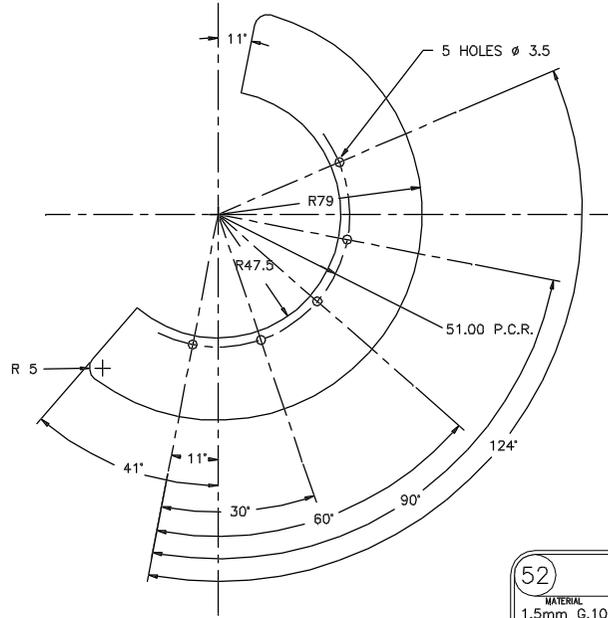


Drawing No.
W/BL/452-455

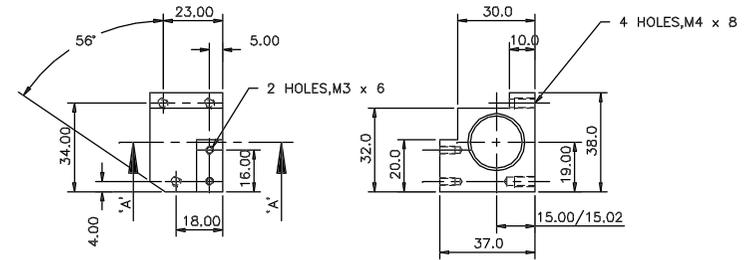
REMOVE ALL SHARP EDGES



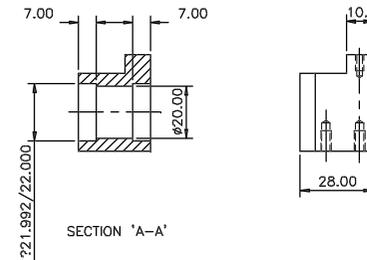
52			
TITLE			
CLAMP VANE			
MATERIAL	SCALE	TOLERANCES	
1.5mm G.10	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/452		

