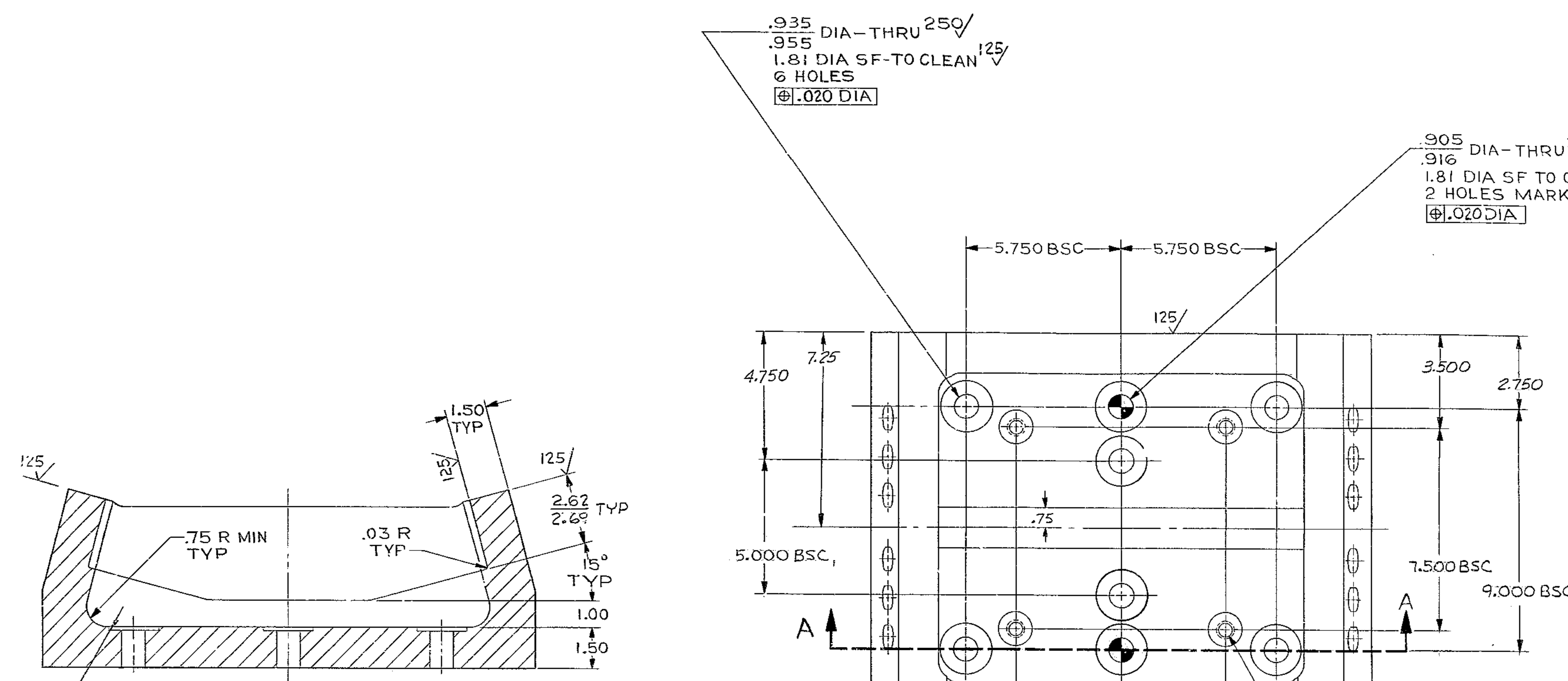
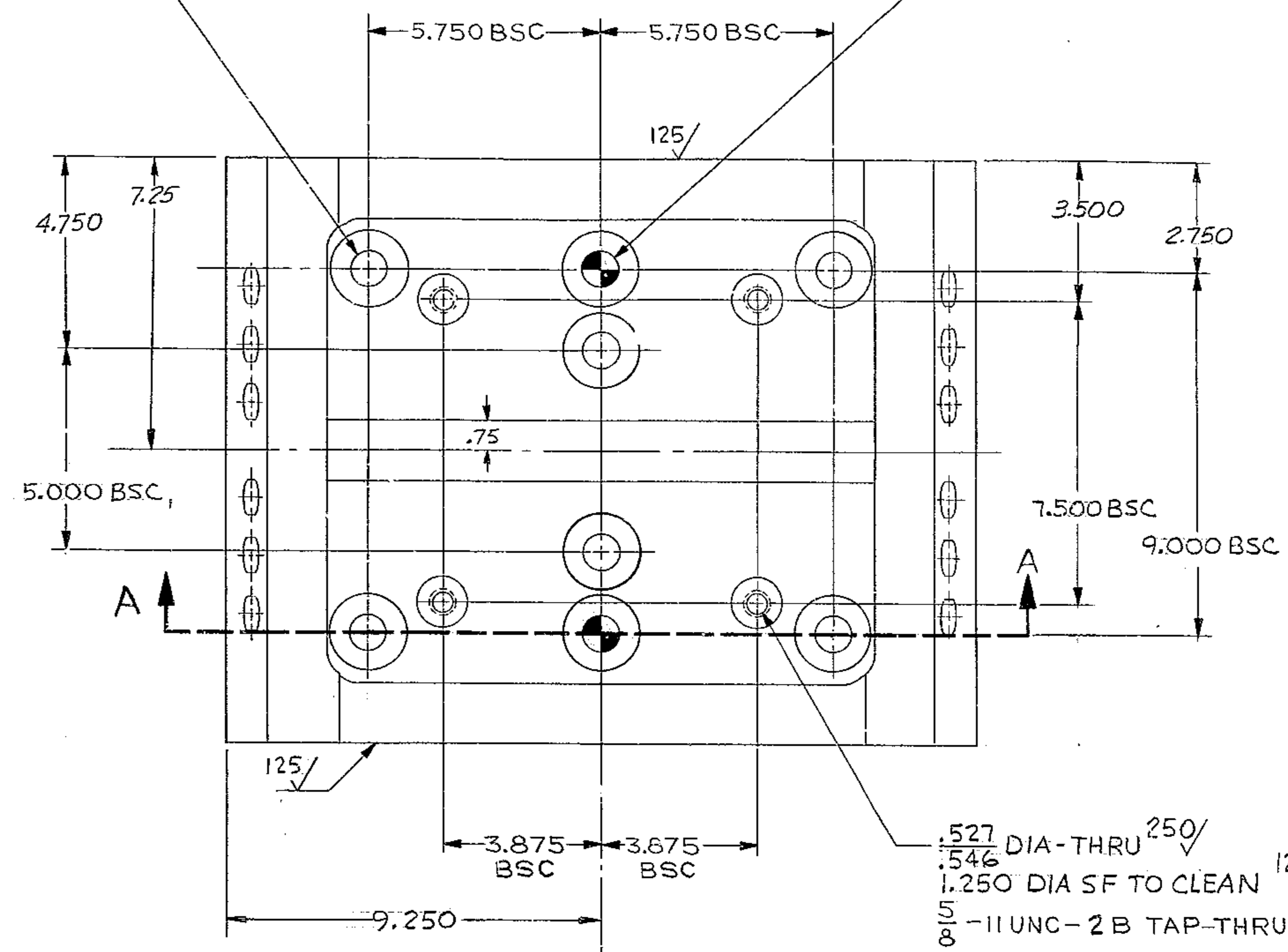


