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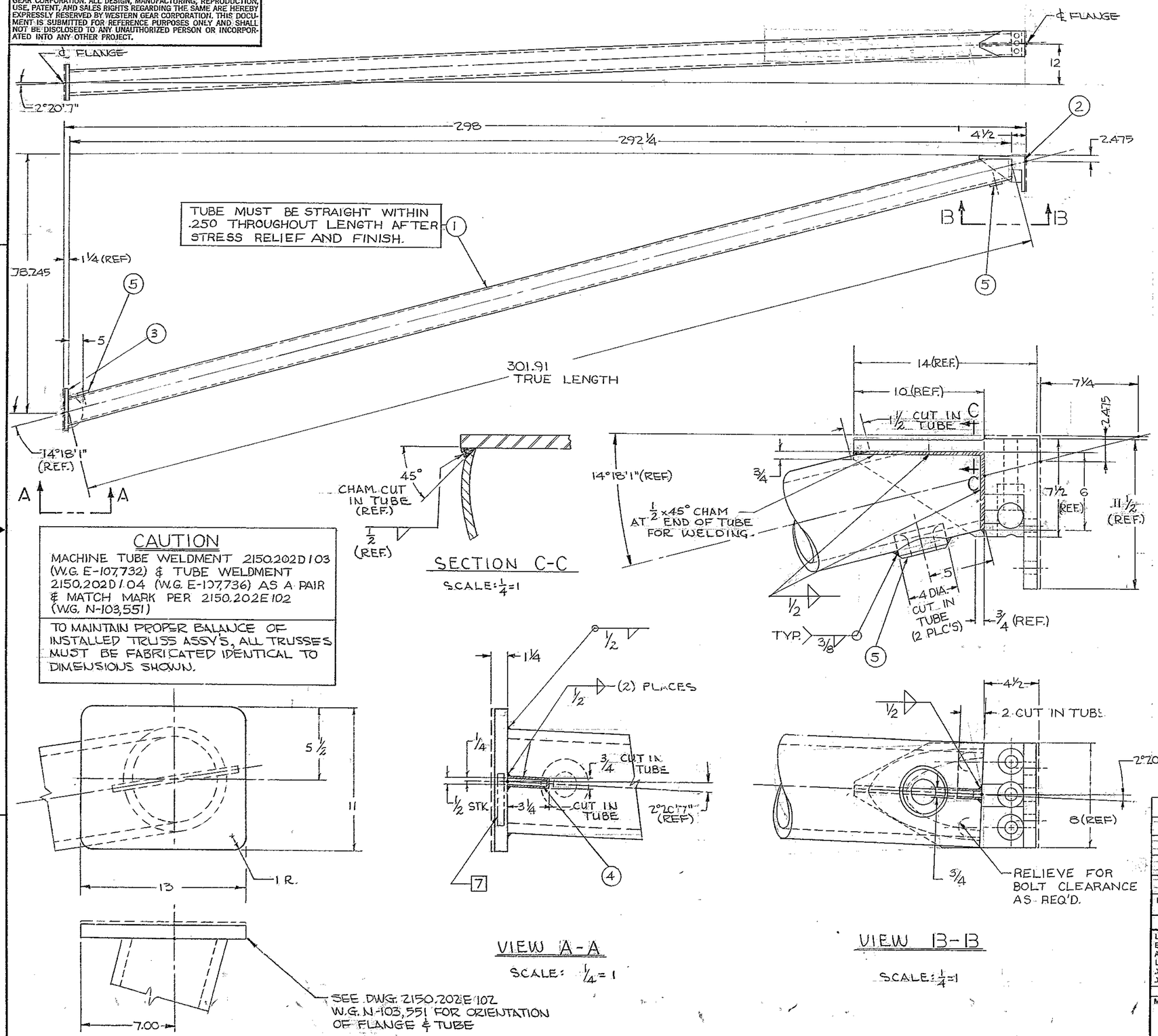
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	REVISED PER AURA REV. DATED 4-3-69	5-14-69	
	B	REVISED PER AURA REV. A DATED 7-1-69	7-23-69	
	C	ADDED WGC NO.S TO P/N'S 2 & 5	13 AUG 69	
	D	10 PSI WAS 100 PSI	15 JUNE 71	



CAUTION

MACHINE TUBE WELDMENT 2150.202D103 (W.G. E-107,732) & TUBE WELDMENT 2150.202D104 (W.G. E-107,736) AS A PAIR & MATCH MARK PER 2150.202E102 (W.G. N-103,551)

TO MAINTAIN PROPER BALANCE OF INSTALLED TRUSS ASSY'S, ALL TRUSSES MUST BE FABRICATED IDENTICAL TO DIMENSIONS SHOWN.

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. FABRICATION TOLERANCES EXCEPT AS NOTED.
   UP TO 10 INCHES ±1/16
   10 TO 50 INCHES ±1/8
   50 INCHES AND OVER ±1/4
3. WELD PER W.G.C. SPEC 752, APPENDIX T.I.
4. LOCAL STRESS RELIEVE ALL WELDED JOINTS BEFORE MACHINING PER W.G.C. SPECIFICATION 510.
5. APPLY ONE (1) COAT OF PRIMER PAINT ALL OVER PER W.G.C. SPEC. 511 IMMEDIATELY AFTER STRESS RELIEVING & CLEANING.

[6] START DIMENSIONS.

[7] STAMP PART Nº 2150.202D103 APPROX. WHERE SHOWN.

[8] PRESSURE CHECK WITH AIR AT 10 PSI FOR NO LEAKAGE, USING SOAPY WATER AT ALL SEAMS AND JOINTS.

NEXT ASSY: 2150.202E102 (W.G. N-103551)

2150.202.D103

1164

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
5	2150.202C110 WGD108,743	PLUG 2" NPT			
4		PL 5 x 1/2 x 10	1	STL, ASTM-A-36.	
3		PL 11 x 1 1/4 x 13	1	STL, ASTM A-36	
2	2150.202D105 WGE 107843	CASTING	1	STL, ASTM A-27-65 GR. 65-35	
1	LEFT HAND	TUBING 8 O.D. x 3/4 WALL x 306.25	1	STL, AISI M.T. 1015 (SEAMLESS)	

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
SEE MAT'L LIST

150 IN. STELLAR TELESCOPE MOUNTING

DRAWN WESTOM 2/20/69
CHECK
ENGR Ellingham 7/10/69

W.G.E-107732
APPROVED

western GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

TRUSS - LEFT HAND
TUBE WELDMENT

SIZE	CODE IDENT NO.		REV
D	16603	2150.202D103	D

SCALE 1/16 WT LB SHEET 1 OF 1