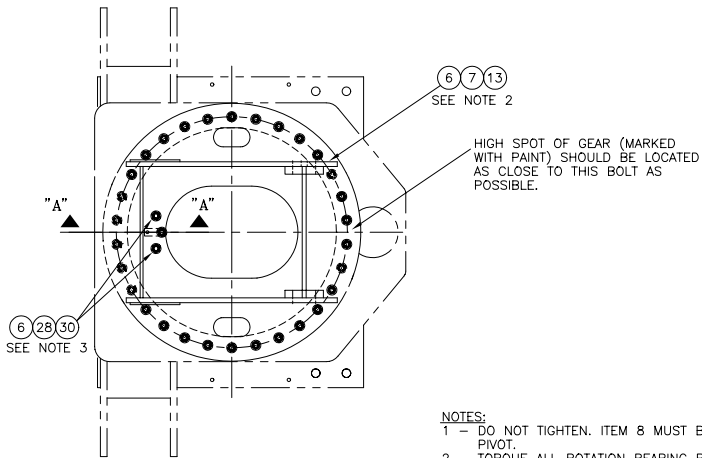
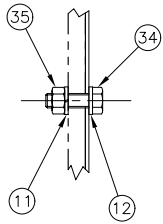


NOTES:

- 1 - POSITION THE ROTATION BEARING INNER RING LOCATING THE GREASE ZERKS DIRECTLY ABOVE THE PEDESTAL HOLES PROVIDED AND THE LOADING PLUG TOWARD THE CAB (180° FROM THE PINION).
- 2 - INSTALL THE GEAR REDUCER WITH ECCENTRIC RING, DO NOT TIGHTEN HARDWARE. POSITION THE ECCENTRIC RING AT THE MIDDLE OF IT'S ADJUSTMENT.
- 3 - PUSH THE ROTATION BEARING TOWARD THE GEAR REDUCER SO THERE IS NO BACKLASH BETWEEN THE ROTATION BEARING GEAR AND THE GEAR REDUCER PINION.
- 4 - REMOVE GEAR REDUCER.
- 5 - TORQUE THE ROTATION BEARING NUTS TO 100 FT-LBS THEN RETORQUE TO 170 FT LBS.
- 6 - REINSTALL THE GEAR REDUCER. DO NOT TIGHTEN THE MOUNTING BOLTS.
- 7 - ROTATE THE OUTER RING SO THE HIGH SPOT OF OF THE ROTATION BEARING GEAR (MARKED WITH PAINT) IS IN MESH WITH THE GEAR REDUCER PINION.
- 8 - ROTATE THE ECCENTRIC RING UNTIL THERE IS NO BACKLASH BETWEEN THE ROTATION BEARING GEAR AND THE GEAR REDUCER PINION.
- 9 - TORQUE THE GEAR REDUCER MOUNTING BOLTS TO 200 FT-LBS.

SPECIFICATIONS		DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED				
1. TORQUE ALL ITEMS DESIGNATED WITHIN A PER USTC TORQUE SPECS SPECIFIED ON THE B.D.M.		DIMENSIONS	0 TO 24"	24" TO 72"	72" TO 300"	> 300"
2. ALL STRUCTURAL WELDING TO CONFORM TO APPLICABLE STRUCTURAL WELDING CODES.		FRACTIONAL	+/- 1/16"	+/- 1/16"	+/- 1/8"	+/- 1/4"
3. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES.		DECIMAL	+/- .010"	+/- .020"	+/- .125"	+/- .25"
		ANGLES	+/- 2 DEGREES			
		SURFACE FINISH SPECIFIED WITH $\sqrt{\text{R}}$ = 125 MICRO INCHES R _a MAX.				

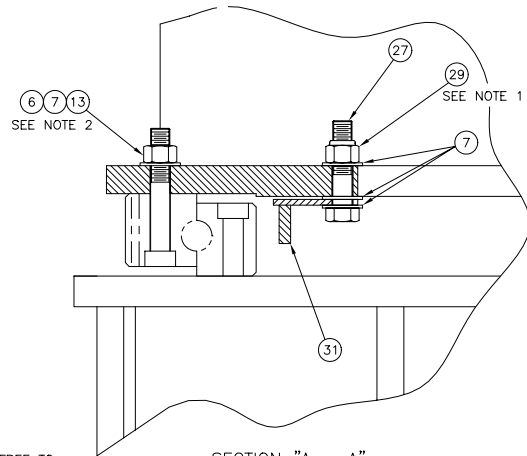
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USTC Incorporated		A Raytheon Company	
76 BOWMAN ROAD - YRKY, PA. 17404-9804		DATE: 6-26-00	
DRAWN BY: J.WOOD	ASSIC. DRAWING	PROJECT:	ER NO. 302461
SCALE:	WEIGHT:	THIRD ANGLE PROJECTION	REV. A SHEET 1 OF 5
MATERIAL:		APPROVED:	DATE: 6/26/00
TITLE: PEDESTAL ASSEMBLY			0257730



6 7 13
SEE NOTE 2

HIGH SPOT OF GEAR (MARKED WITH PAINT) SHOULD BE LOCATED AS CLOSE TO THIS BOLT AS POSSIBLE.

