

4

3

2

1

TO CLEAR .16 MAX
FILLET RADIUS (TYP)

4.000 $\pm .000$
 $\pm .010$

1/8 AXIAL
BALL RELIEF

39/8 B.C.

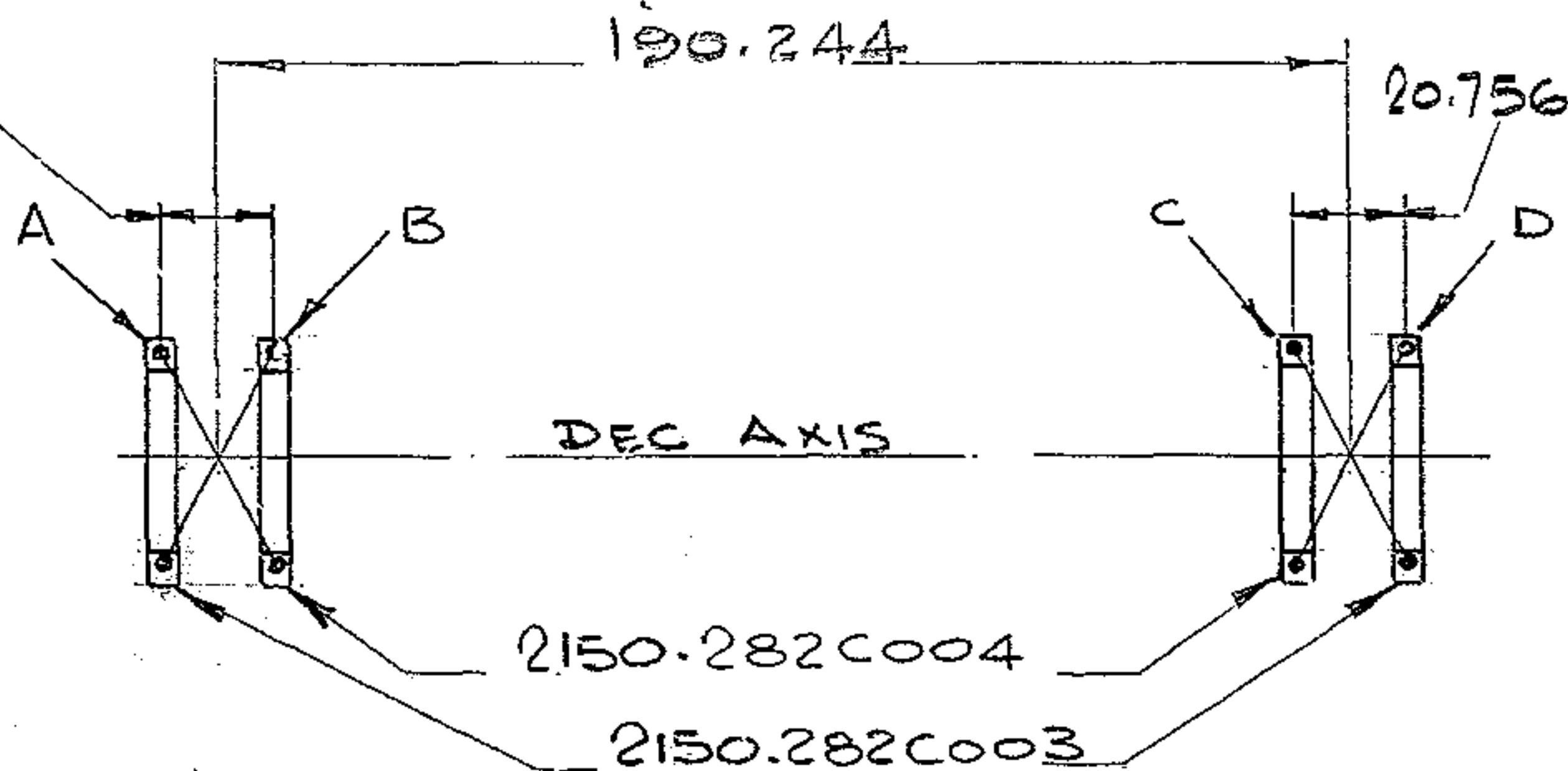
41.000 $\pm .002$ DIA

32 3/4 B.C.

