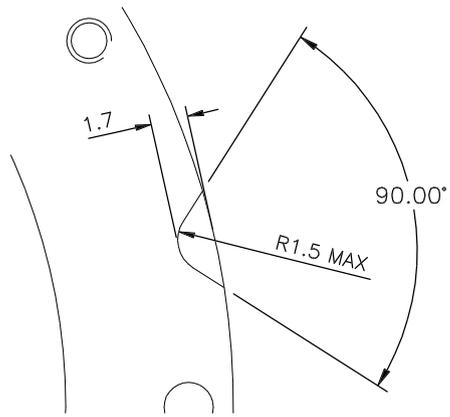


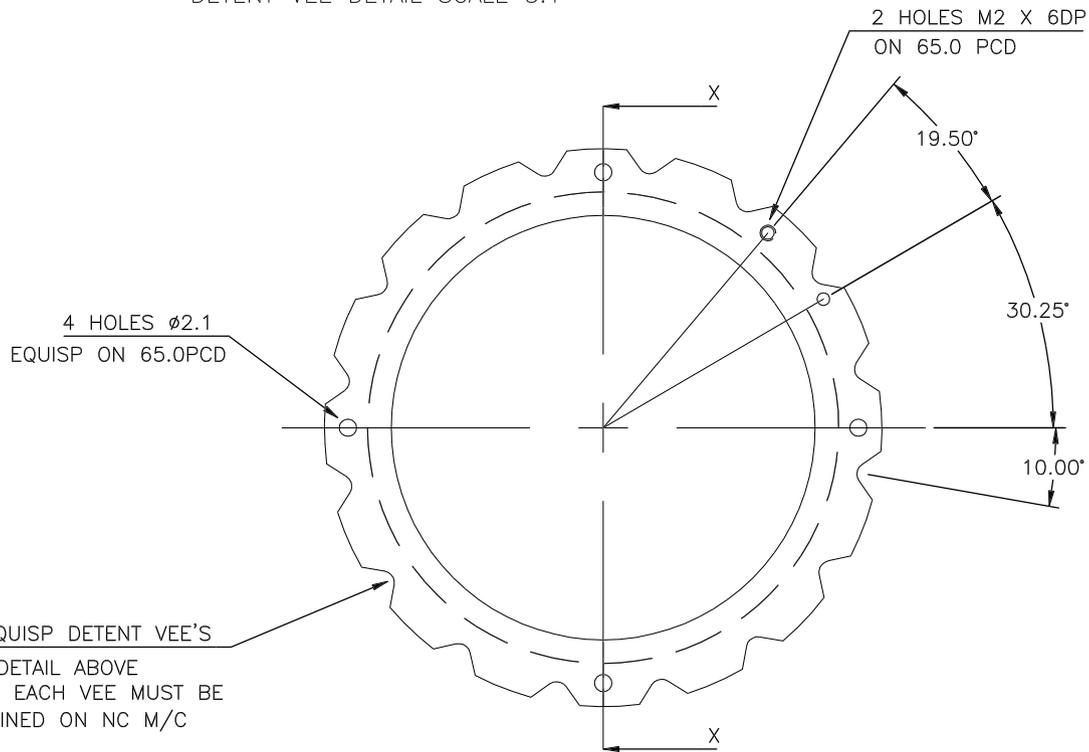
DRG NO.

