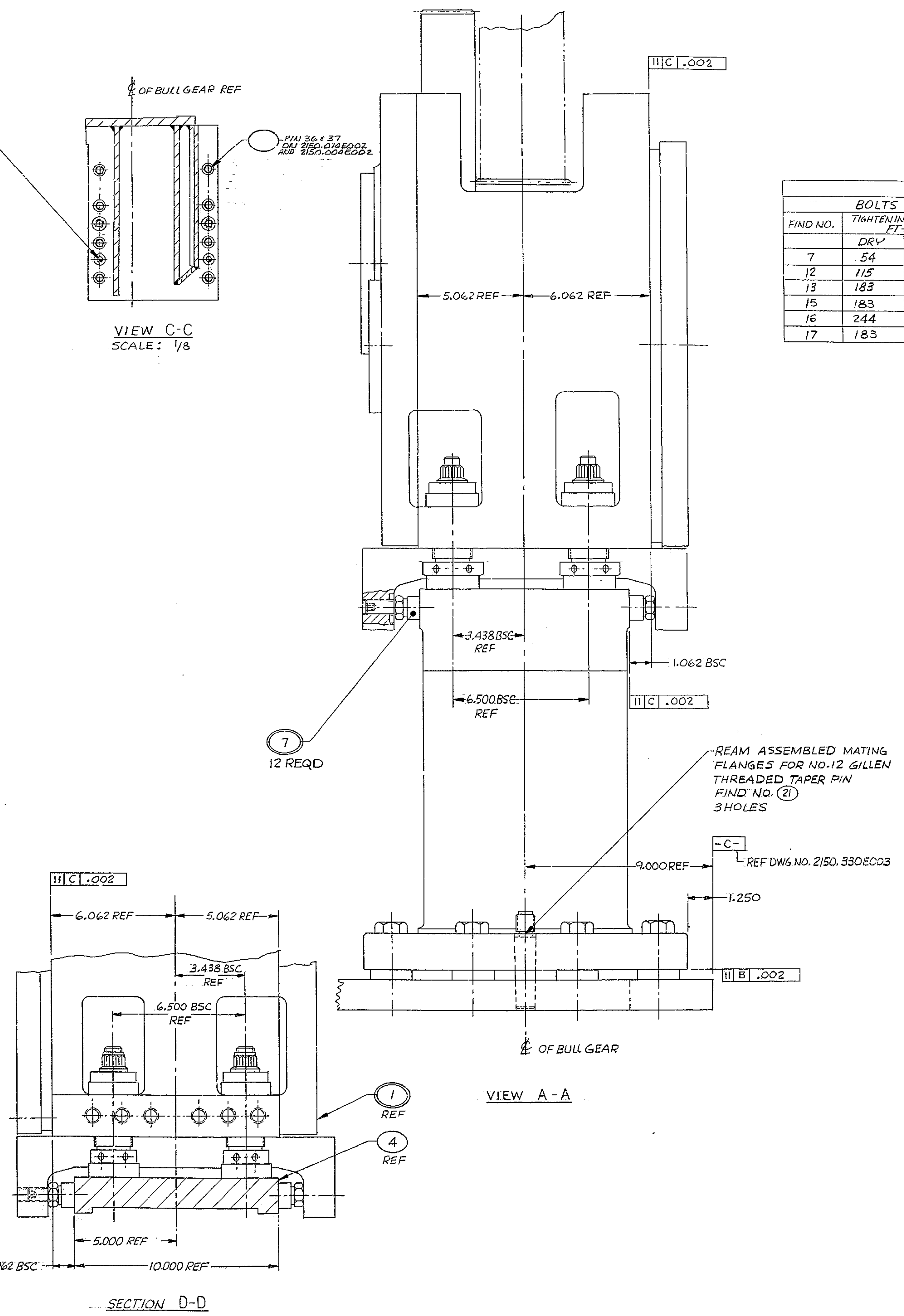