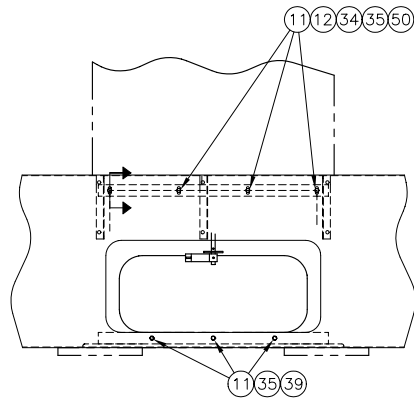
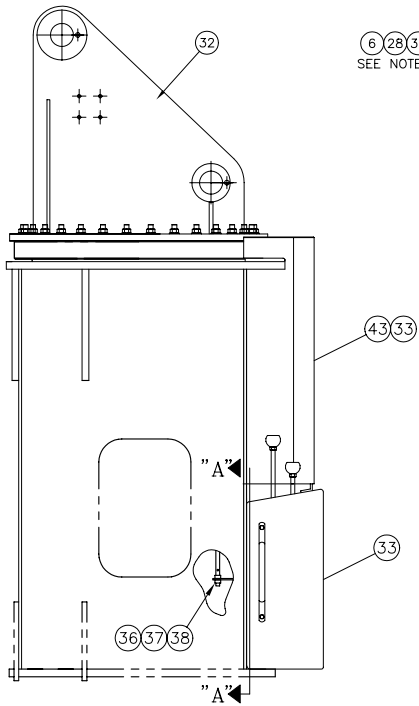
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SEE NOTE 3



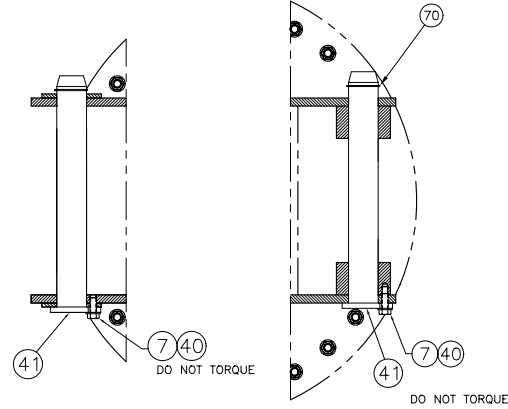
SECTION "A - A"
(SCALE: 1/2"=1")

NOTES:

- 1 - DO NOT TIGHTEN. ITEM 8 MUST BE FREE TO PIVOT.
- 2 - TORQUE ALL ROTATION BEARING BOLTS, LUBRICATED TO 100 FT-LBS. RETORQUE ALL ROTATION BEARING BOLTS TO 170 FT-LBS.
- 3 - HEX. NUT AND LOCKWASHER MUST BE ON TOP.



SECTION "A - A"



