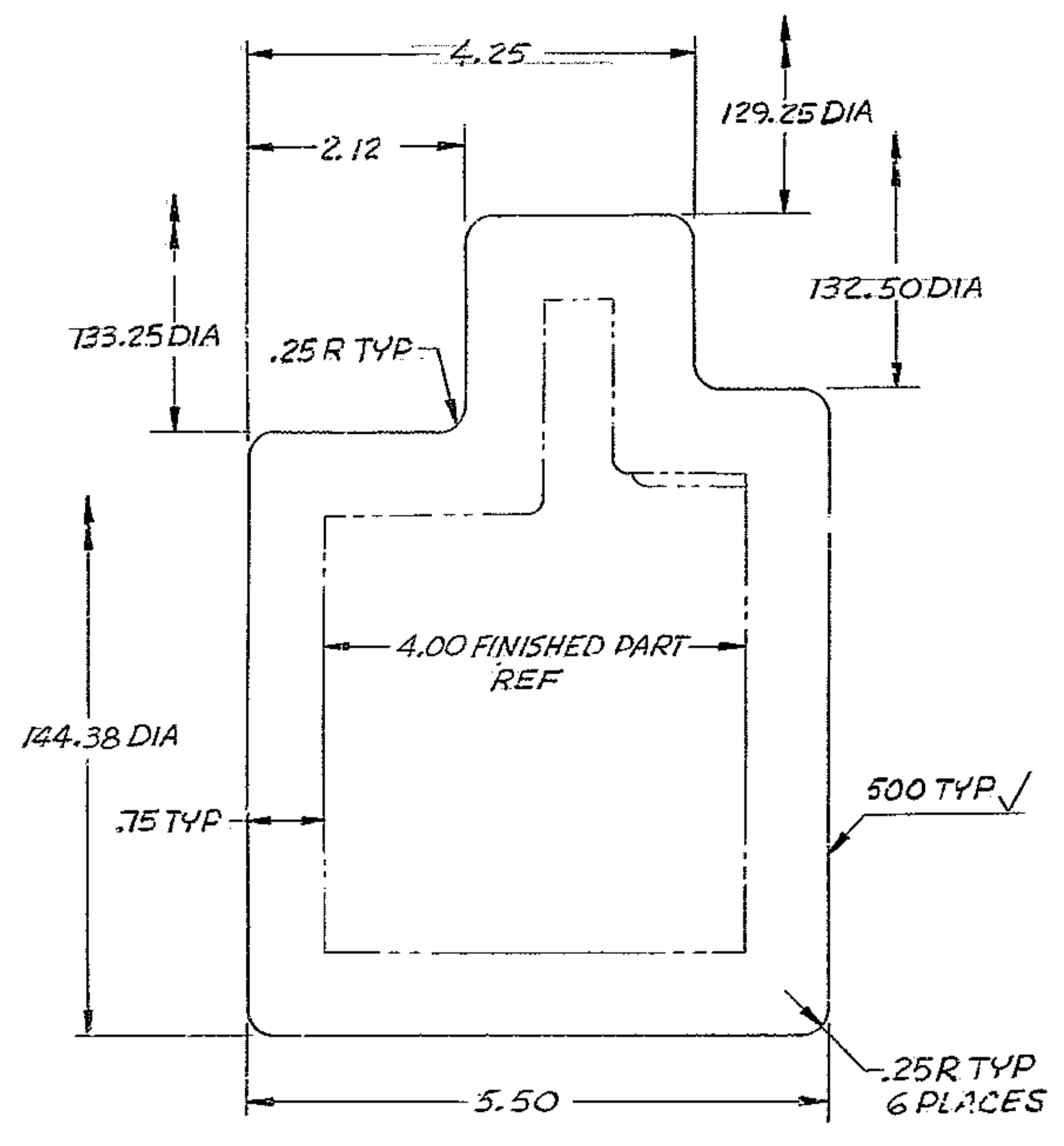