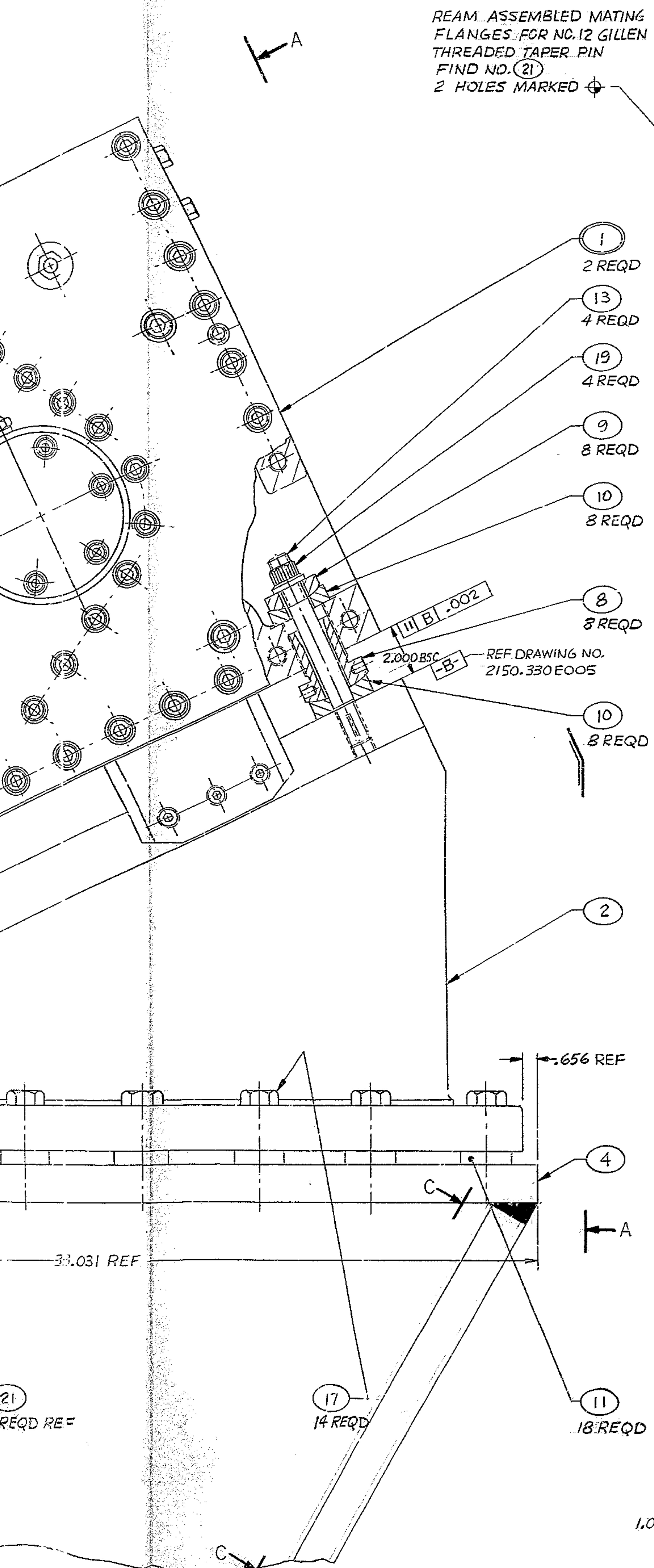