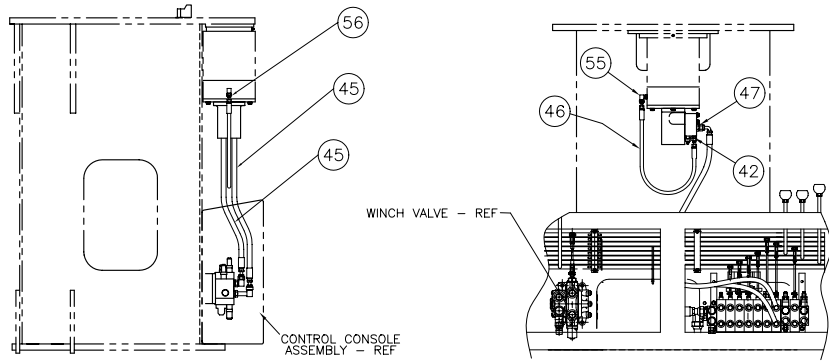
DO NOT TORQUE

DO NOT TORQUE

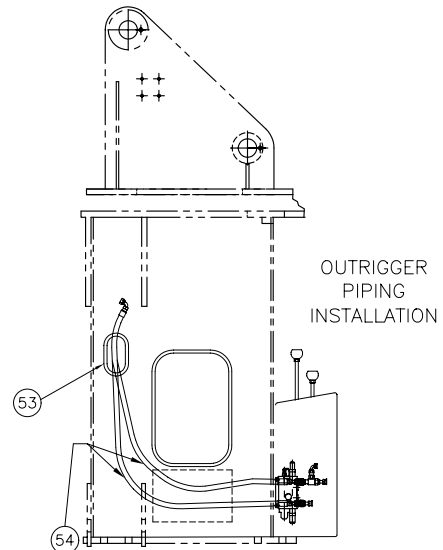
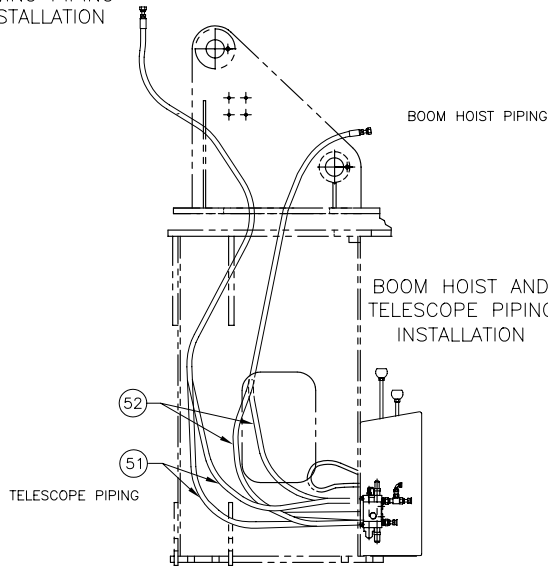
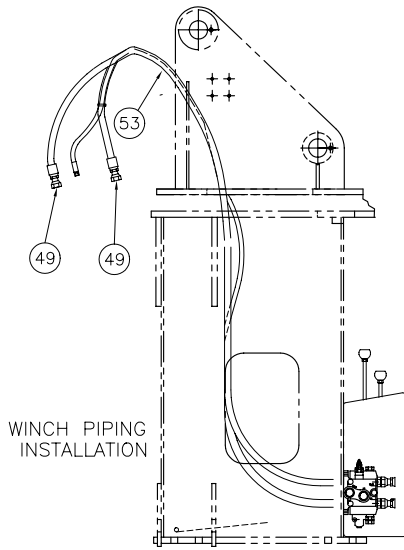
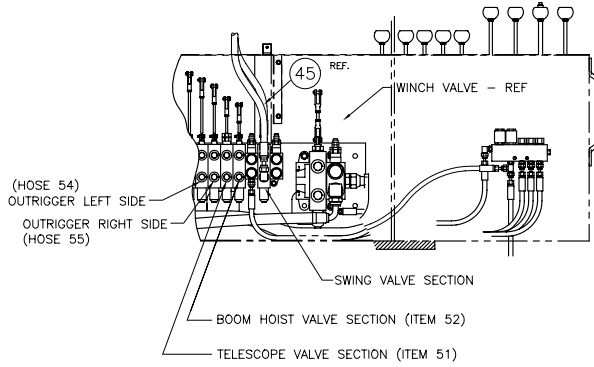
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76 BOWMAN ROAD - YRBY, PA. 17404-9804
A **Raytheon** Company

SPECIFICATIONS		DIMENSIONAL TOLERANCES BOOMLEP HINERS SPECIFICATION				76 BOWMAN ROAD - YRBY, PA. 17404-9804			
1. TORQUE ALL ITEMS DESIGNATED WITHIN A PER USTC TORQUE SPECS SPECIFIED ON THE B.D.M.		DIMENSIONS	0 TO 24"	24" TO 72"	72" TO 300"	> 300"	DRAWN BY: J.WOOD	DATE: 6-26-00	ASSIC. DRAWING
2. ALL STRUCTURAL WELDING TO CONFORM TO APPLICABLE STRUCTURAL WELDING CODES.		FRACTIONAL	+/- 1/16"	+/- 1/16"	+/- 1/8"	+/- 1/4"	SCALE:	WEIGHT:	PROJECT:
3. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES.		DECIMAL	+/- .010"	+/- .020"	+/- .125"	+/- .25"	MATERIAL:		THIRD ANGLE PROJECTION
		ANGLES	+/- 2 DEGREES						APPLIES U. S. S.
		SURFACE FINISH SPECIFIED WITH $\sqrt{\text{R}}$ = 125 MICRO INCHES R _a MAX.					TITLE: PEDESTAL ASSEMBLY		REV. A SHEET 3 OF 5
									ER NO. 302481 REV. A SHEET 3 OF 5 DATE: 6-26-00



SWING PIPING INSTALLATION



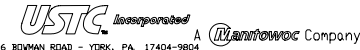
SPECIFICATIONS

- TORQUE ALL ITEMS DESIGNATED WITHIN A PER USTC TORQUE SPECS SPECIFIED ON THE B.D.M.
- ALL STRUCTURAL WELDING TO CONFORM TO APPLICABLE STRUCTURAL WELDING CODES.
- UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES.

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE SPECIFIED

DIMENSIONS	0 TO 24"	24" TO 72"	72" TO 300"	> 300"
FRACTIONAL	+/- 1/16"	+/- 1/16"	+/- 1/8"	+/- 1/4"
DECIMAL	+/- .010"	+/- .020"	+/- .125"	+/- .25"
ANGLES	+/- 2 DEGREES			
SURFACE FINISH SPECIFIED WITH $\sqrt{\text{R}}$ = 125 MICRO INCHES R _a MAX.				

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76 BOYMAN ROAD - YRKY, PA. 17404-9804
 DRAWN BY: J.WOOD DATE: 6-26-00 ASSOC. DRAWING

SCALE: WEIGHT: PROJECT: MATERIAL: THIRD ANGLE PROJECTION REV. A 14 25 5

TITLE: PEDESTAL ASSEMBLY PROJECT NO: 0257730