BI/034

DO NOT SCALE
REMOVE SHARP EDGES

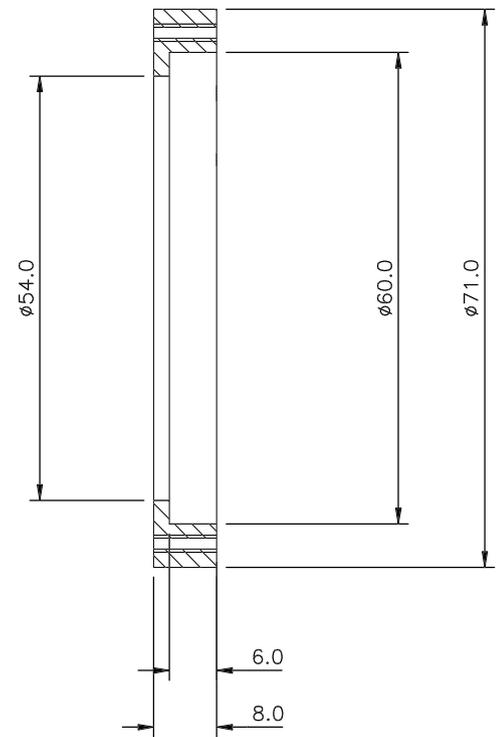


DETENT VEE DETAIL SCALE 5:1



16 EQUISP DETENT VEE'S

SEE DETAIL ABOVE
NOTE: EACH VEE MUST BE
MACHINED ON NC M/C



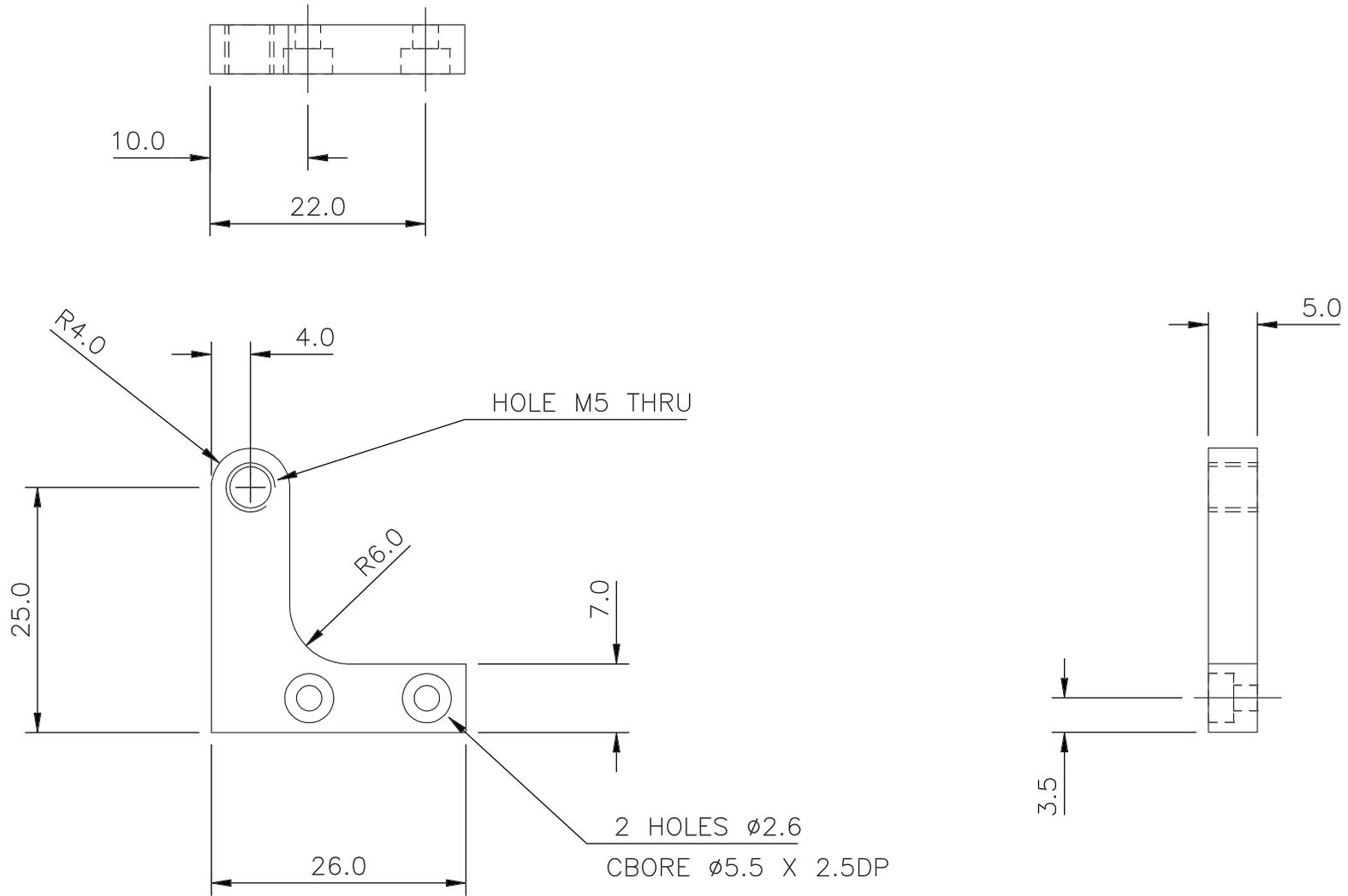
SECTION ON X-X

NOTE: ALL DIMS ARE AFTER PLATING

				TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL BRASS	THIRD ANGLE PROJECTION 	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A2		G.A. NO. BI/037		
				X ±			ROYAL GREENWICH OBSERVATORY	TITLE	QWP RETAINER		LOC'N.	BI	SHT. 1
				X.X ± 0.1	FINISH NICKLE PLATED	NO. REQ'D PER ASS'Y 1	MADINGLEY ROAD	ISIS POLARISATION UPGRADE		DRG NO. BI/034			
