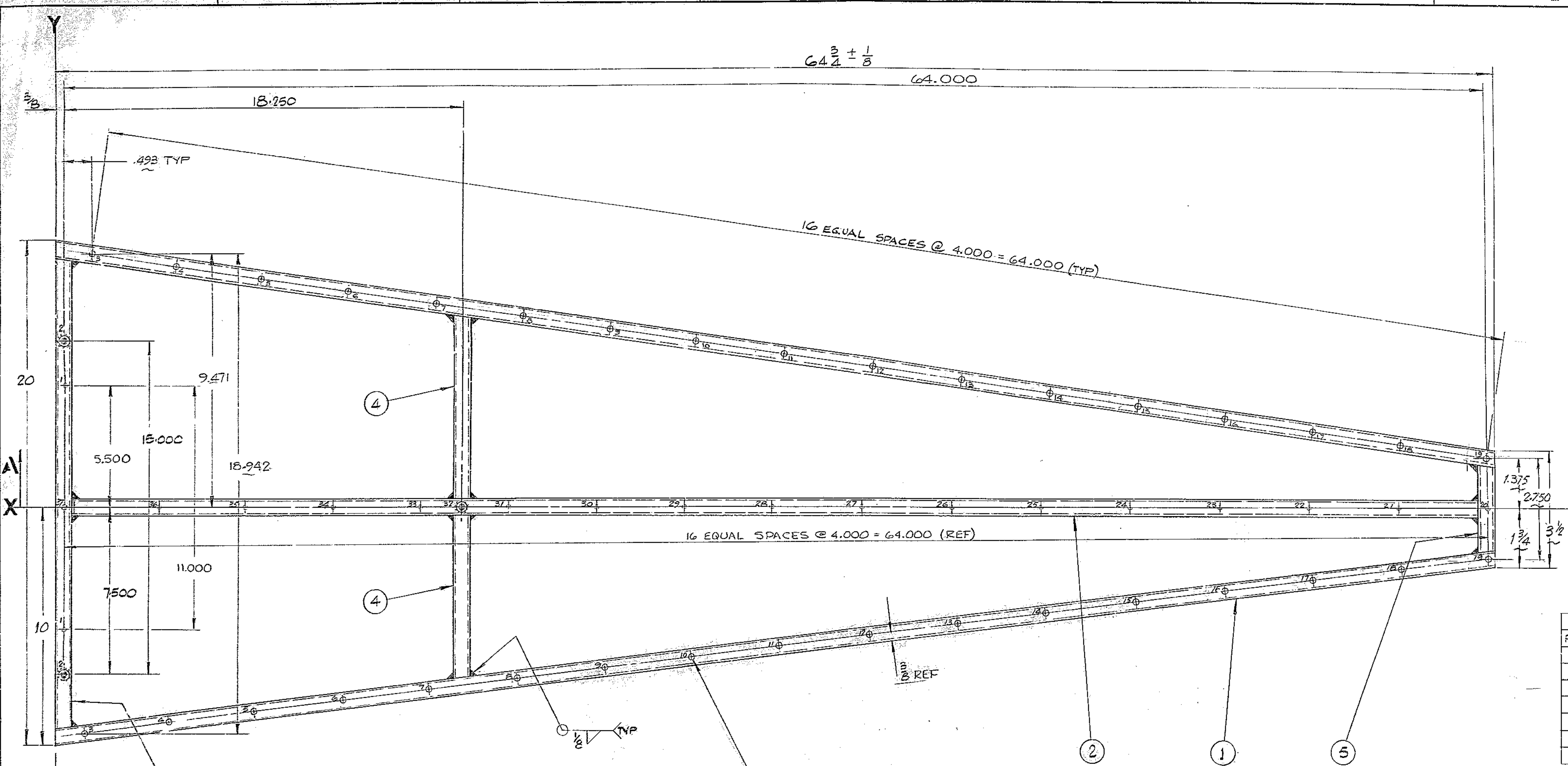


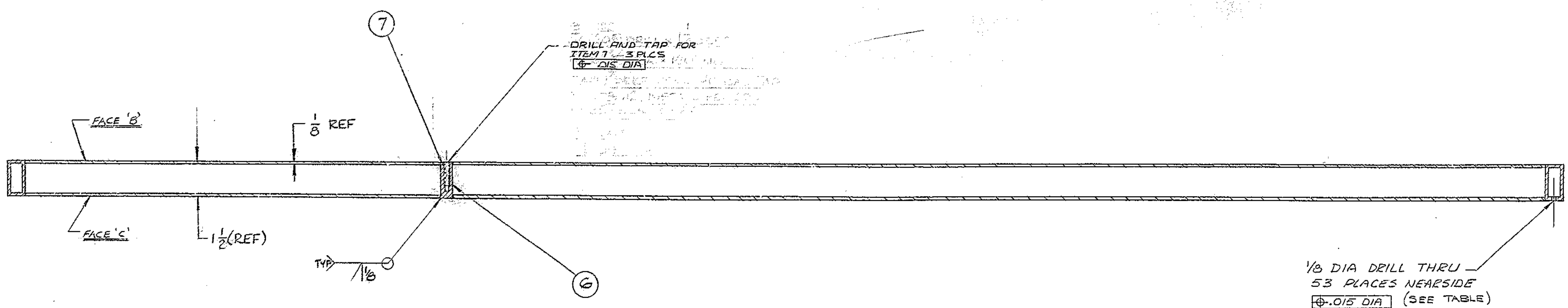
ZONE	LTR	DESCRIPTION	DATE	APPROVED
F2	A	1.375 WAS 2.250 2.750 WAS 4.500	10-2-88	
E2	A	1 3/4 WAS 2 3/8 3 1/2 WAS 5 1/4		
E3	A	10 WAS 11 3/8		
F3	A	20 WAS 22 3/4		
E7	A	9.471 WAS 10.319 18.942 WAS 21.838		
H3	A	.493 2.111 WAS .590		
A		XX Y-Y GO-ORDINATE DIMS ADDED		
A		APPD PER AURA CONSTRUCTION PENT 3/19/88		
B		ITEM 7 WAS 10-24 UNC X 1/2 BUILT	3/28/88	SKILES



PCND	QTY	DESCRIPTION	MATE & SPEC	ROUGH WT
1	2	TUBE 1 1/2 X 3/4 X 1/8 X 65 1/2	ALUM 6063-T5	12
2	1	TUBE 1 1/2 X 3/4 X 1/8 X 64	" " "	12
3	1	TUBE 1 1/2 X 3/4 X 1/8 X 21 1/2	" " "	4
4	2	TUBE 1 1/2 X 3/4 X 1/8 X 7 1/2	" " "	1
5	1	TUBE 1 1/2 X 3/4 X 1/8 X 4 1/4	" " "	1
6	3	1/2 DIA X 3/4 LG BAR	" " "	1
7	3	HELICOIL INSERT 1/8-20 UNC X 3/4 LG	HELICAL WREATHING #1185-ACN-0150	

**NOTES**

- ALL DIMENSIONS ARE IN INCHES
- WELD PER WGC SPEC. 752, APPENDIX TI
- APPLY ONE (1) COAT PRIMER PAINT IMMEDIATELY AFTER STRESS RELIEVE & CLEANING PER NGC SPEC. 511.
- STAMP PART NO. 2150.281.E011 APPROX. WHERE SHOWN.
- FABRICATION TOLERANCES EXCEPT AS NOTED UP TO 10 IN. ± 1/16 10 TO 50 IN. ± 1/8 50 IN. & OVER ± 1/4
- SEE NOTE IN ZONE 6C FOR DRILLING AND TAPPING OF THESE HOLES



HOLE NO.	DISTANCE FROM X-X	DISTANCE FROM Y-Y	HOLE SIZE	HOLE DIA
1	5.500	0.375	7/16	
2	7.500	0.375	7/16	