NOTE ! WAS W/GG/043

REMOVE ALL SHARP EDGES



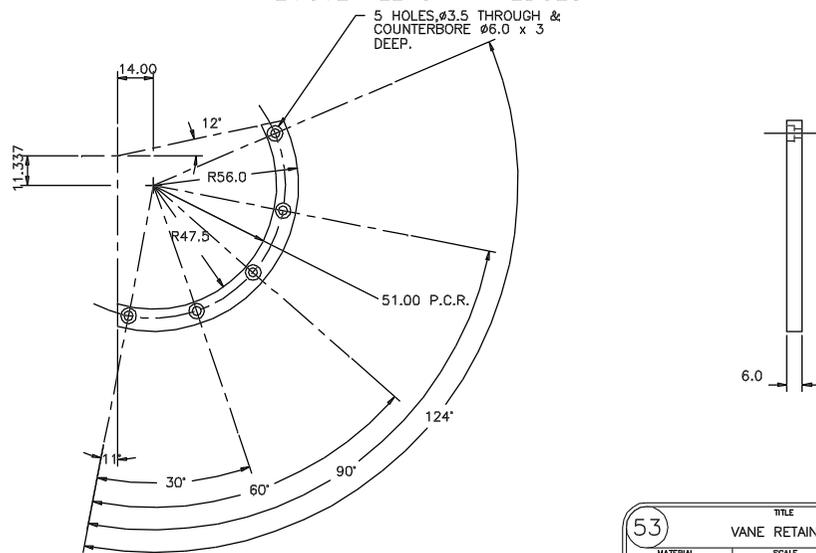
NOTE ! MACHINE BORE'S AFTER ANODISING



NOTE ! WAS W/GG/045

54			
TITLE			
BEARING BLOCK			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/454		

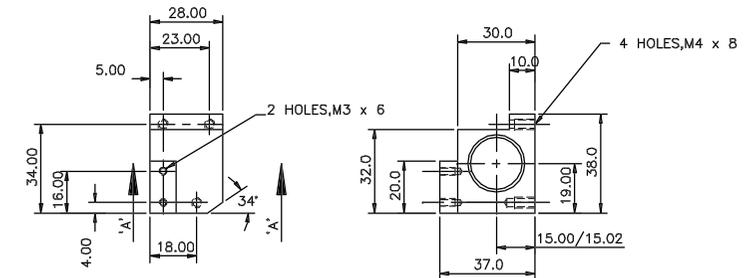
REMOVE ALL SHARP EDGES



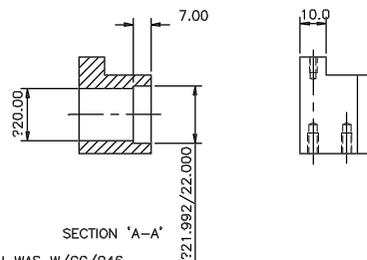
53			
TITLE			
VANE RETAINER			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/453		

