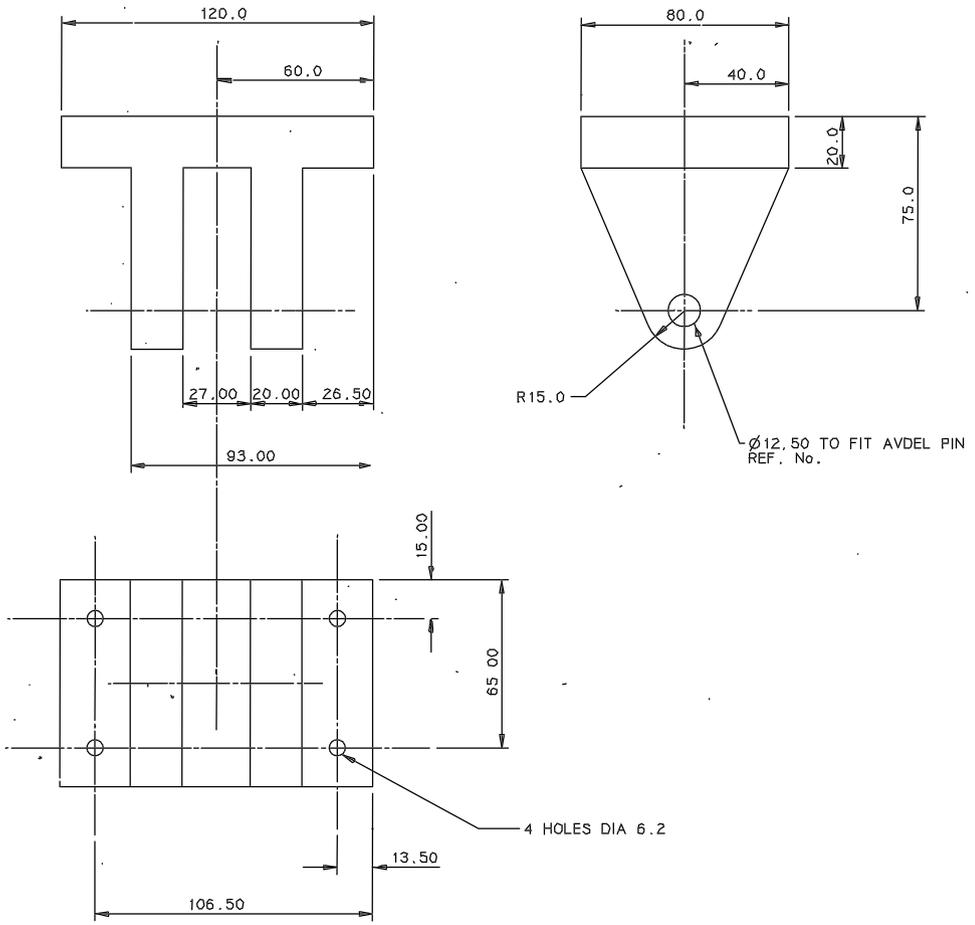


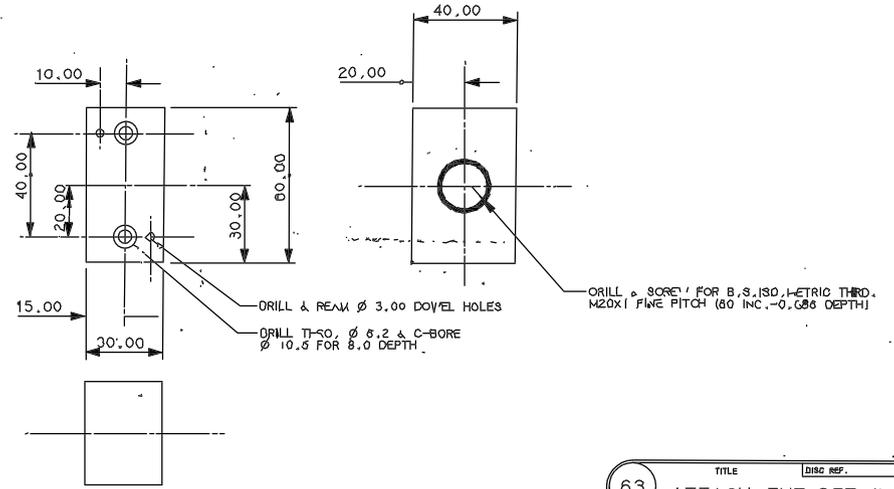
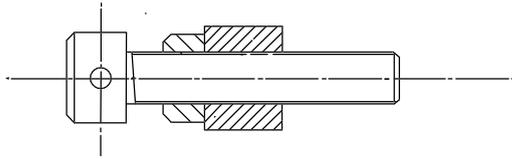
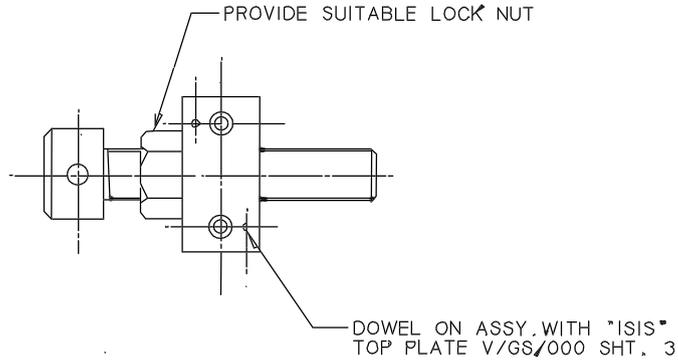
Drawing No.
W/GS/065

REMOVE ALL SHARP EDGES



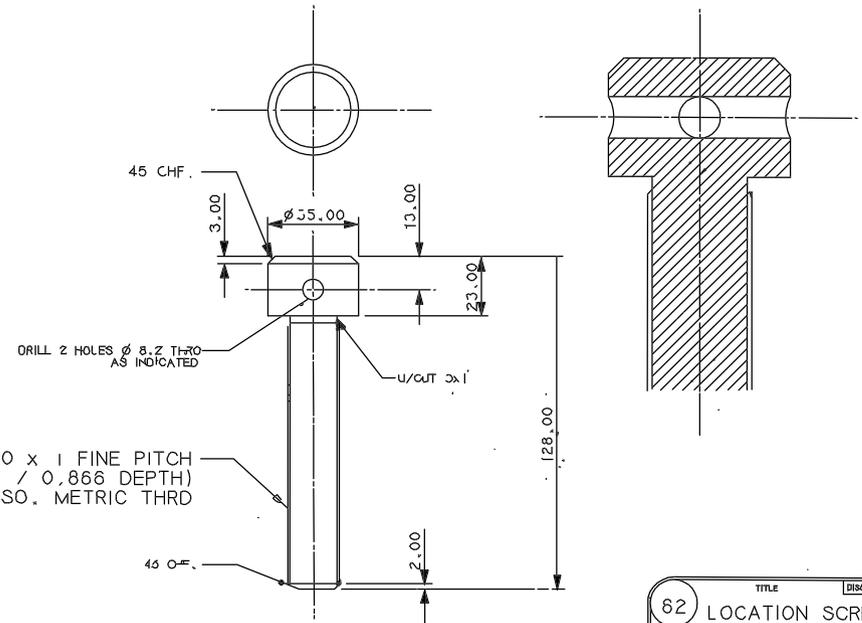
65		TITLE		DISC. REF.	
BRACKET					
MATERIAL	SCALE	TOLERANCES ±			
MILD STEEL	1 : 1	X	X.X	0.5	
FINISH PASS. & CAD. PLATE	No. REQ. PER UNIT 4 OFF	X.X	X.X	0.1	
S.A. No. V/GS/000	DRAWING No. RGO W/GS/065				

				Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No. V/GS/000	
				X +/-		Finish		ROYAL GREENWICH OBSERVATORY		Title		4.2m ISIS - MAIN STRUCTURE		Drawing No.	
				X.X +/- 0.5		Used on		HERSTMONGEUX CASTLE		Used on		BRACKET - SUPPORT FRAME ATTACHMENT		W/GS/065	
				X.XX +/- 0.1				HAILSHAM SUSSEX							



REMOVE ALL SHARP EDGES

83		ATTACHMENT DETAIL	
MATERIAL BRASS	SCALE FULL	TOLERANCES ±	
FINISH BLK NI PLT	No. REQ. PER UNIT 1	X.X	X.XX
S.A. No.	RGD	DRAWING No.	



REMOVE ALL SHARP EDGES

82		LOCATION SCREW	
MATERIAL ST. STEEL	SCALE FULL SIZE	TOLERANCES ±	
FINISH SELF	No. REQ. PER UNIT 1	X.X	0.1
S.A. No.	RGD	DRAWING No.	

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

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

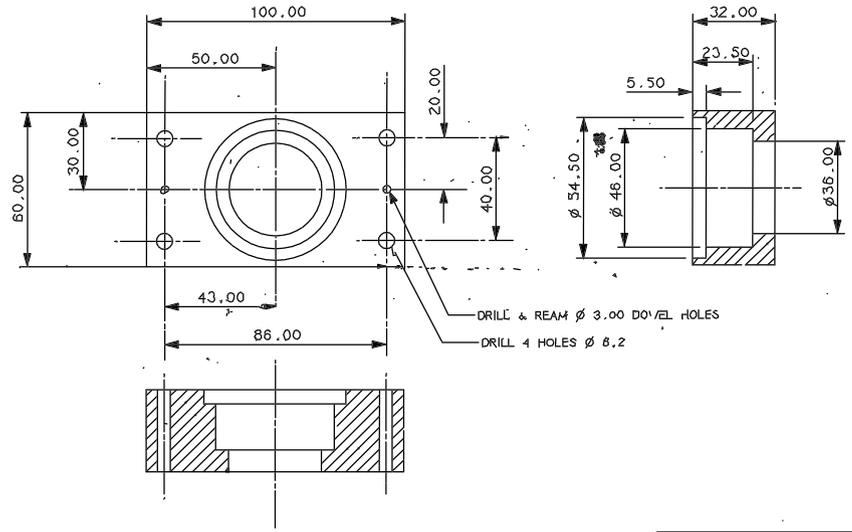
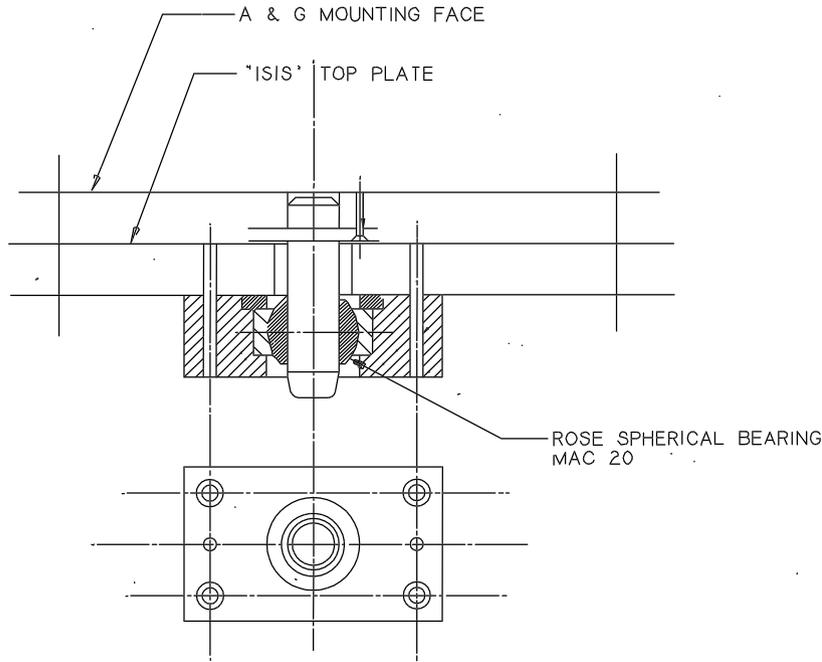
Material	Dimns. in m.m.	Scale
Finish	Dwg. No.	No. Req.
	Used on	

ROYAL GREENWICH OBSERVATORY
HERSTMONCEUX CASTLE
HILSHAM SJSSEX

THIRD ANGLE PROJECTION
Title 4.2m A&G/SPECTRO
LOCATION SCREW & ATTACHMENT

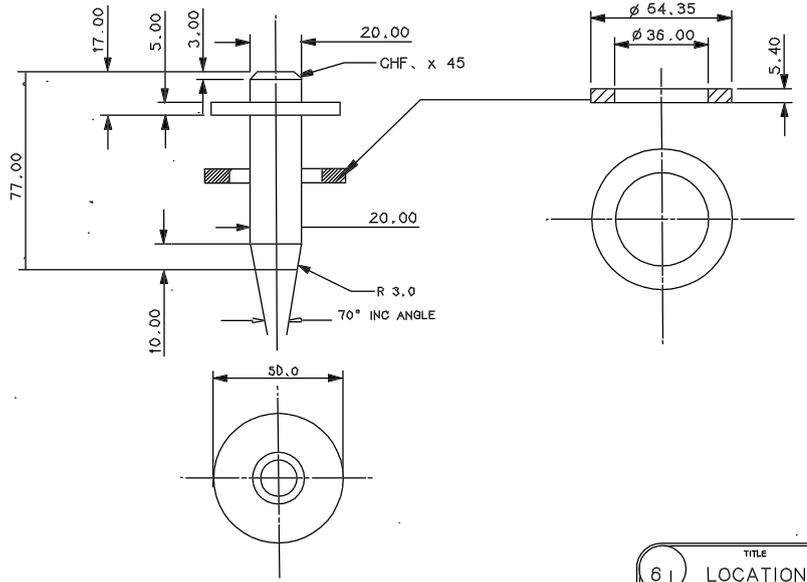
GA No.
Drawing No.
W/GS/062-3

Drawing No.
W/GS/060-1



REMOVE ALL SHARP EDGES

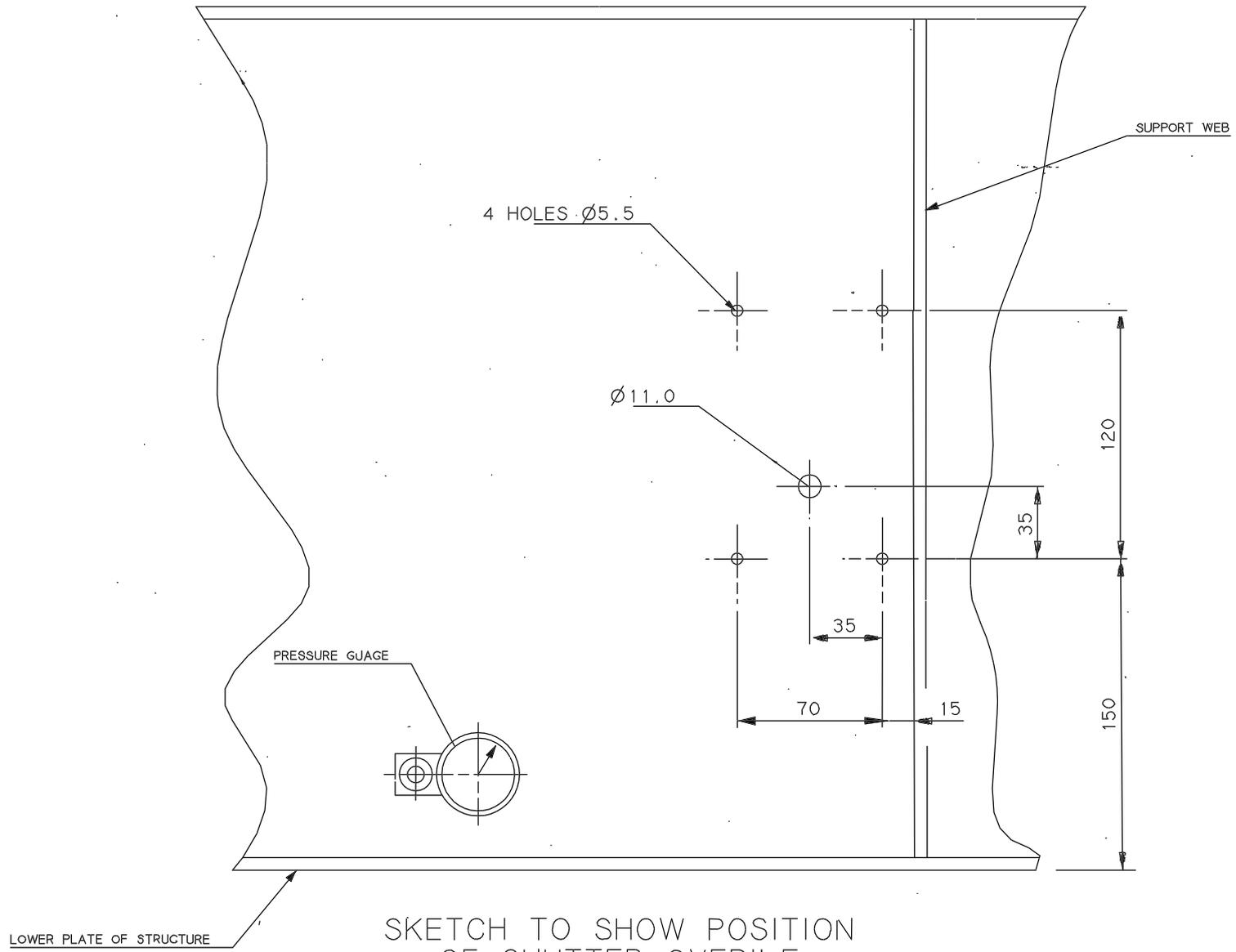
TITLE		DISC REF.
60 LOCATION BLOCK		
MATERIAL	SCALE	TOLERANCES ±
MILD STEEL	FULL	X X.X X.XX
FINISH	No. REQD. PER UNIT	X X.X X.XX
PASS 0. CAD.	ONE	0.1
S.A. No.	DRAWING No.	
	RGO	



REMOVE ALL SHARP EDGES

TITLE		DISC REF.
61 LOCATION PIN		
MATERIAL	SCALE	TOLERANCES ±
MILD STEEL	FULL	X X.X X.XX
FINISH	No. REQD. PER UNIT	X X.X X.XX
PASS 0. CAD.	ONE	
S.A. No.	DRAWING No.	
	RGO	

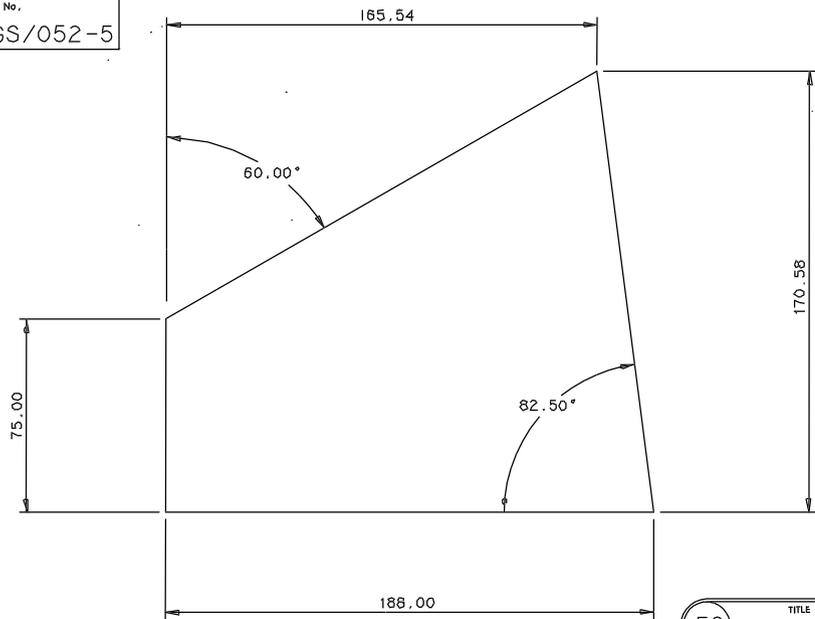
Tolerance (Unless otherwise stated)								Material		Dimns. in m.m.		Scale	THIRD ANGLE PROJECTION		GA No.
X +/-								Finish		ROYAL GREENWICH OBSERVATORY		Title	4.2m A & G/SPECTRO. LOCATION BLOCK & PIN		Drawing No. W/GS/060-1
X.X +/-								Drg. No.		HERSTMENCEUX CASTLE					
X.XX +/-								Used on		HAILSHAM		SUSSEX			



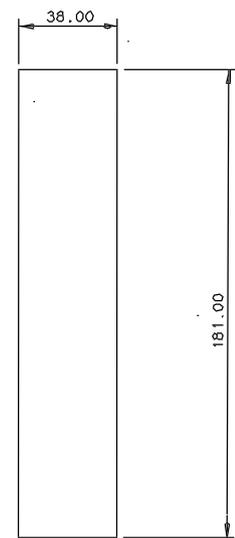
SKETCH TO SHOW POSITION
OF SHUTTER OVER-RIE

								Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale 1:1		THIRD ANGLE PROJECTION		GA No.	
								X +/-				ROYAL GREENWICH OBSERVATORY		Title 4.2m ISIS - MODIFICATION TO STRUCTURE		Drawing No.		W/GS/056	
								X.X +/-		Finish		HERSTMONGEUX CASTLE		TO SUIT SHUTTER OVER-RIDE					
								X.XX +/-		Used on		HAILSHAM SUSSEX							
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by												
				1		JAN. 89	AJW												

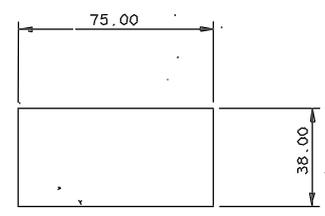
Drawing No.
W/GS/052-5



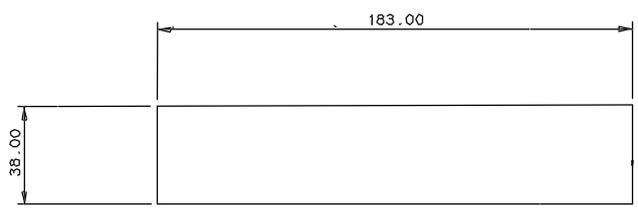
52	TITLE		DISC REF.	WGS052-5
	PLATE			
	MATERIAL	6mm MILD STEEL	SCALE	1 : 1
FINISH	No. REQD. PER UNIT 1 OFF	TOLERANCES	± X X.X X.XX 0.5	
S.A. No.	V/GS/000	DRG. No.	RGO W/GS/052	



53	TITLE		DISC REF.	WGS052-5
	PLATE			
	MATERIAL	6mm MILD STEEL	SCALE	1 : 1
FINISH	No. REQD. PER UNIT 1 OFF	TOLERANCES	± X X.X X.XX 0.5	
S.A. No.	V/GS/000	DRG. No.	RGO W/GS/053	