ISSUE	MOD. NO.	DATE	DRAWN BY	X.XX ±			CAMBRIDGE	CB3	0EZ				
1		26/09/95	PDJ	ANG. ± 0.05									

DRG NO.
BI/015

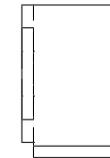
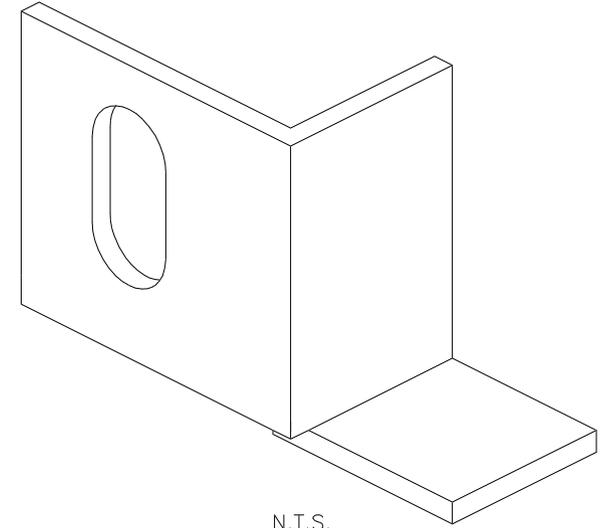
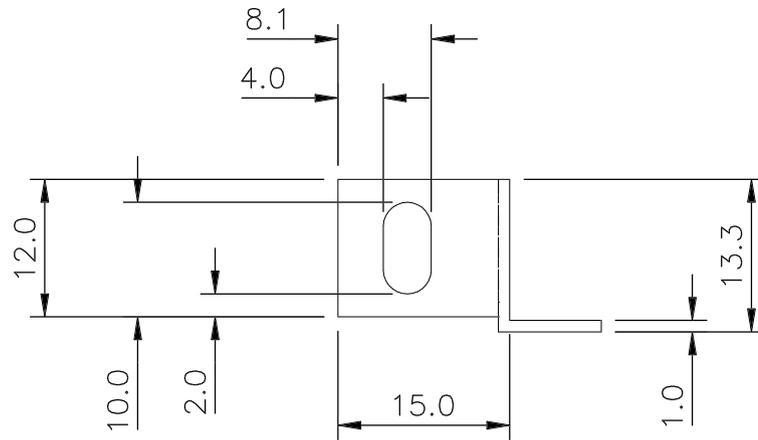
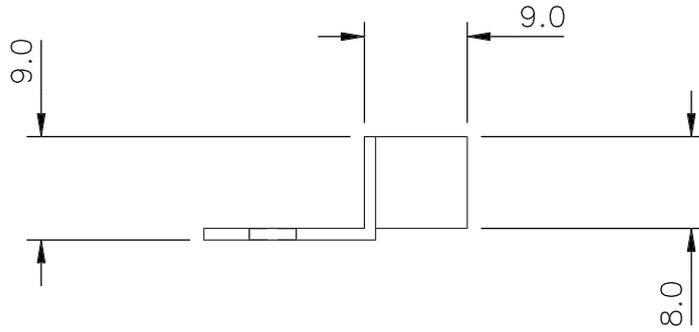
DO NOT SCALE
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/037
			X \pm	ST. ST.		ROYAL GREENWICH OBSERVATORY	TITLE	QWP CYLINDER BRACKET	
1	08/09/95	PDJ	X.X \pm 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE		
ISSUE	DATE	DRAWN	X.XX \pm	CLEAN	1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/015	SHT. 1
			ANG. \pm						LOC'N BI

