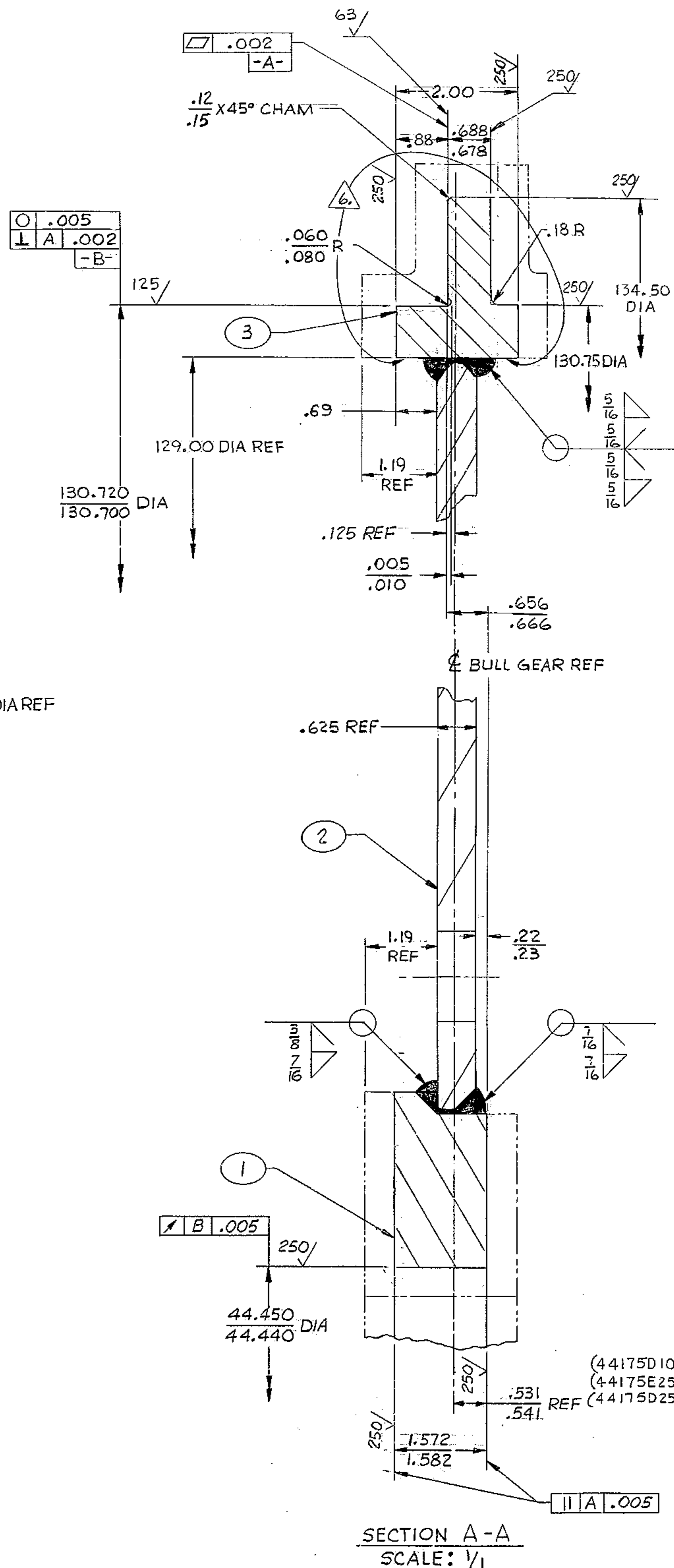
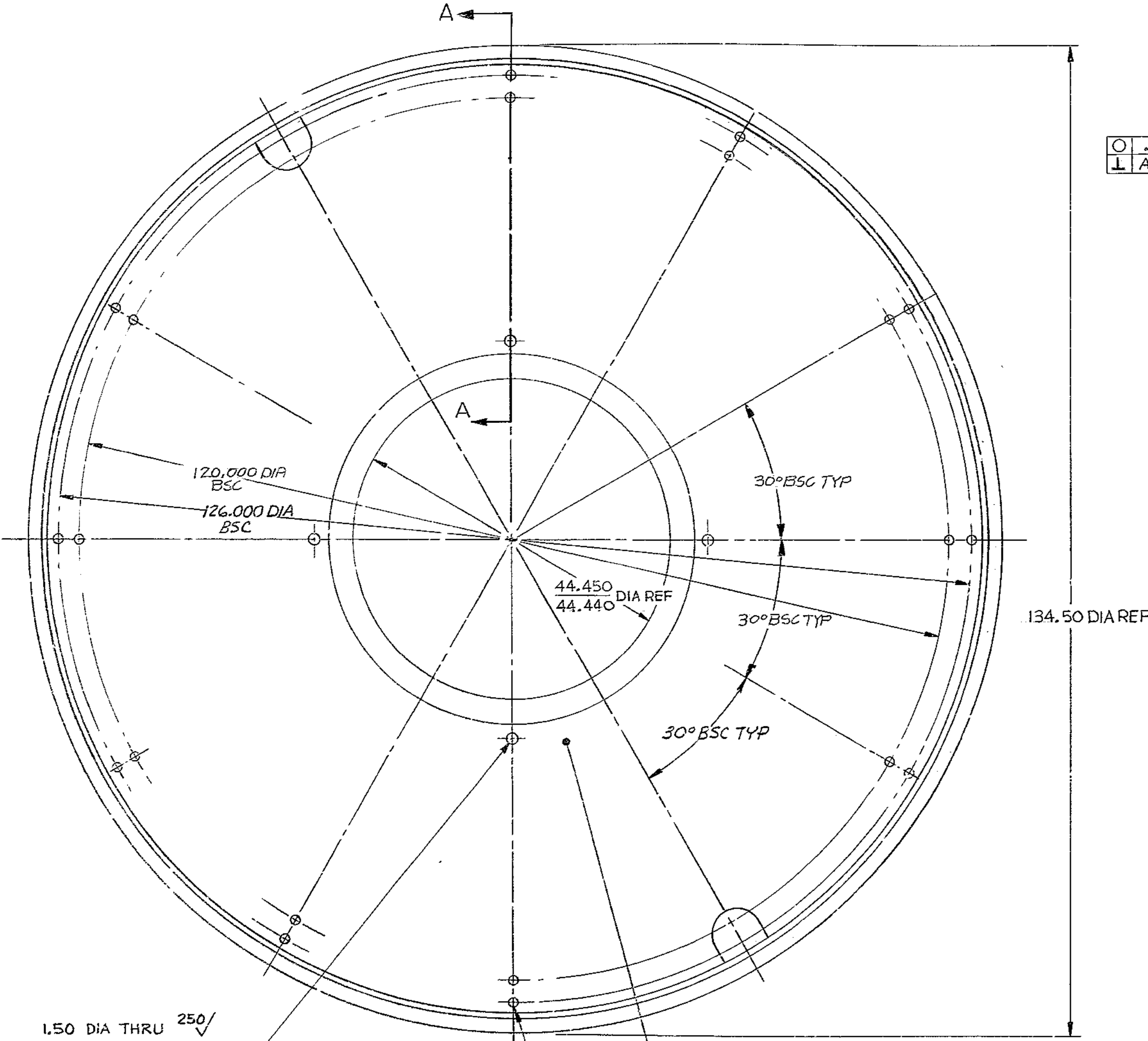