NOTE ! WAS W/GG/044

REMOVE ALL SHARP EDGES



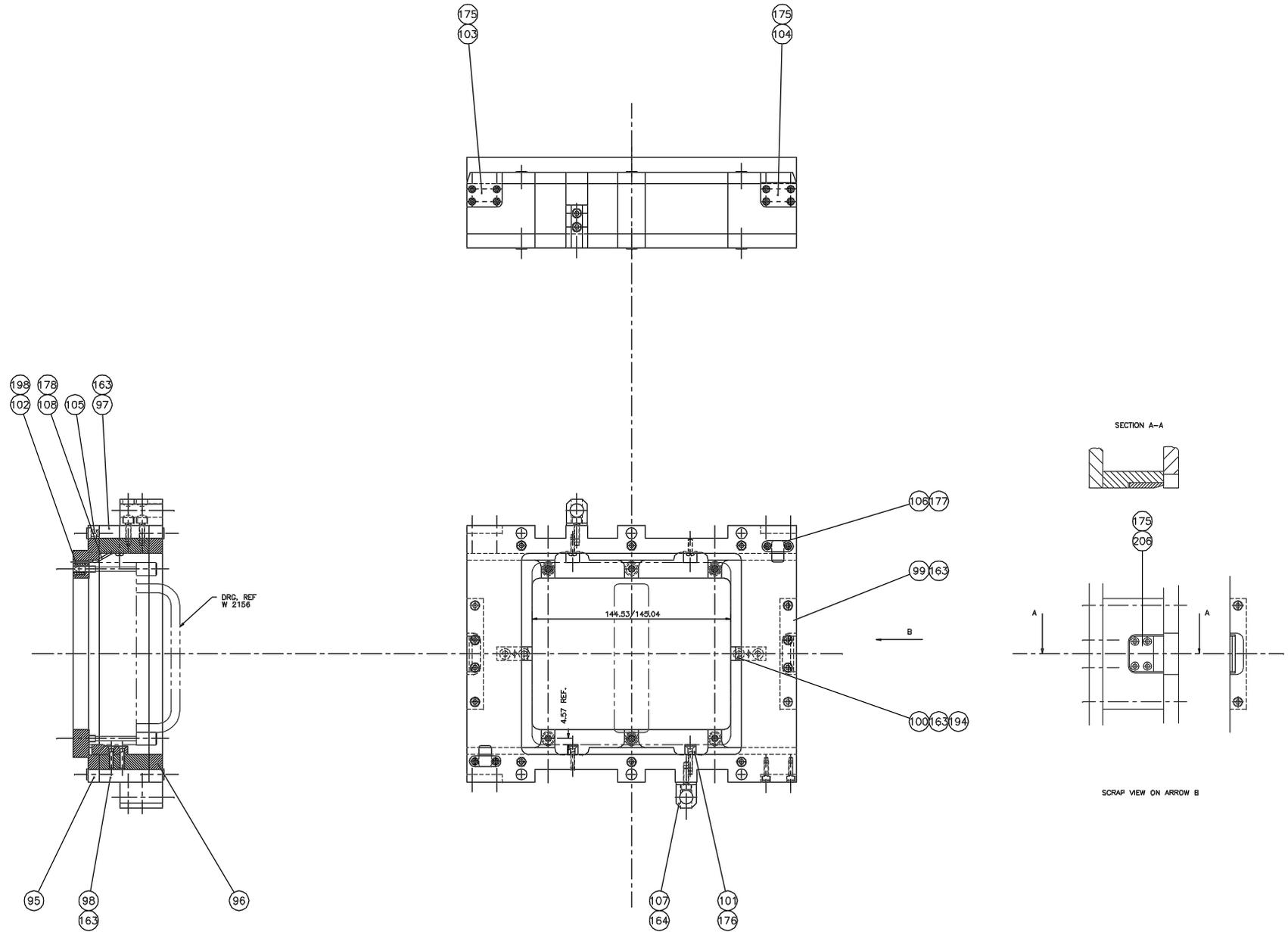
NOTE ! MACHINE BORE'S AFTER ANODISING



NOTE ! WAS W/GG/046

55			
TITLE			
BEARING BLOCK			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/455		

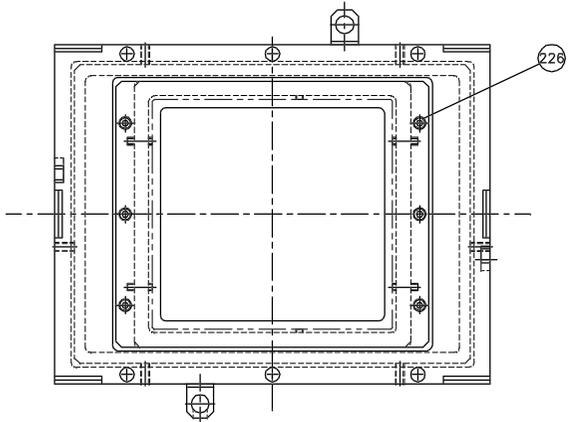
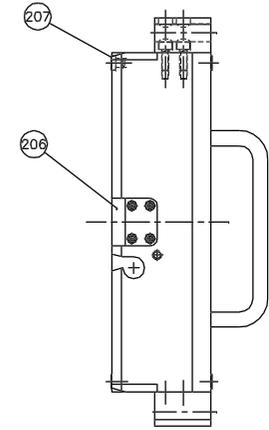
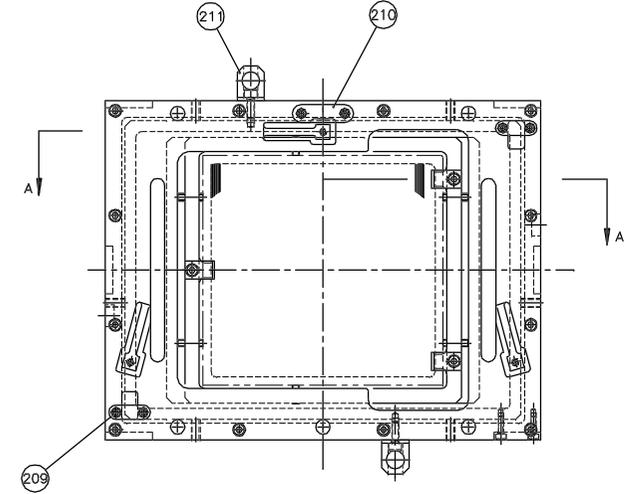
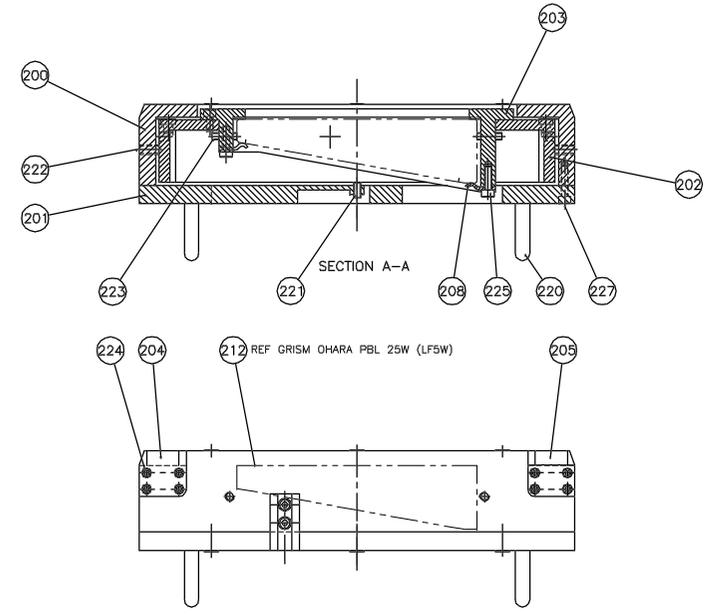
Tolerance (Unless otherwise stated)						Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
						Finish		Drg.No. No.Reg.		ROYAL GREENWICH OBSERVATORY		Title		Drawing No.	
JUNE 91 PROMEC						Drg.No. No.Reg.		ROYAL GREENWICH OBSERVATORY		MADINGLEY ROAD		DETAILS		W/BL/452-455	
Issue Mod.No Date Drawn by Issue Mod.No Date Drawn by						Used on		CAMBRIDGE		CB3 0EZ					