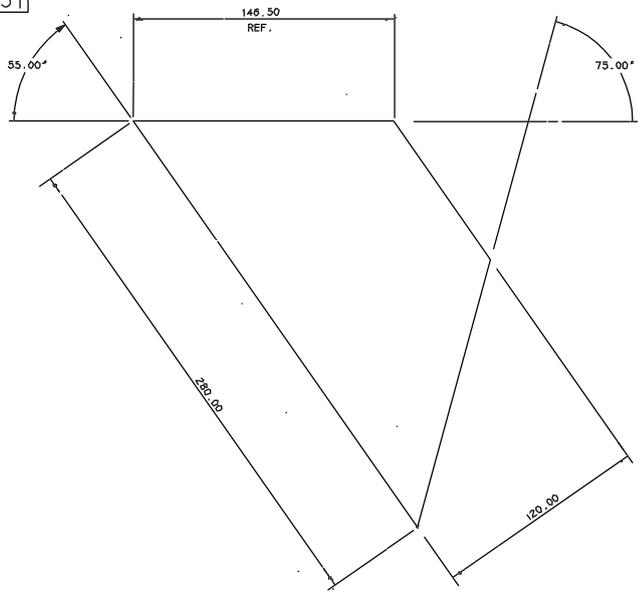
54	TITLE		DISC REF.	WGS052-5
	PLATE			
	MATERIAL	6mm MILD STEEL	SCALE	1 : 1
FINISH	No. REQD. PER UNIT 1 OFF	TOLERANCES	± X X.X X.XX 0.5	
S.A. No.	V/GS/000	DRG. No.	RGO W/GS/054	



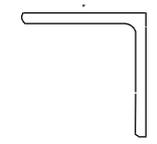
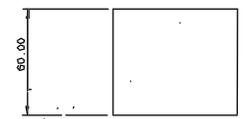
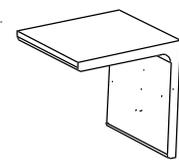
55	TITLE		DISC REF.	WGS052-5
	PLATE			
	MATERIAL	6mm MILD STEEL	SCALE	1 : 1
FINISH	No. REQD. PER UNIT 1 OFF	TOLERANCES	± X X.X X.XX 0.5	
S.A. No.	V/GS/000	DRG. No.	RGO W/GS/055	

Issue	Mod. No.	Date	Drawn by	Issue	Mod. No.	Date	Drawn by	Tolerance (Unless otherwise stated)	Material	Dimns. in m.m.	Scale	1 : 1	THIRD ANGLE PROJECTION	GA No. V/GS/000
								X +/- X.X +/- X.XX +/-	Finish	ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM SUSSEX			Title	4.2m ISIS - MAIN STRUCTURE DETAILS
									Drq. No.	No. Req.				Drawing No. W/GS/052-5

V/GS/047-51

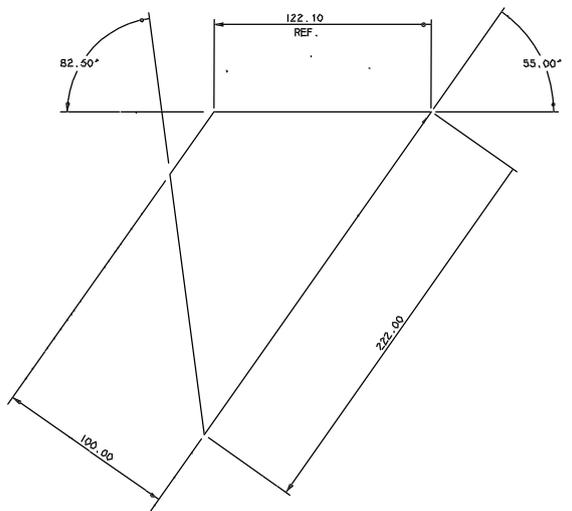


47	TITLE	DESC. REF.
	WEB	
MATERIAL	SCALE	TOLERANCES
6mm MS	1:1	X X 0.5
FINISH	NO. REVISIONS	DATE
	1	OFF
V/GS/000	RGD	V/GS/047

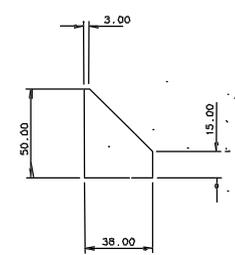
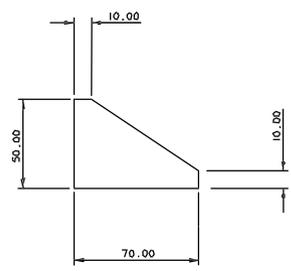


70x70x6 MS ANGLE

49	TITLE	DESC. REF.
	ANGLE BRACKET	
MATERIAL	SCALE	TOLERANCES
SEE ABOVE	1:1	X X 0.5
FINISH	NO. REVISIONS	DATE
	1	OFF
V/GS/000	RGD	V/GS/049



48	TITLE	DESC. REF.
	WEB	
MATERIAL	SCALE	TOLERANCES
6mm MS	1:1	X X 0.5
FINISH	NO. REVISIONS	DATE
	1	OFF
V/GS/000	RGD	V/GS/048



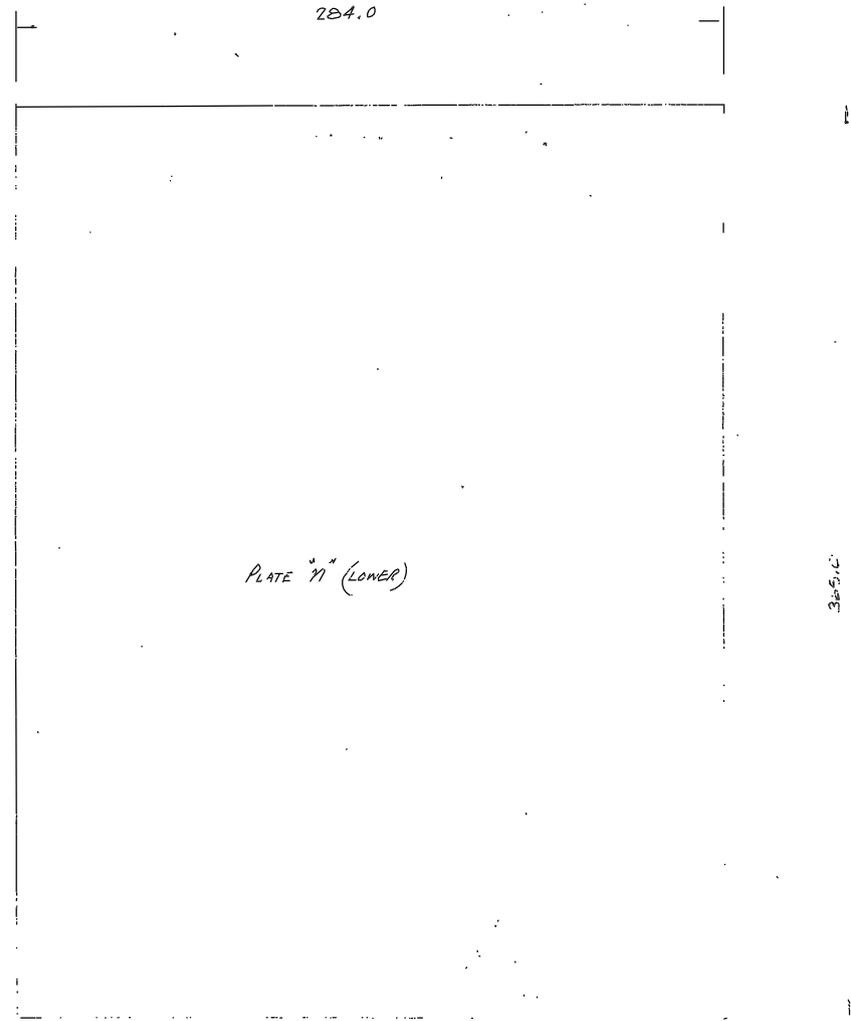
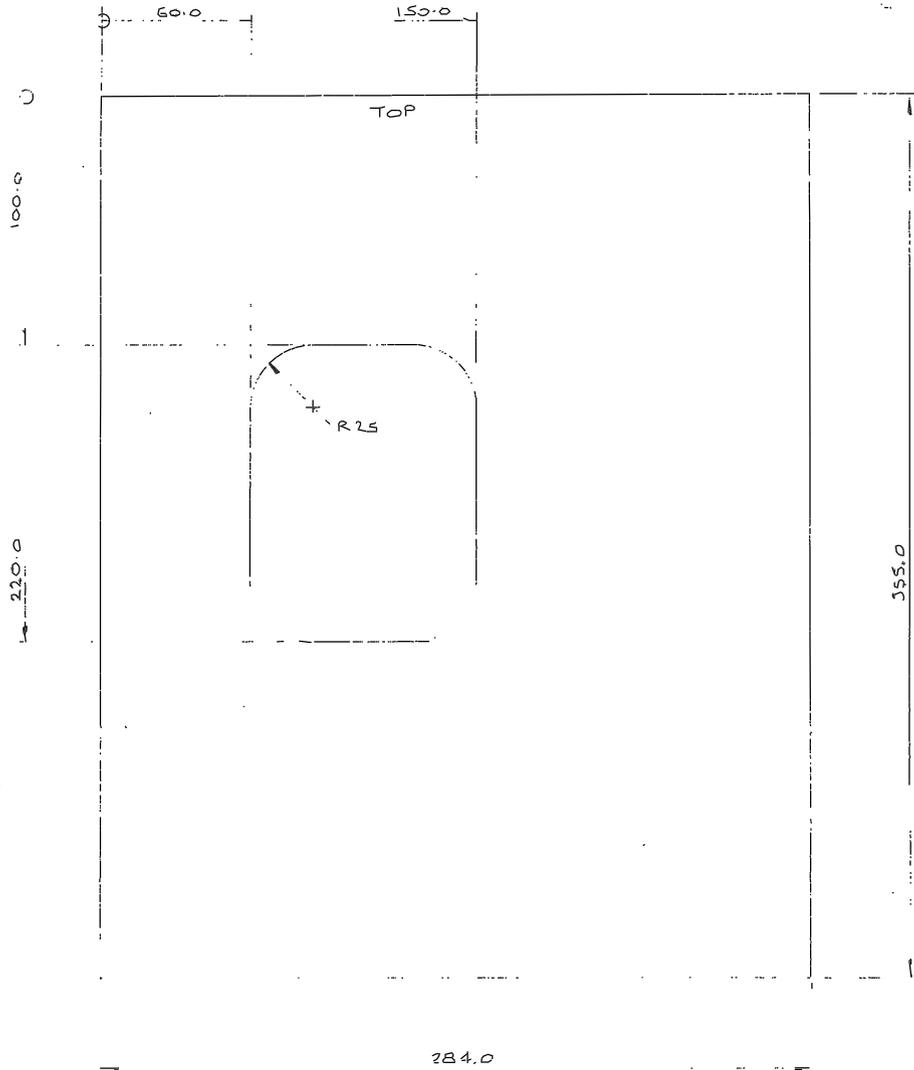
50	TITLE	DESC. REF.
	WEB	
MATERIAL	SCALE	TOLERANCES
6mm MS	1:1	X X 0.5
FINISH	NO. REVISIONS	DATE
	1	OFF
V/GS/000	RGD	V/GS/050

51	TITLE	DESC. REF.
	WEB	
MATERIAL	SCALE	TOLERANCES
6mm MS	1:1	X X 0.5
FINISH	NO. REVISIONS	DATE
	1	OFF
V/GS/000	RGD	V/GS/051

				TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL		DIM IN MM		SCALE		THIRD ANGLE PROJECTION		G.A. NO.		
				X +/-				FINISH		ROYAL GREENWICH OBSERVATORY		TITLE		4.2m ISIS - MAIN STRUCTURE		DRG NO.		
				X.X +/-						HERSTMINGELX CASTLE				DETAILS		V/GS/047-51		
				X.XX +/-						HAILSHAM EAST SUSSEX								
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	USED ON	DRG NO.	NO. REVISIONS	DATE	USED ON						
				1		OCT.86	AJW											

Drawing No.

W/GS/045-6



45		PLATE	
MATERIAL	SCALE	TOLERANCES	
6mm M.S.	1:1	X	± .02
FINISH	NO. REQS. PER UNIT	XX	± .01
1/68/000	1	XXX	± .01
G.A. No.	DRAWING No.		
W/GS/045	R.G.O. W/GS/045		

46		PLATE	
MATERIAL	SCALE	TOLERANCES	
6mm M.S.	1:1	X	± .02
FINISH	NO. REQS. PER UNIT	XX	± .01
1/68/000	1	XXX	± .01
G.A. No.	DRAWING No.		
W/GS/046	R.G.O. W/GS/046		

Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By
				1	SEPT-51		CW

Tolerances (Unless otherwise stated)
 X ± .02
 XX ± .01
 XXX ± .005

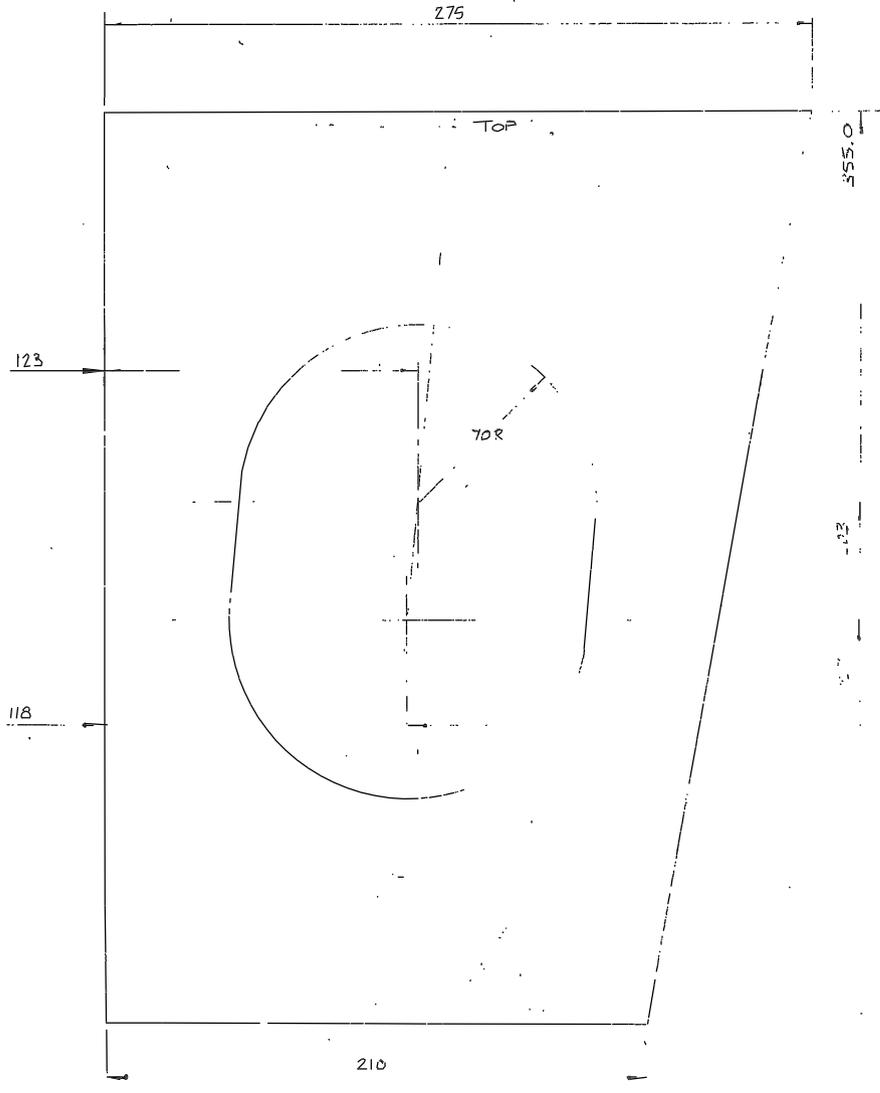
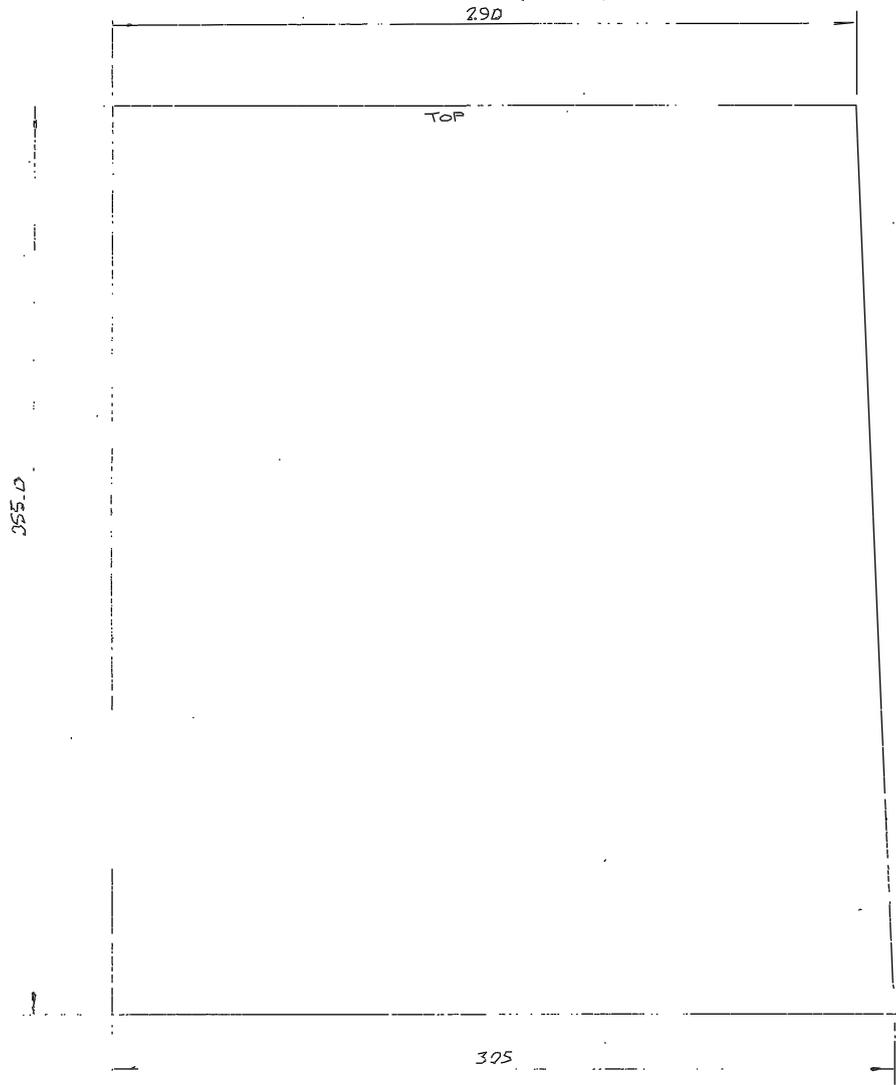
Material	Qty.	Remarks
Finish	Qty.	Remarks
Used on		

Dimensions in m.m.
 Scale
 ROYAL GREENWICH OBSERVATORY,
 HERSTMONCEUX CASTLE,
 HAILSHAM SUSSEX.

THIRD ANGLE PROJECTION
 Title 4.2m ISIS - MAIN STRUCTURE
 DETAILS

G.A. No.
 Drawing No.
 W/GS/045-6

Drawing No.
W



44 NEB		TITLE	
MATERIAL SIMP. M.S.	SCALE 1:1	TOLERANCES UNLESS OTHERWISE STATED	
FINISH	NO. DESIG. PER UNIT	XX ± 0.5	XXX ± 0.5
2.5 mm	DRAWING NO.	R.G.O. W/GS/043	

Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By
				9/9/66			C WEST

Tolerances (Unless otherwise stated)
XX ±
XXX ±

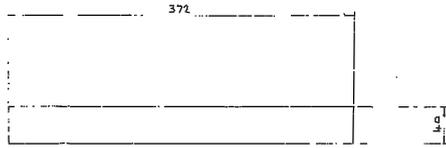
Material	Dimns in m.m.	Scale
Finish	Dwg. No.	No. Req.
	Used on	

ROYAL GREENWICH OBSERVATORY,
HERSTMONCEUX CASTLE,
HAILSHAM
SUSSEX.

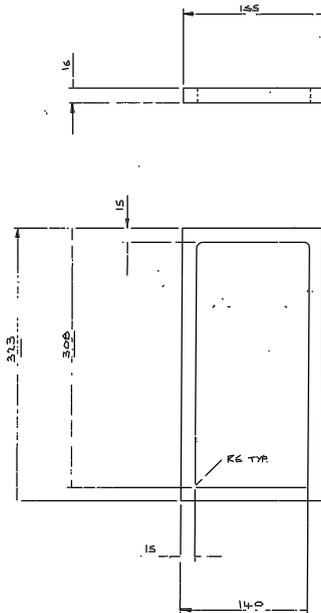
THIRD ANGLE PROJECTION
Title 1/12 STEELWORK
WEB'S

G.A. No.
Drawing No.
W/GS/043-2

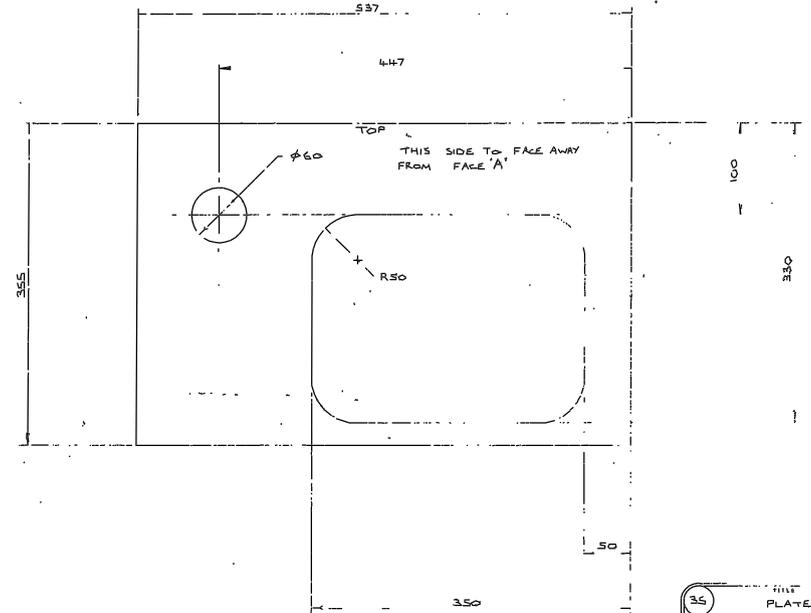
43 WEB	TITLE	
MATERIAL SIMP. M.S.	SCALE 1:1	TOLERANCES UNLESS OTHERWISE STATED
FINISH	NO. DESIG. PER UNIT	XX ± 0.5 XXX ± 0.5
G.A. No. W/GS/043	DRAWING NO. R.G.O. W/GS/043	



33			
TITLE			
PLATE			
MATERIAL	SCALE	TOLERANCES	
6mm MS	1:2	± 0.5	
FINISH	NUMBER PER UNIT	± 0.5	± 0.5
	1 OFF	± 0.5	± 0.5
ST. No.	REVISED BY	DATE	
V/GS/1000	R.G.O. V/GS/033		



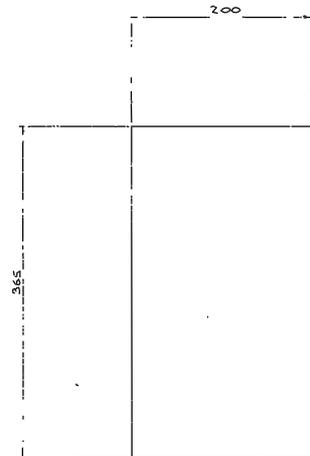
34			
TITLE			
A-DISPERSION MTDG. FLANGE			
MATERIAL	SCALE	TOLERANCES	
MS	1:2	± 0.5	
FINISH	NUMBER PER UNIT	± 0.5	± 0.5
	2 OFF	± 0.5	± 0.5
ST. No.	REVISED BY	DATE	
V/GS/1000	R.G.O. V/GS/034		



