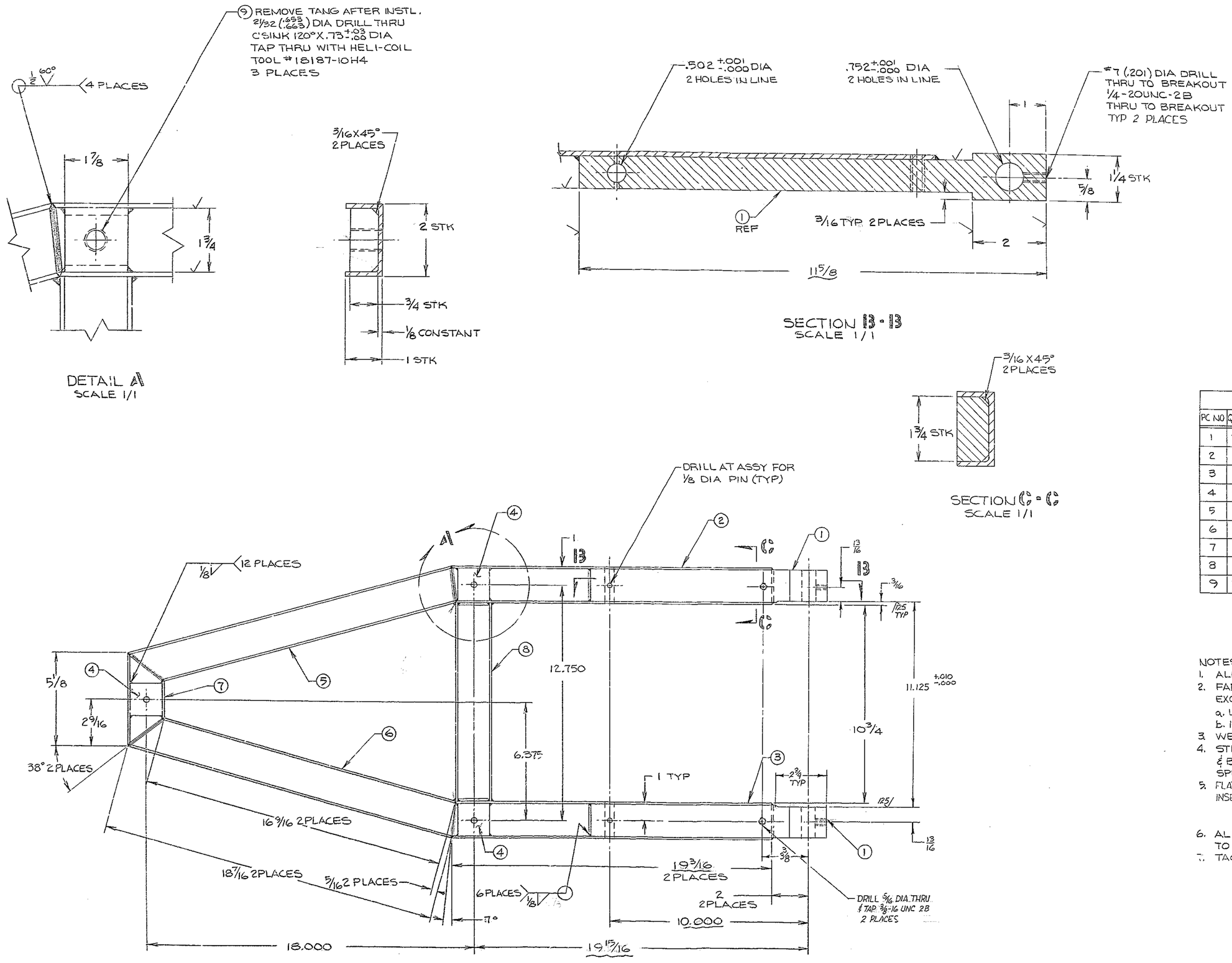
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
D4	A	13/16 DIM ADDED	1-3-68	
D3	A	3/16 DIM ADDED, FINISH MARKS ADDED, HOLES [illegible]	"	
C4	A	2 3/4 TYP ADDED, TAPPED HOLE ADDED	"	
C3	A	13/16 DIM ADDED	"	
G2	A	TYP 2 PLACES ADDED TO NOTE	"	
C1	A	NOTE 3; APP 71 ADDED	"	
B2	A	NOTE 6: 125 FINISH WAS 250 FINISH	"	
B4	A	3/8 TAPPED HOLE DIM'S ADDED, 3 1/8 DIM ADDED	"	
	A	REVISED PER RUBA APPD PRINT		
B4	B	3 3/8 DIM WAS 3 1/8 & 11 3/8 DIM WAS 11 (F4)	2-12-68	
E2	B	P/N 1 WAS 11 LG - ZONE B-4: 10.000 DIM WAS 9.000	"	
E2	C	P/N 1 & 4 MATL WAS AL ALLOY 6063-T5	8-21-0	