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ZONE		LTR		DESCRIPTION	DATE	APPROVED
A-0	A	ADDED	KPND	AS SHOWN	7-18-65	LOS



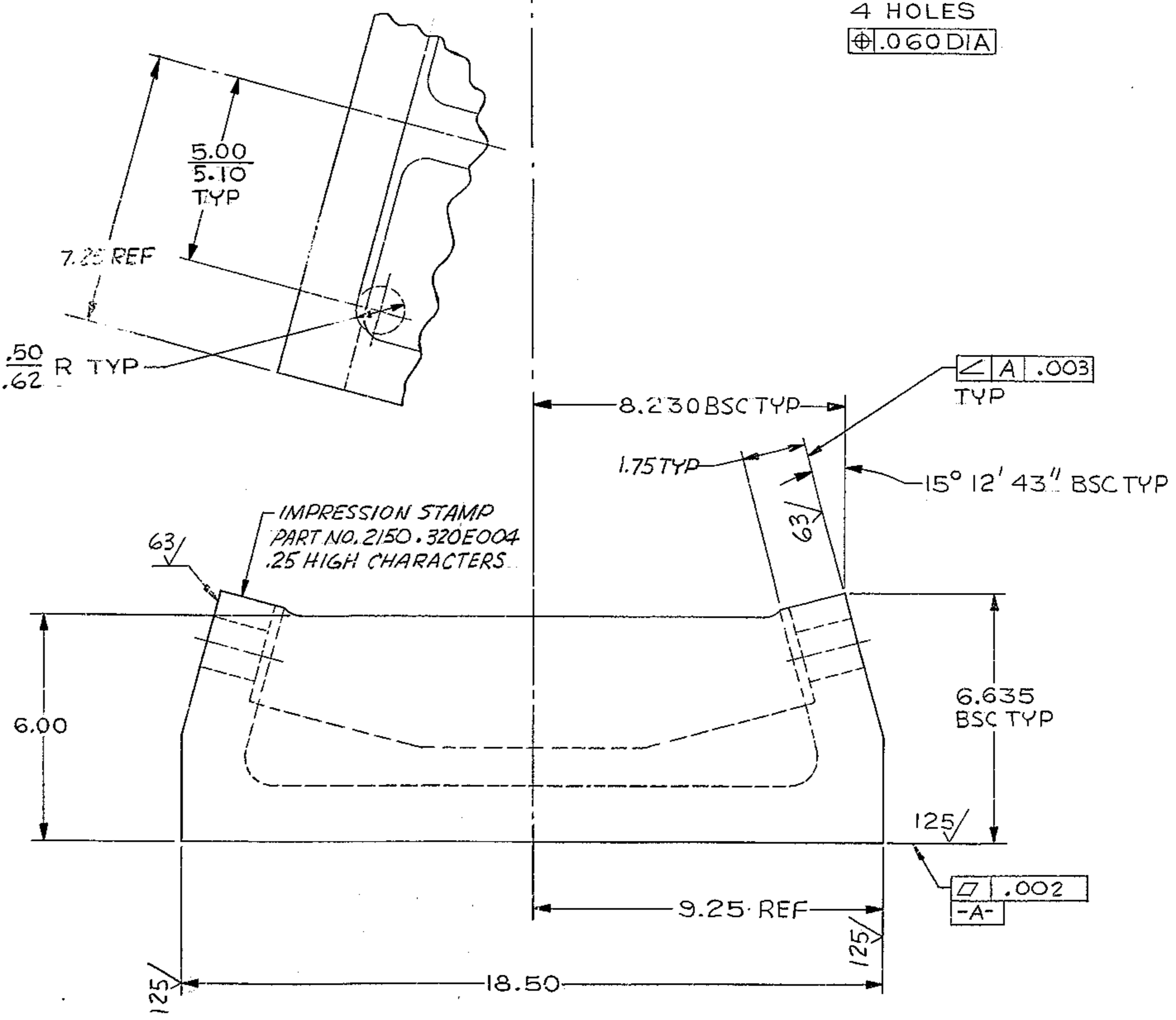
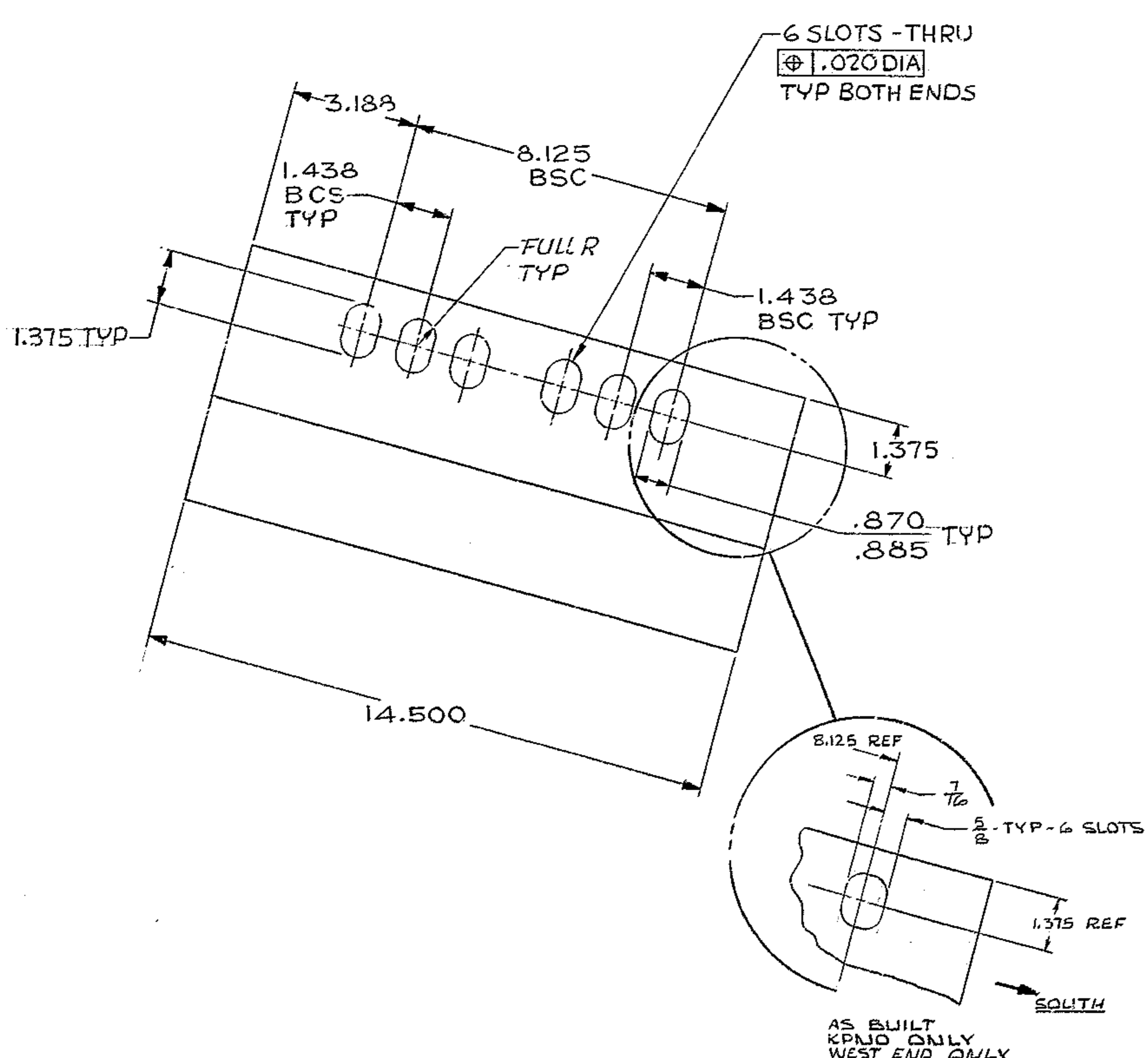
SECTION A-A