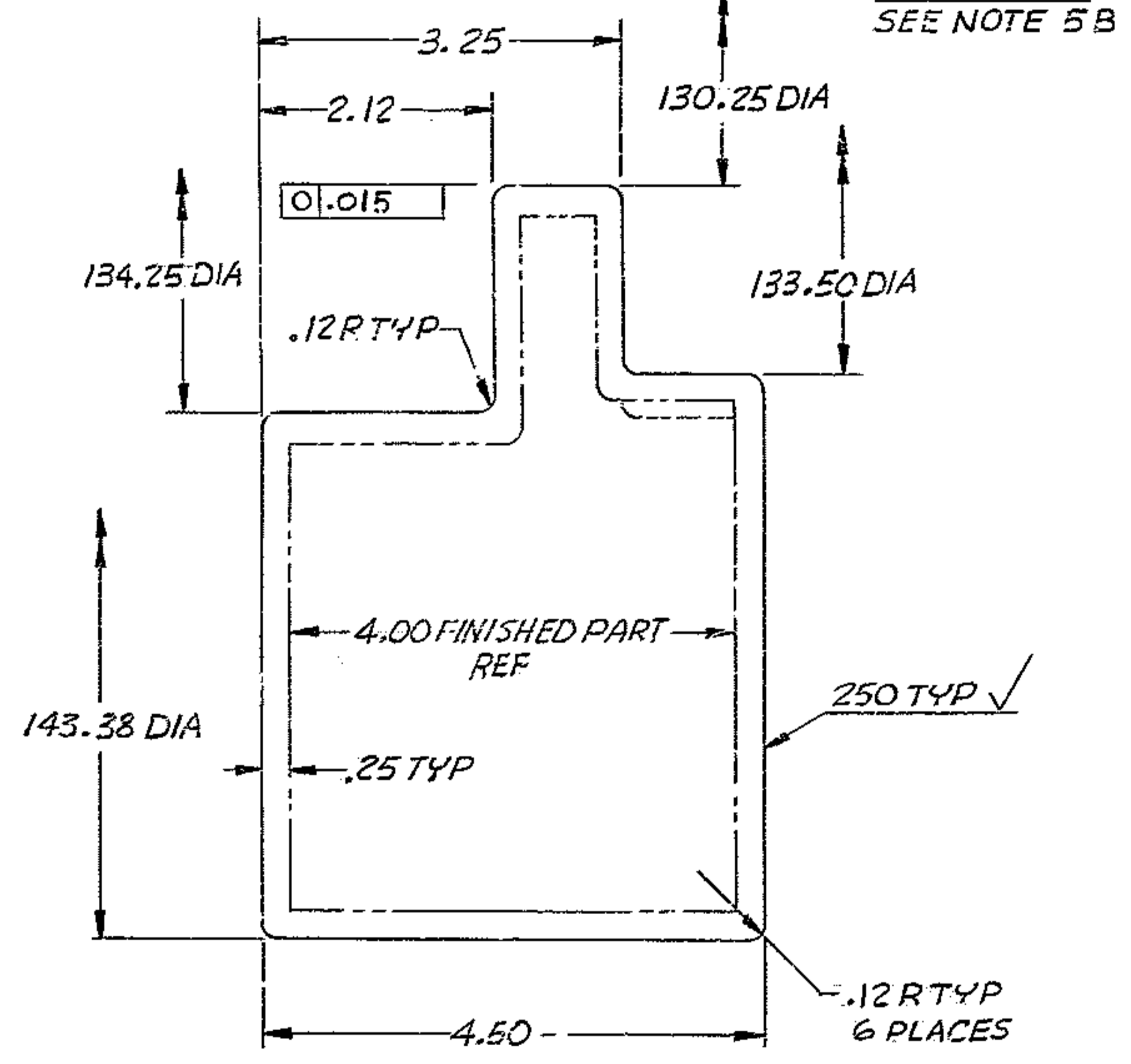