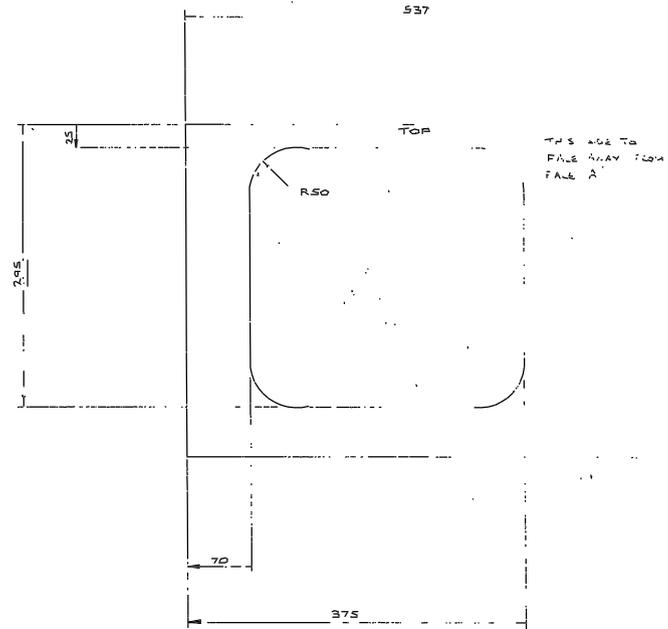
35			
TITLE			
PLATE			
MATERIAL	SCALE	TOLERANCES	
6mm MS	1:2	± 0.5	
FINISH	NUMBER PER UNIT	± 0.5	± 0.5
	1 OFF	± 0.5	± 0.5
ST. No.	REVISED BY	DATE	
V/GS/1000	R.G.O. V/GS/035		



36			
TITLE			
PLATE			
MATERIAL	SCALE	TOLERANCES	
6mm MS	1:2	± 0.5	
FINISH	NUMBER PER UNIT	± 0.5	± 0.5
	1 OFF	± 0.5	± 0.5
ST. No.	REVISED BY	DATE	
V/GS/1000	R.G.O. V/GS/036		



37			
TITLE			
PLATE			
MATERIAL	SCALE	TOLERANCES	
6mm MS	1:2	± 0.5	
FINISH	NUMBER PER UNIT	± 0.5	± 0.5
	1 OFF	± 0.5	± 0.5
ST. No.	REVISED BY	DATE	
V/GS/1000	R.G.O. V/GS/037		



38			
TITLE			
PLATE			
MATERIAL	SCALE	TOLERANCES	
6mm MS	1:2	± 0.5	
FINISH	NUMBER PER UNIT	± 0.5	± 0.5
	1 OFF	± 0.5	± 0.5
ST. No.	REVISED BY	DATE	
V/GS/1000	R.G.O. V/GS/038		

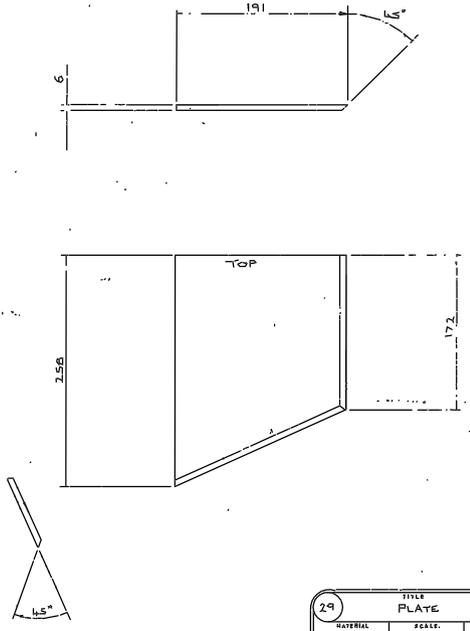
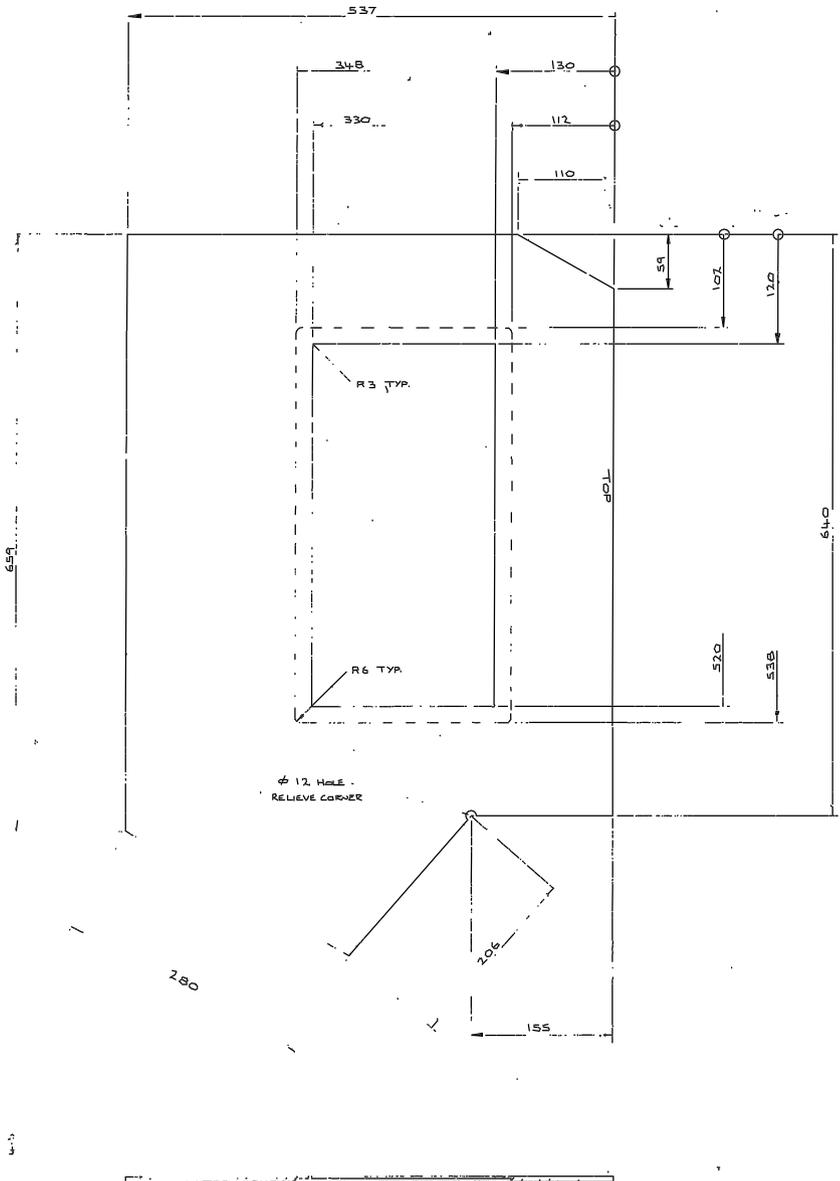
Issue	Mod No.	Date	Drawn By	Issue	Mod No.	Date	Drawn By

Tolerances (Unless otherwise stated)	Material
X ±	Finish
XX ±	
XXX ±	

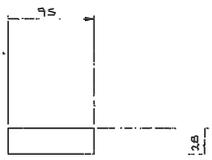
Dwg. No.	No. Rev.	Used on

Dimms. in m.m.	Scale	Project	Title
		ROYAL GREENWICH OBSERVATORY, HERSMONCEUX CASTLE, HAILSHAM SUSSEX	THIRD ANGLE PROJECTION 4.2 m 1515 - MAIN STRUCTURE DETAILS - PLATES

Dwg. No.
V/GS/033-38



29			30		
PLATE			PLATE		
MATERIAL	SCALE	TOLERANCES ±	MATERIAL	SCALE	TOLERANCES ±
MS	1:2	X 0.5	6mm MS	1:2	X 0.5
FINISH	REFER TO UNIT	AS	FINISH	REFER TO UNIT	AS
	1 OFF	XXX		1 OFF	XXX
Dr. No.	DRAWING No.		Dr. No.	DRAWING No.	
V/CS/000	R.O.D. V/CS/029		V/CS/000	R.O.D. V/CS/030	



31		
PLATE		
MATERIAL	SCALE	TOLERANCES ±
6mm MS	1:2	X 0.5
FINISH	REFER TO UNIT	AS
	1 OFF	XXX
Dr. No.	DRAWING No.	
V/CS/000	R.O.D. V/CS/030	

32		
PLATE		
MATERIAL	SCALE	TOLERANCES ±
6mm MS	1:2	X 0.5
FINISH	REFER TO UNIT	AS
	1 OFF	XXX
Dr. No.	DRAWING No.	
V/CS/000	R.O.D. V/CS/032	

Issue	Mat. No.	Date	Drawn By	Issue	Mat. No.	Date	Drawn By

Material	Scale	Dimms. in m.m.

Third Angle Projection	Title

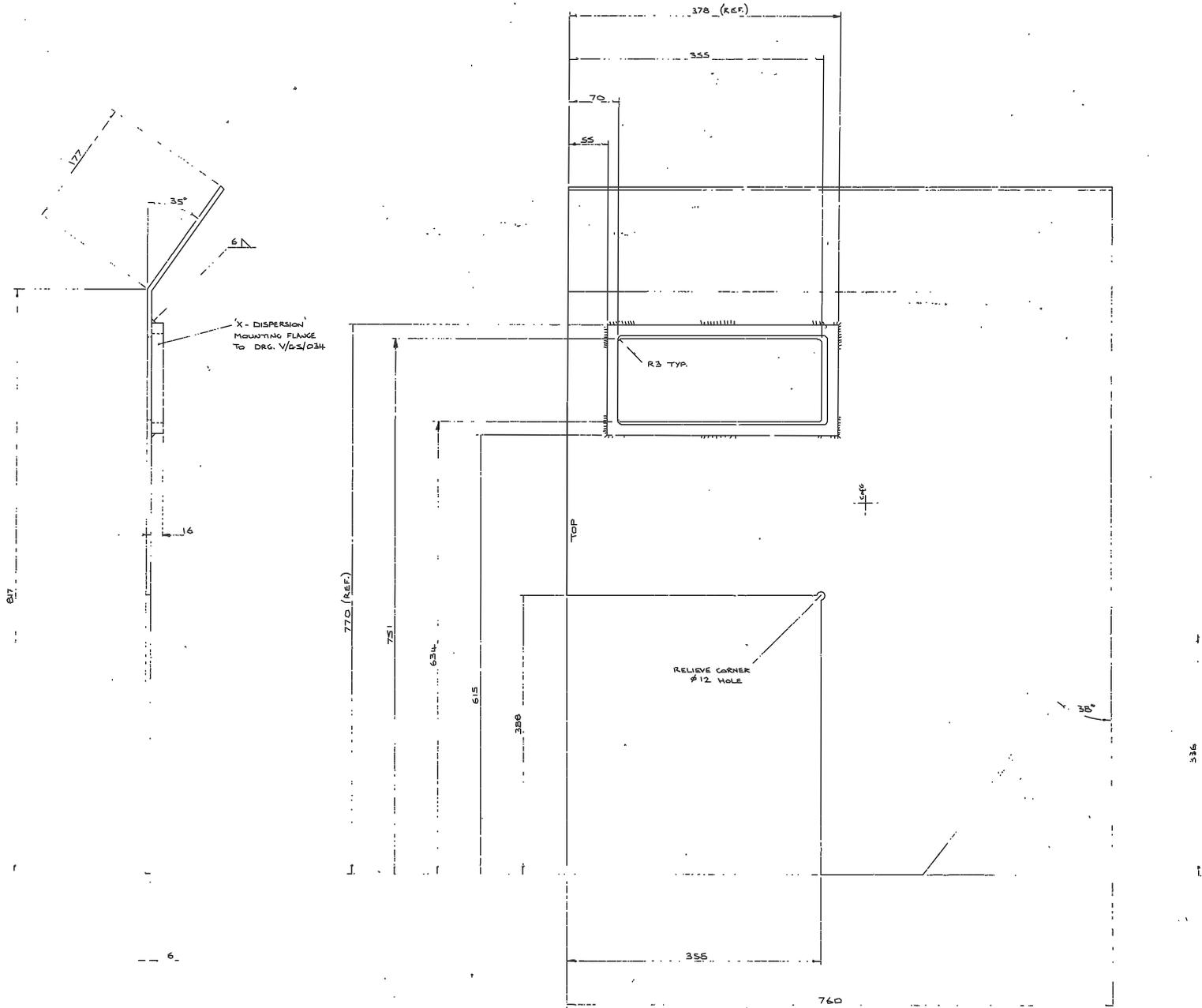
GA No.	Drawing No.
V/CS/000	V/CS/028-32

ROYAL GREENWICH OBSERVATORY,
HERSTMONCEUX CASTLE,
HAILSHAM
SUSSEX.

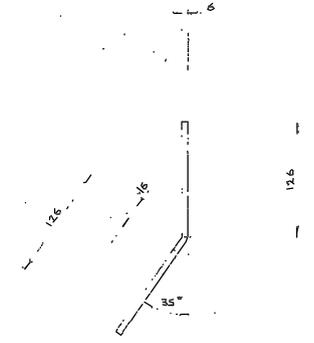
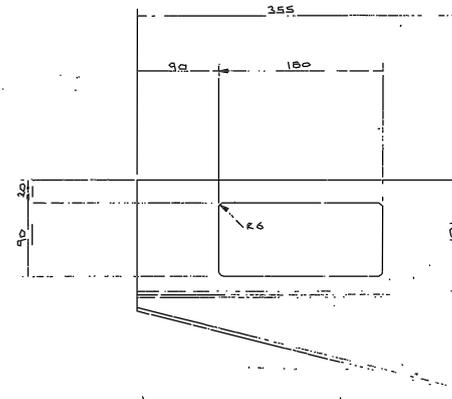
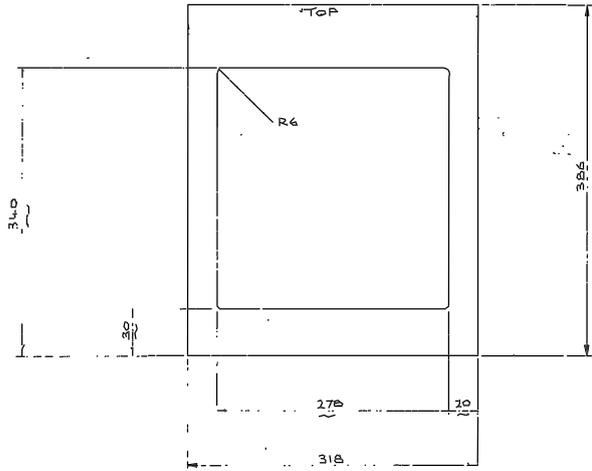
4.2m IS15 - MAIN STRUCTURE
DETAILS - PLATES

Tolerances (Unless otherwise stated)
X ±
XX ±
XXX ±

SEPT. 86
R32

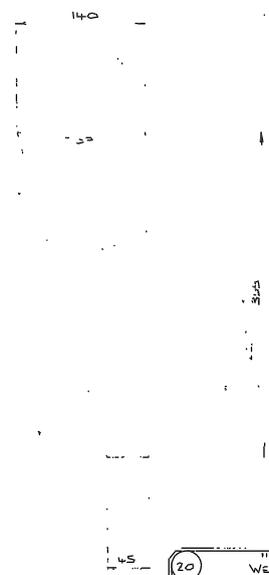
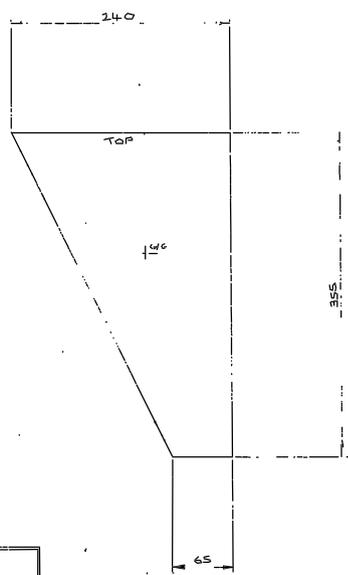
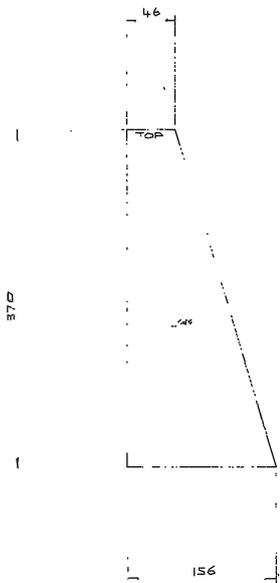


								Tolerances (unless otherwise stated)		Material		Dimms. in m.m		Scale 1:2		THIRD ANGLE PROJECTION		G A No. V/GS/000	
								X ± 0.5 XX ± XXX ±		MILD STEEL FABRICATION		1 OFF		ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM		Title		Drawing No.	
Issue	Mod. No	Date	Drawn By	Issue	Mod. No	Date	Drawn By	AUG. 85	ACW	Drw. No.	No. Rec.	Used on	27		L.2.m 15/5 - MAIN STRUCTURE DETAILS - PLATE		V/GS/027		



16			
TITLE PLATE			
MATERIAL 6mm MS	SCALE 1:2	TOLERANCES ±	
FINISH 1 OFF	QUANTITY 1	± 0.5	± 0.5
DR. No. V/GS/000	DATE R&Q	DESIGNED BY V/GS/D16	

17			
TITLE PLATE			
MATERIAL MS	SCALE 1:2	TOLERANCES ±	
FINISH 1 OFF	QUANTITY 1	± 0.5	± 0.5
DR. No. V/GS/000	DATE R&Q	DESIGNED BY V/GS/D17	



18			
TITLE PLATE			
MATERIAL 6mm MS	SCALE 1:2	TOLERANCES ±	
FINISH 1 OFF	QUANTITY 1	± 0.5	± 0.5
DR. No. V/GS/000	DATE R&Q	DESIGNED BY V/GS/D18	

19			
TITLE WEB			
MATERIAL 6mm MS	SCALE 1:2	TOLERANCES ±	
FINISH 1 OFF	QUANTITY 1	± 0.5	± 0.5
DR. No. V/GS/000	DATE R&Q	DESIGNED BY V/GS/D19	

20			
TITLE WEB			
MATERIAL 6mm MS	SCALE 1:2	TOLERANCES ±	
FINISH 1 OFF	QUANTITY 1	± 0.5	± 0.5
DR. No. V/GS/000	DATE R&Q	DESIGNED BY V/GS/D20	

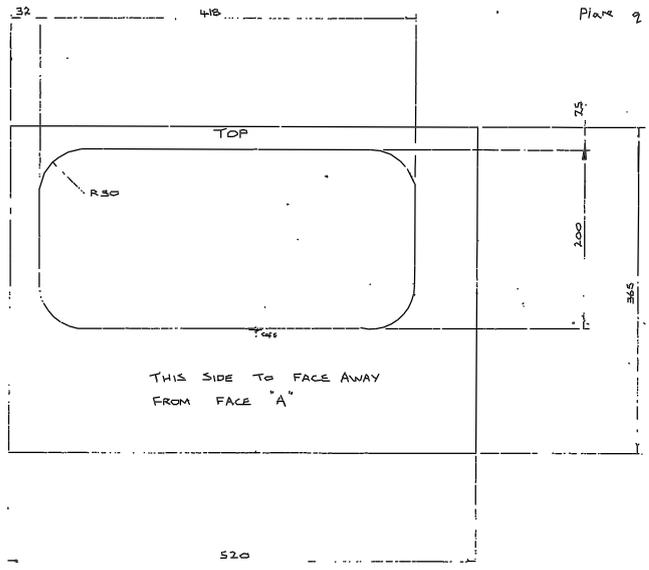
Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By
	2	JAN '08	A3W				
	1	JULY '06	A3W				

Tolerances (Unless otherwise stated)	
X ±	
XX ±	
XXX ±	

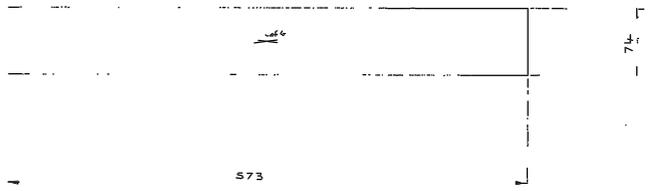
Material		Dimms in m.m.		Scale	
Finish					

ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM SUSSEX		THIRD ANGLE PROJECTION	
Title 4.2m, 151S MAIN STRUCTURE DETAILS		G.A. No. Drawing No. V/GS/016-20	

Drw. No.
V/GS/013-15



TITLE		
13 PLATE		
MATERIAL 6mm MS	SCALE 1:12	TOLERANCES IN mm
FINISH V/GS/000	REFER TO UNIT I OFF	BY R&G
DRN No. V/GS/000	REVISED BY R&G	DATE V/GS/013



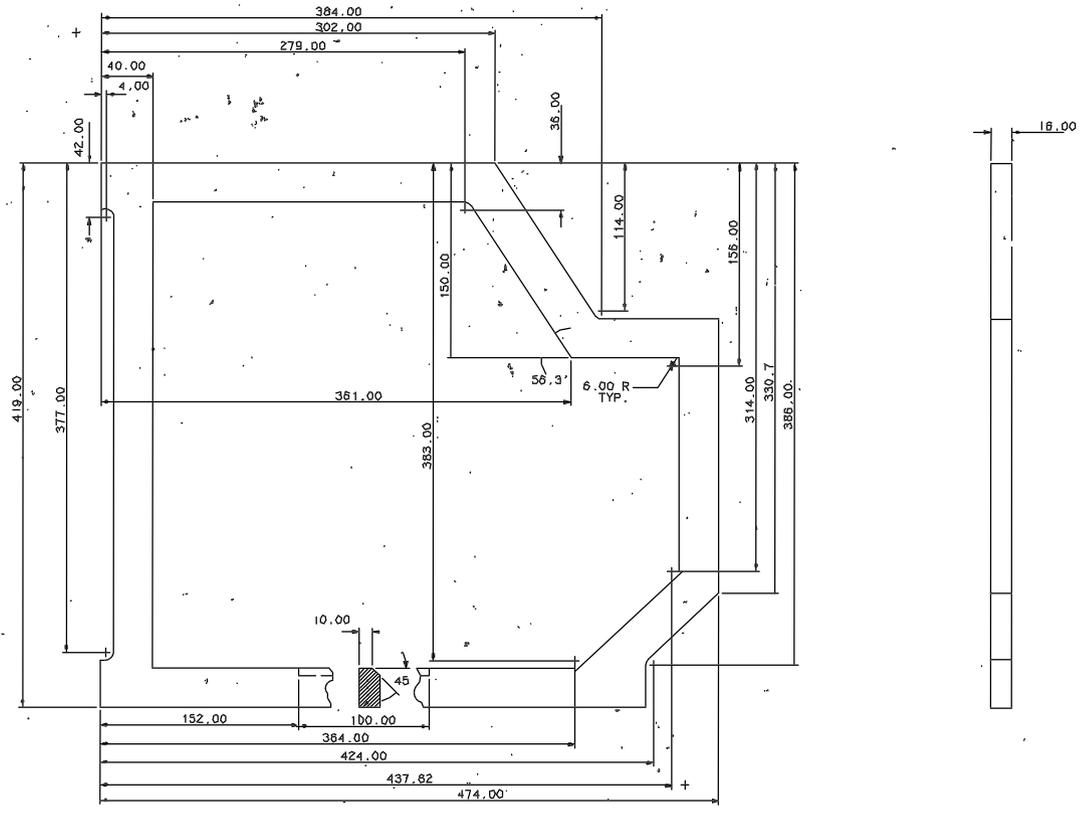
TITLE		
14 PLATE		
MATERIAL V/GS/000	SCALE 1:12	TOLERANCES IN mm
FINISH V/GS/000	REFER TO UNIT I OFF	BY R&G
DRN No. V/GS/000	REVISED BY R&G	DATE V/GS/014