DRG NO.
BI/030

DO NOT SCALE
REMOVE SHARP EDGES

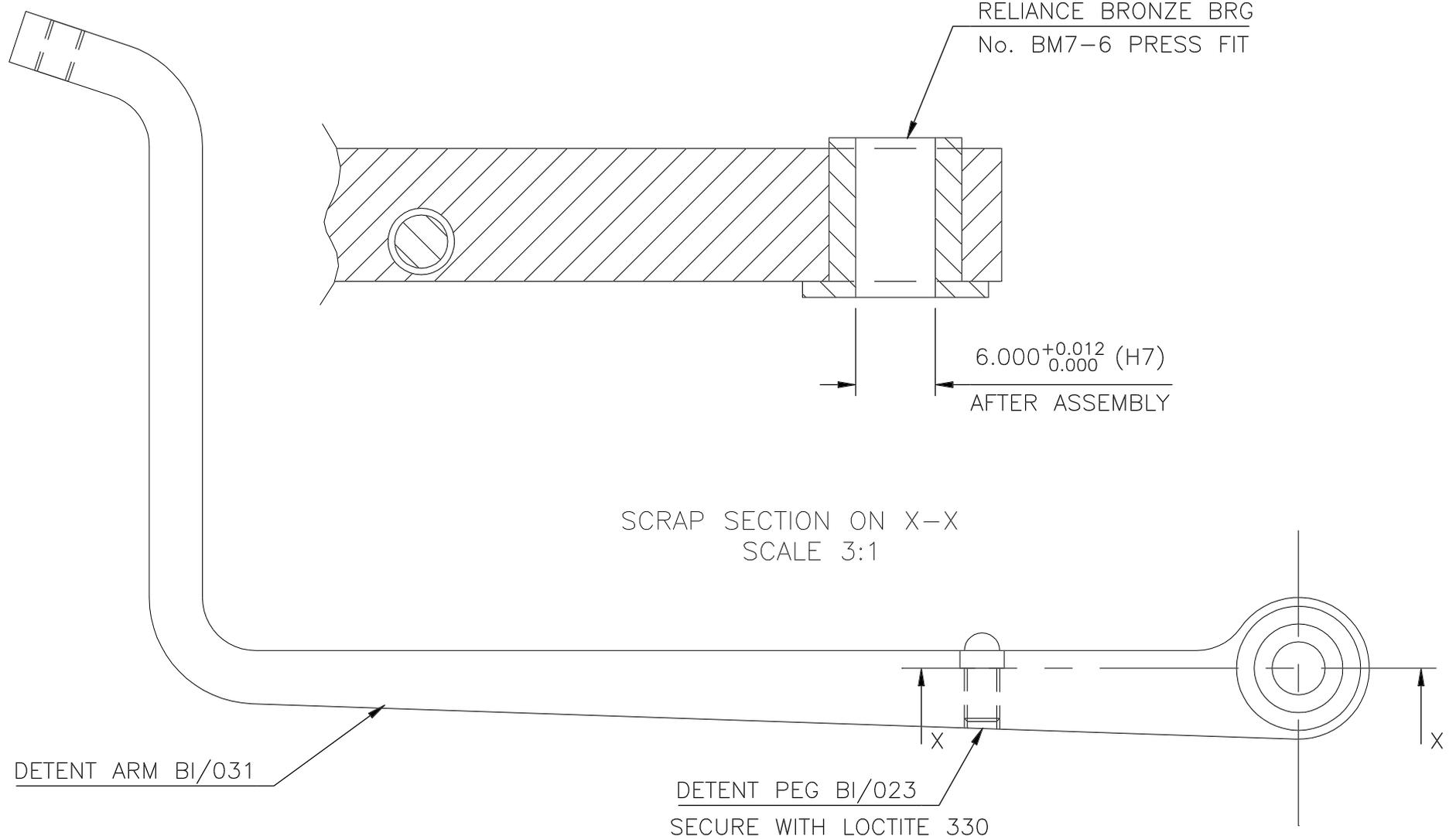


			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL 1mm THK ST. ST.	THIRD ANGLE PROJECTION 	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/037	
			X ±			ROYAL GREENWICH OBSERVATORY				
1	25/09/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD				
ISSUE	DATE	DRAWN	X.XX ±	CLEAN	1	CAMBRIDGE CB3 0EZ				
			ANG. ±			DRG NO. BI/030			SHT. 1	LOC'N BI