NOTE
 ASSEMBLY MODIFIED TO INCORPORATE
 2 OFF PART No. 208 LOCATION PAD.
 SEE DRG. No. W/BL/516 FOR DETAIL

DUMMY HOUSING FOR W 2156

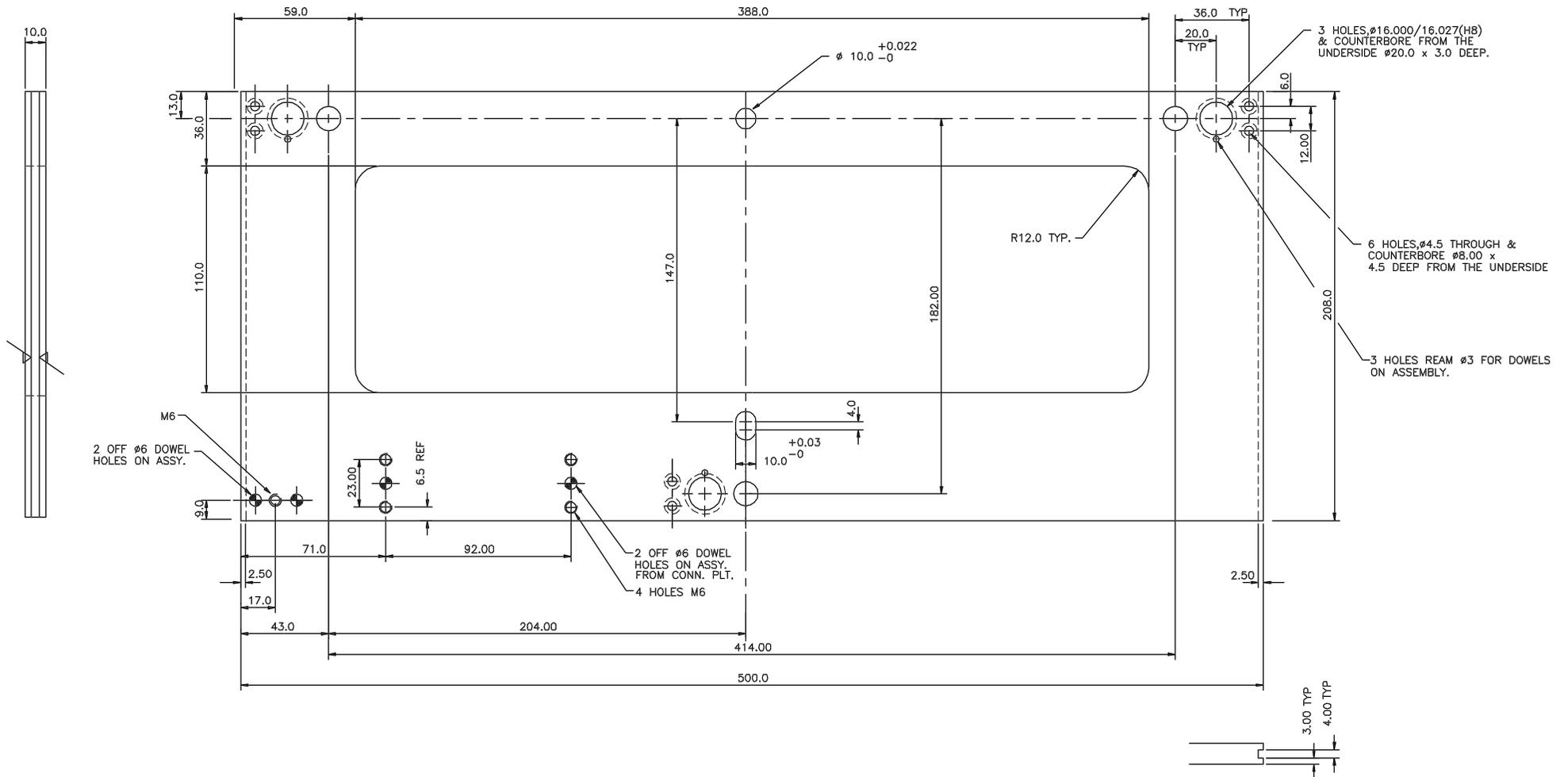
				A				TOLERANCES (UNLESS OTHERWISE STATED)		MATERIAL		DIM IN MM		SCALE		THIRD ANGLE PROJECTION		G.A. NO.	
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	X	+	+	+	DRG NO.	NO REQ	TITLE		DRG NO.		SHIT 2 OF 3	
								±	±	±	±			GRATING HOUSING ASSEMBLY		V/BL/400			
								±	±	±	±			ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ					
								±	±	±	±								



TRANSMISSION GRATING CELL & HOUSING

TOLERANCES (UNLESS OTHERWISE STATED)								MATERIAL		DIM IN MM		SCALE FULL		THIRD ANGLE PROJECTION		G.A. NO.		
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	FINISH	DRG NO.	NO REQ	USED ON	ROYAL GREENWICH OBSERVATORY	MADINGLEY ROAD	CAMBRIDGE CB3 0EZ	TITLE	GRATING HOUSING ASSEMBLY	DRG NO.	SHIT 3 OF 3
						27/5/95	PRDMECH										V/BL/400	