.905 DIA-THRU 250/
.916
1.81 DIA SF TO CLEAN 125/
2 HOLES MARKED
Φ.020 DIA

.527 DIA-THRU 250/
.546
1.250 DIA SF TO CLEAN 125/
5
8-11 UNC-2 B TAP-THRU
4 HOLES
Φ.060 DIA

- NOTES: UNLESS OTHERWISE SPECIFIED:
- ALL DIMENSIONS ARE IN INCHES.
 - INTERPRET DIMENSIONING AND TOLERANCING PER USA STANDARD USAS1-Y14.5-1966.
 - MATERIAL: CAST STEEL, ASTM A148-65; GR 80/50 WITH MAXIMUM CARBON CONTENT OF .4130 ANALYSIS PREFERRED. MECHANICAL PROPERTIES TO BE ATTAINED BY NORMALIZING AT 1600°F. SUBSEQUENT STRESS RELIEVING AT 1250°F.
 - CASTING TO BE FREE FROM ALL INJURIOUS DEFECTS AS PER SPEC. A148-65.
 - ALL CAST WALL AND RIB THICKNESS TO BE 1.50 INCH.
 - ALL CAST FILLET RADIUS TO BE .62; EDGE RADIUS .12 INCHES.
 - PROVIDE .38 STOCK MATERIAL ON ALL MACHINED SURFACES.
 - SURFACE ROUGHNESS AS DESIGNATED PER USA-STANDARD USAS-B46.1-1962
 - HEAT TREAT: A. STRESS RELIEVE AT 1250°F. HOLD FOR 3 HOURS AT TEMPERATURE. CAREFULLY SUPPORT IN FURNACE TO AVOID DISTORTION.
B. FURNACE COOL AT A RATE OF 50°F PER HOUR UNTIL FURNACE TEMPERATURE HAS REACHED 400°F. THEN CASTING MAY BE AIR COOLED.
C. ROUGH MACHINE LEAVING 1/16 STOCK MIN FOR FINISHING ON ALL MACHINED SURFACES AND REPEAT STEPS A AND B.
 - MACHINING: NO CARBIDE TOOLS ON FINISH MACHINING. USE HIGH SPEED STEEL CUTTING TOOLS ONLY.
 - FURNISH CERTIFICATES OF PHYSICAL AND CHEMICAL PROPERTIES OF CASTING.
 - HAND GRIND ALL EXTERIOR NON-MACHINED SURFACES, FILLETS, AND CORNER RADII TO PRODUCE A SMOOTH APPEARANCE. PUTTY ALL UNEVEN NON-MACHINED SURFACES USING GRAY SPOT PUTTY TRAIL CHEM. CO., EL MONTE, CALIFORNIA, TO PRODUCE FLAT SURFACE.
 - APPLY ONE COAT OF PRIME PAINT ALL OVER EXCEPT MACHINED SURFACES PER W.G.C. SPEC. NO. 511.
 - ULTRASONIC AND MAGNETIC INSPECTION OF CASTING REQUIRED.



NEXT ASSY: 2150.320E002 (82402-44175R202)

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (L/M)					
LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED					
ANGULAR = ± 1°					
LINEAR: X = ± .1 XXX = ± .010					
XX = ± .03 FRACTIONAL = ± 1/32					
BREAK ALL SHARP EDGES					
MATERIAL: METALLURGICAL					
SEE NOTE 3.					
APPROVED: [Signature]					

150 IN. STELLAR TELESCOPE MOUNTING
WESTERN GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

BRACKET, INTERMEDIATE R.A. MOUNTING

82402-44175R204
SCALE 1/2 WT

SIZE CODE IDENT NO. E 16603 2150.320E004
REV A

44175 R 204