TITLE
QWP DETENT FLAG
ISIS POLARISATION UPGRADE

DRG NO.
BI/032

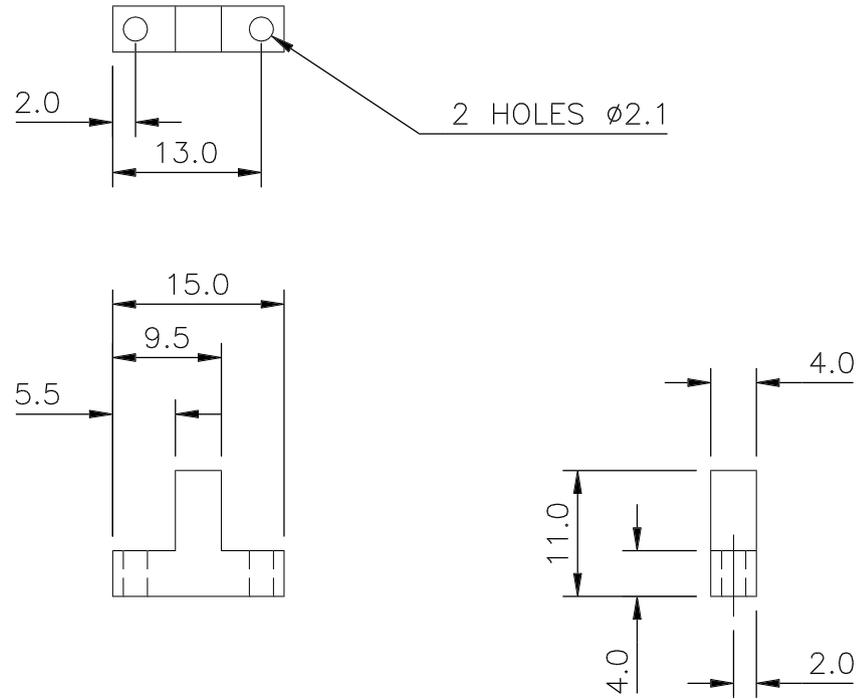
DO NOT SCALE
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE	ORIGINAL SHEET SIZE A3	G.A. NO. BI/037	
			X ±			ROYAL GREENWICH OBSERVATORY		TITLE QWP DETENT ARM SUB-ASSEMBLY		
1	25/09/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD		ISIS POLARISATION UPGRADE		
ISSUE	DATE	DRAWN	X.XX ±			CAMBRIDGE CB3 0EZ		DRG NO. BI/032	SHT. 1	LOC'N BI
			ANG. ±							