ALL INFORMATION CONTAINED IN OR DISCLOSED BY THIS DOCUMENT IS CONSIDERED CONFIDENTIAL AND PROPRIETARY BY WESTERN GEAR CORPORATION. ALL DESIGN, MANUFACTURING, USE, REPRODUCTION, AND ALL SALES RIGHTS ARE EXPRESSLY RESERVED BY AND TO WESTERN GEAR CORPORATION AND COMMUNICATION OF THIS INFORMATION TO OTHERS IS PROHIBITED WITHOUT THE PRIOR WRITTEN CONSENT OF WESTERN GEAR CORPORATION.

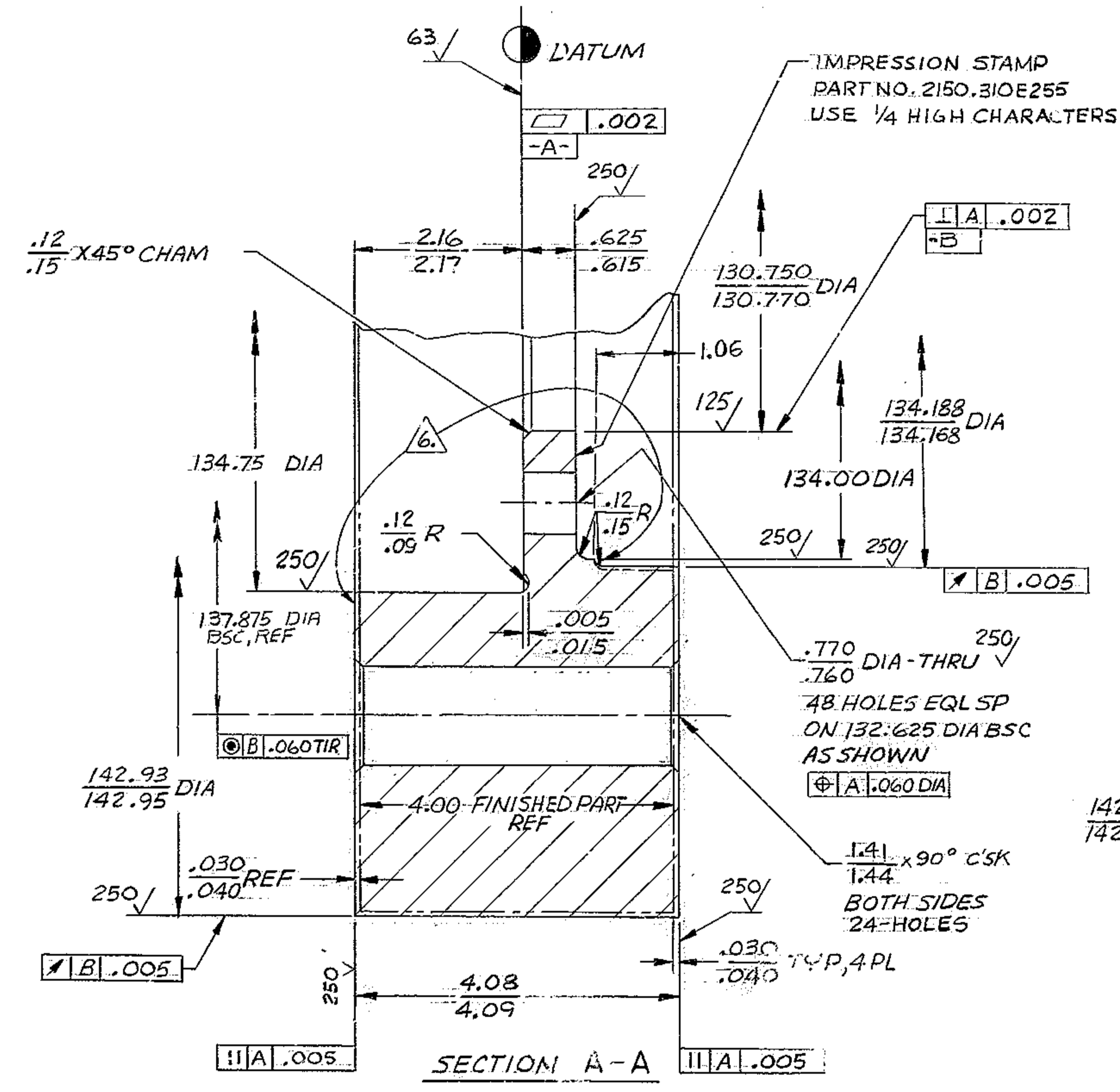
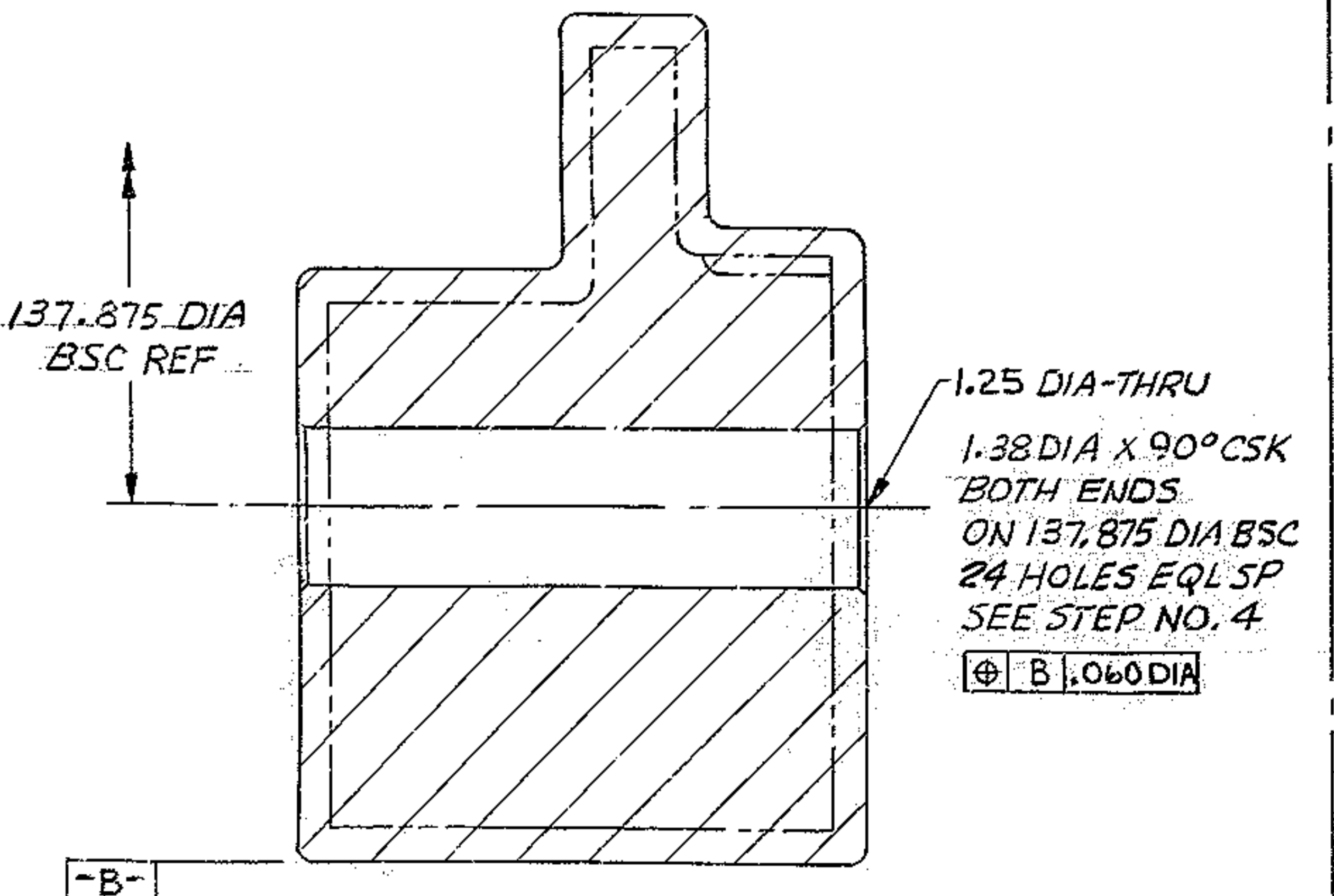
STEP NO. 1
SEE NOTE 5A & 5B



