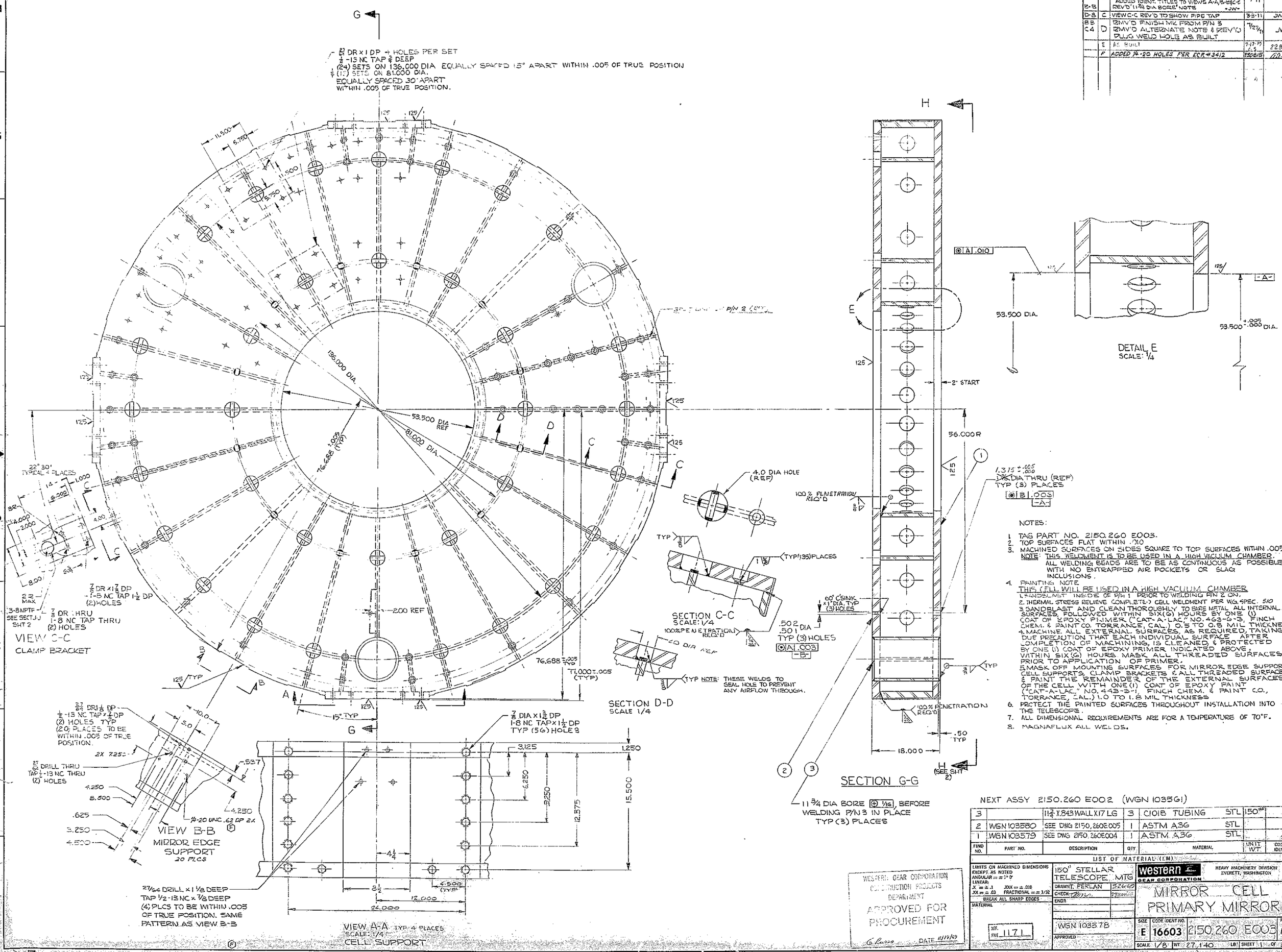
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
-	A	REVISED PER AORA APP'D PRINT.	10-7-67	
E-6 B-6 C-8 E-8	B	76.688±.005 DIA WAS 77.000 ADDED 8 1/2 WIDE RECESS IN CELL SUPP. 3"R2 WAS 4.00 R ADDED IDENT. TITLES TO VIEWS A-A, B-B & C-C REV'D 1 3/4 DIA BORE NOTE -JW-	2/1/71	
D-8	C	VIEW C-C REV'D TO SHOW PIPE TAP	3-8-11	JW
B-8 C-4	D	RMV'D FINISH MK FROM P/N 3 RMV'D ALTERNATE NOTE & REV'D PLUG WELD HOLE AS BUILT	7/27/11	JW
	E	AS BUILT	7-17-75	2283
	F	ADDED 1/4-20 HOLES PER ECR #3412	150815	[illegible]



