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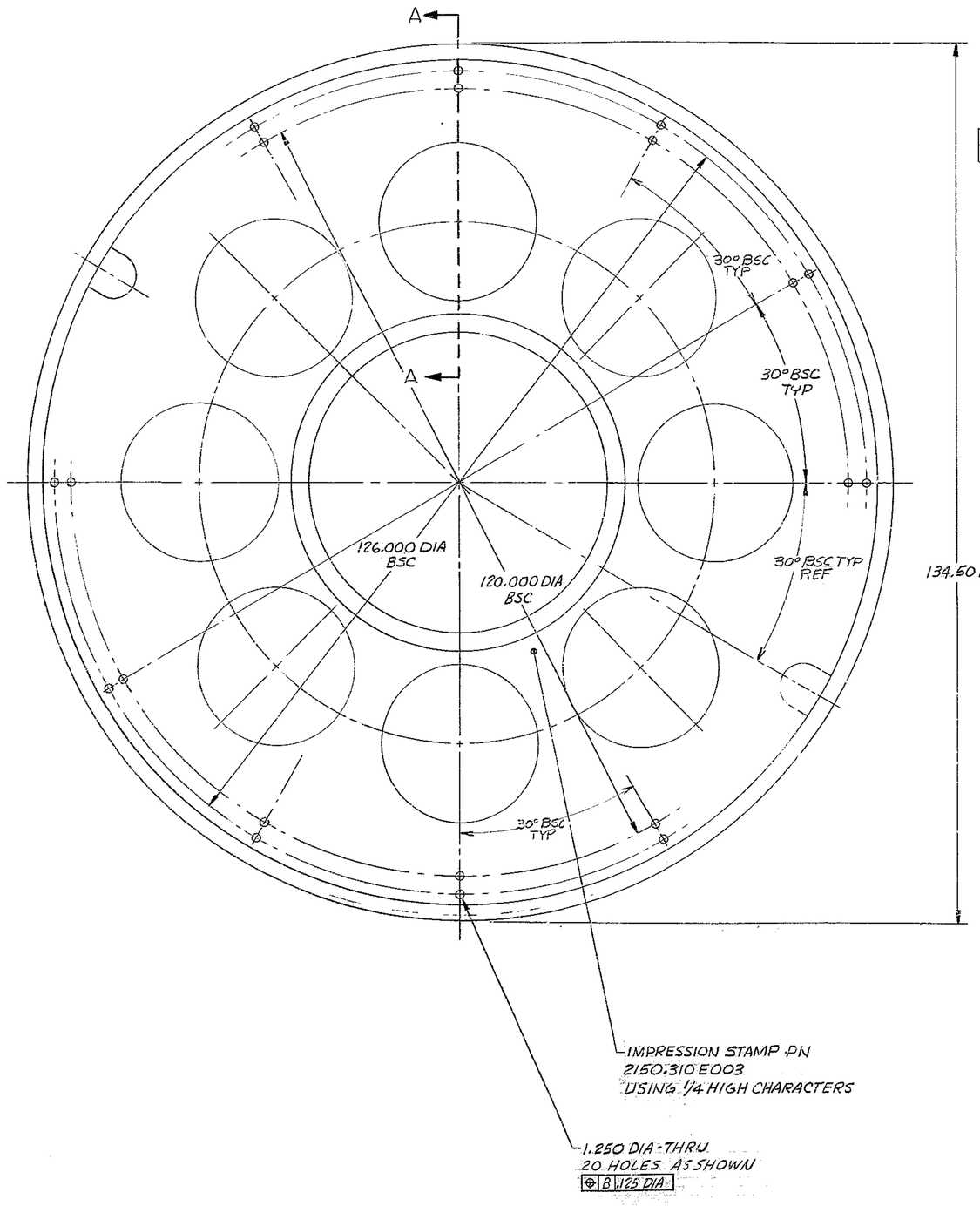
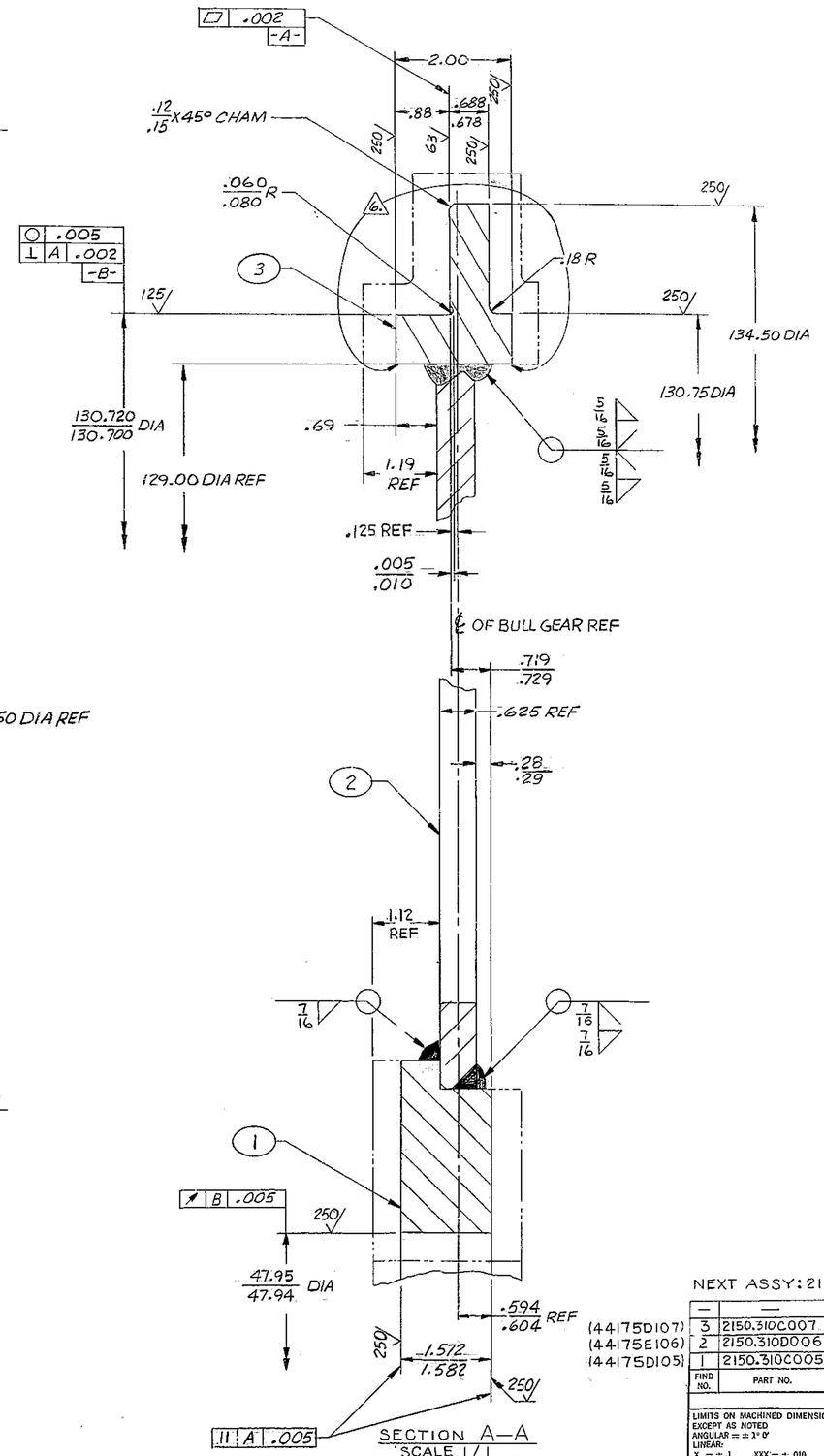
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED





