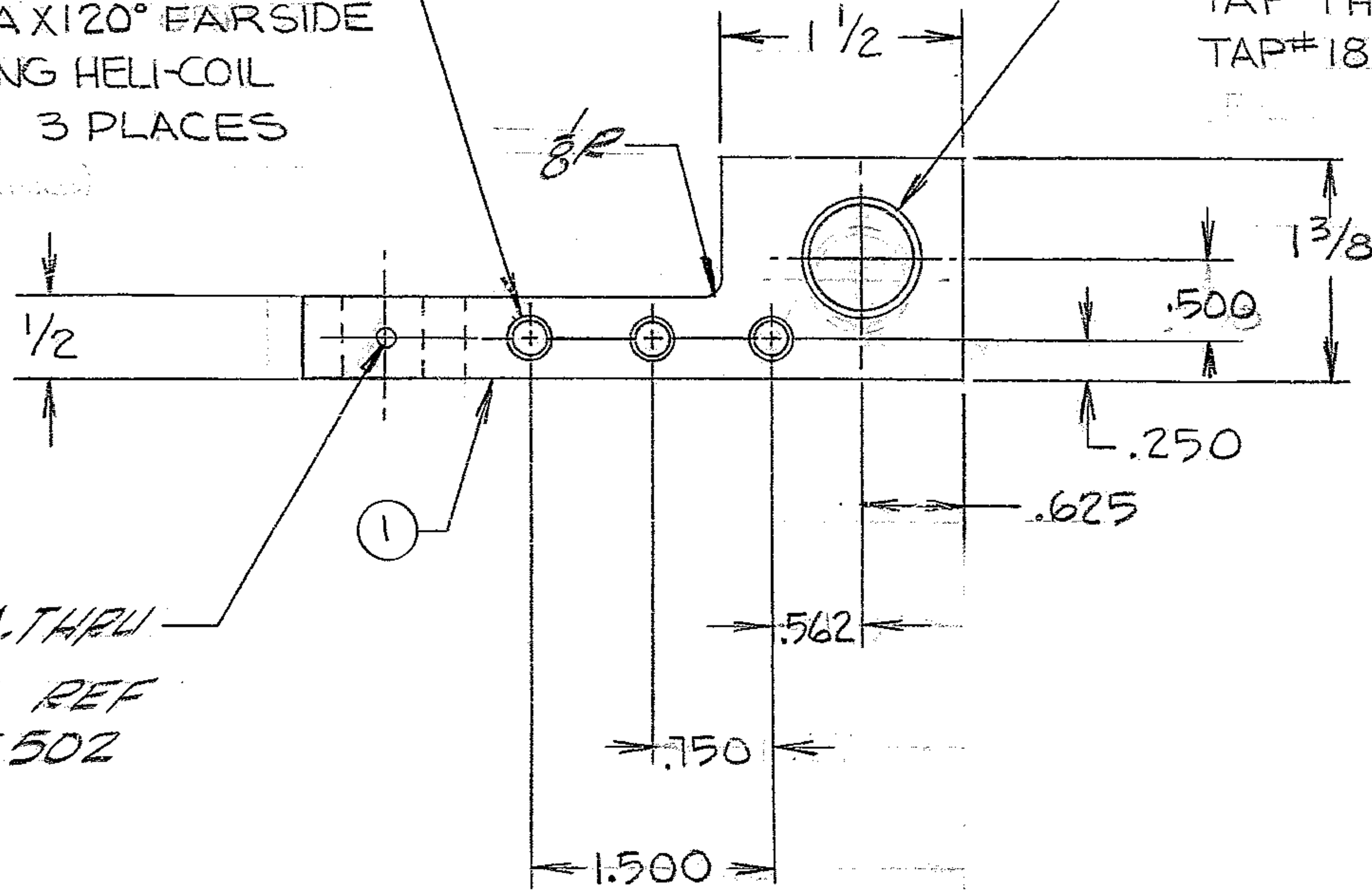


REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	REVISED FOR CONST PER AURA'S APPD PRINT	11/2/68	
	B	P/N 3 WAS No. 1185-10CN0625 ADDED "OR EQ" TO P/N 2 & 3	7/15/71	JW

REMOVE TANG AFTER INSTL
 $\frac{13}{64}$ DRILL $\frac{199}{205}$ DIA. THRU
 C'SINK $\frac{24}{27}$ DIA X 120° FAR SIDE
 TAP THRU USING HELI-COIL
 TAP #3CPAH3 3 PLACES

