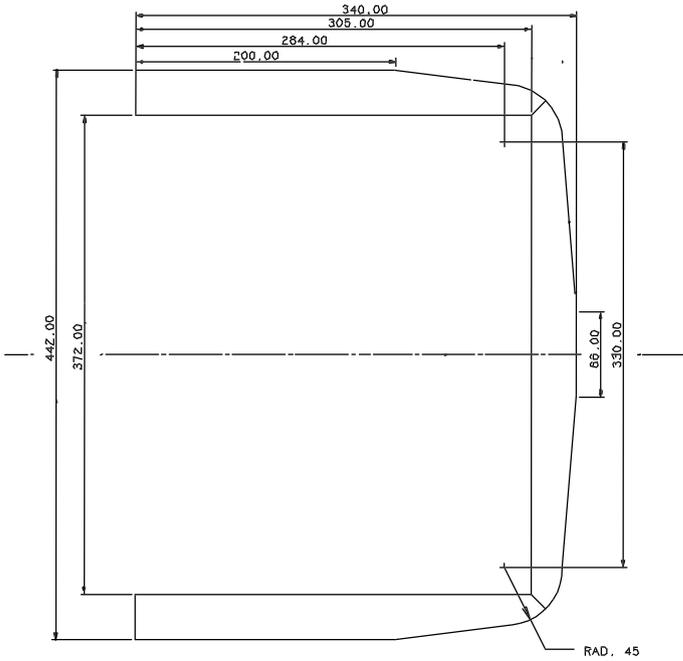


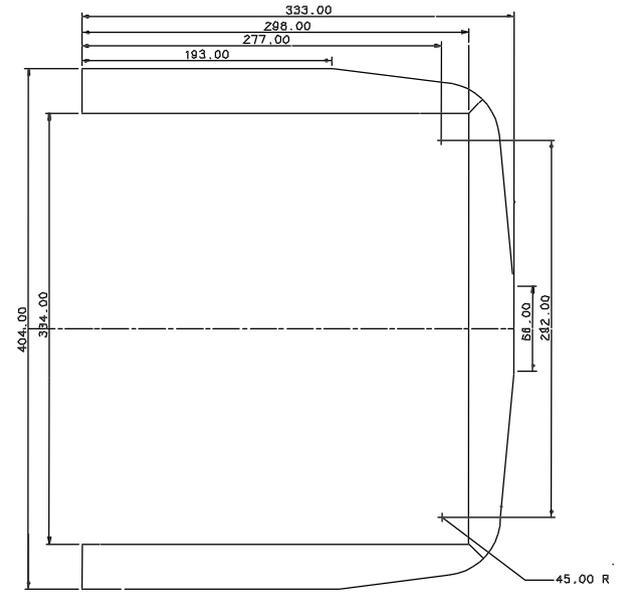
NOTE

CONSISTS OF 4 PIECES, WELD ON ASSY WITH STRUCTURE TO FORM HOOP AS DRAWN
 CORNERS TO BE WELDED ON ASSY. WITH STRUCTURE

								Tolerance (unless otherwise stated)		Material		Dimns. in m.m.		Scale 1:1		THIRD ANGLE PROJECTION		SA No. V/GS/100	
								+/- 1mm		6 mm M.S.						ROYAL GREENWICH OBSERVATORY		Drawing No.	
										Finish		Drg. No.		No. Req.		HERSTMONCEUX CASTLE		W/GS/110	
										Used on						HAILSHAM SUSSEX			
Issue	Mod. No.	Date	Drawn by	Issue	Mod. No.	Date	Drawn by							TITLE		I.S.I.S. COLLIMATOR STRUCTURE RIB			