MATERIAL LIST				
PC NO	QTY	DESCRIPTION	MATL & SPEC	ROUGH WT
1	2	SQ BAR 1 3/4 X 1 3/4 X 11 5/8 LG	AL. ALLOY 6061-T6	3
2	1	CHAN 2X1X 1/8 THK X 19 3/16 LG	AL. ALLOY 6063-T5	9
3	1	CHAN 2X1X 1/8 THK X 19 3/16 LG	AL. ALLOY 6063-T5	9
4	3	SQ BAR 2X2 X 3/4 LG	AL. ALLOY 6061-T6	3
5	1	CHAN 2X1X 1/8 THK X 18 9/16 LG	AL. ALLOY 6063-T5	8
6	1	CHAN 2X1X 1/8 THK X 18 9/16 LG	AL. ALLOY 6063-T5	8
7	1	CHAN 2X1X 1/8 THK X 5 1/8 LG	AL. ALLOY 6063-T5	2
8	1	CHAN 2X1X 1/8 THK X 10 3/4 LG	AL. ALLOY 6063-T5	5
9	3	HELI-COIL INSERT 5/8-11UNC 2AX 5/8 LG	HELI-COIL CORP PART NO. 3585-10CN0625	—

NOTES:
1. ALL DIMENSIONS ARE IN INCHES
2. FABRICATION TOLERANCES EXCEPT AS NOTED:
   a. UP TO 10 INCHES 1/16
   b. 10 TO 50 INCHES 1/8
3. WELD PER W.G.C. SPECIFICATION 752 APP 71
4. STRESS RELIEVE AFTER WELDING & BEFORE MACHINING PER W.G.C. SPECIFICATION 510
5. FLAT BLACK ANODIZE ALL OVER BEFORE INSTALLING INSERTS PC. NO. 9
6. ALL SURFACES MARKED √ TO BE 125√ EXCEPT AS NOTED
7. TAG WITH PART NO. 2150.283E603

REF. FILE 1176

NEXT ASSY 2150.283E602 (W.G.N 102,988)

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (LM)					

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS DEPARTMENT
APPROVED FOR PROCUREMENT
DG DATE 2/38

LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED
ANGULAR = ± 1° 0'
LINEAR:
.X = ± .1 .XXX = ± .010
.XX = ± .03 FRACTIONAL = ± 1/32
BREAK ALL SHARP EDGES
MATERIAL
SEE LIST MATL

150 IN STELLAR TELESCOPE MTG.

DRAWN B. IRKENDAHL 3-16-68
CHECK [illegible] 5-20-68
ENGR

W.G.N 102,990
APPROVED

Western GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

STRONGBACK
COUDE #3 ASSY

SIZE	CODE IDENT NO.		REV
E	16603	2150.283E603	C

SCALE 1/2 WT 45 LB SHEET 1 OF 1