x 3/16 WALL x 180 3/8	STL AISI MT 1010	142
16	2	PL 2 3/4 x 3/8 x 7	STL ASTM A36	2
17	8	TUBE 1 1/2 O.D. x .109 WALL x 6 1/4	STL AISI MT 1015	1
18	2	TUBE 1 1/2 O.D. x .109 WALL x 2 3/4	STL AISI MT 1015	
19	2	PL 2 1/2 x 3/8 x 11	STL ASTM A36	3
20	1	ANGLE 3 x 3 x 1/4 x 20 LG	STL	8
21	2	ANGLE 2 x 2 x 1/4 x 17 LG	STL	5.5



NOTES:
1. ALL DIMENSIONS ARE IN INCHES.
2. FABRICATION TOLERANCE
   UP TO 10 INCHES ± 1/16
   10 TO 50 INCHES ± 1/8
   50 INCHES AND OVER ± 1/4
3. WELD PER W.G.C. SPEC 752, APPENDIX T1.
4. STRESS RELIEVE AFTER WELDING PER W.G.C SPEC 510.
5. APPLY ONE (1) COAT PRIMER PAINT IMMEDIATELY AFTER STRESS RELIEF AND CLEANING PER W.G.C. SPEC 511.
6. STAMP PART NO. 2150.240E003 APPROX WHERE SHOWN.
7. PAINT ALL WALKING SURFACES WITH PIONEER SKIDLESS ENAMEL NO. X1004, COLOR TO BE SPECIFIED BY AURA.

NEXT ASSY: 2150.240E002 (W.G.N 102993)

REF. FILE 1167

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT

LIST OF MATERIAL (LM)

LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED
ANGULAR = ± 1° 0'
LINEAR:
X = ± .1 XXX = ± .010
XX = ± .03 FRACTIONAL = ± 1/32
BREAK ALL SHARP EDGES
MATERIAL
SEE MATL LIST

150 IN. STELLAR TELESCOPE MTG

DRAWN R. ORR APR 2 68
CHECK [illegible] 5-29-68
ENGR

WESTERN GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

RAMP - CASSEGRAIN RAMP ASSEMBLY

W.G.N 102971
APPROVED

SIZE E | CODE IDENT NO. 16603 | 2150.240E003 | REV C
SCALE 1/8 (UNLESS NOTED) WT 1470 LB SHEET 1 OF 1

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS DEPARTMENT
APPROVED FOR PROCUREMENT
SEP 1968