

4

3

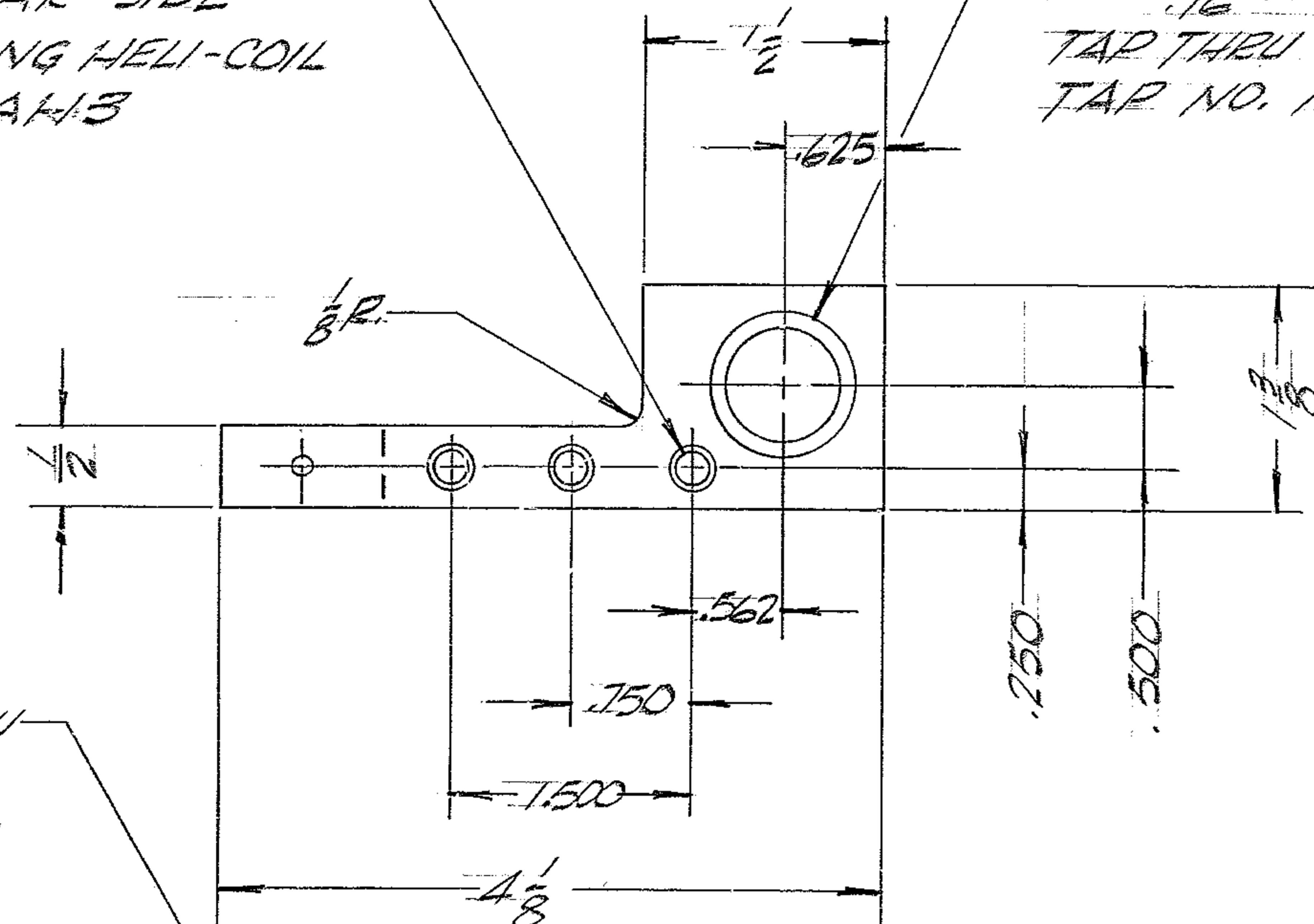
2

1

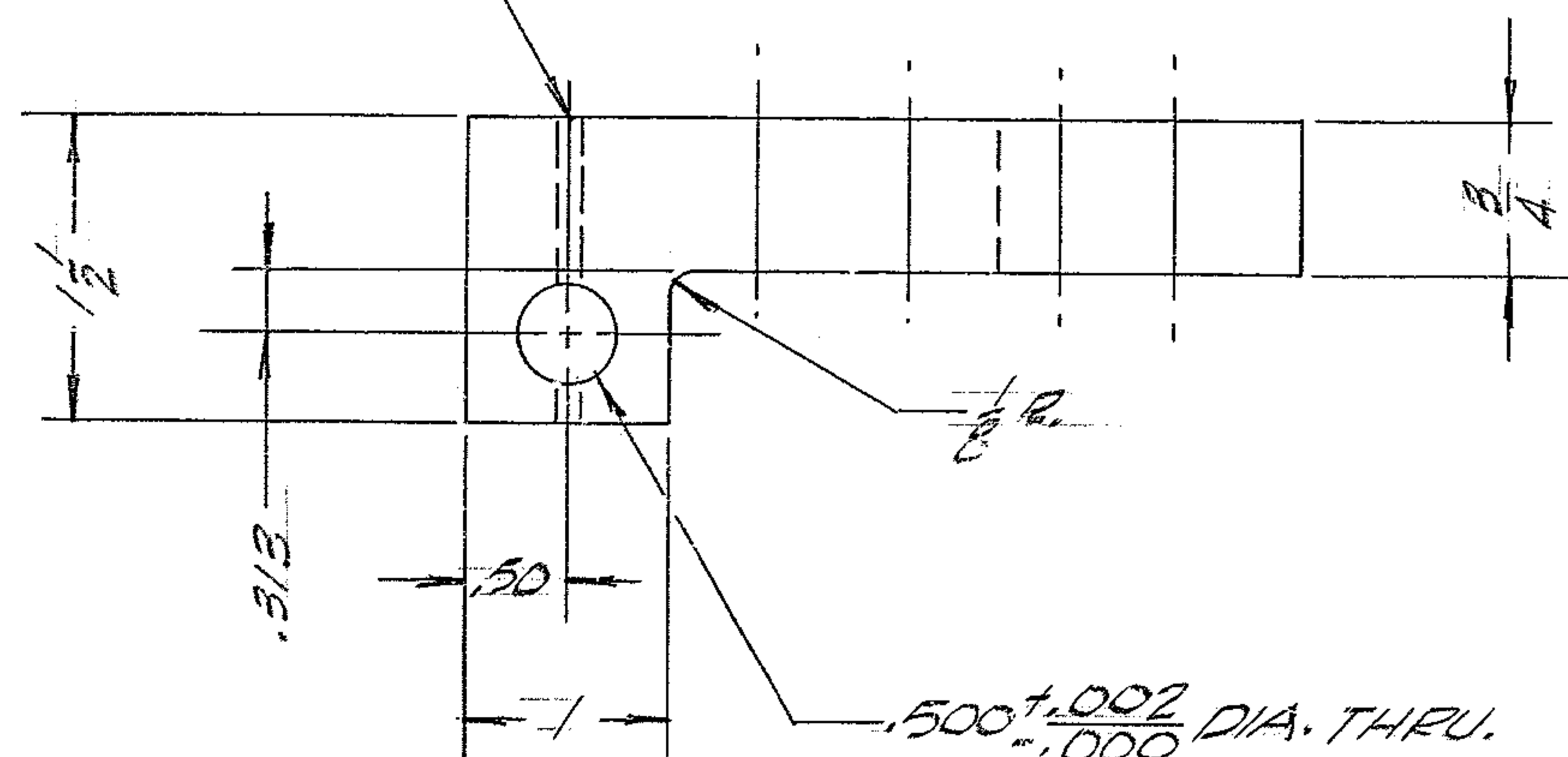
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	RELEASED FOR CONST.	11/5/68	
CI	B	PIN 3 WAS 1185-10CNO625 ADDED "OR EQ" TO P/N'S 2 & 3	11/5/71	JW

REMOVE TANG AFTER INSTL. ②  
 13  
 64 DRILL .199 DIA. THRU  
 205  
 CSK.  $\frac{1}{16}$  x 120° FAR SIDE  
 27  
 TAP THRU USING HELI-COIL  
 TAP NO. 3CPAH3  
 3 PLACES

③ REMOVE TANG. AFTER  
 INSTL. 21 DRILL .653 DIA. THRU  
 22  
 663  
 CSK.  $\frac{1}{16}$  DIA. x 120° NEAR SIDE  
 TAP THRU USING HELI-COIL  
 TAP NO. 18187-10H4



DRILL  $\frac{1}{16}$  DIA. THRU  
 125  
 129  
 AT ASS'Y. REF.  
 2150.283E502



MATERIAL LIST				
PC. NO.	QTY.	DESCRIPTION	MAT'L. & SPEC.	ROUGH WGT.
1	1	SQ. BAR $1\frac{1}{2}$ x $1\frac{1}{2}$ x $4\frac{3}{8}$	AL. ALLOY 6061-T651	.2 LBS.
2	3	HELI-COIL INSERT 10-24 UNC-2B x .570 LG.	HELI-COIL CORP. OR EQ. PART NO. 1185-30N0510	—
3	1	HELI-COIL INSERT 5/8-11 UNC-2B x 5/8 LG.	HELI-COIL CORP. OR EQ. PART NO. 3585-10CNO625	—

NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. METAL STAMP PART NO. 2150.283C510 APPROX. WHERE SHOWN
3. ALL SURFACES TO BE 125/
4. FLAT BLACK ANODIZE ALL OVER BEFORE INSTALLING INSERT PC. NO. 2 & 3.
5. DIMENSIONS APPLY BEFORE ANODIZING.

NEXT ASS'Y: 2150.283E502 (W.G.N 102974)

REF. FILE 1176

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (LM)					
LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED		150 IN. STELLAR TELESCOPE MTG.		<b>Western GEAR CORPORATION</b>	
ANGULAR = ± 1° 0'		DRAWN P. NIEVES 11/8/68		HEAVY MACHINERY DIVISION EVERETT, WASHINGTON	
LINEAR:		CHECK R. GRIFFITHS 11/12/68		HINGE, STRONGBACK CENTRAL DUST COVER COULDE #3	
.X = ± .1    .XXX = ± .010		ENGR			
.XX = ± .03    FRACTIONAL = ± 1/32		MATERIAL		SIZE CODE IDENT NO. REV	
BREAK ALL SHARP EDGES		SEE MAT'L LIST		C 16603 2150.283C510 B	
MATERIAL		W.G. D. 107661		SCALE 1/1 WT LB SHEET / OF /	
APPROVED					

WESTERN GEAR CORPORATION  
 CONSTRUCTION PROJECTS  
 DEPARTMENT  
 APPROVED FOR  
 PROCUREMENT  
 P.G. DATE 11/21/68