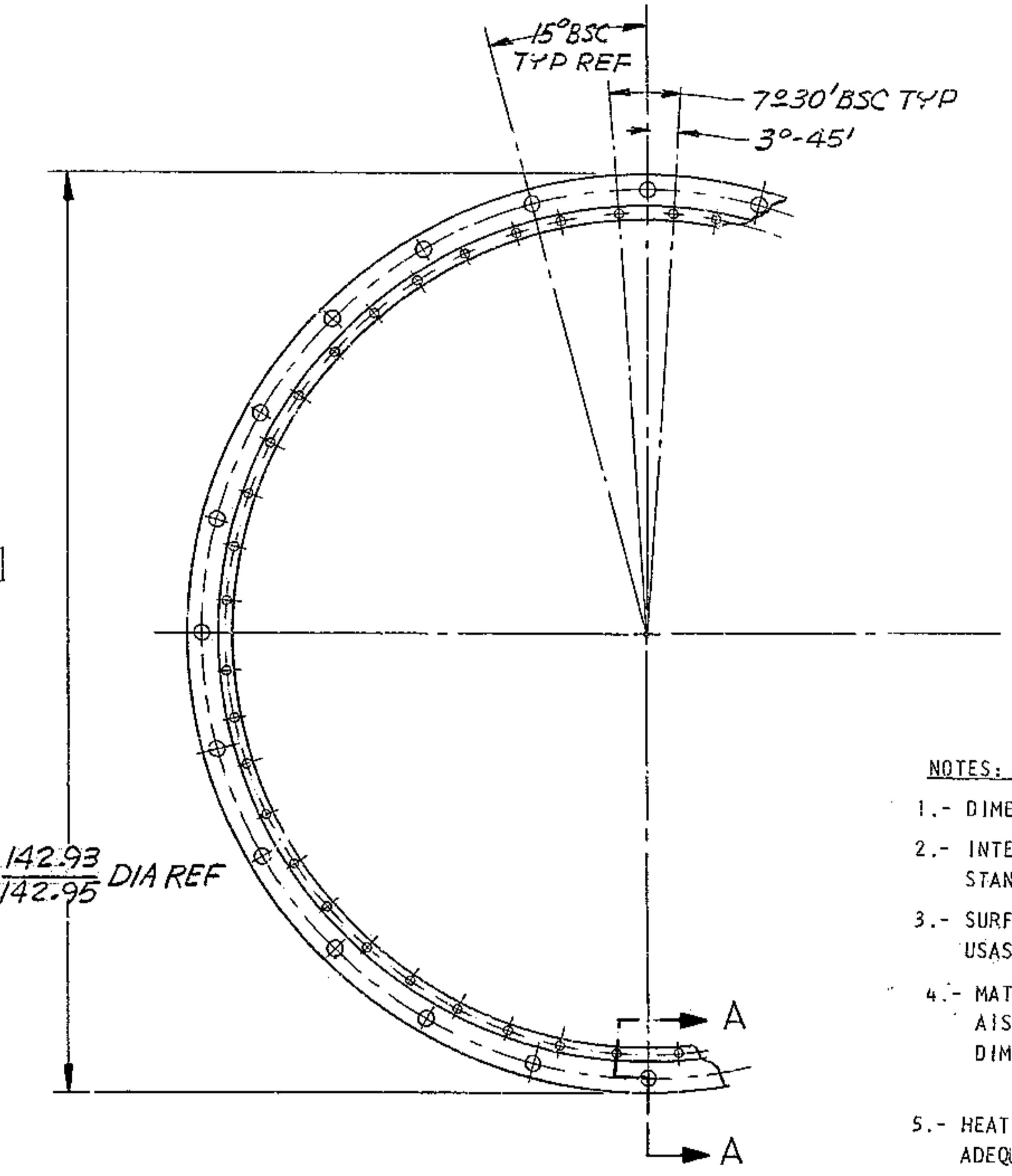
STEP NO. 2
SEE NOTE 5B



STEP NO. 3
SEE NOTE 5C



STEP NO. 4



- NOTES: UNLESS OTHERWISE SPECIFIED:
- DIMENSIONS ARE IN INCHES.
 - INTERPRET DIMENSIONING & TOLERANCING PER USA STANDARD Y14.5-1966.
 - SURFACE ROUGHNESS AS DESIGNATED PER USA STANDARD USAS-B46.1-1962.
 - MATERIAL: A151 4340 FORGED RING, DELIVERED BY FORGE TO DIMENSIONS AS SHOWN IN STEP #2 & HEAT TREATMENT 5A & 5B (SEE HEAT TREAT).
 - HEAT TREAT AS FOLLOWS, SUPPORTING FORGING ADEQUATELY TO AVOID DISTORTION.
 - UNMACHINED FORGING TO BE NORMALIZED AT 1600°F, HOLD FOR 8 (EIGHT) HOURS, AIR COOL, TEMPER AT 1250°F FOR 8 (EIGHT) HOURS, AIR COOL.
 - ROUGH MACHINE AS SHOWN PER STEP NO. 1, HARDEN TO R_c 28/32, SOAK 8 (EIGHT) HOURS AT 1500°F, OIL QUENCH, TEMPER 12 (TWELVE) HOURS AT 1100°F, AIR COOL TO ROOM TEMPERATURE. CHECK HARDNESS AND RETEMPER AT A TEMPERATURE TO GIVE REQUIRED HARDNESS, TIME TO BE 12 (TWELVE) HOURS AT TEMPERATURE.
