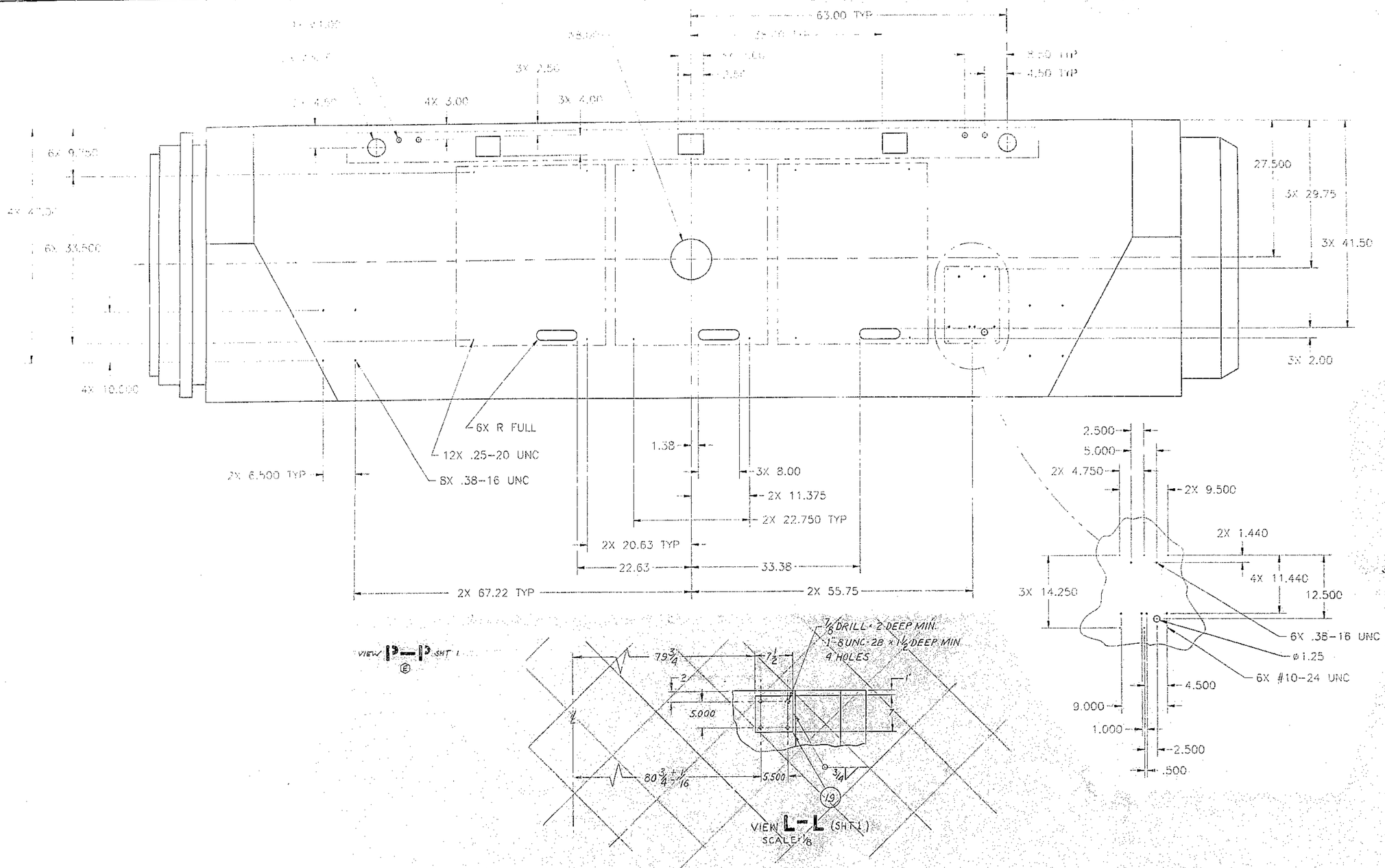
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	A	SEE SHT 1		
	B	SEE SHEET # 2		
	C	SEE SHEETS 1 AND 2		
	D	REMOVED VIEW L-L & PC NO. 18		
	E	ADDED VIEW P-P FOR ECR 3412	150211	