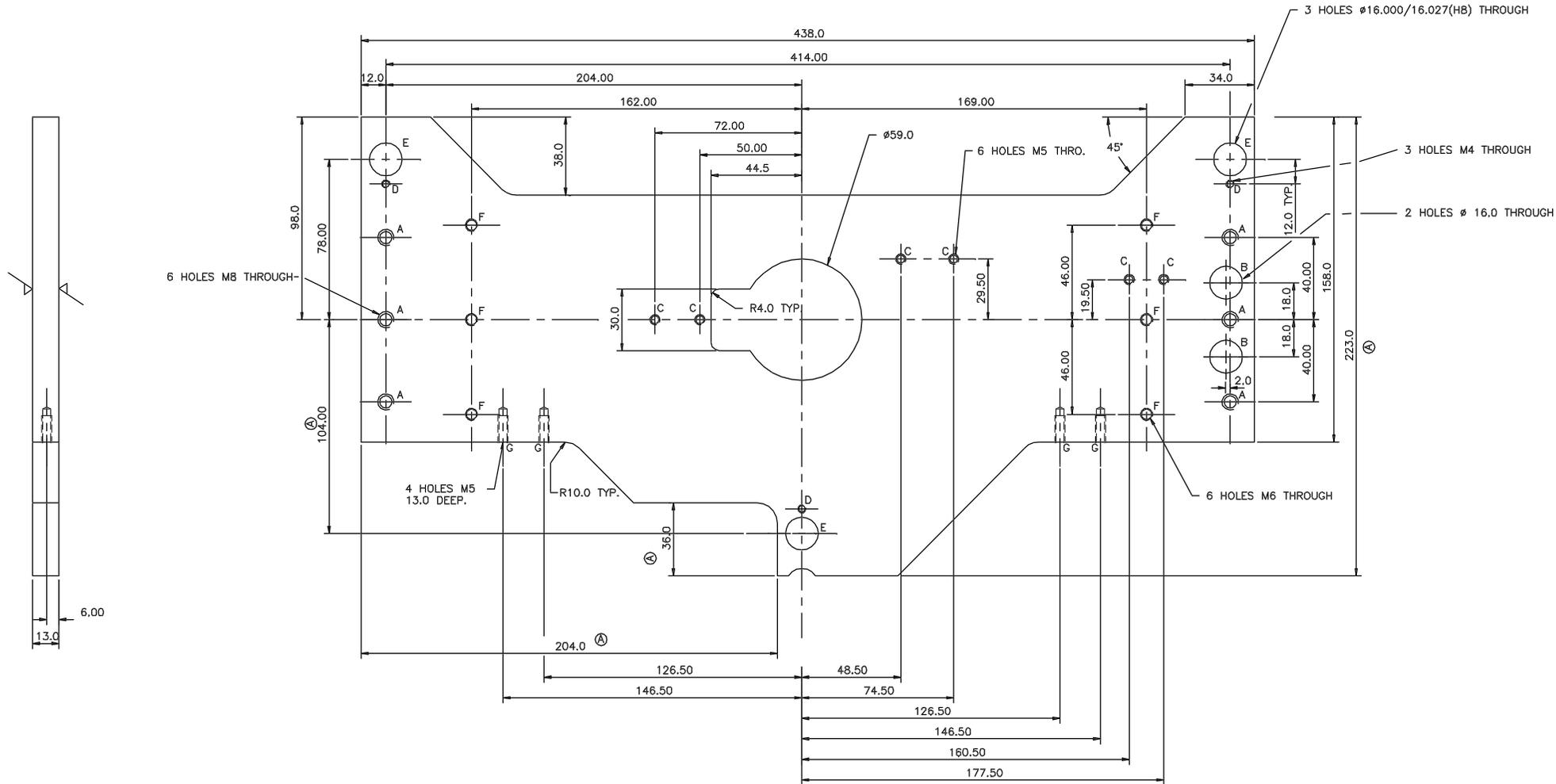
REMOVE ALL SHARP EDGES



1		TITLE	
BASE PLATE			
MATERIAL	SCALE	TOLERANCES	
ALCOA PLT.	1:1	x	0.3
FINISH	No. REQ. PER UNIT	xx	0.1
MATT BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	D R.G.O. W/BL/401	ISS B	

								Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
								X +/-		ROYAL GREENWICH OBSERVATORY		Title		DETAILS		Drawing No.			
								XX +/-		MADINGLEY ROAD						W/BL/401			
								XXX +/-		CAMBRIDGE CB3 0EZ						FILE WBL401B			
								ANG. +/-											
Issue	Mod.No.	Date	Drawn by	Issue	Mod.No.	Date	Drawn by												
				B		21/6/93	PROMECH												