3	9.471	0.868	3/32	1/8
4	8.965	4.837		
5	8.459	6.806		
6	7.953	12.775		
7	7.447	16.745		
8	6.941	20.714		
9	6.435	24.683		
10	5.929	28.652		
11	5.423	32.621		
12	4.917	36.591		
13	4.411	40.560		
14	3.905	44.529		
15	3.399	48.498		
16	2.893	52.467		
17	2.387	56.437		
18	1.881	60.406	3/32	1/8
19	1.375	64.375	9/32	1/8
20	0.000	64.375		
21	0.000	60.375		
22	0.000	56.375		
23	0.000	52.375		
24	0.000	48.375		
25	0.000	44.375		
26	0.000	40.375		
27	0.000	36.375		
28	0.000	32.375		
29	0.000	28.375		
30	0.000	24.375		
31	0.000	20.375		1/8
32	0.000	18.250	7/16	
33	0.000	16.375		1/8
34	0.000	12.375		
35	0.000	8.375		
36	0.000	4.375		
37	0.000	0.375		1/8

**SECTION A-A**

WESTERN GEAR CORPORATION  
CONSTRUCTION PROJECTS  
DEPARTMENT  
APPROVED FOR  
PROCUREMENT  
R.G. DATE 1/21/88

NEXT ASSY. 2150.281E002 (WGN 103002)

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					
XX = ± .03 FRACTIONAL = ± 1/32					
BREAK ALL SHARP EDGES					
ENGR					
MATERIAL					
SEE MAT'L LIST					
150IN STELLAR TELESCOPE MOUNTING GEAR CORPORATION					
DRAWN MAUNDERS 09/68					
CHECK [Signature] 8/5/88					
BREAK ALL SHARP EDGES					
ENGR					
IRIS FRAME, DUST COVER & IRIS ASSY. PRIMARY W/PROK					
WGN 103002					
SIZE CODE IDENT NO. E 16603 2150.281 E011					
APPROVED					
SCALE 1/2" = 1" WT 96 LB SHEET 1 OF 1					