Line 'a-g'



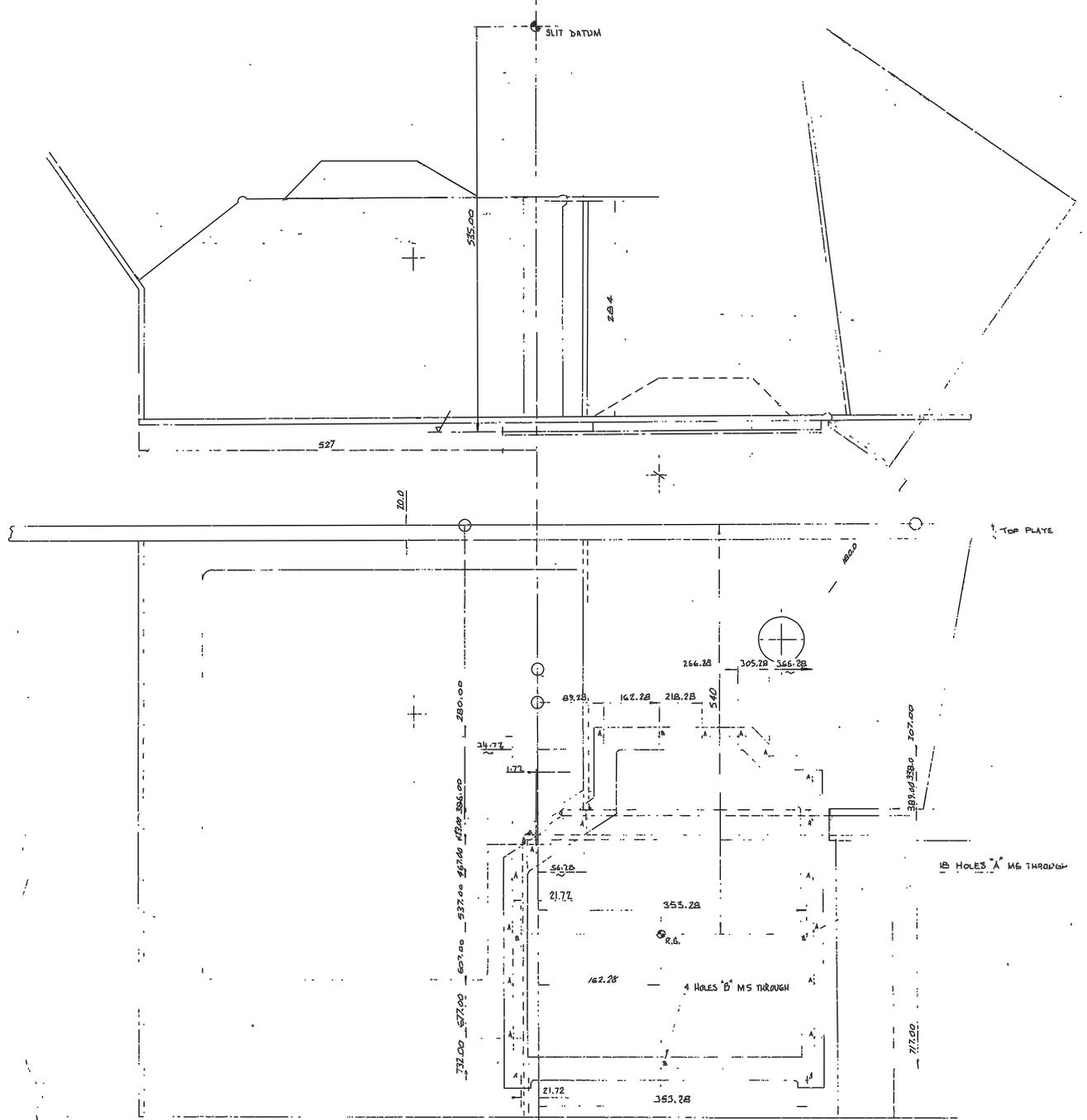
TITLE		
15 PLATE		
MATERIAL MS	SCALE 1:12	TOLERANCES IN mm
FINISH V/GS/000	REFER TO UNIT I OFF	BY R&G
DRN No. V/GS/000	REVISED BY R&G	DATE V/GS/015

Tolerances Unless otherwise stated										Material		Dimm. in m.m.		Scale		THIRD ANGLE PROJECTION		G.A. No.	
Issue	Mod No	Date	Drawn By	Issue	Mod No	Date	Drawn By	Steel	Alum.	1:12	1:12	1:12	1:12	ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HALLSHAM SUSSEX		Title 4.2 m 1515 - MAIN STRUCTURE DETAILS -		Drawing No. V/GS/013-15	



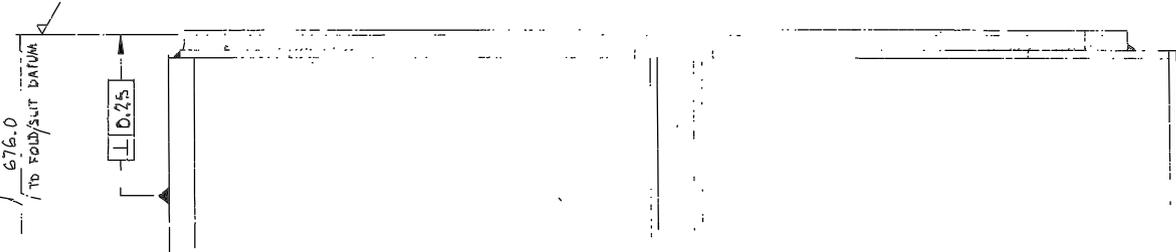
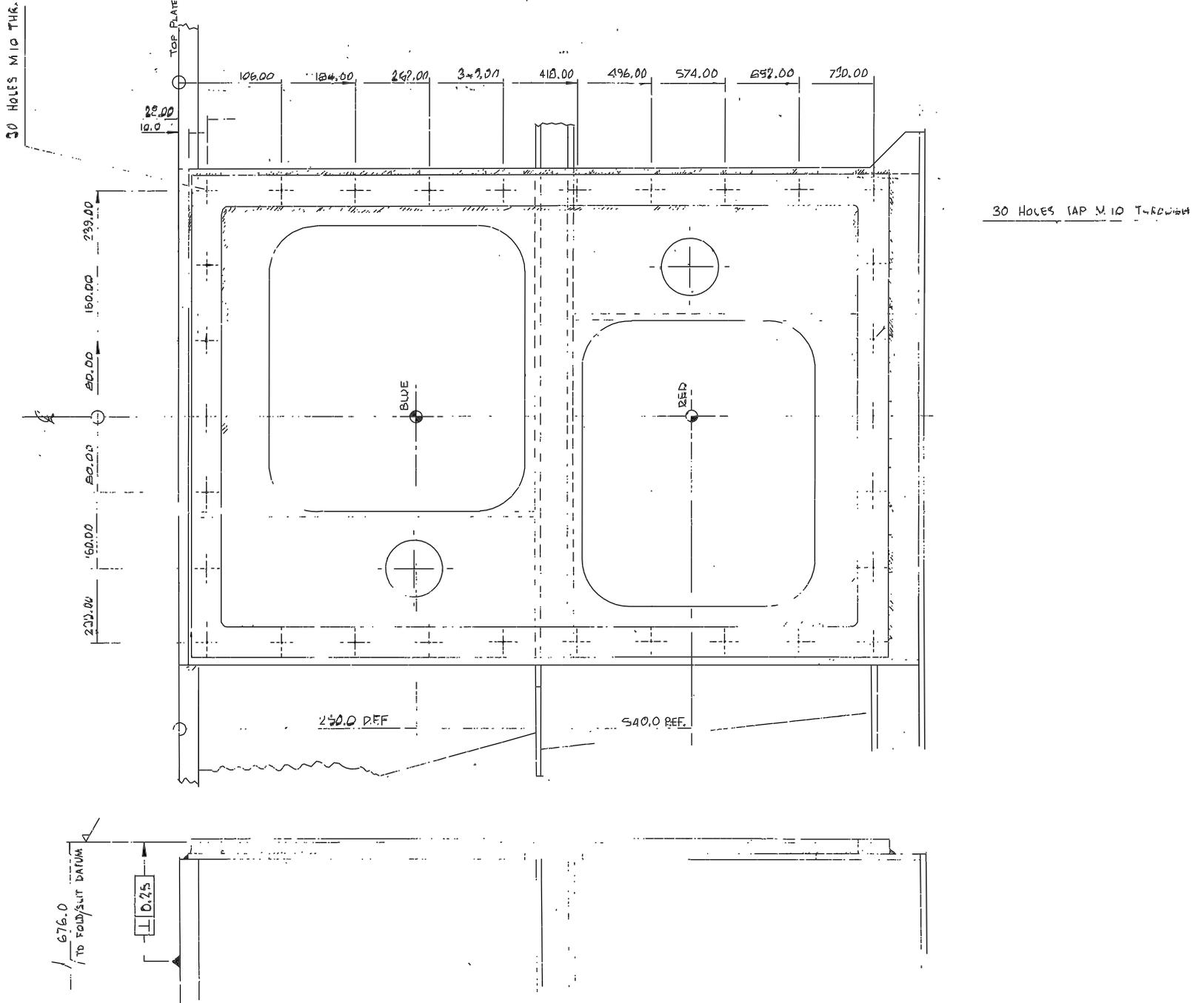
							Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale 0.5		THIRD ANGLE PROJECTION		GA No. V/GS7000	
							X +/-		M.S.		/		RDYAL GREENWICH OBSERVATORY		TITLE ISIS		Drawing No.	
							X.X +/-		Finish		Drg. No. No. Req.		HERSTMENCEUX CASTLE		RED GRATING FACE		W/GS/006	
							X.XX +/- 0.3				Used on W/GS/006 SHZ		HAILSHAM SUSSEX				<small>011</small>	
Issue	Mod. No.	Date	Drawn by	Issue	Mod. No.	Date	Drawn by	C. WEST										

Dwg. No.
V

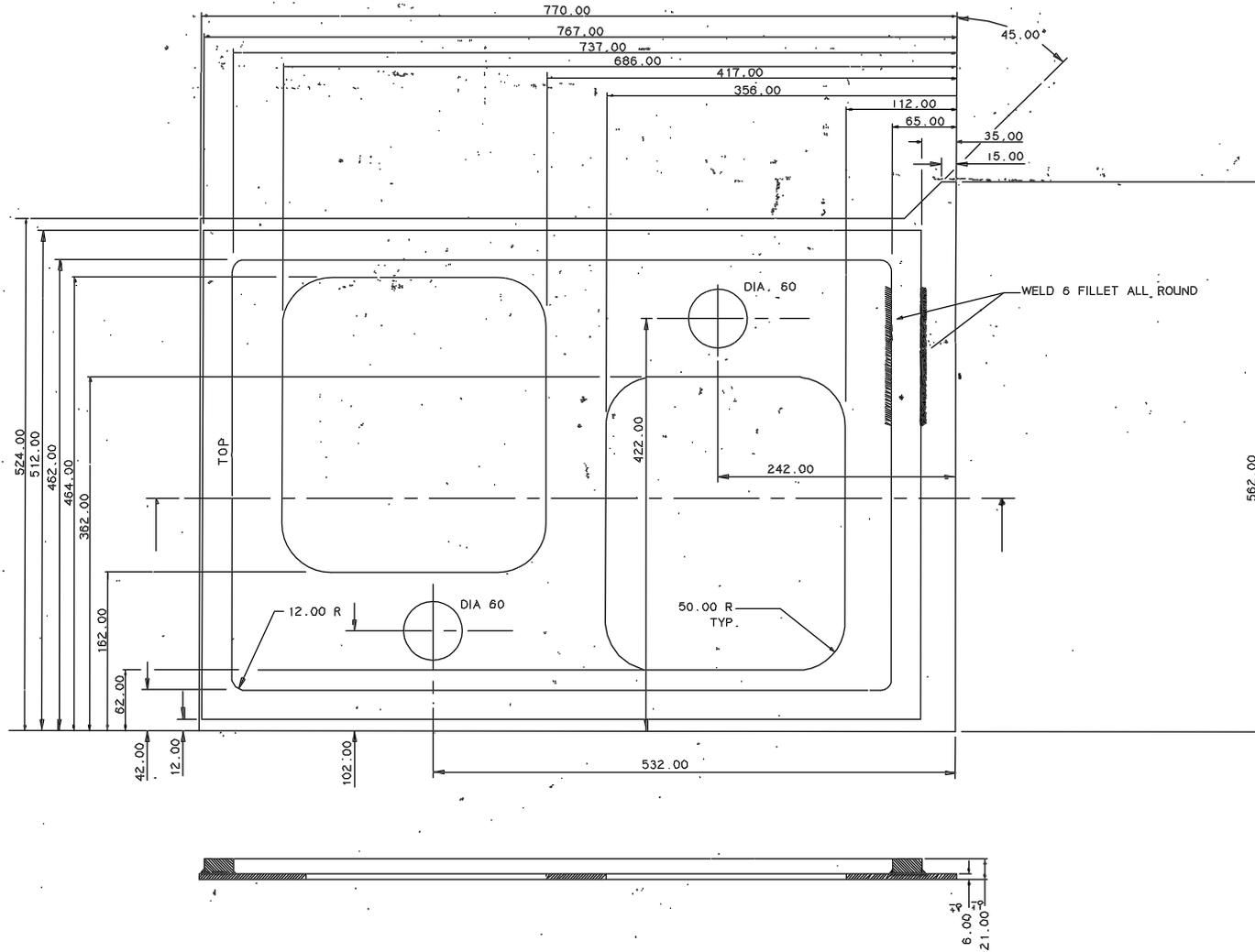


0.25

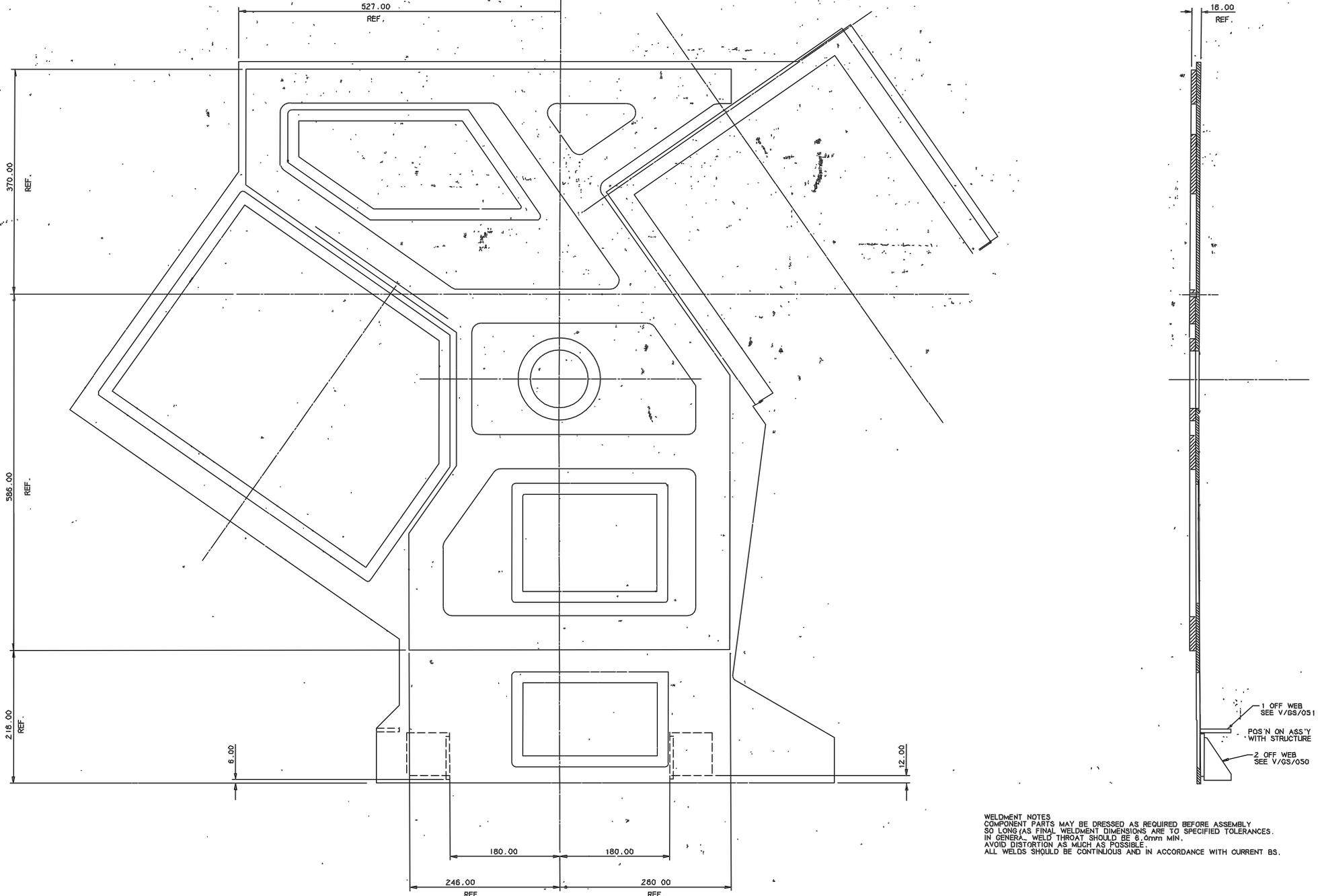
								Tolerances (Unless otherwise stated)		Material		Dimns. in m.m.		Scale 1/2		THIRD ANGLE PROJECTION		G.A. No.	
								X 1				ROYAL GREENWICH OBSERVATORY.		Title 1/515				Drawing No.	
				2/7/86 C WEST				X.X 2		Finish		Dwg. No. No. Rev.		ROYAL GREENWICH OBSERVATORY.		MAIN STRUCTURE 1/2" DET (RED GRATING)		V/GS/006 SH 1	
								X.XX 1		Used on 1/68/000		HALSHAM SUSSEX.						2/3	



				Tolerances (Unless otherwise stated)				Material	Dimms in m.m.		Scale 1/2	THIRD ANGLE PROJECTION		G.A. No.
				X ±				Finish	ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM		Title 1315 MAIN STRUCTURE M/G DET (COLL MFG. FAC)	Drawing No.		
Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By		Used on	SUSSEX.		W/GS/004		

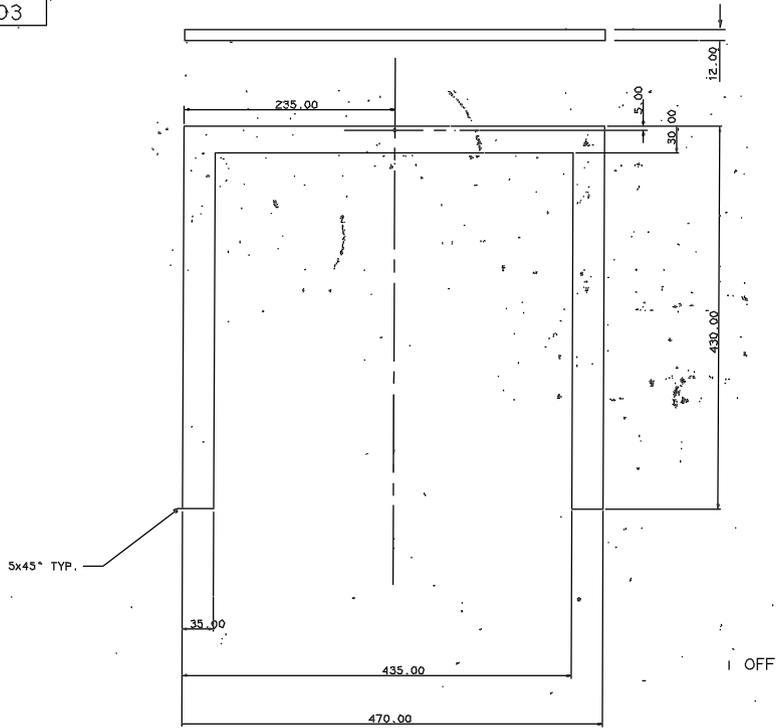


								Tolerance (Unless otherwise stated) X +/- 1.0 X.X +/- X.XX +/-	Material M. S.	Dimns. in m.m.	Scale 1/2	THIRD ANGLE PROJECTION	6A No. V/GS/000
Issue	Mod. No.	Date	Drawn by	Issue	Mod. No.	Date	Drawn by	Finish	Drwg. No.	No. Req.	ROYAL GREENWICH OBSERVATORY HERSTMONGUEUX CASTLE HAILSHAM SUSSEX	THE I.S.I.S.	Drawing No. SHT. 1 OF 2 W./GS/004



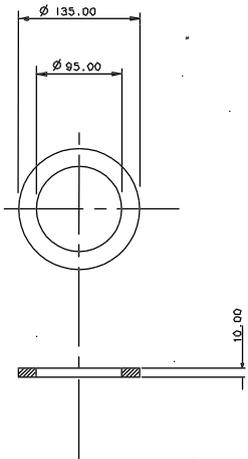
WELDMENT NOTES
COMPONENT PARTS MAY BE DRESSED AS REQUIRED BEFORE ASSEMBLY
SO LONG AS FINAL WELDMENT DIMENSIONS ARE TO SPECIFIED TOLERANCES.
IN GENERAL WELD THROAT SHOULD BE 6.0mm MIN.
AVOID DISTORTION AS MUCH AS POSSIBLE.
ALL WELDS SHOULD BE CONTINUOUS AND IN ACCORDANCE WITH CURRENT BS.

				TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL		DIM IN MM		SCALE 1 : 2		THIRD ANGLE PROJECTION		C.A. NO. V/GS/000	
				X.X +/-				SEE SHTS. 1 & 2		1 OFF		ROYAL GREENWICH OBSERVATORY		TITLE		DRG NO. SHT. 3 OF 3	
				X.XX +/- 0.5				FINISH		DRG NO. NO REQ		HERSTMONEUX CASTLE		4.2m ISIS - MAIN STRUCTURE.		V/GS/003	
				ISSUE MOD. NO. DATE DRAWN BY				USED ON				HAILSHAM EAST SUSSEX		BOTTOM PLATE ASS'Y			
				1 OCT, 86 AJW													

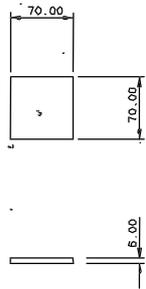


REMOVE ALL SHARP EDGES

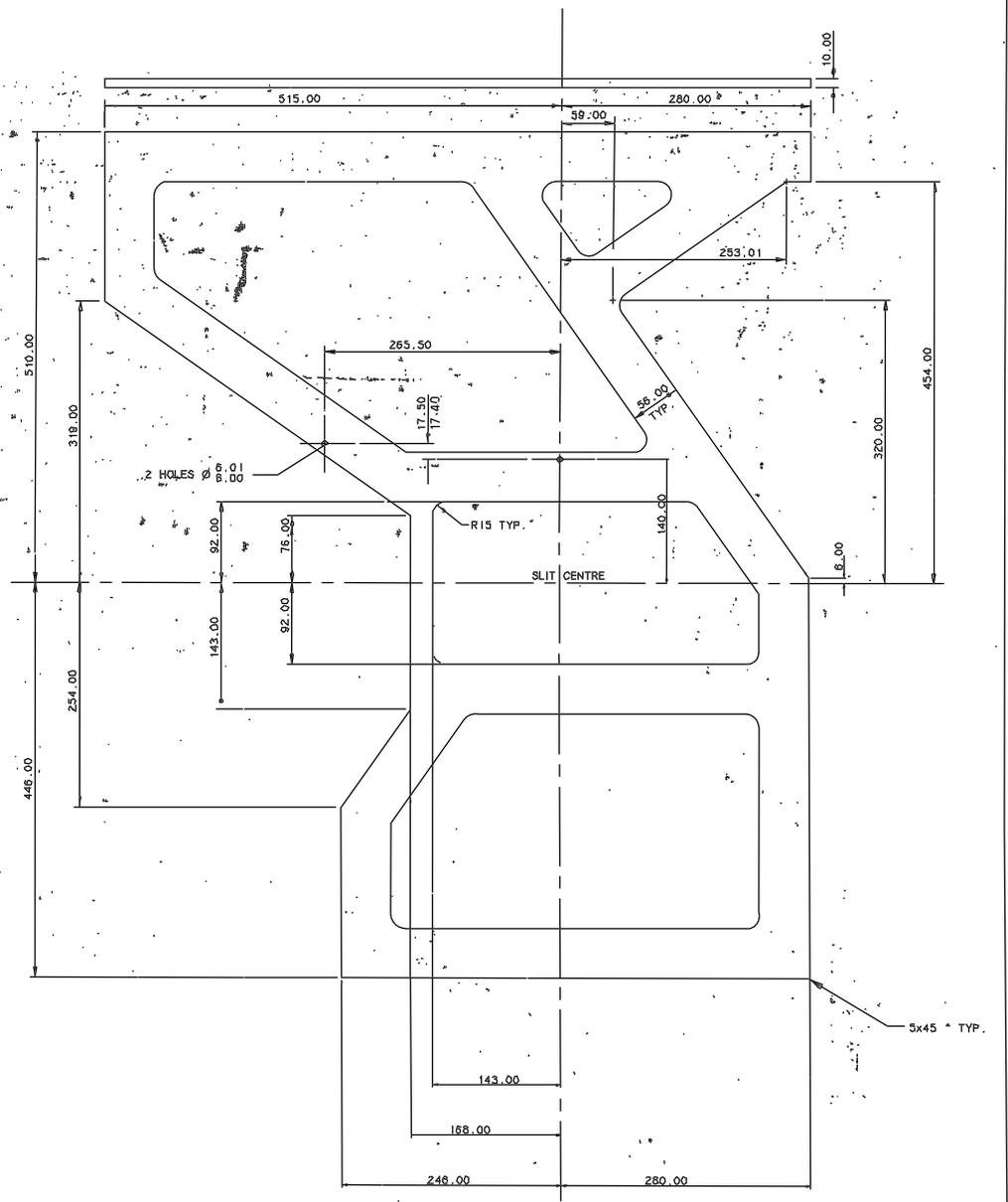
1 OFF



1 OFF



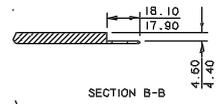
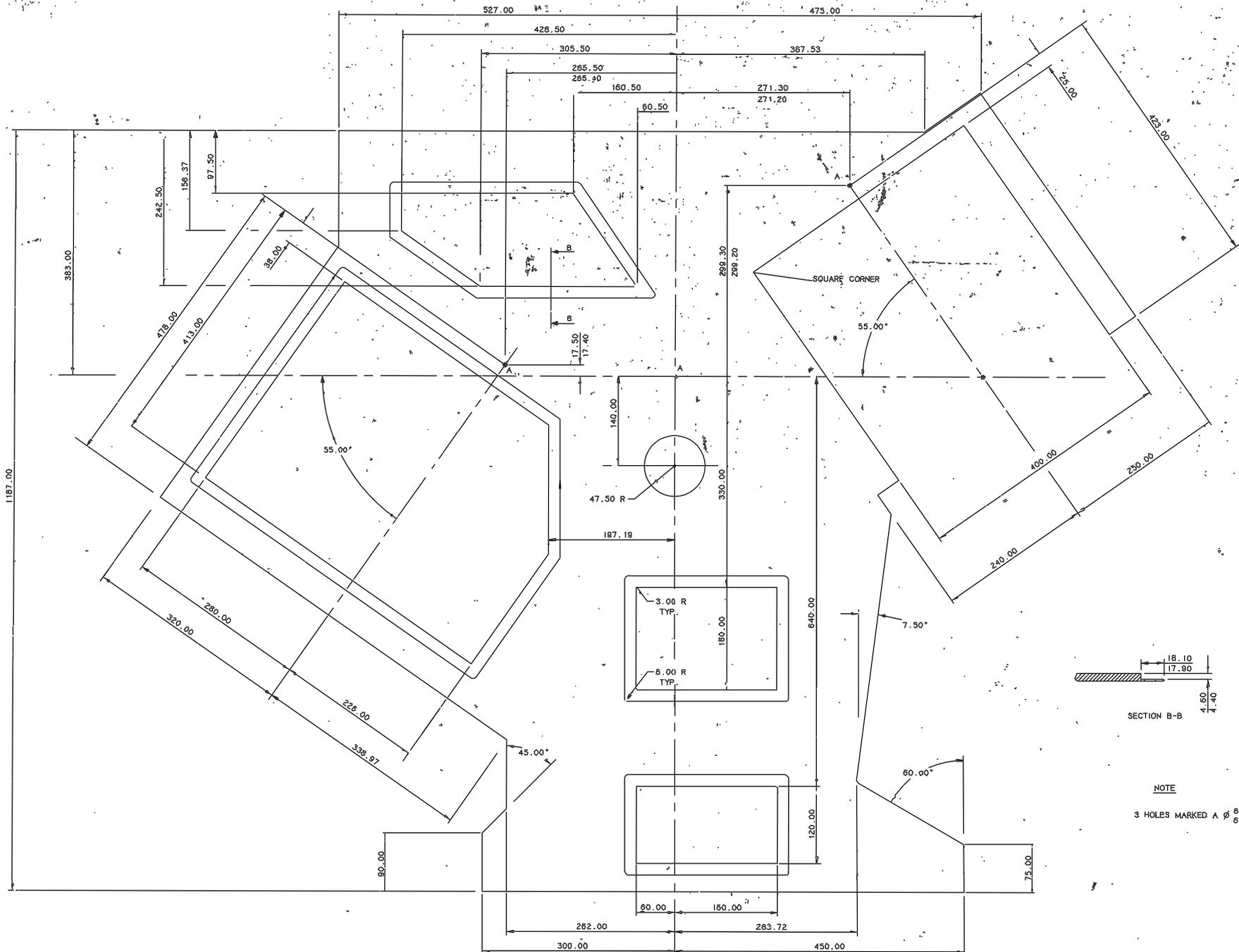
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REMOVE ALL SHARP EDGES

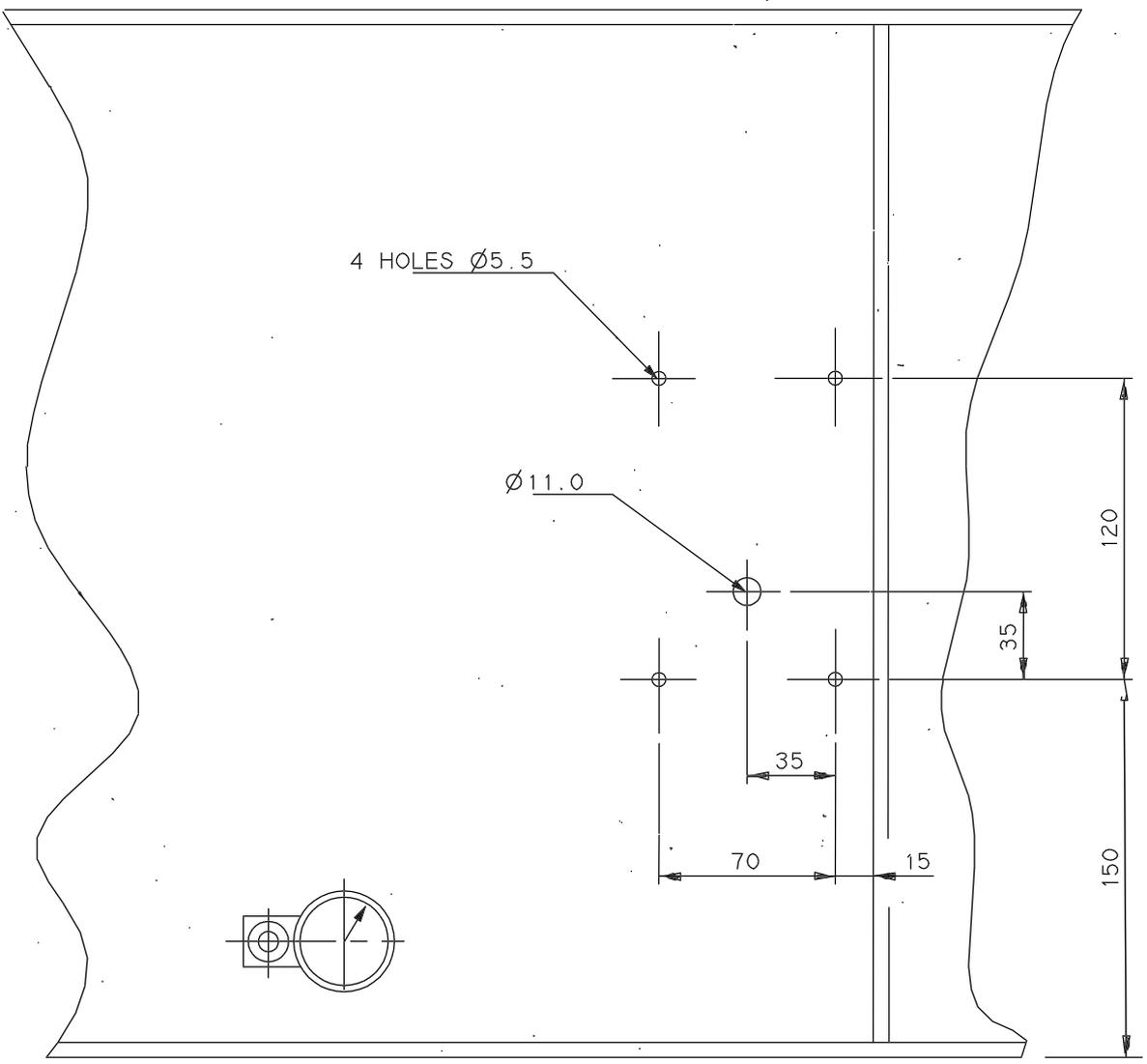
1 OFF

TOLERANCES (UNLESS OTHERWISE STATED)							MATERIAL		DIM IN MM		SCALE 1 : 2		THIRD ANGLE PROJECTION		G.A. NO. V/GS/000	
X:XX	±						MILD STEEL									
X:XX	±						FINISH	SEE DRG.	ROYAL GREENWICH OBSERVATORY	ROYAL GREENWICH OBSERVATORY		TITLE		DRG NO. SHT. 2 OF 3		
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	USED ON	HERSTMONCEUX CASTLE	HAILSHAM EAST SUSSEX		4.2m ISIS - MAIN STRUCTURE BOTTOM PLATE		V/GS/003		
				1		OCT.86	DWG						PLATE DETAILS FOS & CAMERA INTERFACE			



NOTE
3 HOLES MARKED A ϕ 6.01
6.00

TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL S77M MILD STEEL		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		G.A. NO V/GS/000	
2				1 OFF		ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE, HAILSHAM EAST SUSSEX		TITLE 4.2m ISIS - MAIN STRUCTURE BOTTOM PLATE		DRG NO. NO REQ		DRG NO. SH. 1 OF 3	
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	X.XX /- I		FINISH		USED ON	
				1		OCT. 86	DWG					V/GS/003	
				2		MAY 87	AJW						

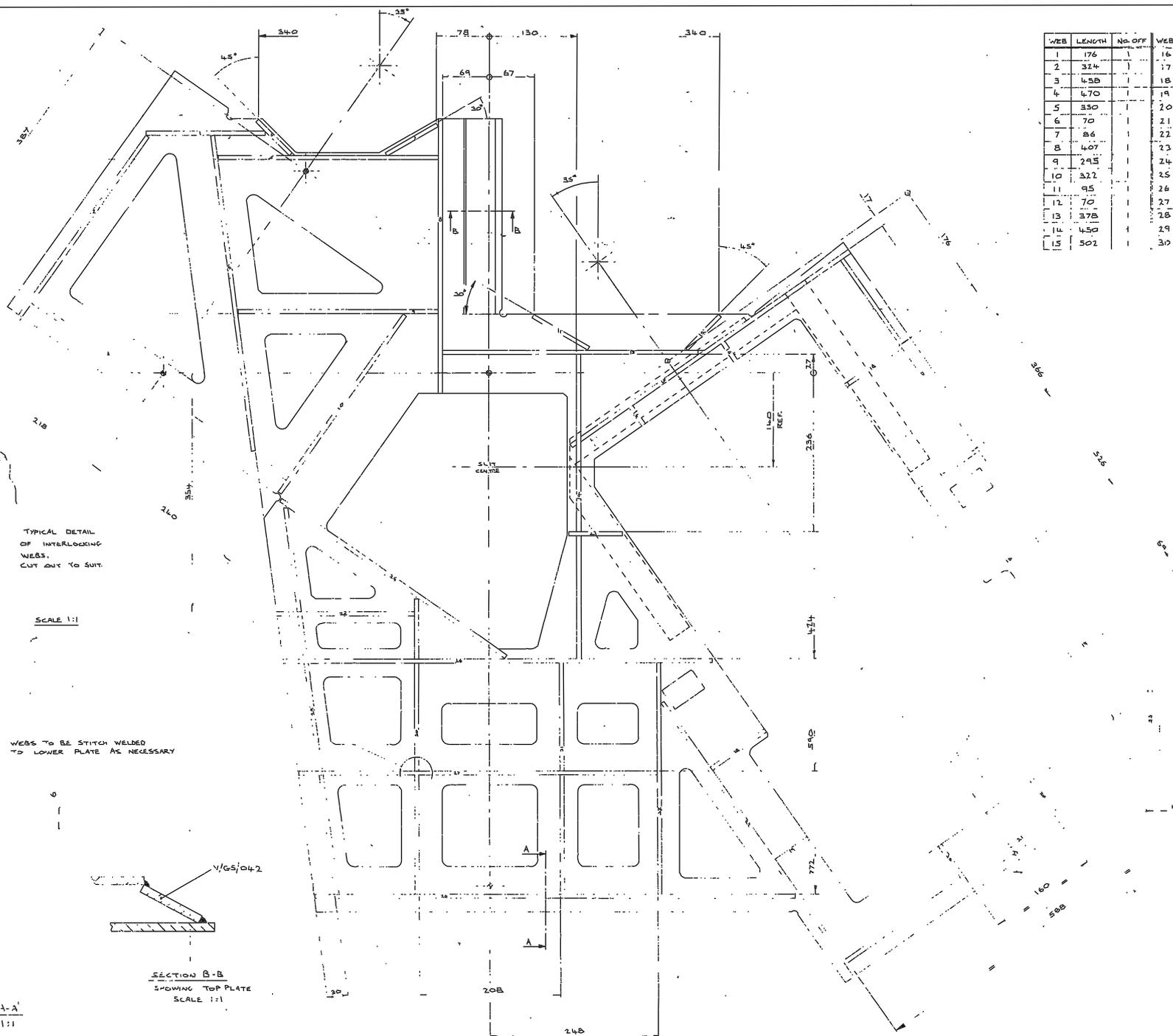


SKETCH TO SHOW POSITION
OF SHUTTER OVERLIE

NOT TO SCALE

								Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale 1:1		THIRD ANGLE PROJECTION			GA No.	
								X +/-		Finish		ROYAL GREENWICH OBSERVATORY				Title			Drawing No.	
								X.X +/-		Used on		HERSTMONCEUX CASTLE				4.2m ISIS STRUCTURE - DETAIL			W/GS/066	
								X.XX +/-				HAILSHAM SUSSEX								
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by													
				1		NOV. 88	AJW													

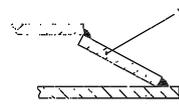
WEB	LENGTH	No. OFF	WEB	LENGTH	No. OFF	WEB	LENGTH	No. OFF
1	176	1	16	32	2	31	342	1
2	324	1	17	676	1	32	342	1
3	458	1	18	98	4	33	90	1
4	470	1	19	58	2	34		
5	330	1	20	56	2	35		
6	70	1	21	588	1	36		
7	86	1	22	490	1	37		
8	407	1	23	80	4	38		
9	245	1	24	405	1	39		
10	372	1	25	202	1	40		
11	95	1	26	635	1	41		
12	70	1	27	530	1	42		
13	378	1	28	708	1	43		
14	450	1	29	576	1	44		
15	502	1	30	436	1	45		



TYPICAL DETAIL OF INTERLOCKING WEBS. CUT OUT TO SUIT.

SCALE 1:1

WEBS TO BE STITCH WELDED TO LOWER PLATE AS NECESSARY

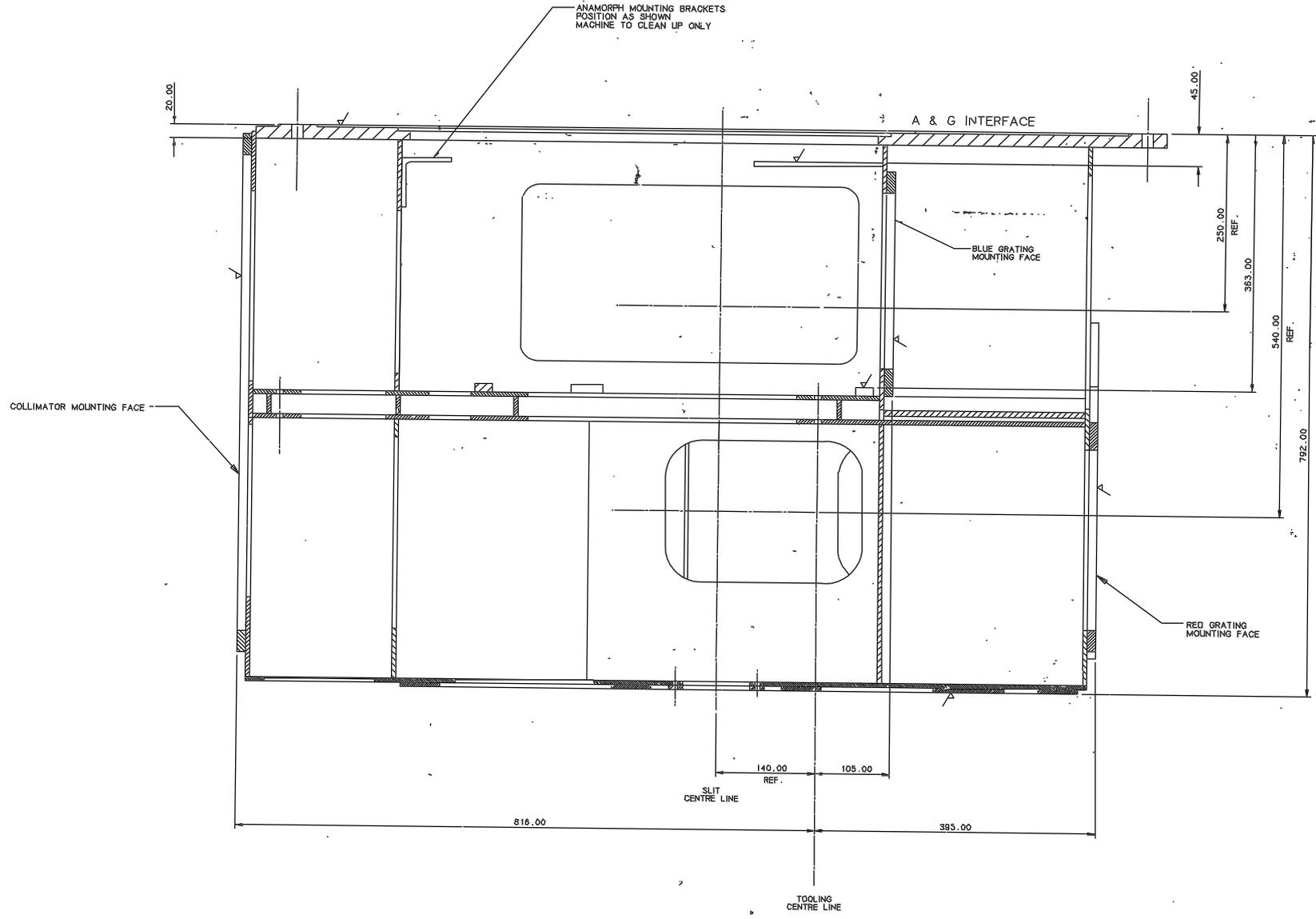


SECTION B-B
SHOWING TOP PLATE
SCALE 1:1

SECTION A-A
SCALE 1:1

								Tolerances (Unless otherwise stated)	Material: MILD STEEL FABRICATION	1 OFF	Dim's. in m.m.	Scale 1:2	THIRD ANGLE PROJECTION	GA No V/C3/000
								X 1:1	Finish	Dwg. No.	No. Rec.	ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM SUSSEX.	Title: 4.2 m ISIS - MAIN STRUCTURE CENTRE PLATE - WEB POSITIONING	Drawing No. SHT. 3 of 3
Issued	Mod No	Date	Drawn By	Issue	Mod No	Date	Drawn By	XXX L	Used on				V/GS/001	

MACHINING NOTE
MACHINE WHERE INDICATED ON DRAWING
SURFACE FINISH 1.6 MICROMETRES CLA.
DEGREASE, PHOSPHATE TO DET. 23. MASK MACHINED AREAS
AND SPRAY TWO COATS OF RED OXIDE PRIMER.
REMOVE MASKS TO MACHINED AREAS AND TREAT WITH RUST PREVENTATIVE.