DRG NO.
BI/033

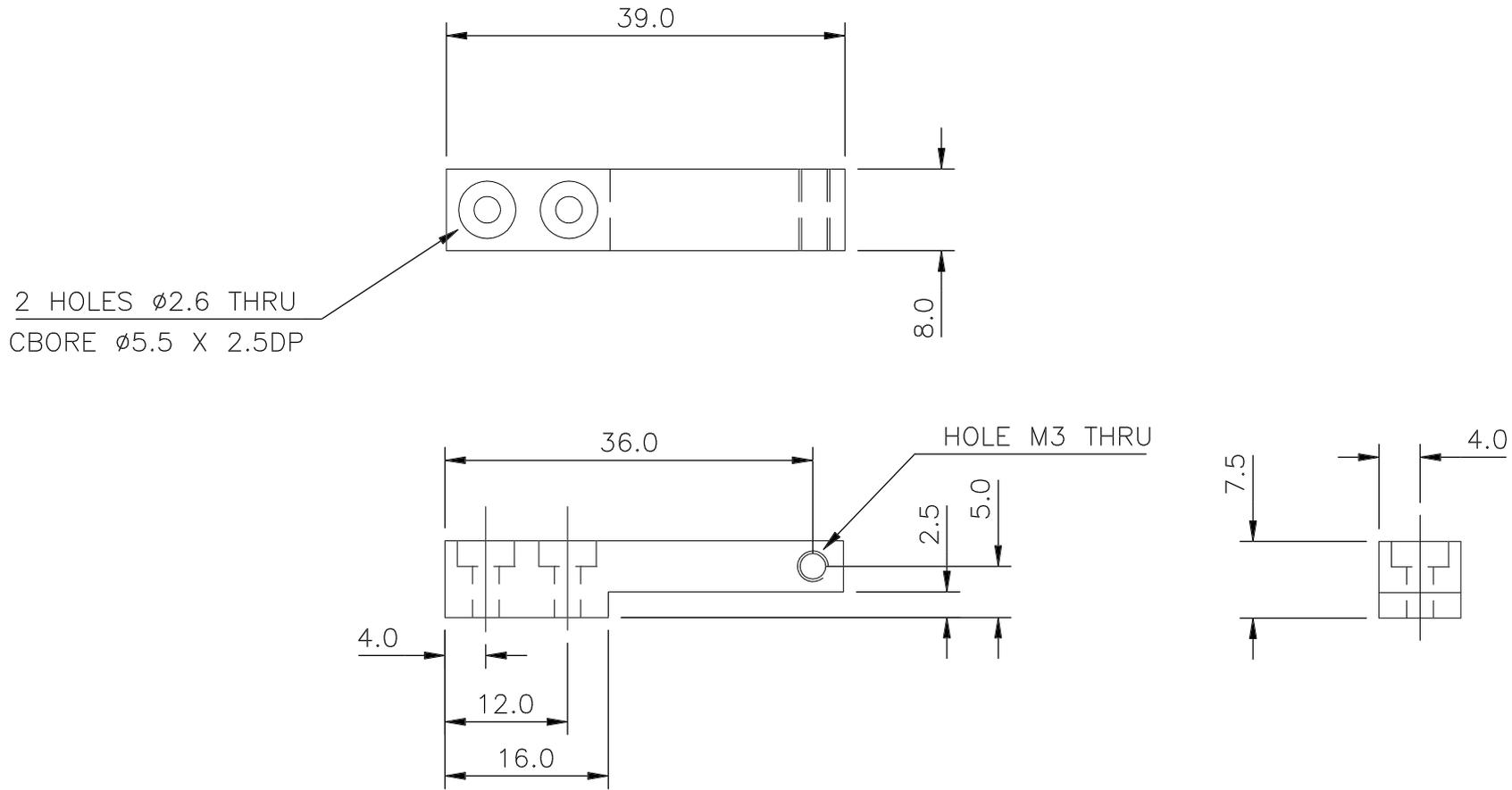
DO NOT SCALE
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/037	
			X \pm	ST. ST.		ROYAL GREENWICH OBSERVATORY	TITLE	QWP ZERO SWITCH FLAG		
1	26/09/95	PDJ	X.X \pm 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE			
ISSUE	DATE	DRAWN	X.XX \pm	CLEAN	1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/033	SHT. 1	LOC'N BI
			ANG. \pm							