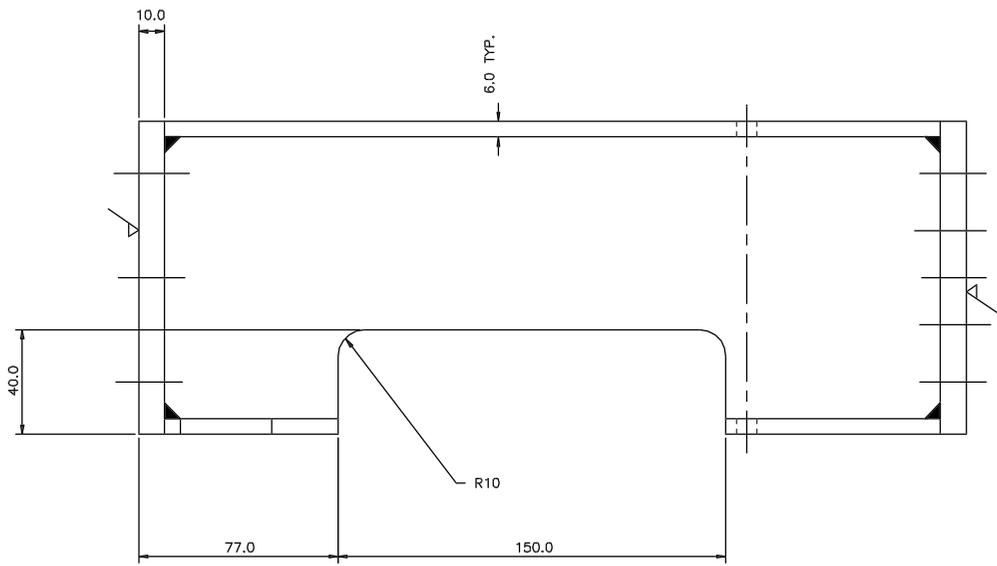
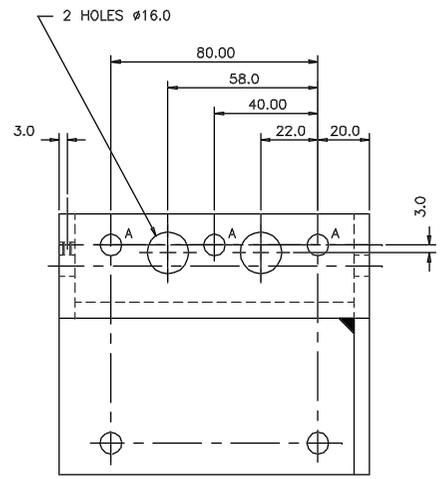
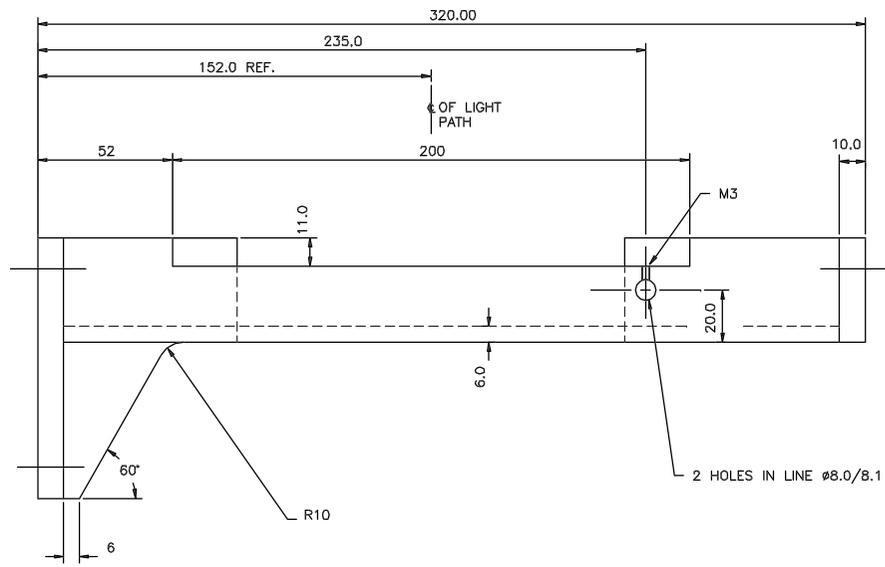
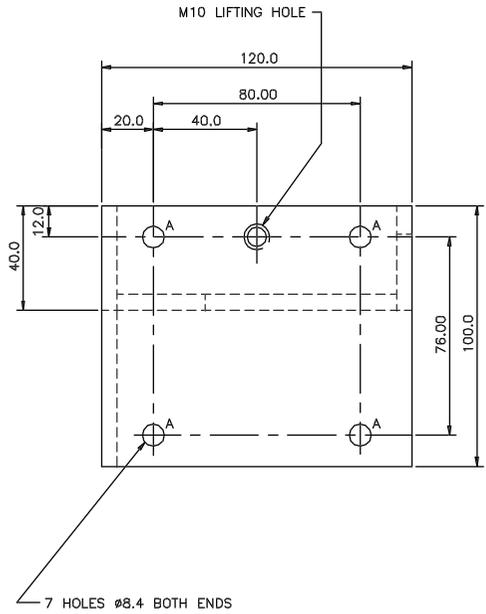
REMOVE ALL SHARP EDGES



