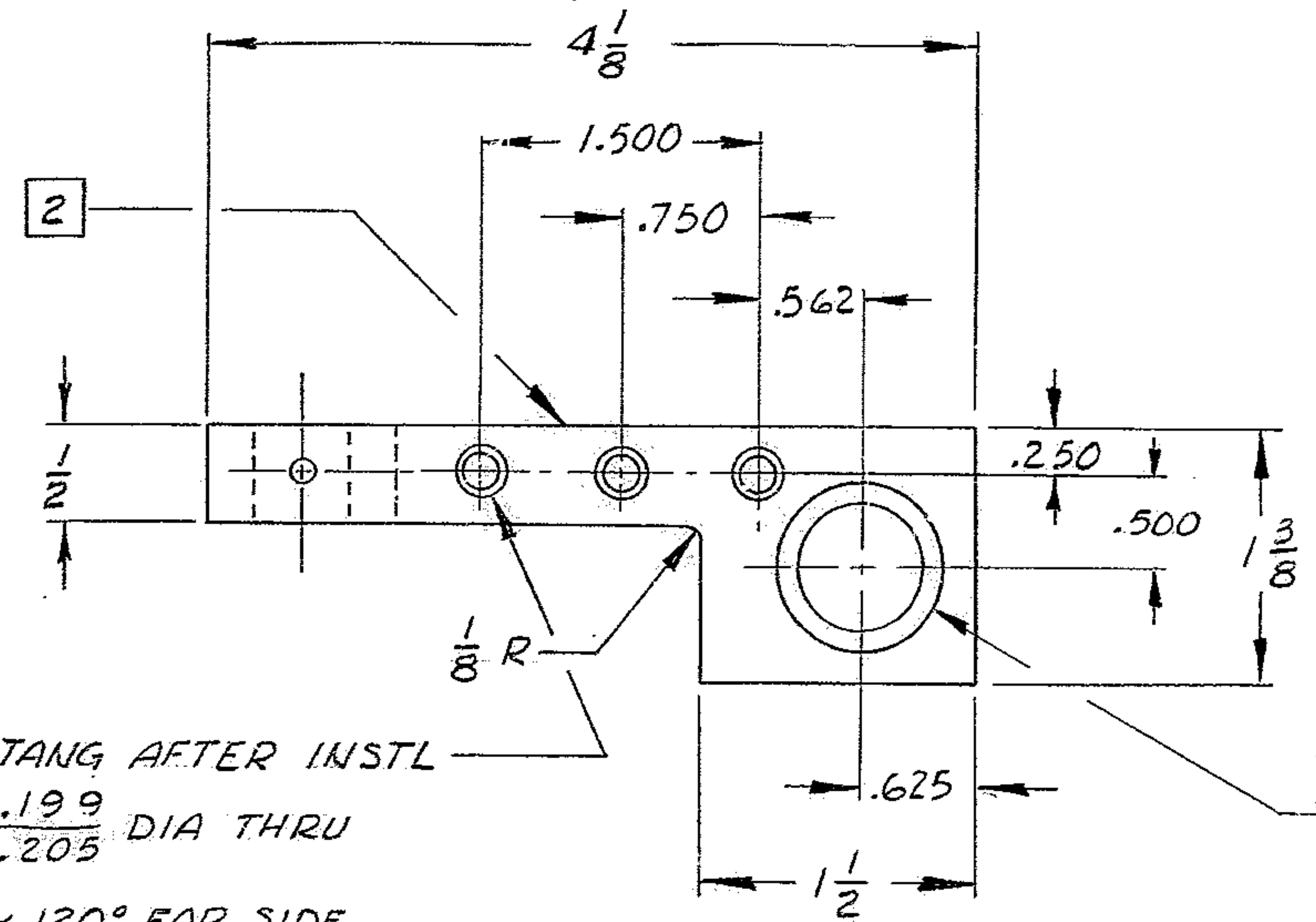
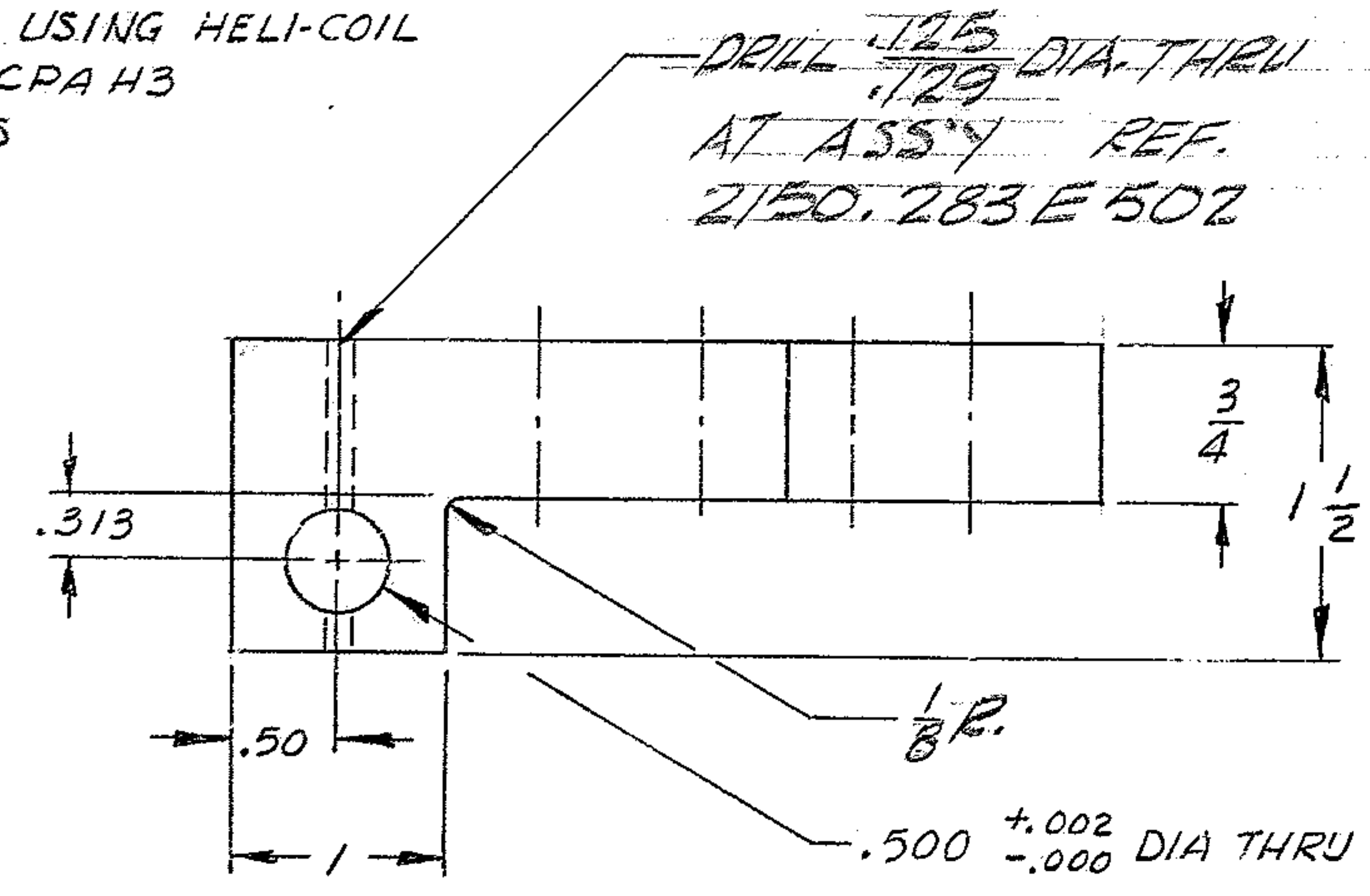


REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	REVISED FOR CONST. PER AURAS APP'D PRINT	1/10/68	
C-1	B	PINS W/AS 1185-10CN0625 ADDED "OR EQ" TO PINS 2 & 3	7/15/71	JW



② REMOVE TANG AFTER INSTL
 $\frac{13}{64}$ DRILL $\frac{.199}{.205}$ DIA THRU
 CSK $\frac{.24}{.27} \times 120^\circ$ FAR SIDE
 TAP THRU USING HELI-COIL
 TAP No. 3 CPA H3
 3 PLACES

③ REMOVE TANG AFTER INSTL
 $\frac{21}{32}$ DRILL $\frac{.653}{.663}$ DIA THRU
 CSK $\frac{.73}{.76}$ DIA $\times 120^\circ$ NEAR SIDE
 TAP THRU USING HELI-COIL
 TAP No. 18187-10 H4



DRILL $\frac{.125}{.129}$ DIA THRU
 AT ASSY REF.
 2150.283 E 502

MATERIAL LIST				
PC No.	QTY	DESCRIPTION	MATL & SPEC	ROUGH WT
1	1	50 BAR $1\frac{1}{2} \times 1\frac{1}{2} \times 4\frac{3}{8}$	AL ALY 6061-T651	.2
2	3	HELI-COIL INSERT, 10-24 UNC-28 \times .570 LG	HELI-COIL CORP, OR EQ, PART No. 1185-3CN 0570	-
3	1	HELI-COIL INSERT $\frac{5}{8}$ -11 UNC-28 \times $\frac{5}{8}$ LG	HELI-COIL CORP OR EQ, PART No. 3785-10CN 0625	-

NOTES:

- ALL DIMENSIONS ARE IN INCHES.
- METAL STAMP PART No. 2150.283B512 APPROX AS SHOWN.
- ALL SURFACES TO BE 125/
- FLAT BLACK ANODIZE ALL OVER BEFORE INSTALLING INSERTS PC. NO 2 & 3
- DIMENSIONS APPLY BEFORE ANODIZING.

NEXT ASSY 2150.283E 502 (WGN102974)

REF. FILE 1176

WESTERN GEAR CORPORATION
 CONSTRUCTION PROJECTS
 DEPARTMENT
 APPROVED FOR
 PROCUREMENT
 R.P. DATE 1/21/68

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 = $\pm 1/32$		150 IN STELLAR TELESCOPE MOUNTING		WESTERN GEAR CORPORATION HEAVY MACHINERY DIVISION EVERETT, WASHINGTON	
BREAK ALL SHARP EDGES		DRAWN COSTA 4-29-68 CHECK J. W. WILSON 5-20-68 ENGR		HINGE, STRONGBACK CENTRAL DUST COVER COUDE No. 3	
MATERIAL SEE MATERIAL LIST		WGD 107526		SIZE CODE IDENT NO. REV C 16603 2150.283C 512 B	
APPROVED		SCALE 1/1		WT 1/4 LB SHEET 1 OF 1	