31.500 $\pm .002$ DIA

3/16-16 UNC-2B x 3/4 DEEP MIN
12 PLACES EQ. SP

20.756



ARRANGEMENT OF BEARINGS WHEN INSTALLED

LOADING CONDITIONS OF BEARINGS

DEC. AXIS HORIZONTAL

	BRG. A	BRG. B	BRG. C	BRG. D
RADIAL	62,000#	62,000#	62,000#	62,000#
THRUST	257,000#	25,000#	125,000#	257,000#

DEC AXIS @ 32° TO HORIZONTAL

	BRG. A	BRG. B	BRG. C	BRG. D
RADIAL	32,800#	32,800#	32,800#	32,800#
THRUST	244,000#	136,000#	356,000#	25,000#

BRG DATA

No OF BALLS = 38
 BALL CIRCLE DIA = 36.750
 BALL DIA = 2.500
 ALL BALLS TO BE SAME DIA
 WITHIN .0001
 CONTACT ANGLE 29°-47'-49"

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	REVISED PER AURA APPVD PRINT	6-29-68	
A1	B	DWG. NO. WAS. 2150.282C004; NEXT ASSY WAS 2150.282E002 W.G.N102938; ADDED NOTE 8	3 Aug 68	G.R.
D3	B	ADDED 1/8 AXIAL BALL RELIEF		
A4	B	ADDED 3/8-16 HOLES		

NOTES

- .0010 T.I.R. MAX RADIAL RUNOUT OF INNER AND OUTER RACES.
AMOUNT & POSITION OF RUNOUT TO BE MARKED ON BRG.
- .0010 T.I.R. MAX AXIAL RUNOUT OF ALL FACES
AMOUNT & POSITION OF RUNOUT TO BE MARKED ON BRG
- ALL DIMENSIONS ARE IN INCHES
- RACE HARDNESS = 60-63 Rc (INNER & OUTER)
BALL HARDNESS = 63-66 Rc
- OPERATING SPEEDS
.125 RPM MAX
0 RPM MIN.
- ALL SURFACES TO BE GROUND ³²
EXCEPT BALL TRACKS TO BE GROUND
TO ACHIEVE MIN. FRICTION
- MARK ON PART NO. "2150.280C004"
- MATING HSG DIA 40.996 $\pm .002$
MATING SHAFT DIA 31.502 $\pm .002$

REF. FILE 1174

NEXT ASSY: 2150.280E002 (W.G.N102,844)

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (LM)					
LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED ANGULAR = $\pm 1^\circ 0'$ LINEAR: .X = $\pm .1$.XXX = $\pm .010$.XX = $\pm .03$ FRACTIONAL = $\pm 1/32$ BREAK ALL SHARP EDGES		150" STELLAR. TELESCOPE MTG	WESTERN GEAR CORPORATION HEAVY MACHINERY DIVISION EVERETT, WASHINGTON		
MATERIAL RACES - AISI 52100 BALLS - AISI 52100 CAGE - BRONZE		DRAWN P. H. CRAW 2/26/68 CHECK GENE RUSSO 4/20/68 ENGR	S.C.D. BEARING CENTER SECTION		
W.G. D107 371 APPROVED		SIZE C 16603	CODE IDENT NO. 2150.280C004	REV B	
SCALE FULL		WT	LB	SHEET 1	OF 1

WESTERN GEAR CORPORATION
 CONSTRUCTION PROJECTS
 DEPARTMENT
 APPROVED FOR
 PROCUREMENT
 J.R. DATE 28 Jan 68