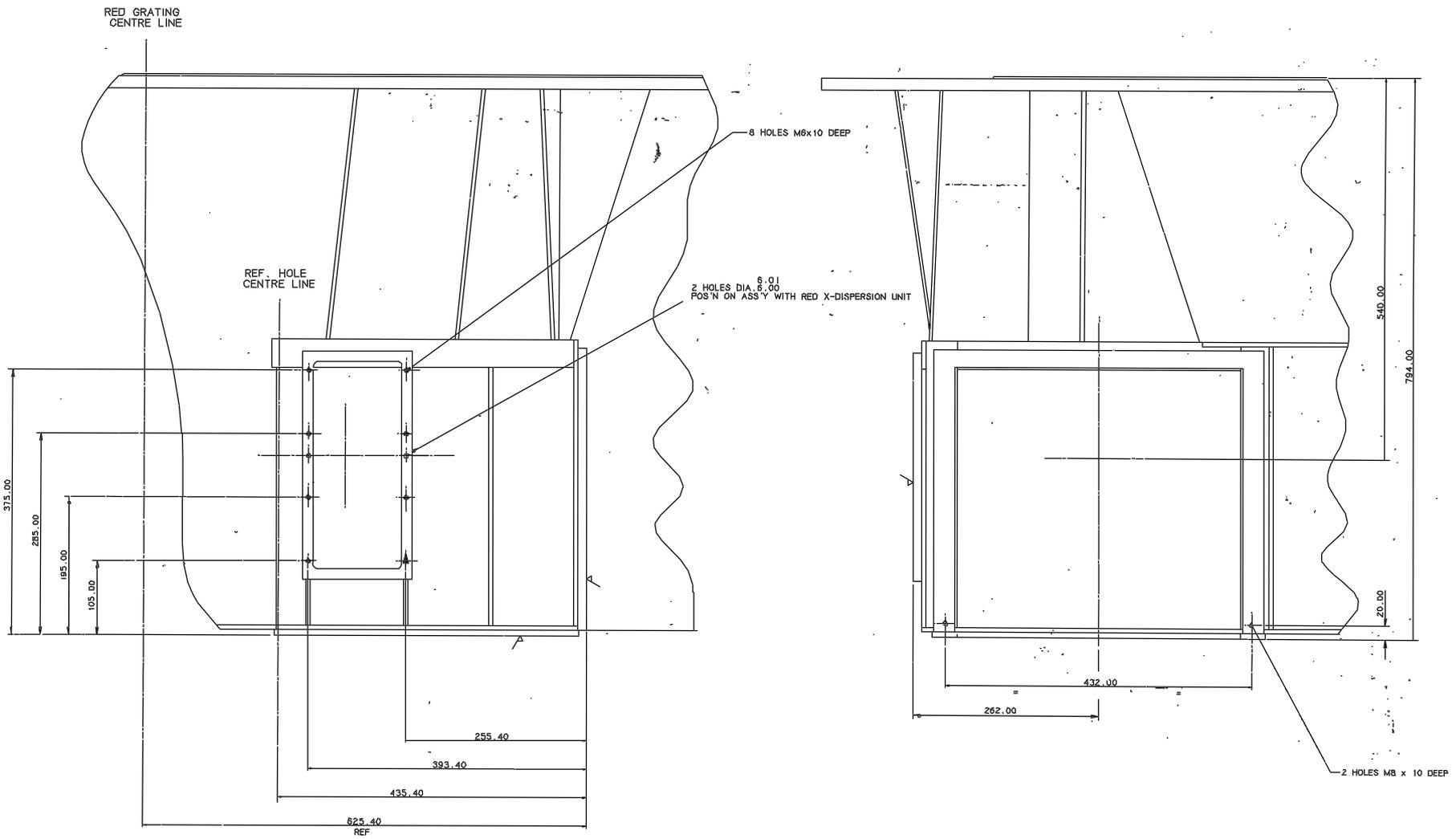


SECTION X-X
SEE SHT. 3

SECTION THRU. CENTRE LINE OF CASE

				1		OCT. 86	AJW	TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	DIM IN MM	SCALE 1:2	THIRD ANGLE PROJECTION	G.A. NO.
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	±.x ✓ x.xx ✓ 0.1	FINISH	DRG NO.	NO REQ	ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM EAST SUSSEX	DRG NO. SHT. 8 OF 9
												TITLE 4.2m ISIS - MAIN STRUCTURE FABRICATION & MACHINING DETAILS	V/GS/000

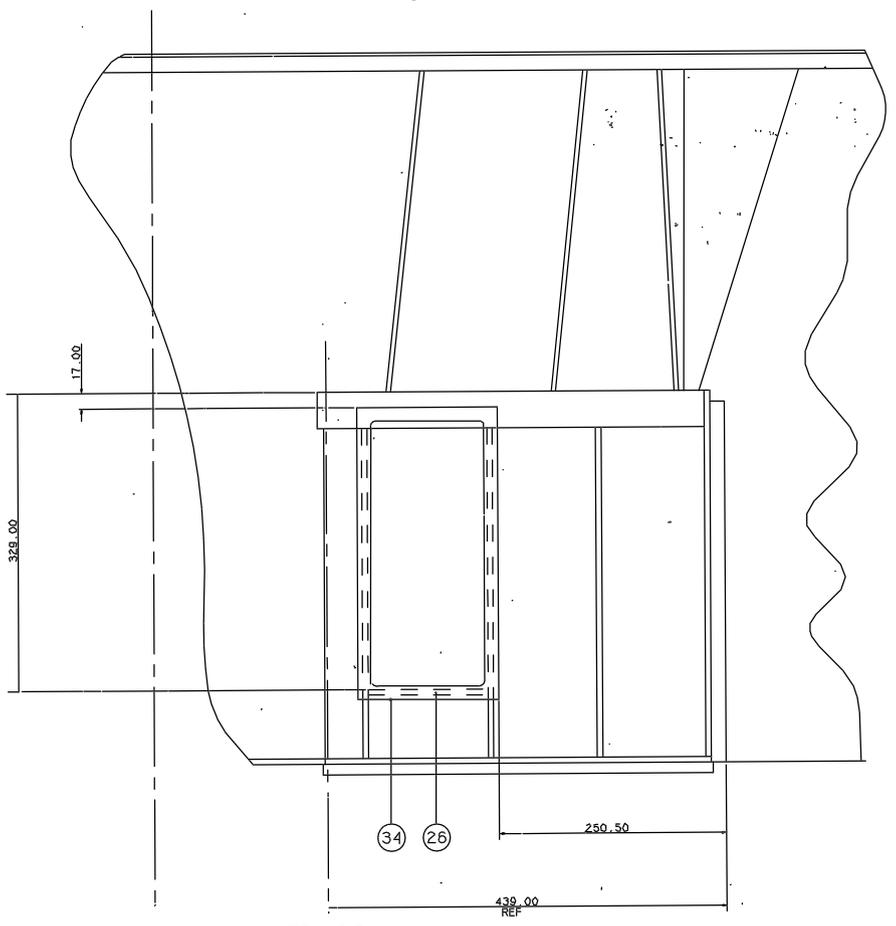
MACHINING NOTE
MACHINE WHERE INDICATED ON DRAWING
SURFACE FINISH 1.6 MICROMETRES CLA
DEGREASE, PHOSPHATE TO DET. 29, MASK MACHINED AREAS
AND SPRAY TWO COATS OF RED OXIDE PRIMER.
REMOVE MASKS TO MACHINED AREAS AND TREAT WITH RUST PREVENTATIVE.



VIEW ON RED CAMERA AND X - DISPERSION
MOUNTING FACES

							TOLERANCES (UNLESS OTHERWISE STATED)		MATERIAL		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		G.A. NO.	
							X ± 0.1		FINISH		DRG NO.		NO. REQ		TITLE		DRG NO. SH1.7 OF 9	
							XX ± 0.1		ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM		USED ON		4.2m ISIS - MAIN STRUCTURE MACHINING DETAIL		V/GS/000			
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY											
				I		SEPT. 86	AJW											

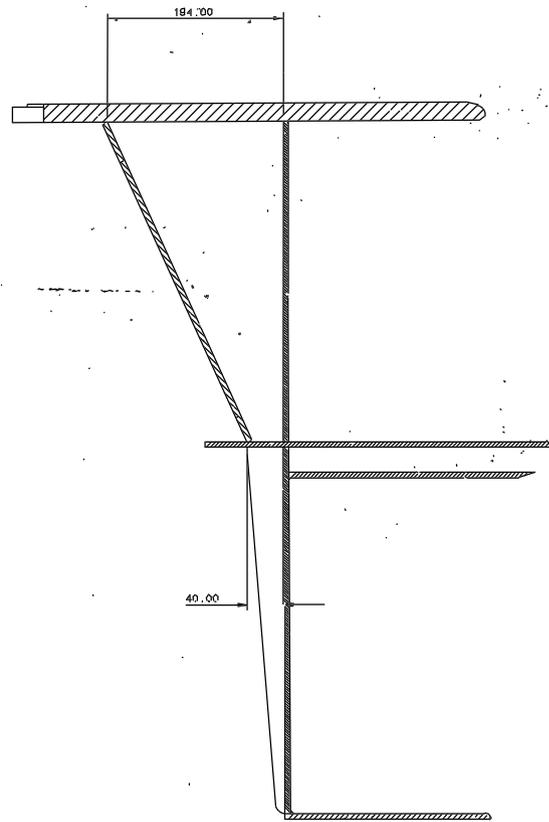
WELDMENT NOTES
 COMPONENT PARTS MAY BE DRESSED AS REQUIRED BEFORE ASSEMBLY
 SO LONG AS FINAL WELDMENT DIMENSIONS ARE TO SPECIFIED TOLERANCES.
 IN GENERAL WELD THROAT SHOULD BE 6.0mm MIN.
 AVOID DISTORTION AS MUCH AS POSSIBLE.
 ALL WELDS SHOULD BE CONTINUOUS AND IN ACCORDANCE WITH CURRENT BS.
 COMPLETE WELDMENT STRESS RELIEVED, HEAT TO 650°C AND
 SOAK FOR 45 MINS. COOL SLOWLY
 SHOT BLAST AND IF NECESSARY DRESS CLEAN.



RED GRATING CENTRE LINE
REF. HOLE CENTRE LINE

VIEW ON ARROW C
SEE SHT. 2

RED CAMERA & X-DISPERSION
MOUNTING FACES



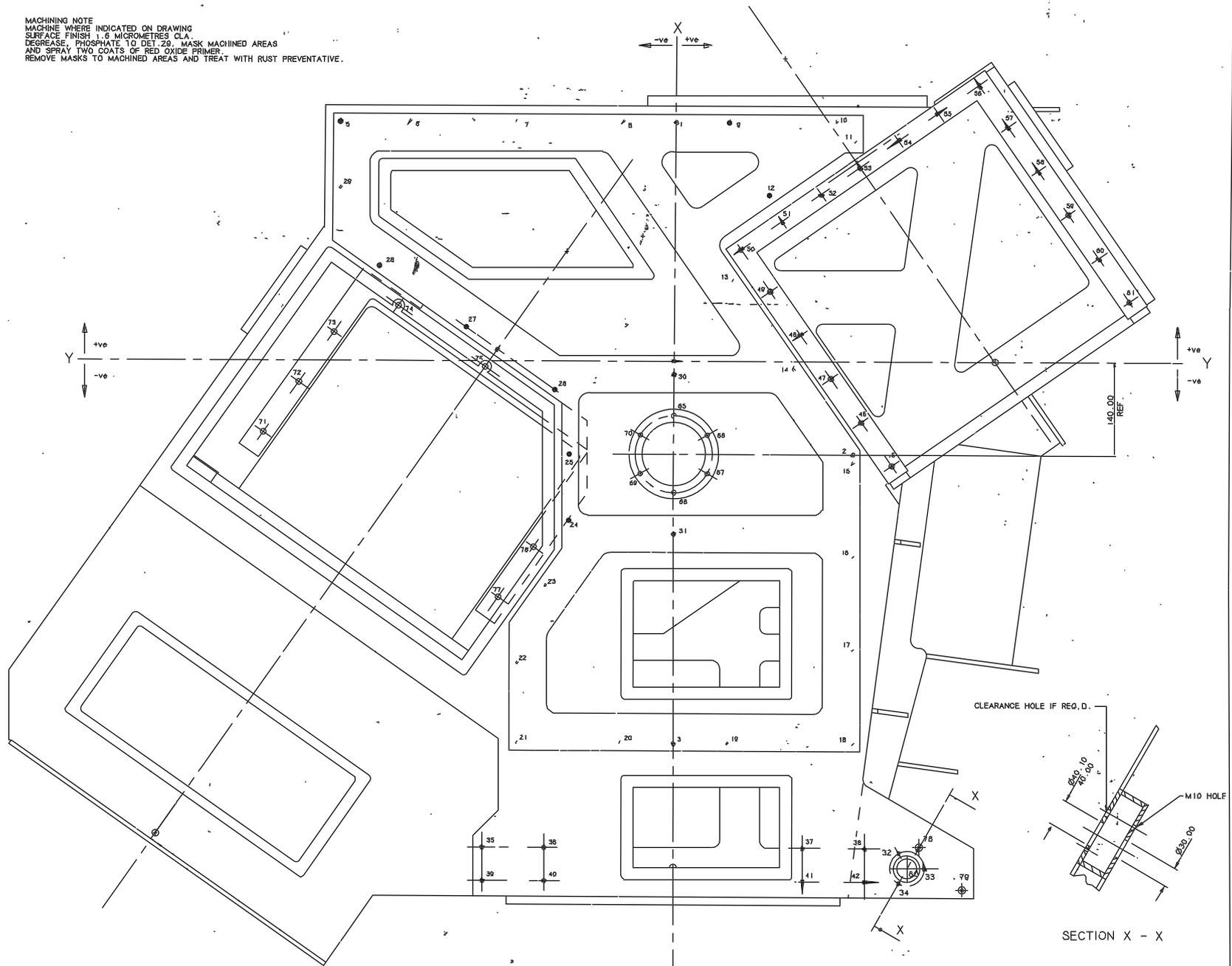
SECTION B-B
SEE SHT. 1

								TOLERANCES (UNLESS OTHERWISE STATED)		MATERIAL		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		G.A. NO.	
								X	±							ROYAL GREENWICH OBSERVATORY		DRG NO. SHT. 8 OF 9	
								X.X	±							HERSTMONCEUX CASTLE		V/GS/000	
								X.XX	± 0.5	FINISH		DRG NO.		NO REG		HAILSHAM EAST SUSSEX			
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	USED ON											
				1		SEPT. 86	AJW												

DRG NO. SHT. 5 OF 9
V/GS/000

MACHINING NOTE
MACHINE WHERE INDICATED ON DRAWING
SURFACE FINISH 1.6 MICROMETRES CLA.
DEGREASE, PHOSPHATE TO DET. 29, MASK MACHINED AREAS
AND SPRAY TWO COATS OF RED OXIDE PRIMER
REMOVE MASKS TO MACHINED AREAS AND TREAT WITH RUST PREVENTATIVE.

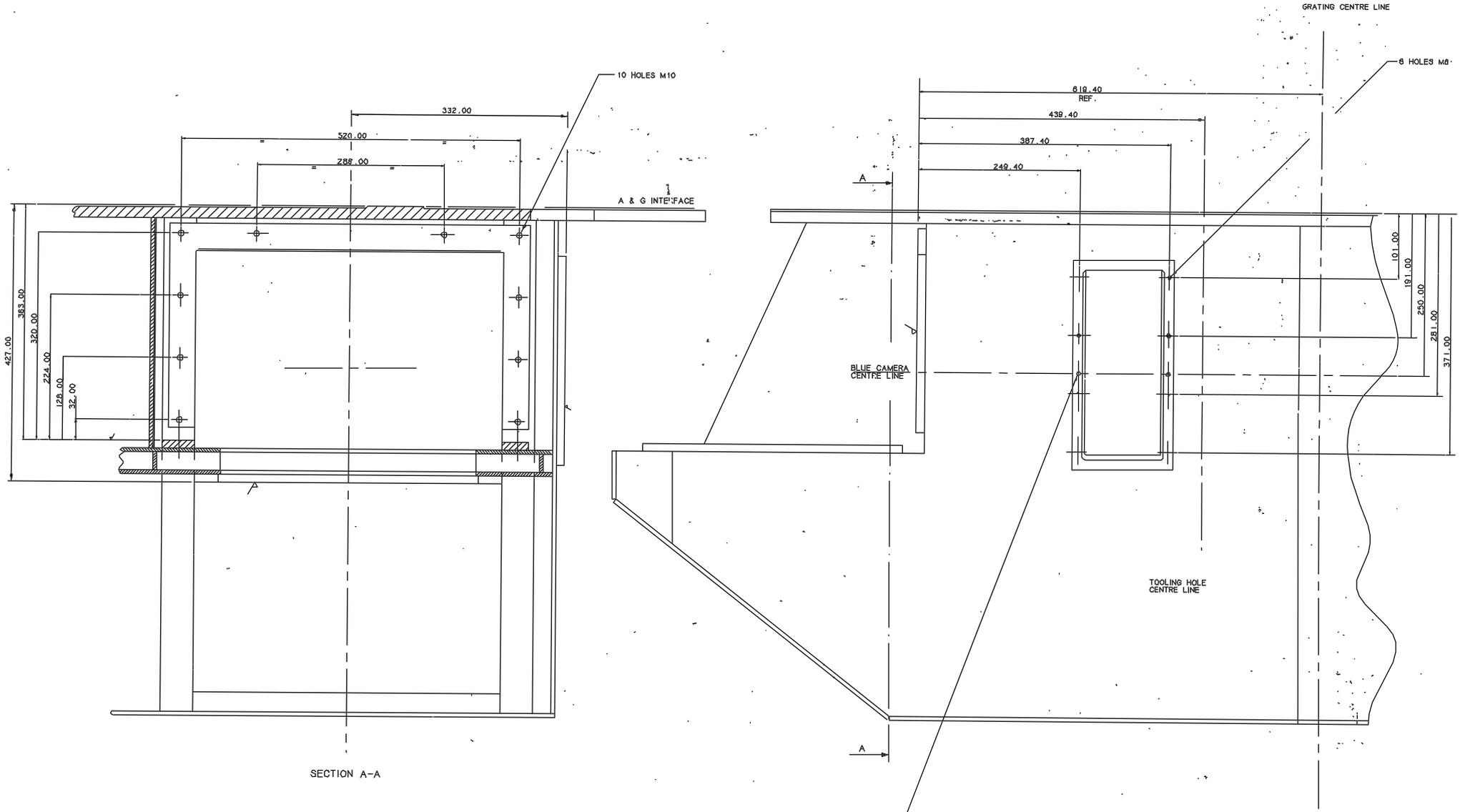
HOLE	SIZE	DATUM "X"	DATUM "Y"
1	Ø6.00 DOWEL HOLE		
2	"		
3	"		
4	"		
5	M8 THRU.	-504.0	+359.0
6	"	-400.0	+359.0
7	"	-240.0	+359.0
8	"	-80.0	+359.0
9	"	+80.0	+359.0
10	"	+240.0	+359.0
11	"	+288.0	+330.0
12	"	+141.0	+260.0
13	"	+87.0	+120.0
14	"	+170.0	-11.0
15	"	+268.0	-184.0
16	"	+258.0	-294.0
17	"	+268.0	-434.0
18	"	+268.0	-575.0
19	"	+80.0	-575.0
20	"	-80.0	-575.0
21	"	-235.0	-575.0
22	"	-235.0	-455.0
23	"	-193.0	-339.0
24	"	-157.0	-240.0
25	"	-157.0	-140.0
26	"	-170.0	-43.0
27	"	-313.0	+81.0
28	"	-444.0	+143.0
29	"	-504.0	+299.0
30	"	0.0	-20.0
31	"	0.0	-260.0
32	"	+337.0	-737.8
33	"	+378.0	-760.0
34	"	+337.0	-782.8
35	"	-286.5	-731.0
36	"	-193.5	-731.0
37	"	+193.5	-731.0
38	"	+289.5	-731.0
39	"	-286.5	-781.0
40	"	-193.5	-781.0
41	"	+193.5	-781.0
42	"	+288.5	-781.0
43	"		
44	"		
45	M8 THRU.	+326.9	+156.7
46	"	+281.0	-81.1
47	"	+235.1	-25.6
48	"	+189.2	+39.9
49	"	+143.3	+105.5
50	"	+99.2	+188.5
51	"	+159.8	+211.0
52	"	+218.8	+252.3
53	"	+276.1	+292.4
54	"	+333.5	+332.6
55	"	+392.4	+373.9
56	"	+453.1	+416.3
57	"	+497.2	+353.2
58	"	+343.1	+287.7
59	"	+589.0	+222.2
60	"	+634.9	+158.6
61	"	+680.8	+91.1
62	"		
63	"		
64	"		
65	Ø7.00 THRU.	0.0	-82.0
66	"	+50.2	-111.0
67	"	+50.2	-169.0
68	"	0.0	-168.0
69	"	-50.2	-169.0
70	"	-50.2	-111.0
71	M10 THRU.	-816.8	-107.8
72	"	-564.0	-32.3
73	"	-511.3	+43.1
74	"	-414.9	+83.1
75	"	-283.9	-8.7
76	"	-210.2	-280.1
77	"	-262.9	-355.4
78	"	+368.2	-728.2
79	"	+431.8	-791.8
80	SEE SECTION X - X	+350.0	-760.0



PLAN VIEW ON UNDERSIDE
TOP PLATE V/GS/002 NOT SHOWN

TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		G.A. NO.	
X	X	X	X										
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	DRG NO.	NO REG	ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE, HAILSHAM EAST SUSSEX	TITLE	4.2m ISIS - MAIN STRUCTURE MACHINING DETAIL	DRG NO. SHT. 5 OF 9 V/GS/000

MACHINING NOTE
MACHINE WHERE INDICATED ON DRAWING
SURFACE FINISH 1.6 MICROMETRES CLA
DEGREASE, PHOSPHATE TO DET. 20, MASK MACHINED AREAS
AND SPRAY TWO COATS OF RED OXIDE PRIMER.
REMOVE MASKS TO MACHINED AREAS AND TREAT WITH RUST PREVENTATIVE.