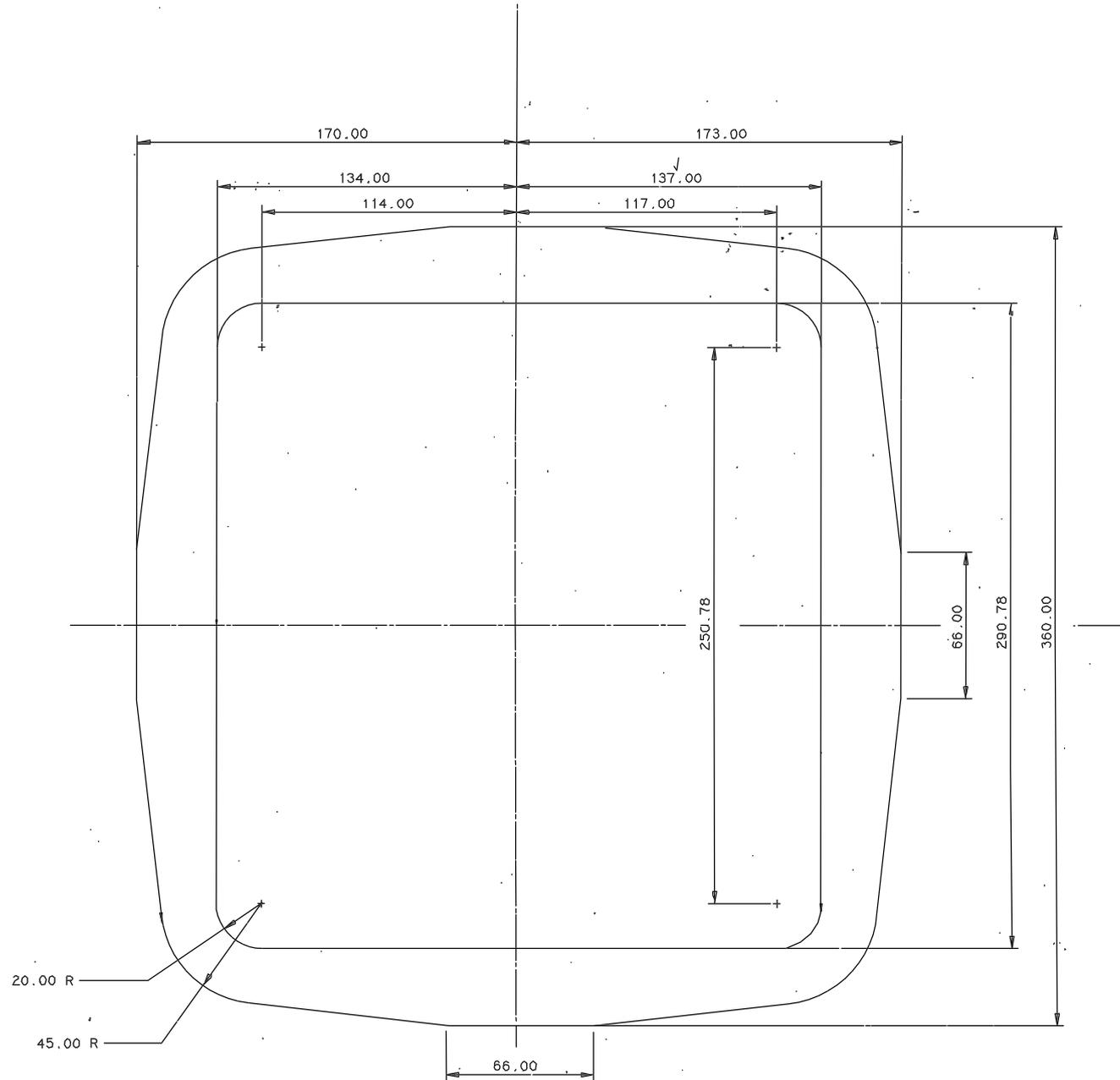
112



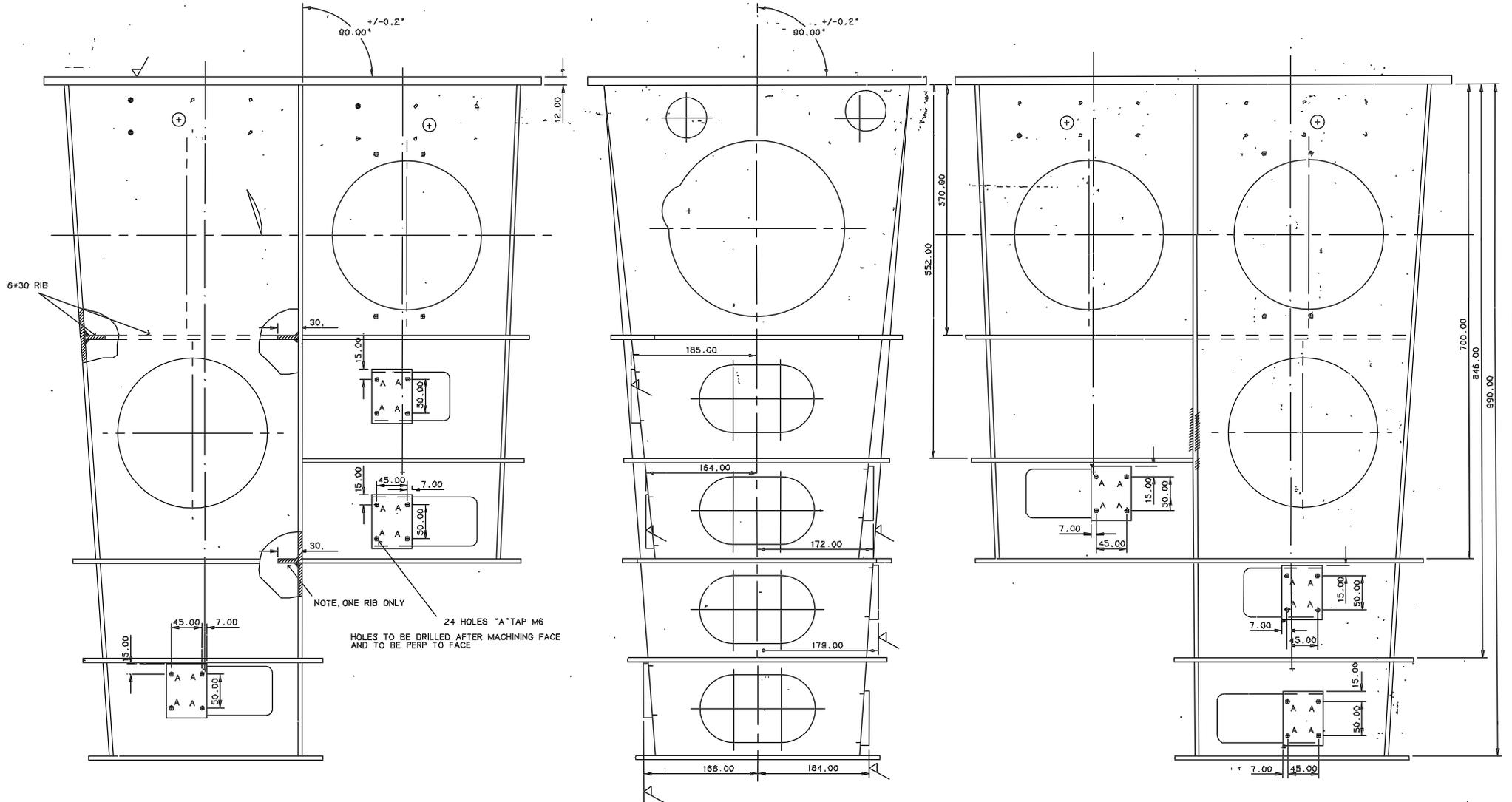
NOTE! RIBS MADE FROM 3 PIECES, TO BE WELDED ON ASSY. WITH STRUCTURE

113

				Tolerance (Unless otherwise stated)				Material		Dimns. in m.m. Scale 0.5		THIRD ANGLE PROJECTION		SA No. V.08/100	
				X +/-				6mm M.S.		Drg. No.		ROYAL GREENWICH OBSERVATORY		Drawing No.	
				X.X +/-				Finish		Used on		HERSTMONCEUX CASTLE		W/GS/112-113	
				X.XX +/-								THE I.S.I.S. COLL. STRUCTURE			
												RIB DET.			
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by								
				28/10/86	C.WEST										