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REVISIONS			
ZONE	LTR	DESCRIPTION	DATE APPROVED
A		DELETED MIRROR ACCESS HOLES	22-70
B		ADDED 1.50 DIA HOLES	3-70



- NOTES: UNLESS OTHERWISE SPECIFIED:
- ALL DIMENSIONS ARE IN INCHES.
 - INTERPRET DIMENSIONING AND TOLERANCING PER USA STANDARD USAS1-Y14.5-1966.
 - SURFACE ROUGHNESS AS DESIGNATED ALL OVER PER USA STANDARD USAS-B46.1-1962.
 - INTERPRET WELDING SYMBOLS PER AWS STANDARD ASW A2.0-1958.
 - 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.
 - MACHINING:
NO CARBIDE TOOLS ON FINISH MACHINING. USE HIGH SPEED CUTTING TOOLS ONLY.
 - REMOVE PART NO. 2150.310C251. IMPRESSION STAMP NEW PART NO AS SHOWN.
 - APPLY ONE COAT OF PRIME PAINT ON ALL NON-MACHINED SURFACES PER W.G.C. SPECIFICATION NO. 511.

1.50 DIA THRU 250/
4 HOLES EQ SPACED
ON 54.000 DIA BASIC
NO TIMING REQD
B .125 DIA

IMPRESSION STAMP PN
2150.310E253
USING 1/4 CHARACTERS

1.250 DIA THRU 250/
20 HOLES AS SHOWN
B .125 DIA

SECTION A-A
SCALE: 1/1

NEXT ASSY: 2150.310E252 (82402 - 44175R252)

QTY	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
3	2150.310C007	WELDING ROD	AR	PER MIL-R-5632	
2	2150.310J251	FLANGE	I	PER PRINT	16603
1	2150.310C254	WEB	I	PER PRINT	16603
1	2150.310C254	HUB	I	PER PRINT	16603

LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED		WESTERN GEAR CORPORATION	
ANGULAR = ± 1°	LINEAR = ± .010	150IN. STELLAR TELESCOPE MTG	HEAVY MACHINERY DIVISION EVERETT, WASHINGTON
X = ± .1	XXX = ± .010	DRAWN: J. R. Bell	11-20-69
XX = ± .03	FRACTIONAL = ± 1/32	CHECK: J. V. G.	10-20-69
BREAK ALL SHARP EDGES		ENGR: J. V. G.	10-20-69
MATERIAL		METALLURGICAL: ST. 1102	

82402-44175R253	SIZE	CODE IDENT NO.	REV
	E 16603	2150.310E253	B
SCALE 1/8		WT	
REV B		44175R253	