 - ROUGH MACHINE AS SHOWN PER STEP NO. 2 AT WGC DRILL 1.25 DIA HOLES AS SHOWN IN STEP NO. 3 STRESS RELIEVE 10 (TEN) HOURS AT 50°F BELOW FINAL TEMPERING TEMPERATURE. COOL IN FURNACE AT 50°F PER HOUR TO 400°F BEFORE REMOVING. PREMACHINE AS PER STEP NO. 4.
 - MACHINING: DO NOT USE CARBIDE TOOLS ON FINISH MACHINING. USE HIGH SPEED CUTTING TOOLS ONLY.

NEXT ASSY: 2150.310E252 (82402-44175R252)

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (LM)					
TOLERANCES UNLESS OTHERWISE SPECIFIED: LINEAR .001 IN. ANGULAR ± 0° 30' HOLE .001 IN. HOLE .001 IN. HOLE .001 IN.					
150 IN. STELLAR TELESCOPE MOUNTING					
DRAWN: [Signature] 10-3-69					
CHECK: [Signature] 10-20-69					
ENGR: [Signature] 10-20-69					
DO NOT SCALE DRAWING					
MATERIAL: SEE NOTE 4					
HEAT TREAT: SEE NOTE 5					
APPROVED: [Signature]					
SIZE: E					
CODE IDENT NO: 2150.310E255					
SCALE: 1/1					
REV: A					

1183

RIM, BULL GEAR
R.F. & DECL.

44175R255