NOTES:

1. TAG PART NO. 2150.260 E003.
2. TOP SURFACES FLAT WITHIN .010
3. MACHINED SURFACES ON SIDES SQUARE TO TOP SURFACES WITHIN .005.
   NOTE: THIS WELDMENT IS TO BE USED IN A HIGH VACUUM CHAMBER. ALL WELDING BEADS ARE TO BE AS CONTINUOUS AS POSSIBLE WITH NO ENTRAPPED AIR POCKETS OR SLAG INCLUSIONS.
4. PAINTING NOTE
   THIS CELL WILL BE USED IN A HIGH VACUUM CHAMBER
   1. SANDBLAST INSIDE OF P/N 1 PRIOR TO WELDING P/N 2 ON.
   2. THERMAL STRESS RELIEVE COMPLETED CELL WELDMENT PER W.G. SPEC. 510
   3. SANDBLAST AND CLEAN THOROUGHLY TO BARE METAL ALL INTERNAL SURFACES, FOLLOWED WITHIN SIX(6) HOURS BY ONE (1) COAT OF EPOXY PRIMER ("CAT-A-LAC" NO. 463-G-3, FINCH CHEM. & PAINT CO. TORRANCE, CAL.) 0.5 TO 0.8 MIL THICKNESS
   4. MACHINE ALL EXTERNAL SURFACES, AS REQUIRED, TAKING DUE PRECAUTION THAT EACH INDIVIDUAL SURFACE AFTER COMPLETION OF MACHINING, IS CLEANED, & PROTECTED BY ONE (1) COAT OF EPOXY PRIMER INDICATED ABOVE, WITHIN SIX (6) HOURS. MASK ALL THREADED SURFACES PRIOR TO APPLICATION OF PRIMER.
   5. MASK OFF MOUNTING SURFACES FOR MIRROR EDGE SUPPORTS, CELL SUPPORTS, CLAMP BRACKETS & ALL THREADED SURFACES & PAINT THE REMAINDER OF THE EXTERNAL SURFACES OF THE CELL WITH ONE (1) COAT OF EPOXY PAINT ("CAT-A-LAC," NO. 443-B-1, FINCH CHEM. & PAINT CO., TORRANCE, CAL.) 1.0 TO 1.8 MIL THICKNESS
   6. PROTECT THE PAINTED SURFACES THROUGHOUT INSTALLATION INTO THE TELESCOPE.
   7. ALL DIMENSIONAL REQUIREMENTS ARE FOR A TEMPERATURE OF 70°F.
   8. MAGNAFLUX ALL WELDS.

NEXT ASSY 2150.260 E002 (WGN 103561)

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	UNIT WT.	CODE IDENT
3		11 3/4 X .843 WALL X 17 LG	3	C1018 TUBING	STL	150"
2	WGN 103580	SEE DWG 2150.260E005	1	ASTM A36	STL	
1	WGN 103579	SEE DWG 2150.260E004	1	ASTM A36	STL	

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

REF FILE 1171

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS DEPARTMENT
APPROVED FOR PROCUREMENT
G. Russo DATE 11/19/69

150" STELLAR TELESCOPE MTG

DRAWN T. FERLAN 5-26-69
CHECK
ENGR
WGN 103578
APPROVED

western GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

MIRROR CELL PRIMARY MIRROR

SIZE	CODE IDENT NO.		REV
E	16603	2150.260 E003	F

SCALE 1/8 WT 27,140 LB SHEET 1 OF 2