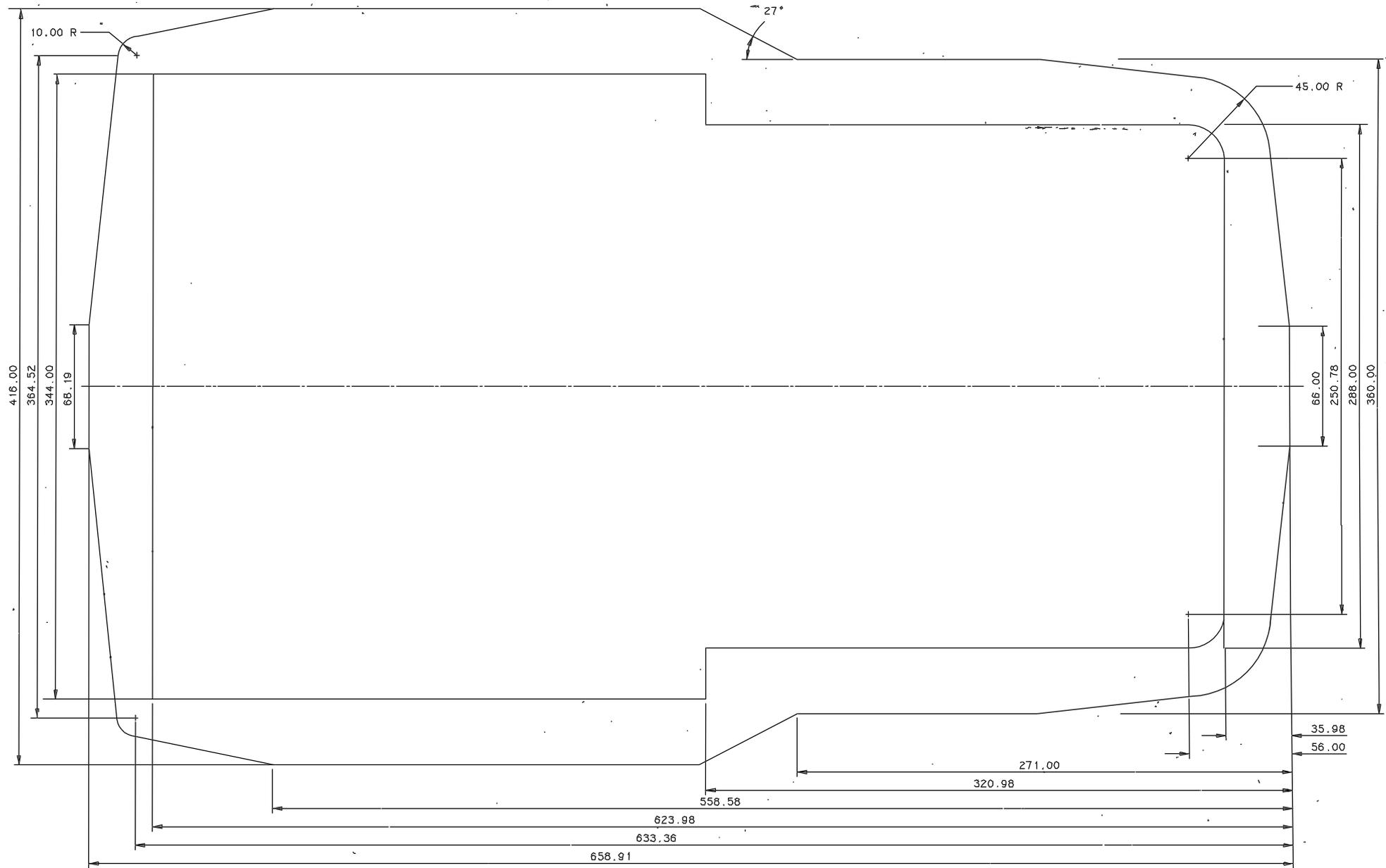


								Tolerance (Unless otherwise stated)	Material	Dimns. In m.m.	Scale 1: 1	THIRD ANGLE PROJECTION	GA No.
								+/- 1.5 mm	6mm M. S.	1			v/GS/100
								Finish	Drg. No.	No. Rec.	ROYAL GREENWICH OBSERVATORY	TITL	Drawing No.
									Used on		HERSTMONEUX CASTLE	I. S. I. S. COLLIMATOR STRUCTURE	W/GS/111
											HALSHAM SUSSEX	BLUE END FLANGE	

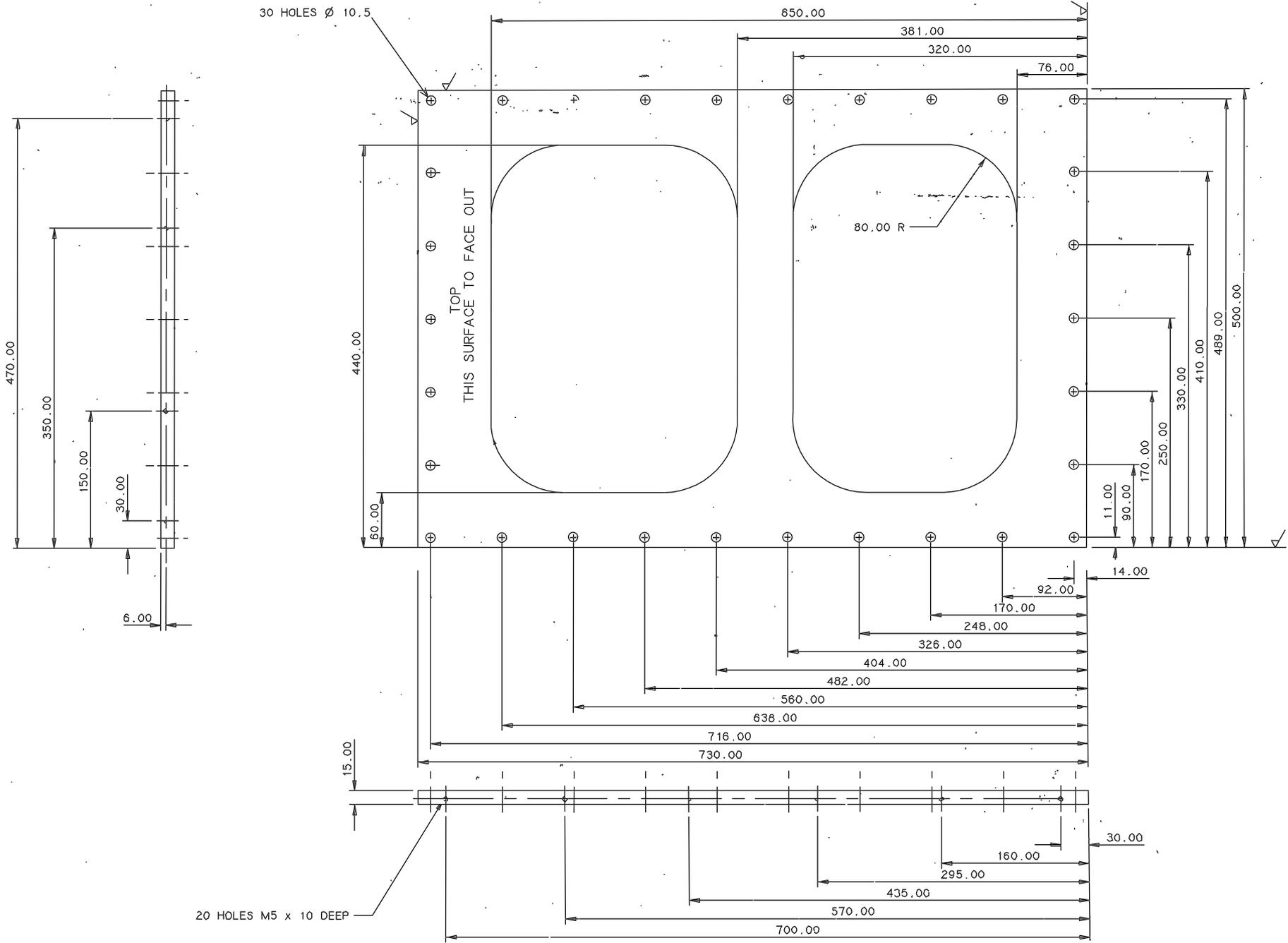


				3	MAY 87	AJW	TOLERANCE +/-	MATERIAL	DIM IN MM		SCALE 0.5	THIRD ANGLE PROJECTION		6.A. NO. V/GS/100
				2	MAR. 87	AJW	HOLE CRS. 0.1	FINISH	DRG NO.		NO RED	ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM EAST SUSSEX		DRG NO.
					27/10/88	G.WEST	GEN. TOL 0.3		USED ON			TITLE I.S.I.S.		COLLIMATOR STRUCTURE MACHINING DET.
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY							