ZONE	TR	REVISIONS	DATE	APPROVED
A	1	NOTES 2D & 2K-DELETE (1) TORQUE TABLE DEL (2)	5/1/70	2/21
A-3	2	ADDED FIND (1) 4 READ (WAS PART) FIND (2) WAS FIND (2)		
B-5	3	ADDED FIND NO. 14	11/1/70	2/21
C	4	ADDED "PIN 36 & 37 ON 2150..." AND "PIN 35, 47 & 37 ON 2150..."	1/18/73	125

TORQUE TABLE					
BOLTS			NUTS		
FIND NO.	TIGHTENING TORQUE FT-LB		FIND NO.	TIGHTENING TORQUE FT-LB	
	DRY	OILED		DRY	OILED
7	54	38	19	244	167
12	115	78			
13	183	125			
15	183	125			
16	244	167			
17	183	125			

- NOTES:
- THE DECLINATION ASSY WILL BE DELIVERED TO THE CUSTOMER COMPLETELY ASSEMBLED, ALIGNED & ADJUSTED AS SHOWN ON THIS DRAWING.
 - IN PLANT ASSEMBLY PROCEDURE:
 - LOCATE BRACKET, FIND (4) HORIZONTALLY WITH FACE (5) & SECURE.
 - PREPARE GEARBOX, FIND (1), FOR MOUNTING BY BACKING OFF ALL ADJUSTING SCREWS, FIND (7) TO PROVIDE MOUNTING CLEARANCE. MOUNT ADJUSTING SCREWS, FIND (8) TO PROTRUDE 1-5/6" FROM BOTTOM OF FIND (1).
 - PREPARE FOUR (4) MOUNTING BLOCKS 2" DIA X 1.980" HIGH & SET L.H. GEARBOX ON TOP OF THESE BLOCKS IN APPROXIMATE POSITION ON FIND (4).
 - INTRODUCE CLAMPING HARDWARE, FIND (10), (9) & (13) & (19). ADJUST FIND (8) TO BEAR. ADJUST FIND (13) & (19) TO LOOSE BEFORE TIGHT.
 - REMOVE MOUNTING BLOCKS & ADJUST FIND (1) TO MEET PROPER LOCATION, PARALLELISM & SQUARENESS AS SPECIFIED ON DWG. FOR PARALLEL ADJUST SIDEWISE USE ONE PAIR OF OPPOSING ADJUST SCREWS, FIND (7) AT EACH END OF GEARBOX.
 - TIGHTEN FIND (13), (19) & TWO (2) PAIRS OF FIND (7).
 - RECHECK, READJUST AS NECESSARY TO MEET SPECIFIED CONDITIONS.
 - ADJUST REMAINING SCREWS, FIND (7) IN PAIRS (OPPOSITE ENDS) BY ADJUSTING ONE SIDE TO LIGHT CONTACT. TIGHTEN OPPOSITE SCREW TO LIGHT CONTACT. ADJUST EACH SCREW NOT TO EXCEED 1/4 TURN ON OPPOSITE SIDES UNTIL TIGHT.
 - FOLLOW SAME PROCEDURE UNTIL ALL SCREWS FIND (7) ARE PROPERLY TIGHTENED.
 - RECHECK & READJUST IF NECESSARY.
 - MOUNT INTERBRACKET, FIND (2) & (5) SHIM ON GEAR SIDE. CHECK FOR 80% MIN. CONTACT ON RELATED FACES. SCRAPE TRUE AS NECESSARY. MOUNT & TIGHTEN FIND (12), (15) & (16) & (19) ALTERNATELY TO SECURE PROPER BEARING ON ALL CONTACTING SURFACES. OMIT TAPER PIN FIND (21) AT THIS TIME.
 - Mount angle bracket FIND (2) WITH SPACERS FIND (11) CHECK FOR PROPER CONTACT. GRIND SPACERS TO SUIT IF NECESSARY. INTRODUCE FIND (17), (18) & (19) ADJUST FOR SIDE PARALLELISM AS SPECIFIED. TIGHTEN FIND (17) & (19). RECHECK, READJUST AS NECESSARY. REAM FOR & FIT TAPER PINS FIND (21).
 - MOUNT R.H. GEARBOX ON ANGLE BRACKET FIND (2), USING MOUNTING BLOCKS 2.000" HIGH. ADJUSTING PROCEDURE IS SIMILAR AS DESCRIBED BY NOTES 2B THRU 2K.
 - FINALLY CHECK PARALLELISM OF INPUT GEARS WHICH MUST BE WITHIN .001" IN 12 INCHES. IF PARALLELISM DOES NOT CONFORM, ONE OR BOTH GEARBOXES FIND (1) MAY BE OUT OF ADJUSTMENT AND HAVE TO BE RESET BY ANY OR ALL OF THE FOLLOWING:
 - GRIND SHIM FIND (5) TO SUIT.
 - READJUST FIND (8) TO SUIT.
 - READJUST FIND (7) TO SUIT.
 - REAM & FIT TAPER PIN, FIND (22).



2150.330E002	REV D	SH 1
44175R302		

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (LM)					
LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED					
ANGULAR = ± 1°					
LINEAR:					
X = ± .1	XXX = ± .010	2-30-69			
XX = ± .03	FRACTIONAL = ± 1/32	CHECK 1/29	1-13-70		
BREAK ALL SHARP EDGES					
ENGR 1/29					
MATERIAL					
SEE DETACHED					
PL 2150.330E002					
(44175R302)					
APPROVED: <i>John H. Elmer</i>					
SIZE CODE IDENT NO.					
E 16603 2150.330E002					
SCALE 1/2 WT LB SHEET 1 OF 1					