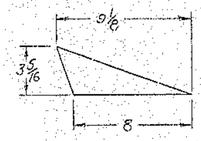


VIEW P-P SHT 1

VIEW L-L (SHT 1)
SCALE 1/8

MATERIAL LIST				
PC NO.	QTY	DESCRIPTION	MATL & SPEC	APPX WT
1	2	52½ O.D. × 23 × 37¾ I.D.	STL. FORGING	8600
2	2	R 55½ × 2½ × 76½ LG	ASTM A-36	3000
3	2	R 55½ × 1½ × 81 LG		3200
4	4	R 76 × 1¾ × 143		4677
5	2	R 54 × 1¼ × 145		2065
6	2	R 55½ × 1 × 185		2500
7	1	R 55 × 1 × 50		780
8	2	R 55 × 1 × 179		2750
9	50	R 5½ × 1 × 8		4
10	4	R 32½ × 1 × 25¾		360
11	3	R 16¾ × 1 × 25½		72
12	2	R 47½ × 1 × 52¾		710
13	1	R 47½ × 1 × 54½		700
14	15	R 7½ × 1 × 12½		13
15	2	R 12½ × 1 × 17½		47
16	2	R 12½ × 1 × 15½		41
17	14	R 5½ × 1 × 12½		9
18	1	R 53 O.D. × 2½ × 43 I.D.		250
19				
20	4	R 6½ × ¼ × 5½		5.1
21	4	R 5 × ¼ × 32		6.5
22	4	R 5 × ¼ × 5	ASTM A-36	1.7
23	8	½ I.D. TUBE × 96 APPROX	ELECT. CONDUIT TUBE	
24	1	½ I.D. TUBE × 120 APPROX		
25	16	1 I.D. TUBE × 72 APPROX		
26	4	1 I.D. TUBE × 144 APPROX		
27	2	1 I.D. TUBE × 60 APPROX		
28	2	1 I.D. TUBE × 24 APPROX	ELECT. CONDUIT TUBE	

CUT TO SUIT



DETAIL PC. NO. 9

NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. FABRICATION TOLERANCES, EXCEPT AS NOTED
   0 TO 10 INCHES ±1/16
   10 TO 50 INCHES ±1/8
   50 INCHES & OVER ±1/4
3. WELD PER A.W.S. SPEC. D1.0-66 [7]
4. STRESS RELIEVE AFTER WELDING & BEFORE MACHINING PER W.G.C. SPEC. NO. 510.
5. APPLY ONE COAT OF PRIME PAINT ALL OVER IMMEDIATELY AFTER STRESS RELIEVE PER W.G.C. SPEC. NO. 511.
6. THESE ARE ROUGH MACHINE, FORGING DIMENSIONS.
7. DOUBLE FILLET WELD, INSIDE & OUTSIDE FILLET, OF ALL JOINTS WHERE POSSIBLE EXCEPT PIECES NO. 7 (WHICH ARE INSTALLED LAST). SEE SECT A-A (SHT 1)
8. ALL SURFACES MARKED THUS ✓ TO BE 125 ✓ EXCEPT AS NOTED
9. RADII MARKED 'R' TO BE .032 RADIUS
10. THESE HOLES TO BE DIAMETRICALLY OPPOSITE EACH OTHER (SEE SHT 2 SECTION G-G)

FIG. 1175

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT

LIST OF MATERIAL (LM)

WESTERN GEAR CORPORATION
CONSTRUCTION PROJECTS DEPARTMENT
APPROVED FOR PROCUREMENT
DATE 12/MAR/68

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

REQ'D STEEL
FINISH COATS

DRAWN
CHECK
ENGR
W.G. N102-853
APPROVED

western GEAR CORPORATION
HEAVY MACHINERY DIVISION
EVERETT, WASHINGTON

CENTER SECTION
CENTER SECTION & LWR GIRDER

SIZE	CODE IDENT NO.		REV
E	16603	2150.281E103	

SCALE — WT 54,289 LB SHEET 3 OF 4