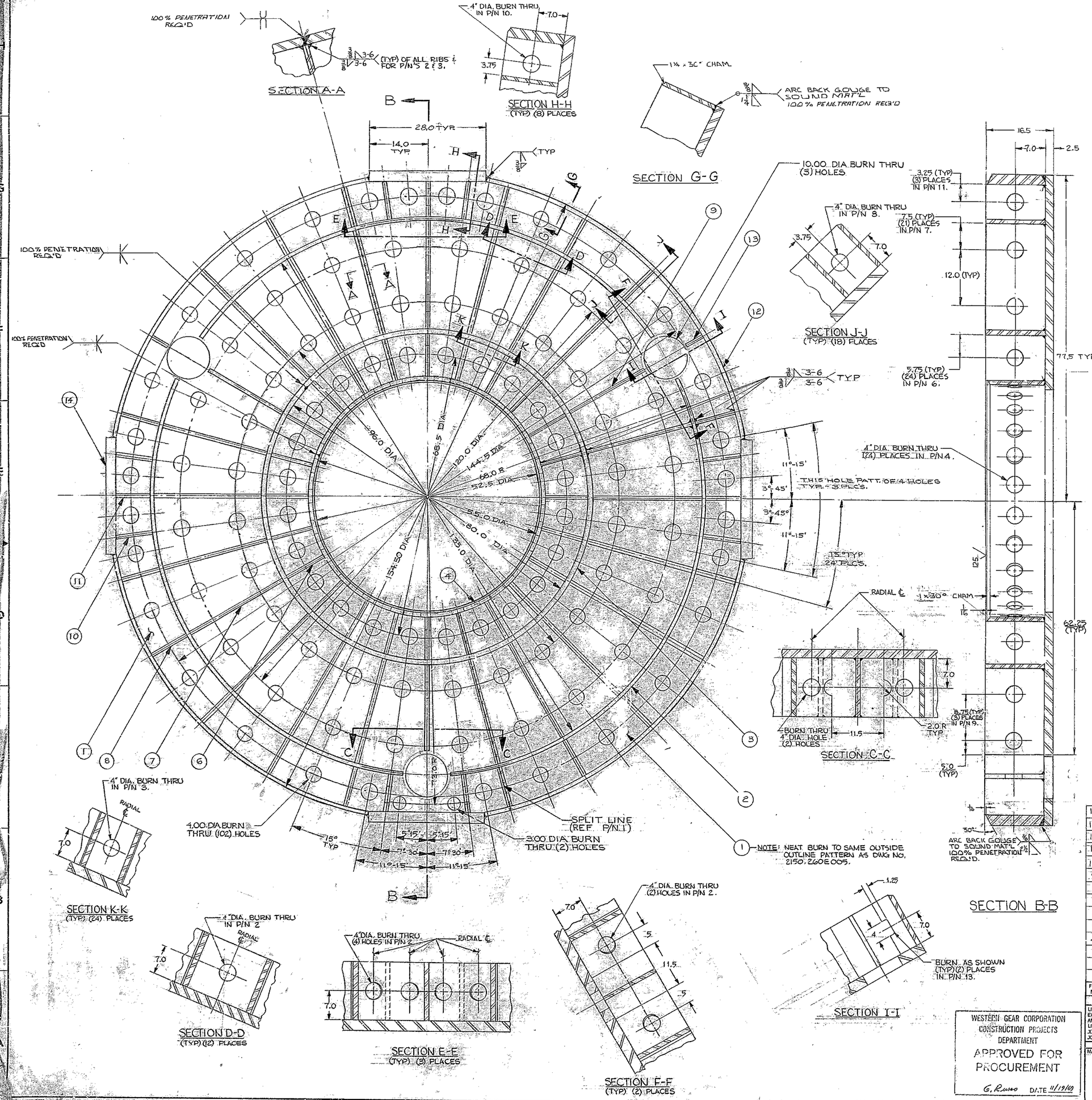
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPRO'D
–	A	REVISED FOR AURA APP'D PRINT	10-7-69	
	B	REVISED TO SHOW CHAM. ON SEC'S H-H, I-I, & J-J	24 AUG '70	
C	AS BUILT		7-17-79	



1. ALL DIMENSIONS ARE IN INCHES.
2. FAB TOLERANCES EXCEPT AS NOTED
   UP TO 10" ±1/16
   UP TO 50" ±1/8
   50" & OVER ±1/4
3. NOTE: THIS WELDMENT IS TO USED IN A HIGH VACUUM CHAMBER. ALL WELDING BEADS ARE TO BE AS CONTINUOUS AS POSSIBLE WITH NO ENTRAPPED AIR POCKETS OR SLAG INCLUSIONS. NOTE INTERMITTENT WELDING ON RIBS & RINGS WHERE EVER WELDING ON BOTH SIDES OF THE MEMBERS IS DONE.
4. SANDBLAST COMPLETELY & THOROUGHLY CLEAN ALL SLAG & WELD SPATTER TO BARE METAL FROM ALL INTERIOR SURFACES OF THIS PART BEFORE INSTALLING TOP COVER. SEE 2150.260E003 FOR ALL STRESS RELIEF, CLEANING & SPECIAL PAINTING INSTRUCTIONS.
5. TAG PART NO. 2150.260E004.
6. MAGNAFLUX ALL WELDS

NEXT ASSY 2150.260 E003 (WGN 103578)

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	WT/UNIT	CODE IDENT
14		PL 14⅜ x 2½ x 28"	4	STL ASTM A36	286	
13		PL 14⅜ x 1" x 2¾"	2	STL ASTM A36	11	
12		PL 14⅜ x 93¼	4	STL ASTM A36	477	
11		PL 14⅜ x 1" x 6½"	3	STL ASTM A36	26	
10		PL 14⅜ x 1" x 6¾"	8	STL ASTM A36	28	
9		PL 14⅜ x 1" x 21"	3	STL ASTM A36	86	
8		PL 14⅜ x 1" x 7¾"	18	STL ASTM A36	32	
7		PL 14⅜ x 1" x 26½"	21	STL ASTM A36	108	
6		PL 14⅜ x 1" x 11½"	24	STL ASTM A36	47	
5						
4		PL 14⅜ x 1 x 176"	1	STL ASTM A36	719	
3		PL 14⅜ x 1" x 255"	1	STL ASTM A36	1042	
2		PL 14⅜ x 1" x 133"	3	STL ASTM A36	542	
1		PL 78½ x 2½ x 156	2	STL ASTM A36	6044	

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 L/M

150" STELLAR TELESCOPE MTG
DRAWN S TOUTENBURGH 5-20-68
CHECK 12-14-68
ENGR

WGN 103579
APPROVED

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

Western GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

MIRROR CELL WELDMENT
REF. FILE 1171

SIZE E | CODE IDENT NO. 16603 | 2150.260E004 | REV C
SCALE 1/8 | WT 23,081 LB | SHEET 1 OF 1