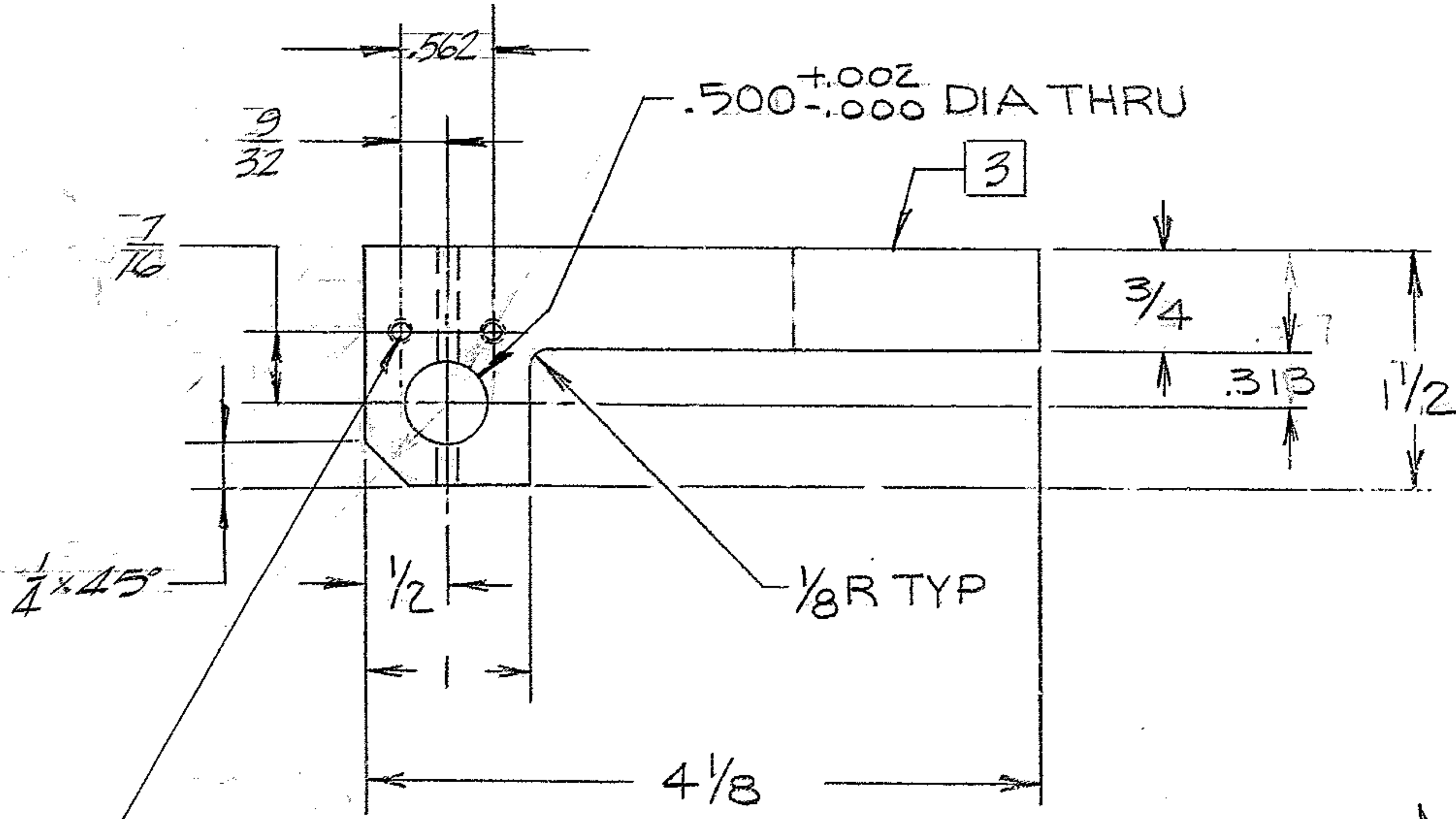
3 REMOVE TANG AFTER INSTL
 $\frac{21}{32}$ DRILL $\frac{653}{663}$ DIA THRU
 C'SINK $\frac{73}{76}$ DIA X 120° NEAR SIDE
 TAP THRU USING HELI-COIL
 TAP #18187-10H4



DRILL $\frac{125}{129}$ DIA. THRU
 AT ASSY - REF
 2150.283E502

- NOTES:
1. ALL DIMENSIONS ARE IN INCHES
 2. ALL SURFACES TO BE $125\sqrt{}$
 3. STAMP WITH PART NO. 2150.283C515
 4. FLAT BLACK ANODIZE ALL OVER BEFORE INSTALLING INSERTS PCNO. 2 & 3.
 5. DIMENSIONS APPLY BEFORE ANODIZING.

MATERIAL LIST				
PC NO	QTY	DESCRIPTION	MATL & SPEC	ROUGH WT
1	1	SQ BAR $1\frac{1}{2} \times 1\frac{1}{2} \times 4\frac{3}{8}$	AL ALLOY 6061-T651	.2
2	3	HELI-COIL INSERT 10-24UNC-2BX $\frac{5}{8}$ LG	HELI-COIL CORP. OR EQ. PART NO. 1185-3CN0570	-
3	1	HELI-COIL INSERT $\frac{3}{8}$ -11UNC-2B $\frac{5}{8}$ LG	HELI-COIL CORP OR EQ. PART NO. 3585-10CN0625	-



#29 (.1360 DIA.) THRU
 TAP #8-32 UNC THRU
 2 HOLES

NEXT ASSY 2150.283E502 (W.G.N 102,974)

REF. FILE 1176

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

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 MTG.		WESTERN GEAR CORPORATION HEAVY MACHINERY DIVISION EVERETT, WASHINGTON	
BREAK ALL SHARP EDGES		DRAWN BIRKENDAHL 4-6-68 CHECK <i>Nicolay</i> 5-18-68 ENGR		HINGE, STRONGBACK CENTRAL DUST COVER COUDE #3	
MATERIAL RECT. BAR AL ALLOY SEE LIST, MATL 6061-T651		W.G.D. 107454 APPROVED		SIZE C 16603	CODE IDENT NO. 2150.283C515
				REV B	
SCALE 1/1		WT 1/4		LB SHEET 1 OF 1	