2 HOLES DIA. 6.01 POS'N ON ASS'Y WITH X-DISPERSION UNIT V/GF/000

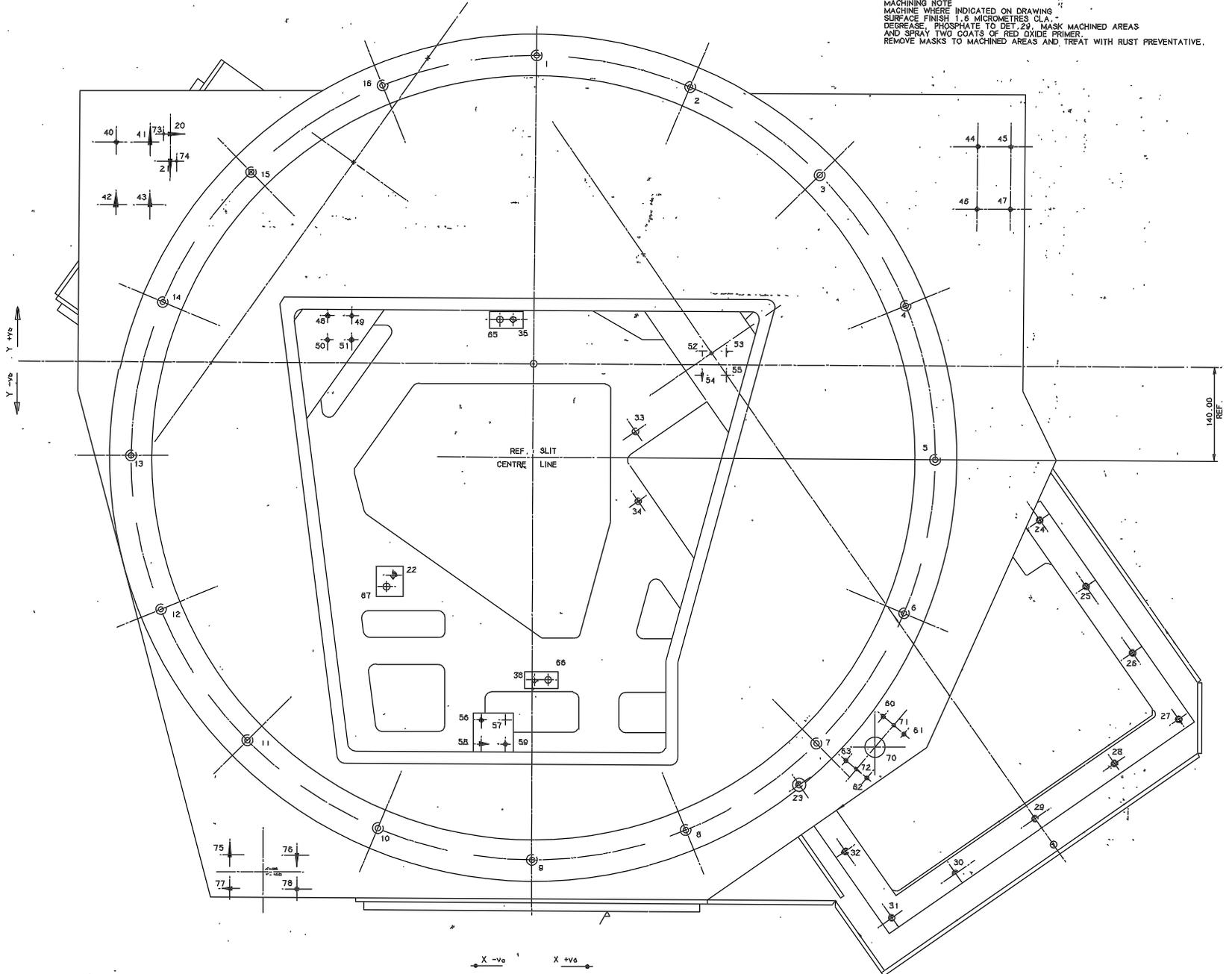
VIEW ON ARROW E
SEE SHT. 1

MACHINING DETAIL BLUE CAMERA & X - DISPERSION MOUNTING FACES

								TOLERANCES UNLESS OTHERWISE STATED		MATERIAL		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		G.A. NO.	
								X.XX +/- 0.1				ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM EAST SUSSEX				TITLE 4.2m 1SIS - MAIN STRUCTURE MACHINING DETAIL		DRG NO. SHT. 4 OF 9	
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY			USED ON						V/GS/000			
				I		SEPT 85	AJW												

MACHINING NOTE
MACHINE WHERE INDICATED ON DRAWING
SURFACE FINISH 1.6 MICROMETRES CLA.
DEGREASE, PHOSPHATE TO DET. 20, MASK MACHINED AREAS
AND SPRAY TWO COATS OF RED OXIDE PRIMER.
REMOVE MASKS TO MACHINED AREAS AND TREAT WITH RUST PREVENTATIVE.

HOLE	SIZE	DATUM-X	DATUM-Y
1	M16 THRU.	0	+460.0
2	"	+229.6	+414.3
3	"	+424.3	+284.3
4	"	+554.3	+89.6
5	"	+800.0	-140.0
6	"	+554.3	-369.6
7	"	+424.3	-664.3
8	"	+229.6	-884.3
9	"	0	-740.0
10	"	-229.6	-664.3
11	"	-424.3	-564.3
12	"	-554.3	-369.6
13	"	-600.0	-140.0
14	"	-554.3	+89.6
15	"	-424.3	+284.3
16	"	-229.6	+414.3
17			
18			
19			
20	M6 THRU.	-545.0	+340.0
21	"	-545.0	+300.0
22	M10 THRU.	-208.0	-317.0
23	"	+398.8	-829.9
24	"	+755.7	-229.3
25	"	+824.6	-327.5
26	"	+893.4	-425.9
27	"	+982.2	-524.2
28	"	+887.2	-590.8
29	"	+749.3	-673.4
30	"	+631.3	-798.0
31	"	+538.3	-822.5
32	"	+467.4	-724.2
33	"	+152.8	-100.5
34	"	+157.4	-204.7
35	"	-31.0	+86.0
36	"	+4.0	-472.0
37			
38			
39			
40	M6 THRU.	-625.0	+327.5
41	"	-575.0	+327.5
42	"	-825.0	+234.5
43	"	-575.0	+234.5
44	"	+659.0	+327.5
45	"	+709.0	+327.5
46	"	+659.0	+234.5
47	"	+709.0	+234.5
48	"	-308.0	+70.5
49	"	-272.0	+70.5
50	"	-308.0	+34.5
51	"	-272.0	+34.5
52	"	+252.0	+20.5
53	"	+289.0	+20.5
54	"	+252.0	-15.5
55	"	+288.0	-15.5
56	"	-75.5	-532.0
57	"	-39.5	-532.0
58	"	-75.5	-588.0
59	"	-39.5	-588.0
60	"	+523.8	-523.4
61	"	+554.5	-549.1
62	"	+499.2	-615.0
63	"	+468.5	-589.3
64			
65	Ø10.00/10.01 THRU.	-51.00	+66.00
66	"	+24.00	-472.00
67	"	-218.00	-334.00
68			
69			
70	Ø30.00 THRU.	511.5	-560.2
71	Ø5.00/5.01 THRU.	POS. N ON ASS'Y	
72	"	WITH W/GS/060	
73	Ø3.00/3.01 x 6 DEEP	POS. N ON ASS. Y	
74	"	WITH W/GS/082	
75	M6 THRU.	-450.0	-735.0
76	"	-350.0	-735.0
77	"	-450.0	-785.0
78	"	-350.0	-785.0
79			
80			



PLAN VIEW TOP HOLE POSITIONING

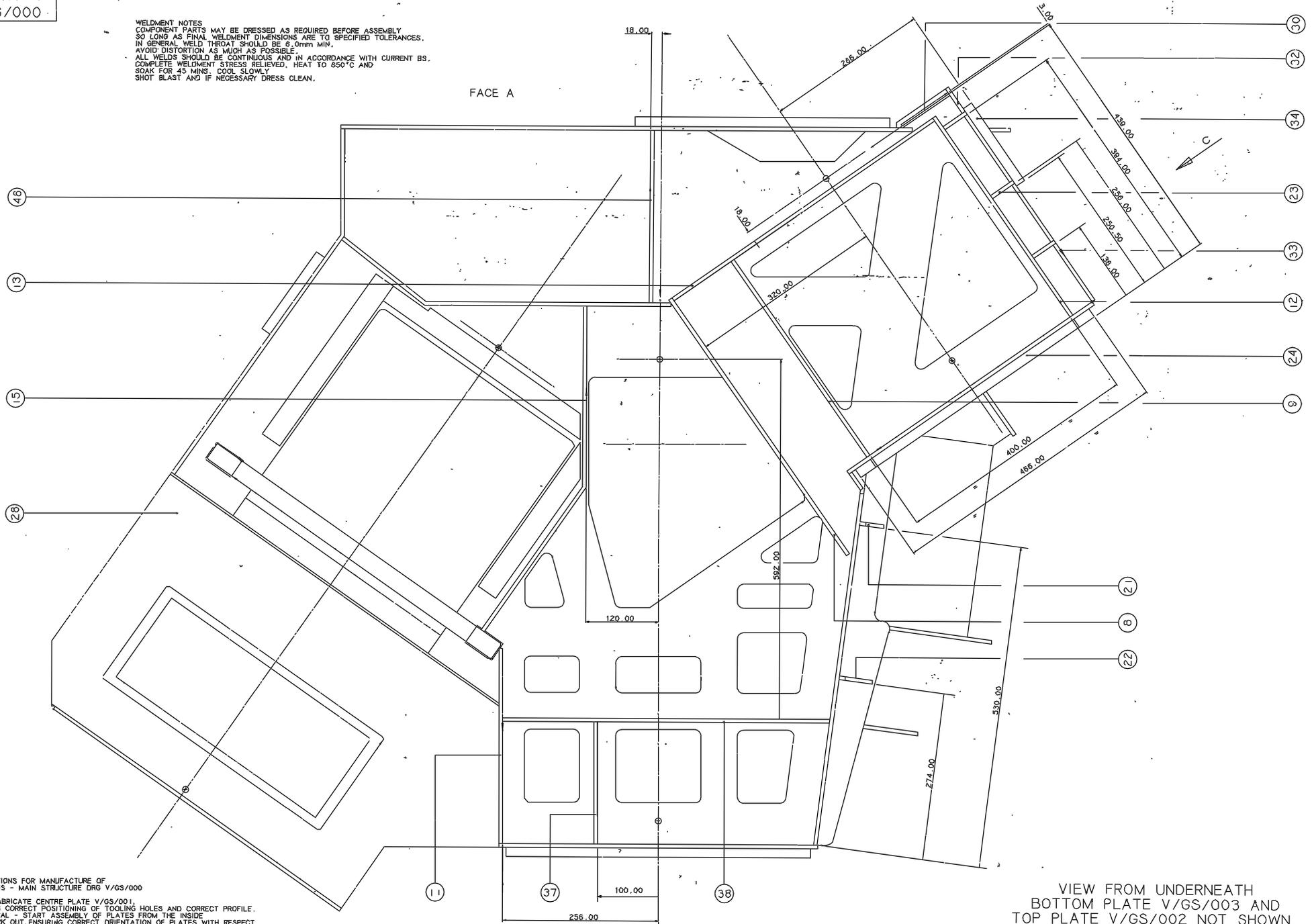
NOTE

HOLE MARKED * MUST BE TAPPED M10 IN CENTRE PLATE.
A HOLE MAY BE MACHINED IN TOP PLATE TO PROVIDE ACCESS
BUT MUST BE PLUGGED TO FINISH

TOLERANCES UNLESS OTHERWISE STATED				MATERIAL MILD STEEL FABRICATION		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		S.A. NO.	
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	DRG NO.	NO. REV.	ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM	TITLE	DRG NO.	SHT. 3 OF 9
											4.2m ISIS - MAIN STRUCTURE MACHINING DETAIL	V/GS/000	

WELDMENT NOTES
 COMPONENT PARTS MAY BE DRESSED AS REQUIRED BEFORE ASSEMBLY
 SO LONG AS FINAL WELDMENT DIMENSIONS ARE TO SPECIFIED TOLERANCES.
 IN GENERAL WELD THROAT SHOULD BE 6.0mm MIN.
 AVOID DISTORTION AS MUCH AS POSSIBLE.
 ALL WELDS SHOULD BE CONTINUOUS AND IN ACCORDANCE WITH CURRENT BS.
 COMPLETE WELDMENT STRESS RELIEVED, HEAT TO 350°C AND
 SOAK FOR 45 MINS. COOL SLOWLY.
 SHOT BLAST AND IF NECESSARY DRESS CLEAN.

FACE A



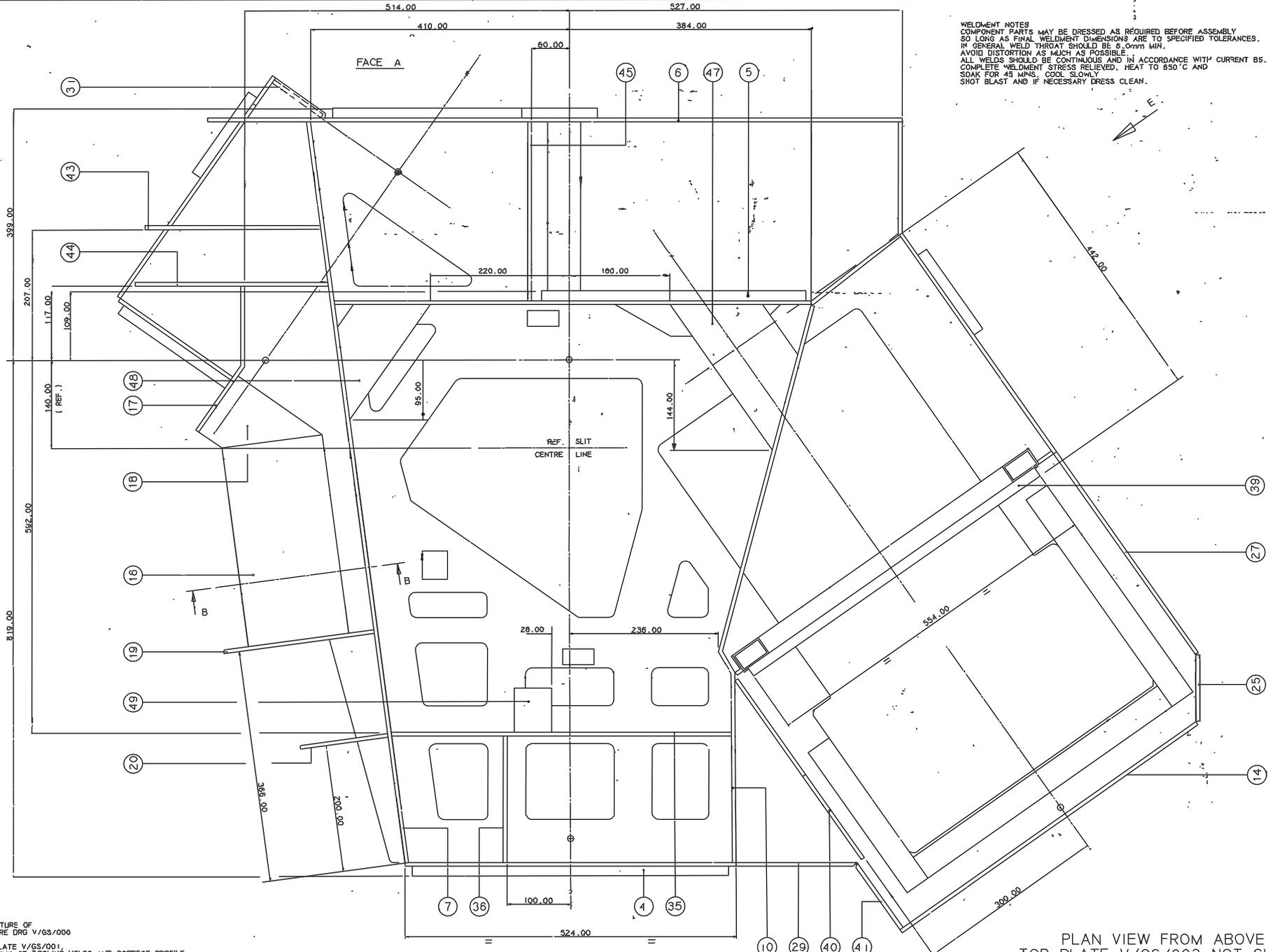
INSTRUCTIONS FOR MANUFACTURE OF
 4.2m ISIS - MAIN STRUCTURE DRG V/GS/000

FULLY FABRICATE CENTRE PLATE V/GS/001,
 ENSURING CORRECT POSITIONING OF TOOLING HOLES AND CORRECT PROFILE.
 IN GENERAL - START ASSEMBLY OF PLATES FROM THE INSIDE
 AND WORK OUT, ENSURING CORRECT ORIENTATION OF PLATES WITH RESPECT
 TO FACE A AND TOP PLATE.
 IF IN DOUBT ASK RGO DESIGN OFFICE.

STAGES OF INSPECTION BY RGO STAFF
 1. AFTER FABRICATION PRIOR TO HEAT TREATMENT
 2. AFTER ALL MACHINING

VIEW FROM UNDERNEATH
 BOTTOM PLATE V/GS/003 AND
 TOP PLATE V/GS/002 NOT SHOWN

TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL: WILD STEEL FABRICATION		DIM IN MM		SCALE 1:2		THIRD ANGLE PROJECTION		G.A. NO.	
X.X +/-				FINISH		DRG NO.		NO REQ		ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM EAST SUSSEX		TITLE	
X.XX +/- 0.5						USED ON				4.2m ISIS - MAIN STRUCTURE FABRICATION ASS'Y		DRG NO. SHT. 2 OF 9 V/GS/000	
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY						
				1		SEPT. '86	AJW						



WELDMENT NOTES
 COMPONENT PARTS MAY BE DRESSED AS REQUIRED BEFORE ASSEMBLY SO LONG AS FINAL WELDMENT DIMENSIONS ARE TO SPECIFIED TOLERANCES. IN GENERAL WELD THROAT SHOULD BE 6.0mm MIN. AVOID DISTORTION AS MUCH AS POSSIBLE. ALL WELDS SHOULD BE CONTINUOUS AND IN ACCORDANCE WITH CURRENT BS. COMPLETE WELDMENT STRESS RELIEVED. HEAT TO 850°C AND SOAK FOR 45 MINS. COOL SLOWLY. SHOT BLAST AND IF NECESSARY DRESS CLEAN.



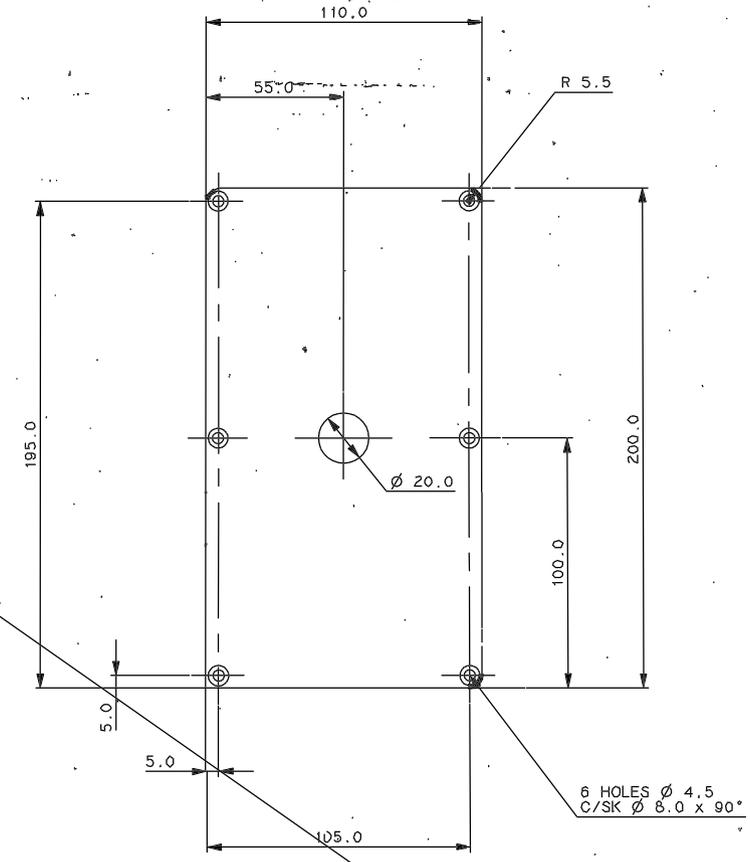
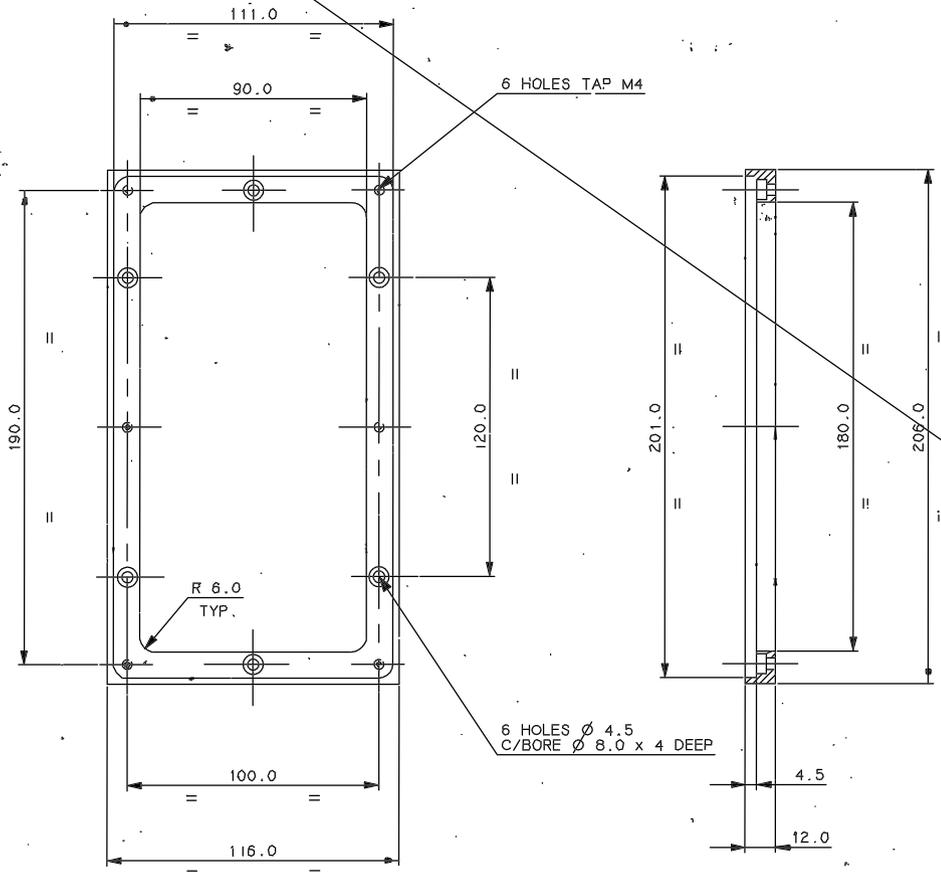
INSTRUCTIONS FOR MANUFACTURE OF
 4.2m ISIS - MAIN STRUCTURE DRG V/GS/000
 FULLY FABRICATE CENTRE PLATE V/GS/001.
 ENSURE CORRECT POSITIONING OF TOOLING HOLES AND CORRECT PROFILE.
 IN GENERAL - START ASSEMBLY OF PLATES FROM THE INSIDE
 AND WORK OUT, ENSURING CORRECT ORIENTATION OF PLATES WITH RESPECT
 TO FACE A AND TOP PLATE.
 IF IN DOUBT ASK RGD DESIGN OFFICE.