NOTES: UNLESS OTHERWISE SPECIFIED.

1.- ALL DIMENSIONS ARE IN INCHES.

2.- INTERPRET DIMENSIONING AND TOLERANCING PER USA STANDARD USASI-Y14.5-1966.

3.- SURFACE ROUGHNESS AS DESIGNATED ALL OVER PER USA STANDARD USAS-B46.1-1962.

4.- INTERPRET WELDING SYMBOLS PER AWS STANDARD ASW A2.0-1958.

5.- HEAT TREAT AS FOLLOWS:
PLACE WELDMENT IN FURNACE. FURNACE TEMPERATURE NOT TO EXCEED 400°F. FORGING TO BE SUPPORTED ADEQUATELY DURING HEAT TREATMENT TO AVOID DISTORTION.
A. BRING FURNACE TEMPERATURE UP TO 1250°F AT A RATE OF 50°F PER HOUR.
HOLD AT TEMPERATURE FOR (6) HOURS.
B. FURNACE COOL AT A RATE OF 50°F PER HOUR UNTIL FURNACE TEMPERATURE HAS REACHED 400°F. THEN WELDMENT MAY BE AIR COOLED.
C. ROUGH MACHINE LEAVING (.12) STOCK MIN FOR FINISHING MACHINED SURFACES.
D. REPEAT STEPS A AND B.

6. MACHINING:
NO CARBIDE TOOLS ON FINISH MACHINING. USE HIGH SPEED CUTTING TOOLS ONLY.

7.- REMOVE PART NO. 2150.310D006 AND IMPRESSION STAMP NEW PART NO. AS SHOWN.

8.- APPLY ONE COAT OF PRIME PAINT ON ALL NON-MACHINED SURFACES PER W.G.C. SPECIFICATION NO. 511.

NEXT ASSY: 2150.310E002 (82402-44175R102)

REF. FILE 1183

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
—	—	WELDING ROD	AR	PER MIL-R-5632	—
3 (44175D107)	2150.310C007	FLANGE	1	PER PRINT	16603
2 (44175E106)	2150.310D006	WEB	1	PER PRINT	16603
1 (44175D105)	2150.310C005	HUB	1	PER PRINT	16603

LIST OF MATERIAL (LM)

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

150 IN. STELLAR TELESCOPE MTG

DRAWN	L BELL	9-5-69
CHECK	V V G	10-20-69
ENGR	V V G	10-20-69
METALLURGIST		

82402-44175R103

APPROVED

western GEAR CORPORATION — HEAVY MACHINERY DIVISION EVERETT, WASHINGTON

WEB ASSY, & MTG WELDMENT-R.A.-BULL GEAR

SIZE	CODE IDENT NO.		REV
E	16603	2150.310E003	

SCALE 1/8 WT — LB SHEET 1 OF

REV -

44175R103