Drawing No.
W /GS/ 109

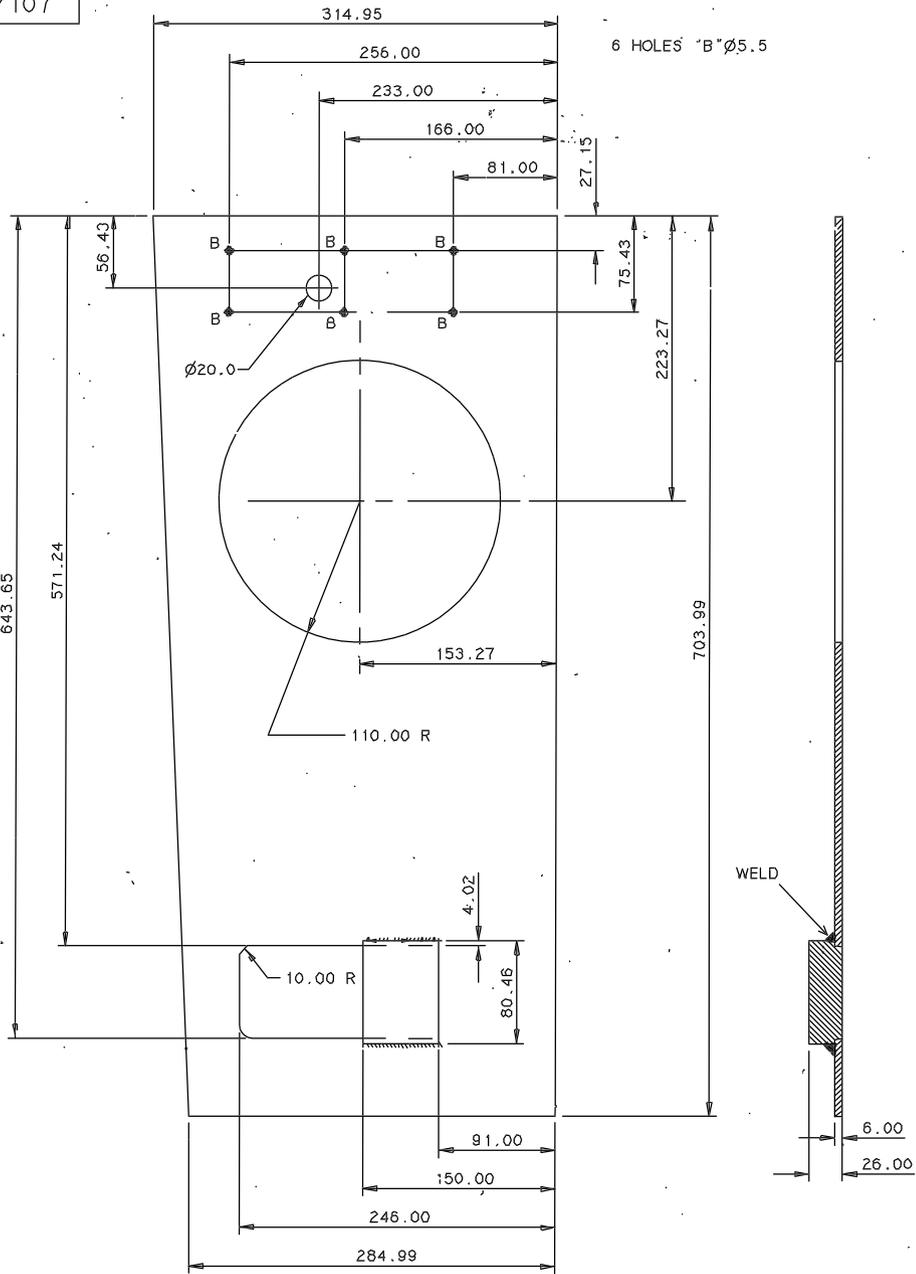


								Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale 1:1		THIRD ANGLE PROJECTION		SA No. v/28/109	
								-0		M.S. 6mm		1		ROYAL GREENWICH OBSERVATORY		Title I.S.I.S. COLLIMATOR STRUCTURE		Drawing No.	
								+1.5		Finish		Drg. No.		HERSTMONCEUX CASTLE		RED END FLANGE		W/GS/109	
										Used on		No. Req.		HAILSHAM SUSSEX					
Issue	Mod. No.	Date	Drawn by	Issue	Mod. No.	Date	Drawn by												



Issue		Mod.No		Date		Drawn by		Issue		Mod.No		Date		Drawn by		Tolerance (Unless otherwise stated)		Material		M.S. 6mm		Finish		Dimns. in m.m.		Scale 0.5		THIRD ANGLE PROJECTION		BA No. V/GS/100	
		2		MAR.87		AJW		22/10/88		O.WEST						HOLE CRS 0.1				1				ROYAL GREENWICH OBSERVATORY				Drawing No.			
																GEN.TOL 0.5				Used on		HERSTMONGEU CASTLE		HAILSHAM		SUSSEX		TITLE		W/GS/108	
																												I.S.I.S. COLLIMATOR STRUCTURE			

Drawing No.
W/GS/107



7		TITLE		DISC REF. WGS107	
I.S.I.S. COLLIMATOR STRUCT.					
MATERIAL		SCALE		TOLERANCES ±	
6 mm M.S.		0.5		HOLE CRS. 0.1	
FINISH		No. RECD. PER UNIT		GEN. TOL. 0.5	
		1			
D.A. No.		DRAWING No.			
V/GS/100		RGO W/GS/107			

Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by

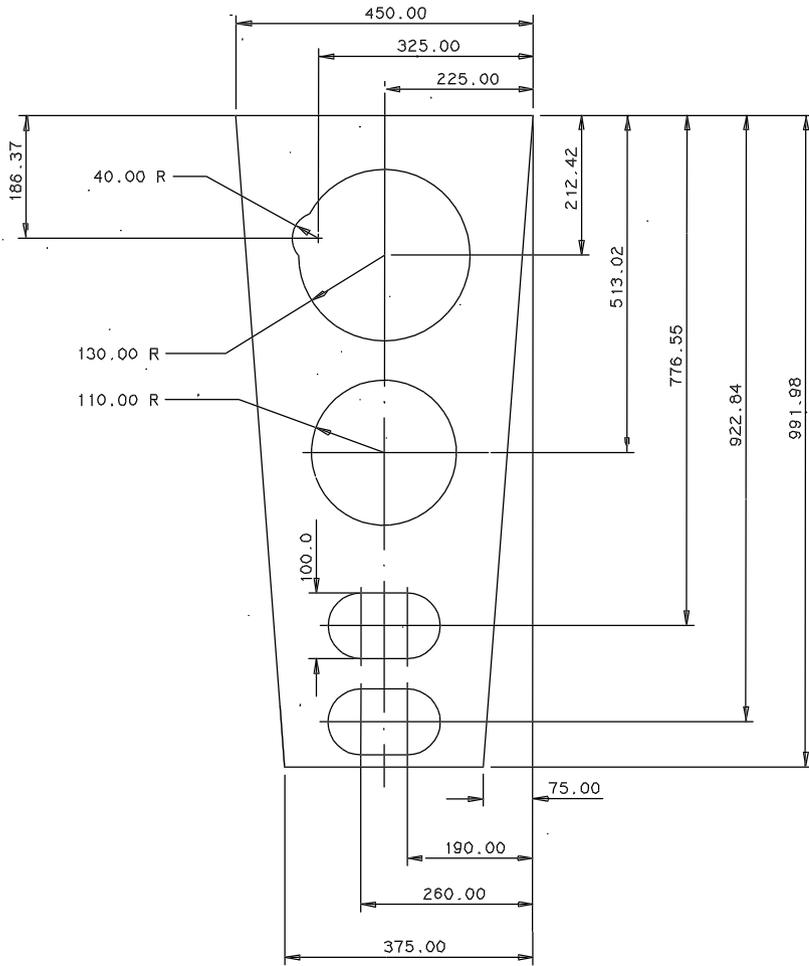
Material	
Finish	

Dimns. in m.m.	Scale
ROYAL GREENWICH OBSERVATORY	
HERST-JONCEUX CASTLE	
HAILSHAM	SUSSEX

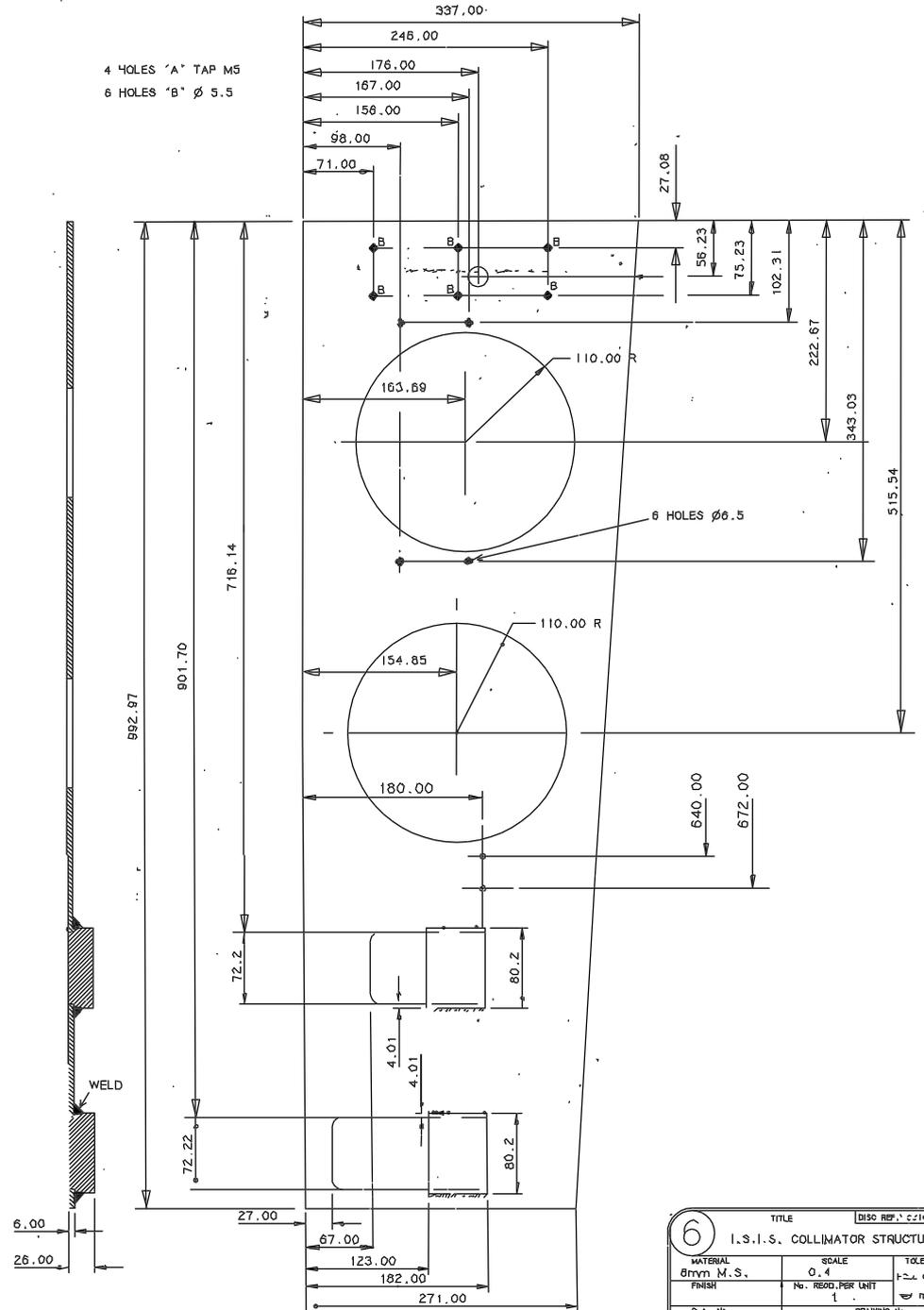
THIRD ANGLE PROJECTION	
DRG. No.	No. Req.
Used on	
Title	
ISIS COLLIMATOR STRUCTURE	
DETAILS	

GA No. V/GS/100
Drawing No.
W/GS/107

Drawing No.
W/GS/105-6



4 HOLES "A" TAP M5
6 HOLES "B" ϕ 5.5



5	TITLE		DISC REF. 0510-6
	I.S.I.S. COLLIMATOR STRUCTURE		
MATERIAL	SCALE	TOLERANCES \pm	
Brvn M.S.	0.25	0.5	
FINISH	No. REED. PER UNIT		
	1		
B.A. No.	DRAWING No.		
V/GS/100	RGO	W/CS/105	

Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by
			AY 87 AuW				C. VEST

Tolerance (Unless otherwise stated)
X +/-
X.X +/-
X.XX +/-

Material	Finish	Drng. No.	No. Req.	Used on

Dimns. in m.m. Scale
ROYAL GREENWICH OBSERVATORY
HERSTMONCEUX CASTLE
HAILSHAM SUSSEX

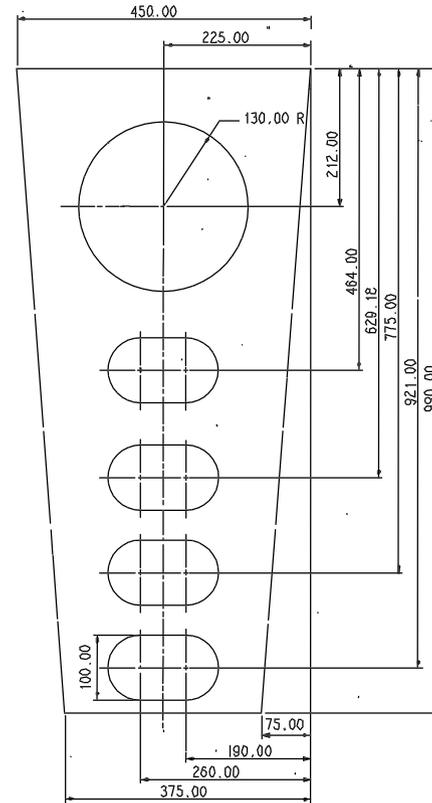
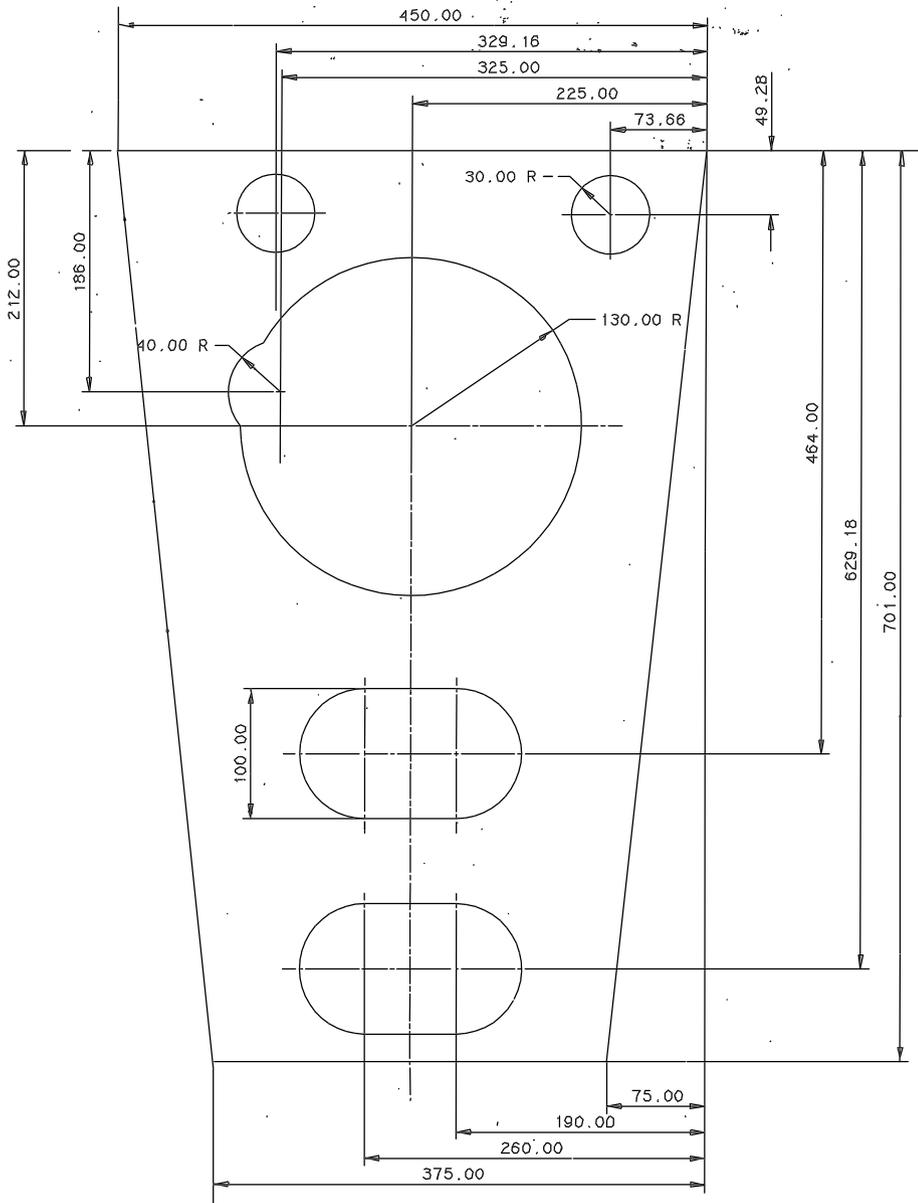
THIRD ANGLE PROJECTION
ISIS COLLIMATOR STRUCTURE
DETAILS

6	TITLE		DISC REF. 0510-6
	I.S.I.S. COLLIMATOR STRUCTURE		
MATERIAL	SCALE	TOLERANCES \pm	
Brvn M.S.	0.4	0.1	
FINISH	No. REED. PER UNIT		
	1		
B.A. No.	DRAWING No.		
V/GS/100	RGO	W/CS/105	

DA No. 1
Drawing No.
W/GS/105-6

Drawing No.

W



3		TITLE		DISC REF. WGS103-4	
I.S.I.S. COLL. STRUCTURE					
MATERIAL		SCALE		TOLERANCES ±	
6 mm M.S.		1/2		±	
FINISH		No. RECD. PER UNIT		GEN. TOL. 0.5	
		1			
G.A. No.		DRAWING No.		DRAWING No.	
V/GS/100		RGO W/GS/103		W/GS/104	

Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by

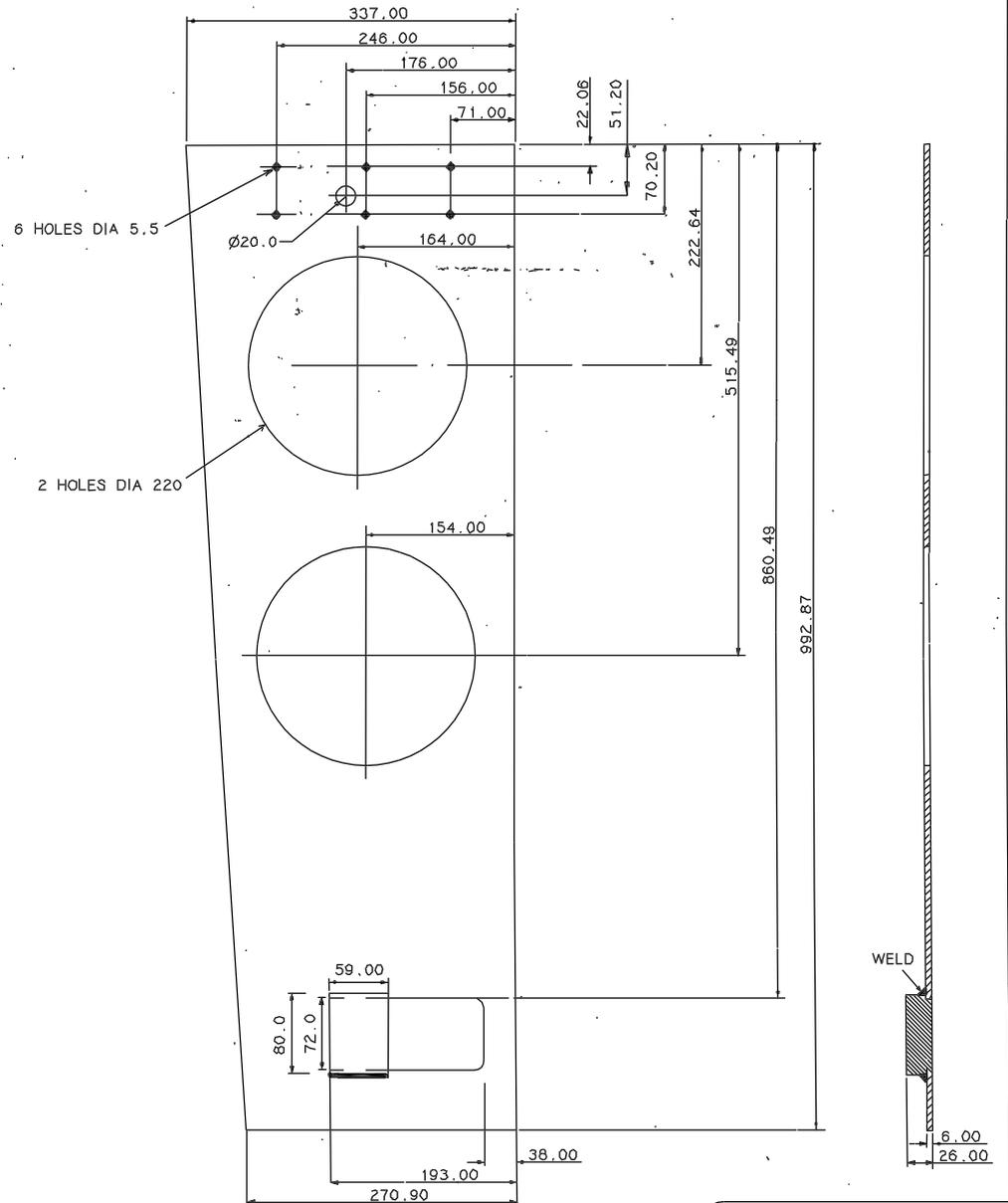
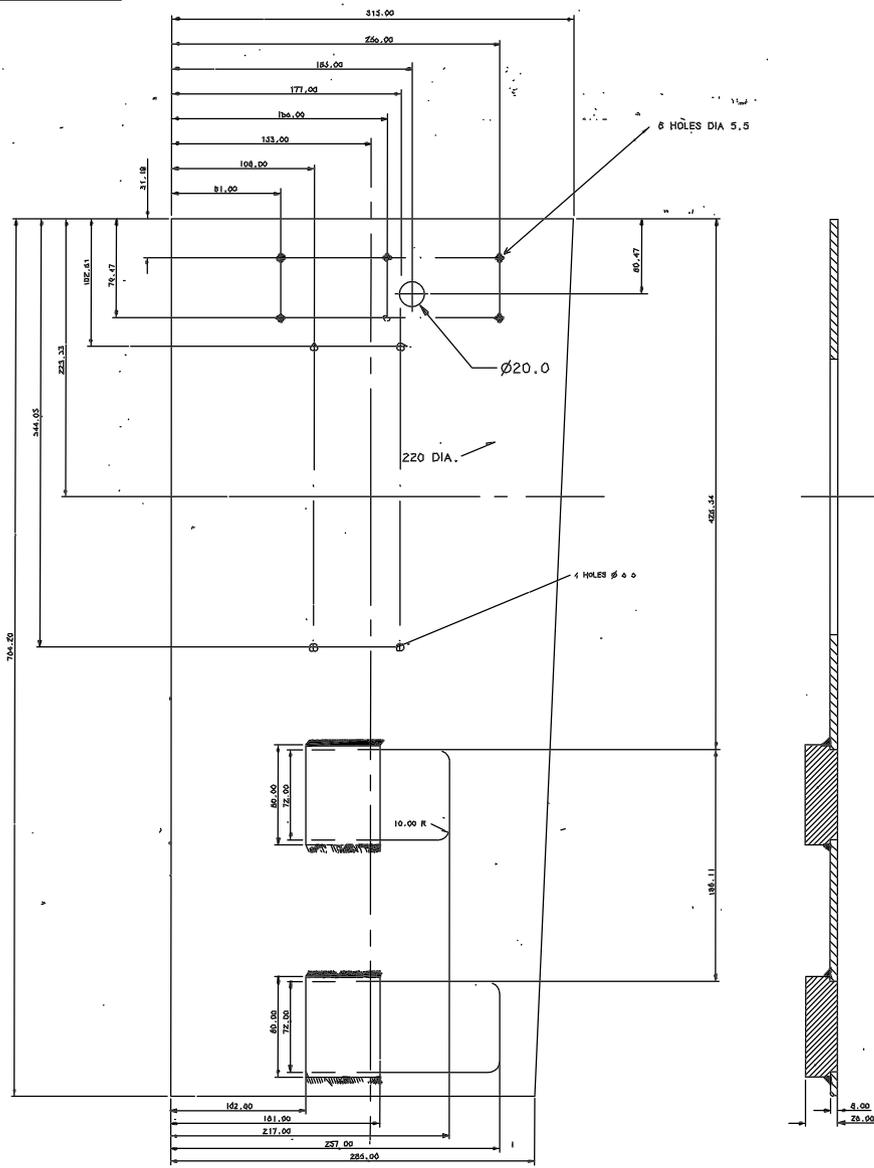
Tolerance (Unless otherwise stated)
 X +/-
 X.X +/-
 Y.XX +/-