STAGES OF INSPECTION BY RGD STAFF
 1. AFTER FABRICATION PRIOR TO HEAT TREATMENT
 2. AFTER ALL MACHINING

				TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL MILD STEEL FABRICATION		DIM IN mm		SCALE 1:2		THIRD ANGLE PROJECTION		D.A. NO.	
				X +/- 0.5				FINISH		ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM EAST SUSSEX		DRG NO. NO. REV.		TITLE		DRG NO. SHT 1 OF 9	
ISSUE MOD. NO. DATE DRAWN BY				SEPT 86 AJW				USED ON				4.2m ISIS - MAIN STRUCTURE FABRICATION ASS'Y		V/GS/000			

PLAN VIEW FROM ABOVE
 TOP PLATE V/GS/002 NOT SHOWN

Drawing No.
W/GP/351-2

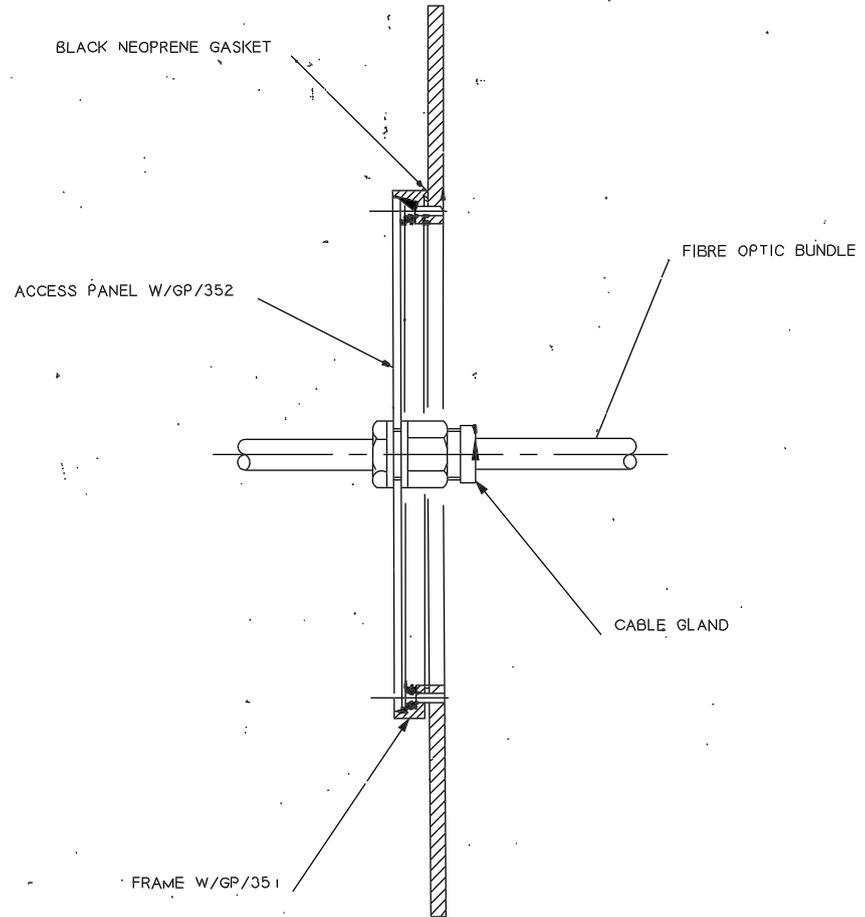
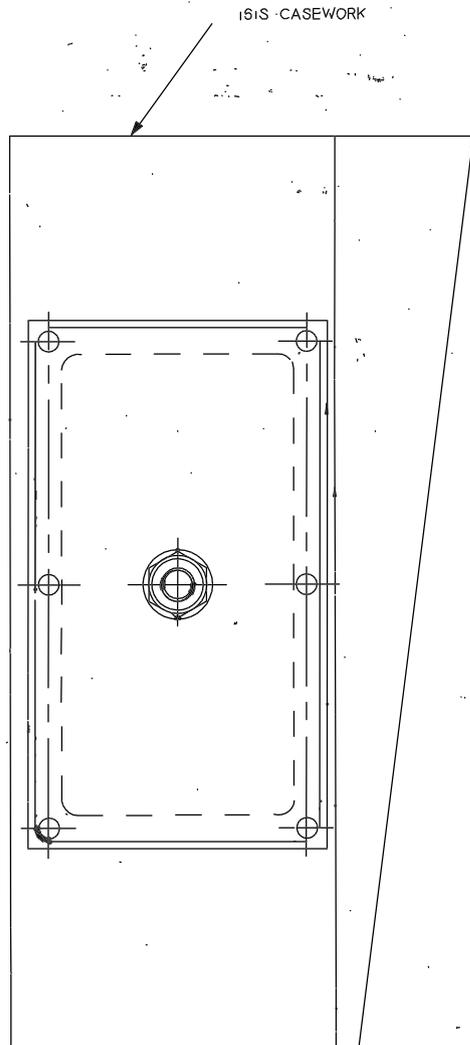


351		TITLE		DESC. REF.	
FRAME					
MATERIAL	SCALE	TOLERANCES			
AL. ALLOY	1:1	±			
FINISH	No. REQ. PER UNIT	X	±	0.1	
BLK. ANODISE	1 OFF	X.X	±		
G.A. No.	DRAWING No.				
W/GP/350	RGO W/GP/351				

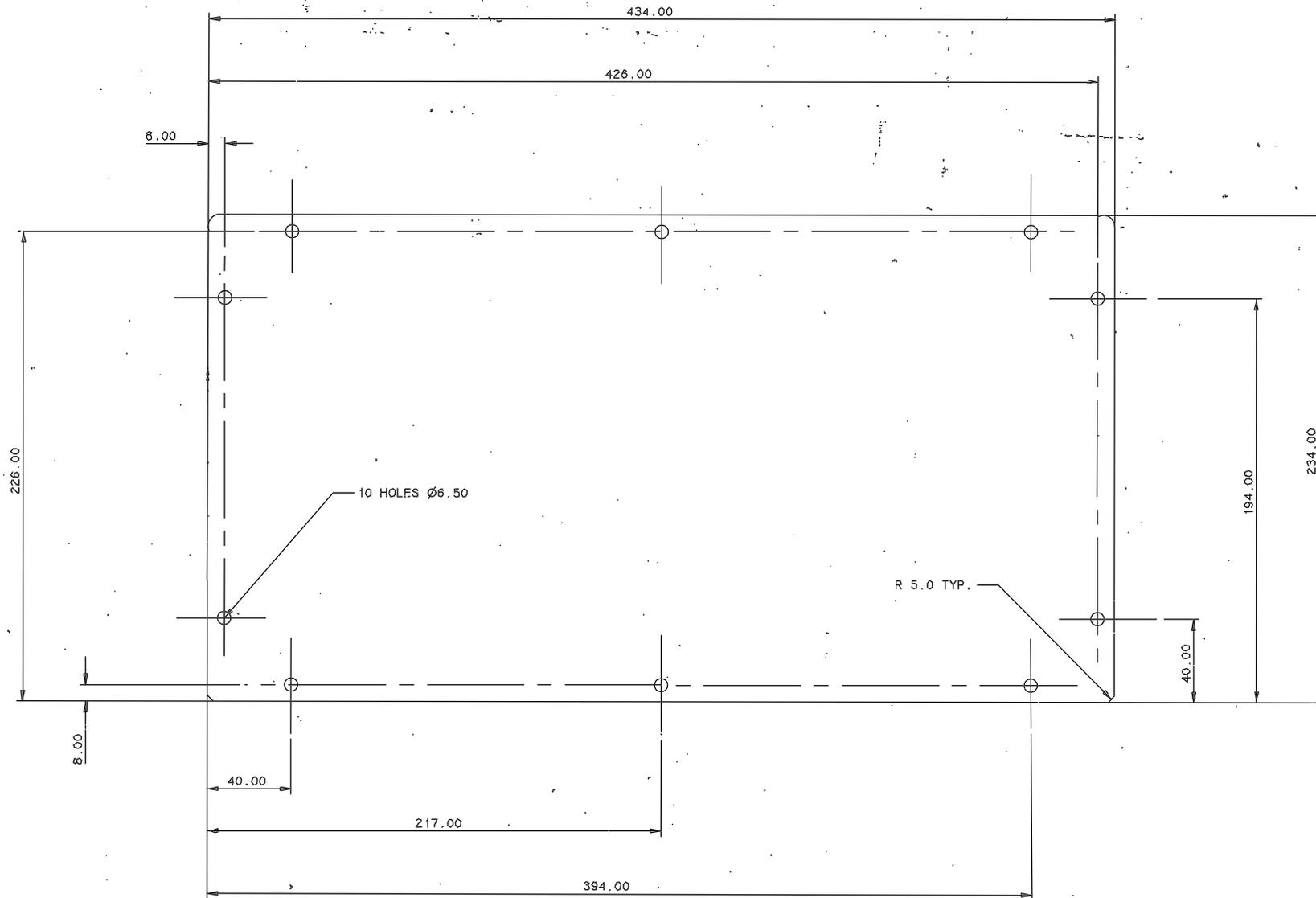
352		TITLE		DESC. REF.	
ACCESS PANEL					
MATERIAL	SCALE	TOLERANCES			
AL. ALLOY	1:1	±			
FINISH	No. REQ. PER UNIT	X	±	0.1	
BLK. ANODISE	1 OFF	X.X	±		
G.A. No.	DRAWING No.				
W/GP/350	RGO W/GP/352				

Issue				Mod. No.				Date				Drawn by				Issue				Mod. No.				Date				Drawn by				Material		Finish		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		Drawing No.	
																								ROYAL GREENWICH OBSERVATORY		1:1		4.2m ISIS - ACCESS PANELS		G.A. No.													
																								HERSTMONEUX CASTLE				W/GP/351-2															
																								HAILSHAM				W/GP/351-2															

Drawing No.
W/GP/350



								Tolerance (unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
								X +/-				ROYAL GREENWICH OBSERVATORY		T1116		4.2m ISIS - ACCESS PANEL		Drawing No.	
								X.X +/-		Finish		HERSTMONCEUX CASTLE				FIBRE OPTIC SLIDE		W/GP/350	
								X.XX +/-		Used as		HAILSHAM SUSSEX							
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by												
				MAR 88			AJW												

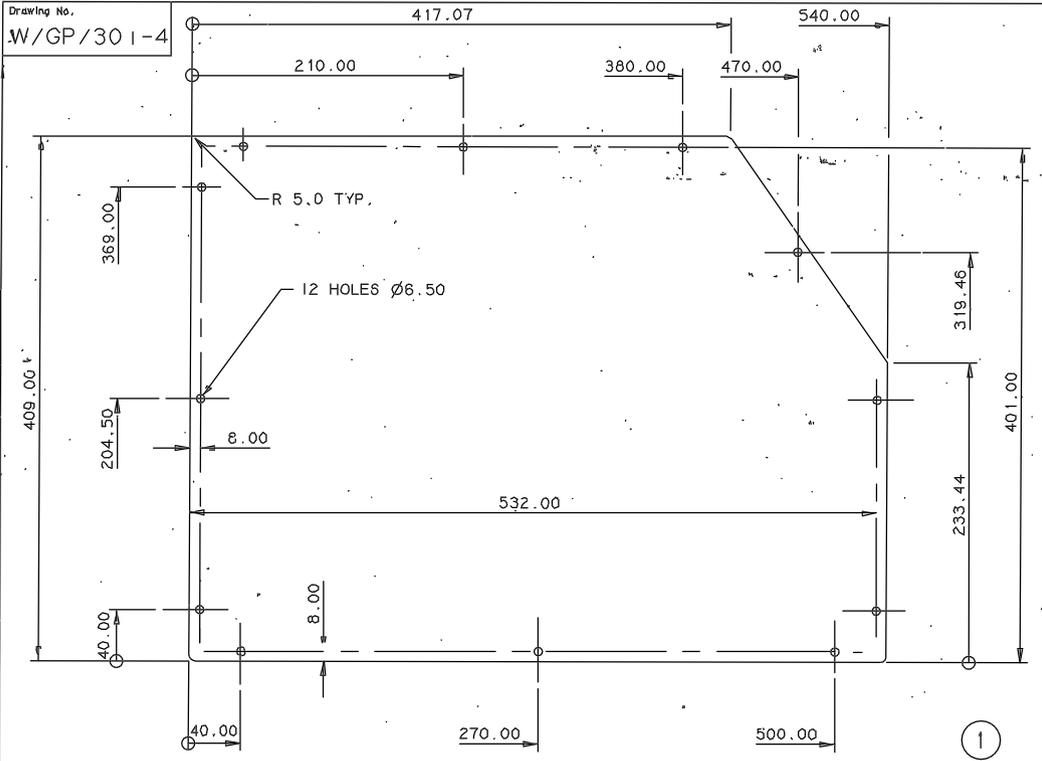


NOTE

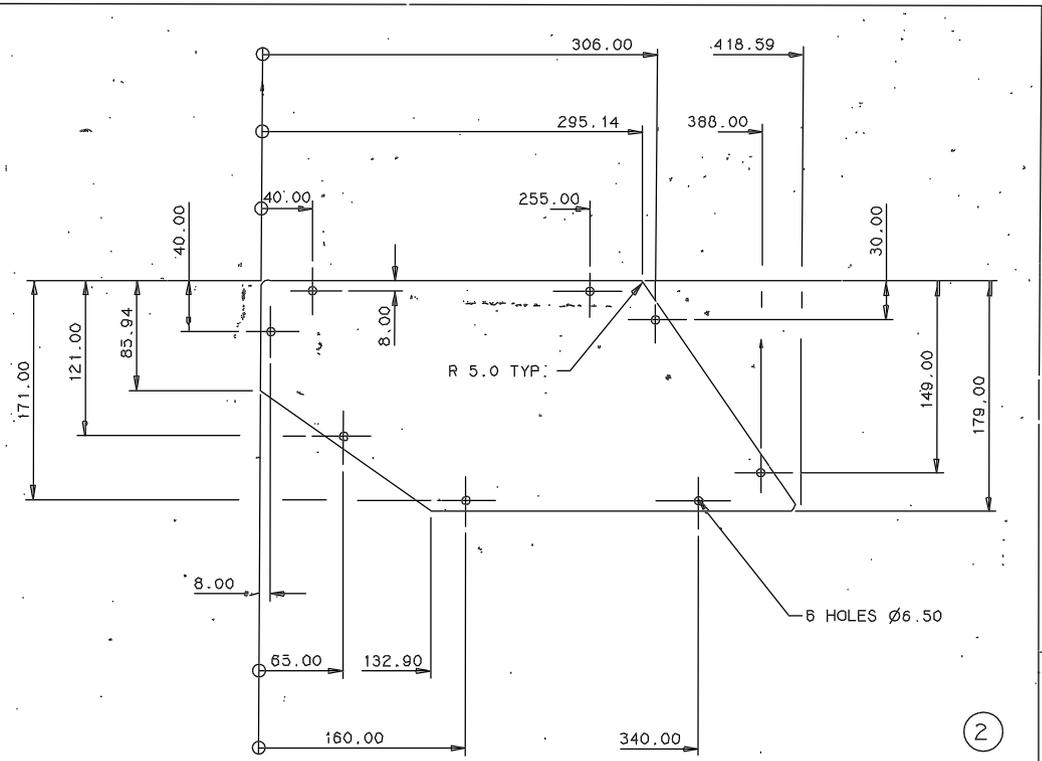
CHECK DIMENSIONS AGAINST HOLE IN PLATE
V/GS/028 OF ISIS STRUCTURE BEFORE MANUFACTURE

								Tolerance (Unless otherwise stated) X +/- X.X +/- X.XX +/- 0.2	Material 1.6mm AL PVC COATED	Dimns. in m.m. Scale 1:1		THIRD ANGLE PROJECTION		GA No.
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	Finish	1 OFF	Drg.No.	No.Reg.	ROYAL GREENWICH OBSERVATORY HERSTMONCEUX CASTLE HAILSHAM SUSSEX		Drawing No. W/GP/305
										Title 4.2m ISIS - MAIN STRUCTURE CLOSURE PANEL				

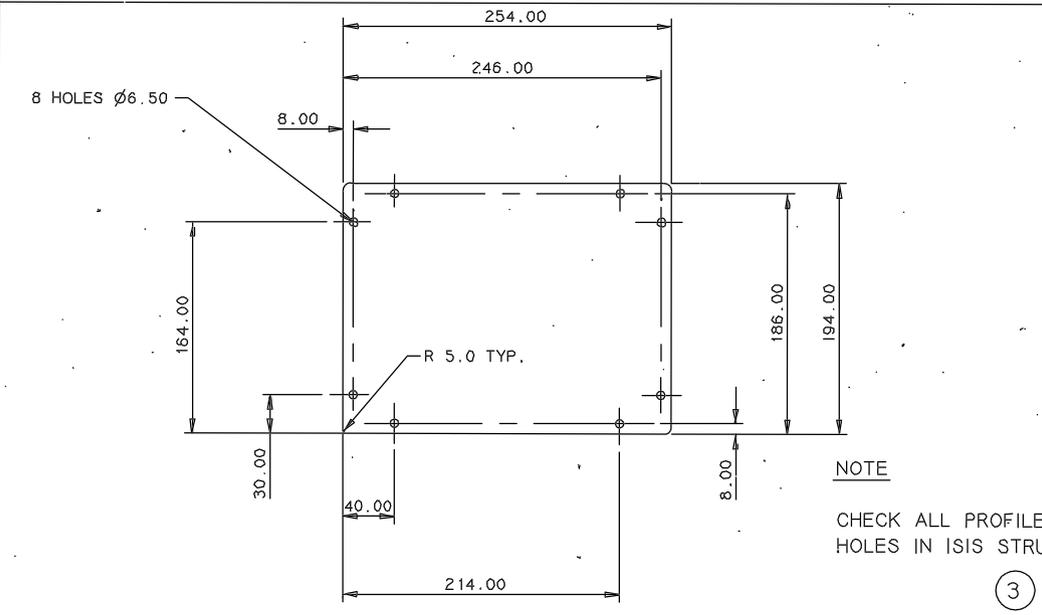
Drawing No.
W/GP/30 1-4



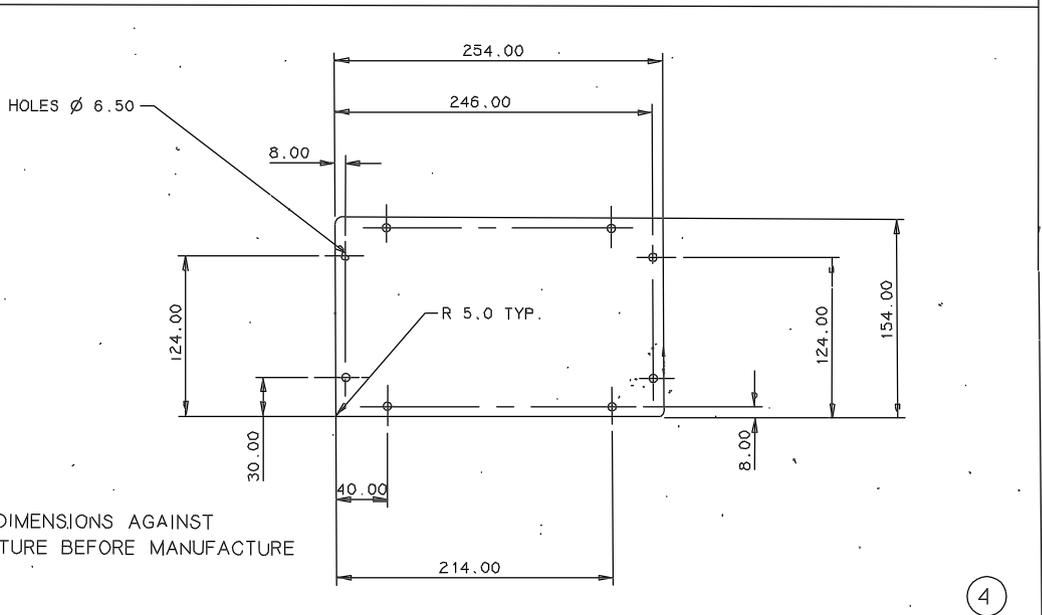
1



2



3



4

NOTE
CHECK ALL PROFILE DIMENSIONS AGAINST
HOLES IN ISIS STRUCTURE BEFORE MANUFACTURE

Tolerance (Unless otherwise stated)								Material		1 OFF EACH		Dim's. in m.m.		Scale 1:1		THIRD ANGLE PROJECTION		SA No.			
X +/-								1.6mm AL		1		ROYAL GREENWICH OBSERVATORY		Title		4.2m ISIS - MAIN STRUCTURE		Drawing No.			
XX +/-								PVC COATED		2		HERSTMONCEUX CASTLE		CLOSURE PANELS		W/GP/30 1-4					
XX +/- 0.2								Finish		Used on		HAILSHAM									
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by														
						JULY 87	AJW														

DRAWING NUMBER	No. of Sheets	G.A. Item No.	DRAWING TITLE OR COMPONENT NAME	No. of	MATERIAL STOCK OR ORDER No. AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE
V/GS/036	1	36	PLATE	1					
/ /037		37	"	1					
/ /038		38	"	1					
V/GS/039		39	SUPPORT FRAME	1					
/ /040		40	WEB	1					
/ /041		41	PLATE	1					
/ /042		42	"	1					
W/GS/043		43	WEB	1					
/ /044		44	"	1					
W/GS/045		45	PLATE	1					
/ /046		46	"	1					
V/GS/047		47	WEB	1					
/ /048		48	"	1	VG 35 + 75'				
/ /049		49	BRACKET	1	"				
/ /050		50	WEB	1	"				
/ /051		51	"	1	"				
v. /GS/052		52	PLATE	1	"				
/ /052		53	"	1	"				
/ /054		54	"	1	"				
/ /055		55	"	1	"				
/ /		56							
/ /		57							
/ /		58							
/ /		59							
W/GS/060		60	ASST/SPECTRO - LOCATION BLOCK						
/ /061		61	" " - LOCATION PIN & SCREW						
W/GS/062		62	" " - LOCATION SCREW & LOCK NUT						
/ /063		63	" " - LOCATION SCREW & LOCK NUT						
/ /		64							
W/GS/065	1	65	BRACKET - SUPPORT FRAME ATTACHMENT						
W/GS/066	1	66	SKETCH TO SHOW POS'N OF SPECTRO CRACK	1					
/ /									
/ /									
/ /									
/ /									
/ /									
/ /									
JOB TITLE						ASSY DRG. No.	SHEET No.	DRAWN BY	
4-2 m ISIS - MAIN STRUCTURE						V/GS/000	2 OF 2	AJSW	
ROYAL GREENWICH OBSERVATORY,						HERSTMONCEUX CASTLE,	HAILSHAM,	SUSSEX	
								DATE SEPT. '86	

DRAWING NUMBER	No. of Sheets	G.A. Item No.	DRAWING TITLE OR COMPONENT NAME	No. of	MATERIAL STOCK OR ORDER No. AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE
V/GS/000	9		ASSEMBLY			VG3000-1 to 9			
V/GS/001	3	1	CENTRE PLATE	1					
V/GS/002	1	2	TOP PLATE	1		VG3002			
V/GS/003	3	3	BOTTOM PLATE	1		VG3003-1 to 3			
W/GS/004	2	4	COLLIMATOR MTG. FACE	1		WG3004			
W/GS/005	3	5	BLUE GRATING FACE	1		WG3005			
W/GS/006	3	6	RED GRATING FACE	1		WG3006			
V/GS/007	}	7	PLATE	1					
V/GS/008		8	"	1					
V/GS/009		9	"	1					
V/GS/010	}	10	"	1					
V/GS/011		11	"	1					
V/GS/012		12	"	1					
V/GS/013	}	13	"	1					
V/GS/014		14	"	1					
V/GS/015		15	"	1					
V/GS/016	}	16	"	1					
V/GS/017		17	"	1					
V/GS/018		18	WEB	1					
V/GS/019	}	19	"	1					
V/GS/020		20	"	1					
V/GS/021		21	"	1					
V/GS/022	}	22	"	1					
V/GS/023		23	PLATE	3					
V/GS/024		24	FRAME	1					
V/GS/025	}	25	PLATE	1					
V/GS/026		26	"	1					
V/GS/027		27	PLATE	1					
V/GS/028	}	28	"	1					
V/GS/029		29	"	1					
V/GS/030		30	"	1					
V/GS/031	}	31	"	1					
V/GS/032		32	"	1					
V/GS/033		33	"	1					
V/GS/034	}	34	'X-DISPERSION' MTG FLANGE	1					
V/GS/035		35	PLATE	1					
JOB TITLE						ASSY DRG. No.	SHEET No.	DRAWN BY	
4.2m 1315 - MAIN STRUCTURE						V/GS/000	1 of 2	A34	
ROYAL GREENWICH OBSERVATORY,						HERSTMONCEUX CASTLE,	HAILSIAM,	DATE SEPT. 80	
								SUSSEX	