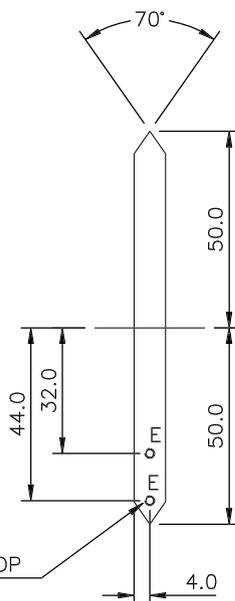
DRG NO.
BI/013

DO NOT SCALE
REMOVE SHARP EDGES

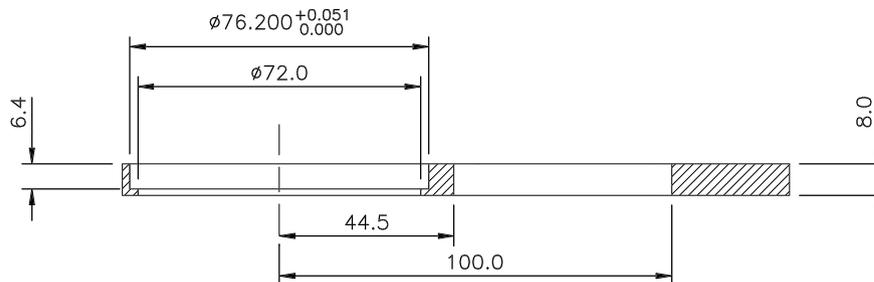
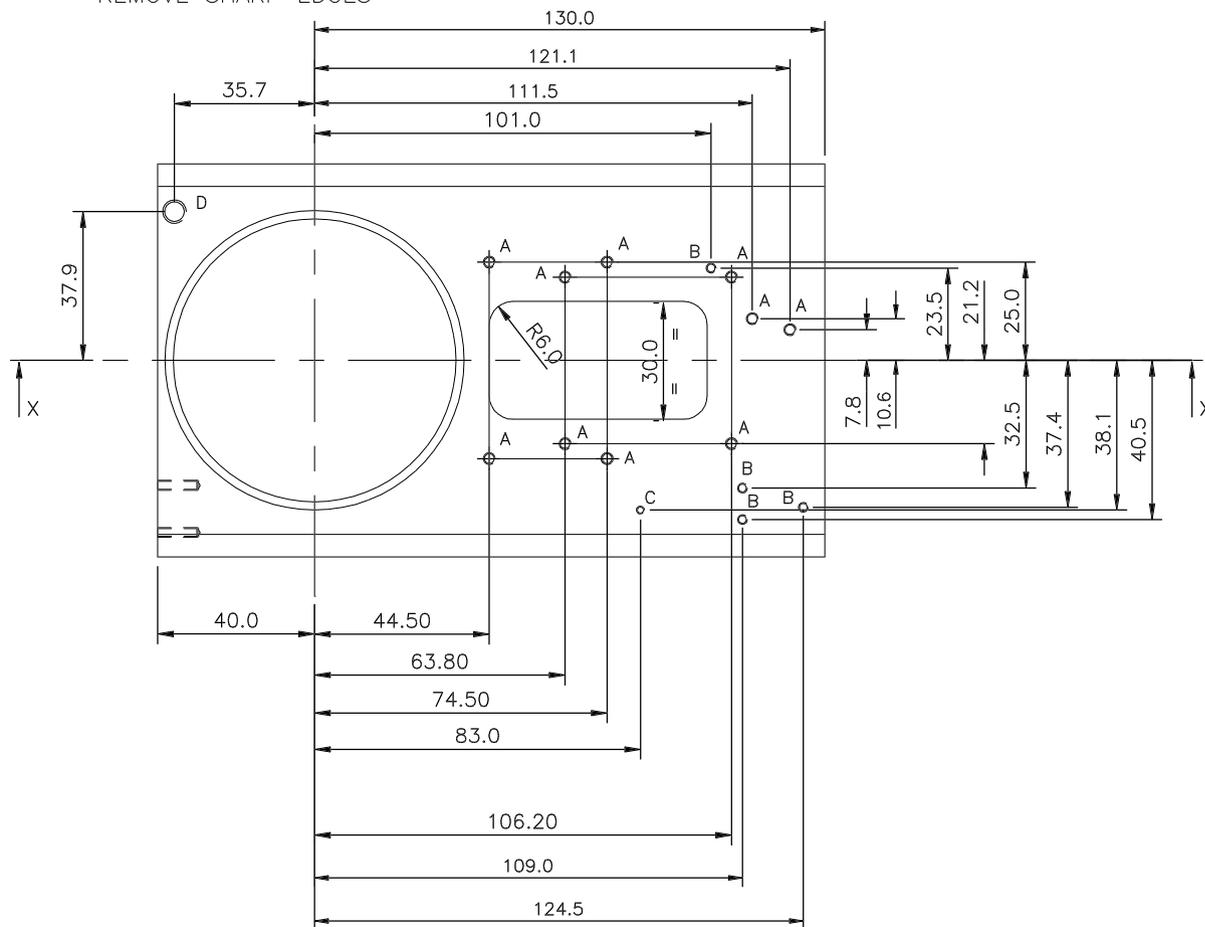


			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/037	
			X \pm	AL. ALLOY						
1	07/09/95	PDJ	X.X \pm 0.1	FINISH	No. REQ'D	ROYAL GREENWICH OBSERVATORY	TITLE	QWP CYLINDER STOP		
ISSUE	DATE	DRAWN	X.XX \pm	BLK	1	MADINGLEY ROAD	ISIS POLARISATION UPGRADE			
			ANG. \pm	ANODISE		CAMBRIDGE CB3 0EZ	DRG NO.	BI/013	SHT. 1	LOC'N BI