Material		Dimns. In m.m.		Scale	
Finish		Drg.No.		No. Req.	
		Used on			

ROYAL GREENWICH OBSERVATORY
 HERSTMONCEUX CASTLE
 HAILSHAM SUSSEX

THIRD ANGLE PROJECTION

4		TITLE		DISC REF. WGS103-4	
I.S.I.S. COLL. STRUCTURE					
MATERIAL		SCALE		TOLERANCES ±	
6 mm M.S.		1/4		±	
FINISH		No. RECD. PER UNIT		GEN. TOL. 0.5	
		1			
G.A. No.		DRAWING No.		DRAWING No.	
V/GS/100		RGO W/GS/104		W/GS/104	



1	TITLE		DISC REF.	WGS101-2
	I.S.I.S. COLL. STRUCTURE			
	MATERIAL	SCALE	TOLERANCES ±	
	FINISH	No. RECD. PER UNIT	HOLE CRS. 0.1mm GEN. TOL. 0.5mm	
S.A. No.	RGD	DRAWING No.	W/GS/101	
V/GS/100				

Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by
				2		MAY 87	AJV
				1		14/10/88	C. WAT

Material		Dimns. in m.m.		Scale	
Finish		Drg. No.		No. Req.	
		Used on			

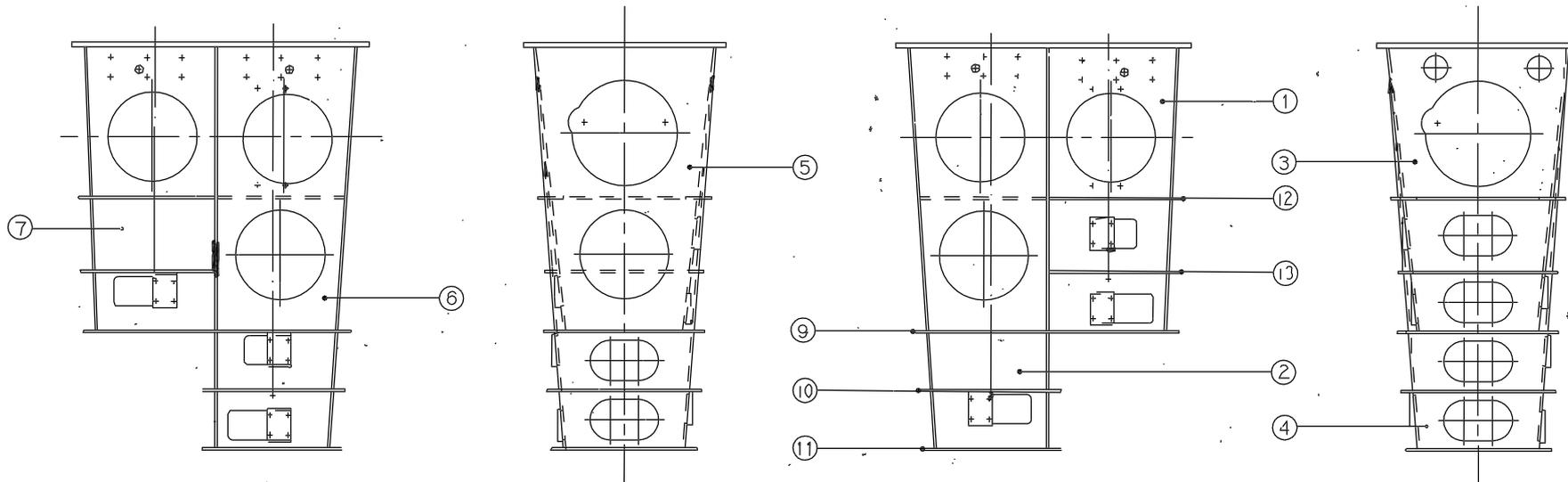
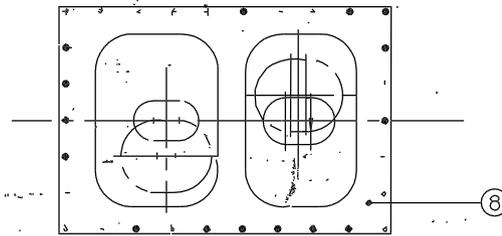
ROYAL GREENWICH OBSERVATORY		Title		THIRD ANGLE PROJECTION	
HERSTMONCEUX CASTLE		I.S.I.S. COLL. STRUCTURE DET.			
HAILSHAM		SUSSEX			

2		TITLE		DISC REF.	WGS101-2
I.S.I.S. COLL. STRUCTURE					
MATERIAL	SCALE	TOLERANCES ±			
FINISH	No. RECD. PER UNIT	HOLE CRS. 0.1mm GEN. TOL. 0.5mm			
S.A. No.	RGD	DRAWING No.		W/GS/102	
V/GS/100					

GA No. W/GS/100	
Drawing No.	
W/GS/101-2	

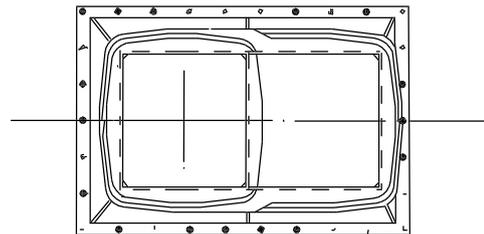
STAGES OF INSPECTION BY RGO STAFF

1. AFTER FABRICATION PRIOR TO HEAT TREATMENT
2. AFTER ALL MACHINING



NOTE'S

- 1/ COMPONENT PARTS MAY BE DRESSED AS REQ. PRIOR TO ASSEMBLY.
- 2/ ALL WELDS TO BE CONTINUOUS, 6mm BUTT/FILLET AS REQ.
- 3/ AVOID DISTORTION AS MUCH AS POSSIBLE.
- 4/ STRESS RELIEVE: HEAT TO 650 CENTIGRADE, SOAK FOR 40 MINUTES, COOL SLOWLY.
- 5/ SHOT BLAST AND IF NECESSARY DRESS CLEAN.
- 6/ FINISH: DEGREASE, PHOSPHATE TO DET.29 MASK MACHINED AREAS AND SPRAY TWO COATES OF RED OXIDE PRIMER.
- 7/ MASKED AREAS TO BE COATED WITH RUST PREVENTATIVE



						2		MAY 87		AdjW		TOLERANCES (UNLESS OTHERWISE STATED)		MATERIAL		DIM IN MM		SCALE 1/4		THIRD ANGLE PROJECTION		G.A. NO.			
								8/10/88		C. WEST		X .XX +/-		FINISH		DRG NO.		NO REQ		ROYAL GREENWICH OBSERVATORY		DRG NO.			
ISSUE		MOD. NO.		DATE		DRAWN BY		ISSUE		MOD. NO.		DATE		DRAWN BY		USED ON				HAILSHAM EAST SUSSEX		V /GS/100			
																				TITLE		I.S.I.S. COLL STRUCTURE			