DO NOT SCALE
REMOVE SHARP EDGES



2 HOLES E M2.5 X 10DP



SECTION ON X-X

HOLE	SIZE
A	M3 THRU
B	M2.5 THRU
C	M2 THRU
D	M6 THRU

NOTE
ALL DIMENSIONS ARE FINISHED SIZES

				TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE	1:1	ORIGINAL SHEET SIZE A2		G.A. NO.	BI/037		
				X ±	MILD STEEL					TITLE		LOC'N.	BI	SHT.	
				X.X ± 0.1	FINISH	NO. REQ'D PER ASS'Y	ROYAL GREENWICH OBSERVATORY			QWP MAIN SLIDE PLATE		1			
				X.XX ± 0.05	Ni PLATED	1	MADINGLEY ROAD			ISIS POLARISATION UPGRADE		DRG NO.			
				ANG. ± 0.1			CAMBRIDGE CB3 0EZ					BI/035			
ISSUE	MOD. NO.	DATE	DRAWN BY												
1		26/09/95	PDJ												

DRAWING NUMBER	No. OF SHEETS	GA ITEM No.	DRAWING TITLE OR COMPONENT NAME	No. OFF	MATERIAL STOCK OR ORDER No. AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE	
		1	SMC PIN CYLINDER	1	CJPB6-15H4					
BI/027		2	DETENT CYLINDER BRACKET	1	ST.ST					
BI/010		3	CYLINDER COUPLING	1	AL. ALLOY					
		4	SMC FLOATING JOINT	1	JA10-4-070					
		5	INDUCTIVE PROXIMITY SWITCH	1	RS 285-201					
BI/030		6	QWP DETENT FLAG	1	ST. ST.					
BI/011		7	PROXIMITY SWITCH FLAG	1	ST. ST.					
BI/019		8	ENCODER SUPPORT	1	AL. ALLOY					
		9	INDUCTIVE PROXIMITY SWITCH	1	RS 633-458					
BI/020		10	ZERO PROXIMITY SWITCH BRACKET	1	AL. ALLOY					
BI/033		11	QWP ZERO SWITCH FLAG	1	ST. ST.					
BI/024		12	DETENT PIVOT PIN	1	ST. ST.					
		13	CIRCLIP	1	SIZE CODE 0060 (TO DIN 471)					
BI/032		14	QWP DETENT ARM SUB-ASSEMBLY	1						
BI/038		15	DETENT ARM SUPPORT	1	NYLON					
		16	MOTOR GEAR	1	RELIANCE C10A1B5	F4A-16 A				
		17	GEAR CLAMP	1	RELIANCE CGM1-5					
		18	PORTESCAPP MOTOR	1	P520					
BI/022		19	ENCODER SHAFT	1	RELIANCE SMI-6A					
		20	GEAR CLAMP	1	RELIANCE CGM1-6					
		21	ENCODER ANTIBACKLASH GEAR	1	RELIANCE AC10A1B6	F35A-35 A				
		22	KAYDON FOUR POINT CONTACT BRG	1	KA 025XP6					
BI/018		23	LOAD GEAR	1	RELIANCE P10A 1B12	F12A-84 A				
BI/034		24	QWP RETAINER	1	BRASS					
		25								
		26	HEIDENHAIN ENCODER	1	ERO 1421					
BI/013		27	QWP CYLINDER STOP	1	AL. ALLOY					
BI/035		28	QWP MAIN SLIDE PLATE	1	MILD STEEL					
BI/015		29	QWP CYLINDER BRACKET	1	ST. ST.					
		30	DEEP GROOVED BALL BEARING	1	SKF No. 618/6 OR	EQUIVALENT				
			M3 X 16LG CAP HD SCREWS	3	ST. ST.					
			M3 X 8LG CAP HD SCREWS	7	ST. ST.					
			M2.5 X 15LG CAP HD SCREWS	2	ST. ST.					
			M2.5 X 10LG CAP HD SCREWS	4	ST. ST.					
			M2 X 15LG CSK HD SCREWS	4	ST. ST.					
			M2 X 6LG CSK HD SCREWS	2	ST. ST.					
			M2 X 8LG CAP HD SCREWS	5	ST. ST.					
			M2 X 6LG CAP HD SCREWS	3	ST. ST.					
TITLE	QWP ASSEMBLY - PARTS LIST ISIS POLARISATION UPGRADE				LOC'N. BI	ISSUE 2	ASS'Y DRG. NO. BI/037	SHEET NO. 1	DRAWN BY PDJ	DATE 29/01/96
ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE								DRG. NO.	BI/037/PL	