2		TITLE	
PIVOT PLATE			
MATERIAL	SCALE	TOLERANCES	
STEEL	1:1	x	
FINISH	No. RECD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
GA. No.	DRAWING No.		
V/BL/400	D R.G.O. W/BL/402	ISS A	

				Tolerance (Unless otherwise stated)		Material		Dimns.in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-				ROYAL GREENWICH OBSERVATORY		Title		DETAIL		Drawing No.	
				XX +/-		Finish		MADINGLEY ROAD						W/BL/402	
				XXX +/-		Drg.No.		CAMBRIDGE						ISS A	
				ANG. +/-		No.Req.		CB3 OEZ							
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by								
				A		9/6/93	PROMECH								

REMOVE SHARP EDGES

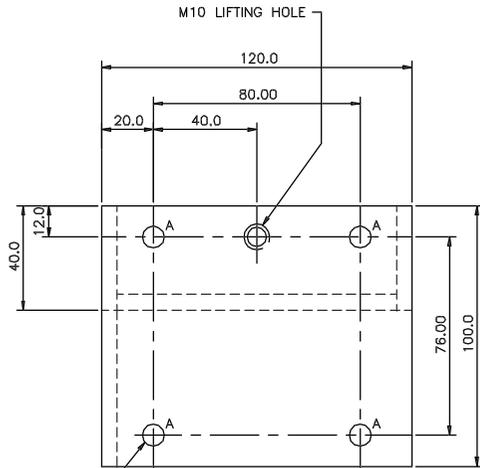


NOTE: CONTINUOUS WELD AT STRESS RELIEVE AS REQUIRED & MACHINE AT PAINT UNMACHINED SURFACES MATT BLACK.

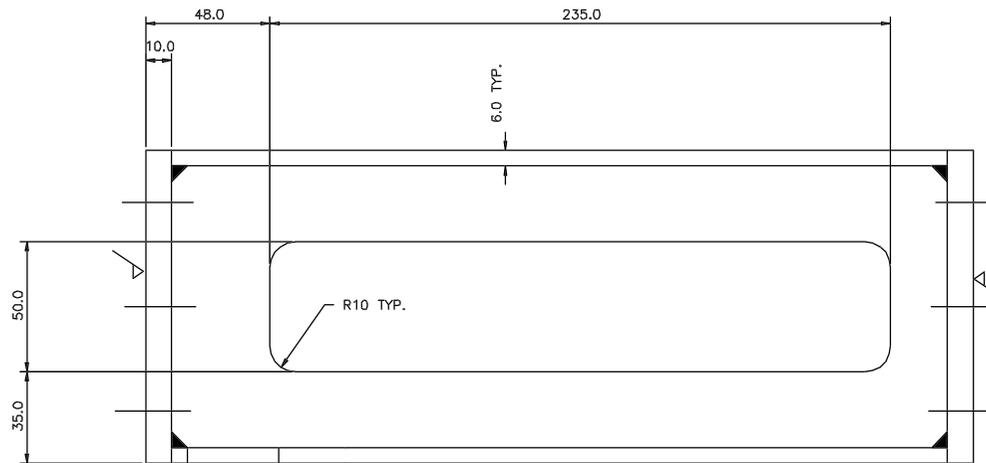
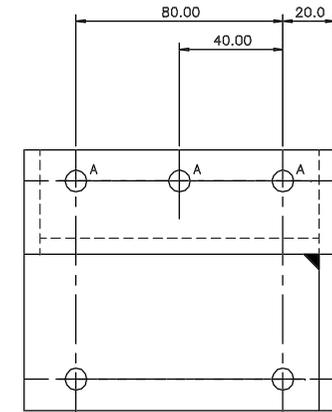
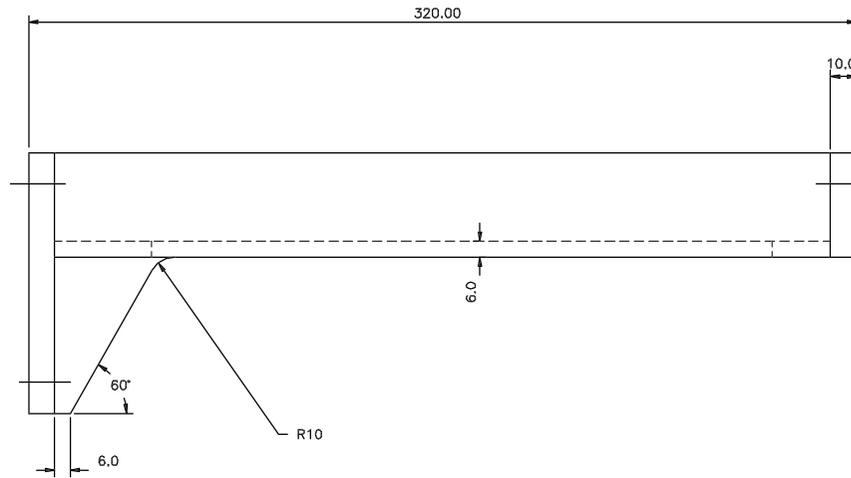
3		TITLE	
M.S. FABN.		LEG R.H.	
MATERIAL	SCALE	TOLERANCES	
SEE NOTE	1:1	x	0,3
	No. REQ. PER UNIT	xx	0,1
	1	xxx	
G.A. No.	DRAWING No.		
V/BL/400	W/BL/403		

				Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-											
				XX +/-		Finish		Drg.No.		ROYAL GREENWICH OBSERVATORY		Title		Drawing No.	
				XXX +/-		Used on		No. Req.		MADINGLEY ROAD		DETAIL		W/BL/403	
				ANG +/-						CAMBRIDGE CB3 0EZ					
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by								
				JUNE 91	PROMEK										

REMOVE SHARP EDGES



7 HOLES Ø8.4 BOTH ENDS

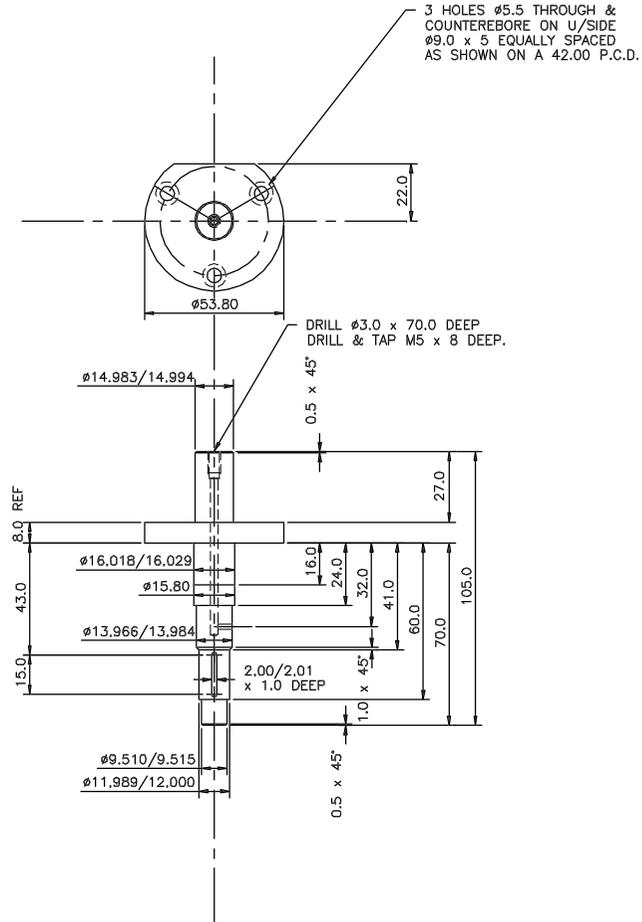


NOTE: CONTINUOUS WELD AT STRESS RELIEVE AS REQUIRED & MACHINE AT PAINT UNMACHINED SURFACES MATT BLACK.

4		TITLE LEG L.H.	
MATERIAL M.S. FABN.	SCALE 1:1	TOLERANCES x xx 0,3 xxx 0,1	
FINISH SEE NOTE	No. REQ. PER UNIT 1		
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/404	

				Tolerance (Unless otherwise stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/- X.X +/- X.XX +/- ANG. +/-													
				JUNE 01 PROMEC				Finish		Drg.No.		No.Reg.		ROYAL GREENWICH OBSERVATORY		Drawing No.	
Issue Mod.No				Date Drawn by Issue Mod.No				Used on		CAMBRIDGE		CB3 0EZ		DETAIL		W/BL/404	

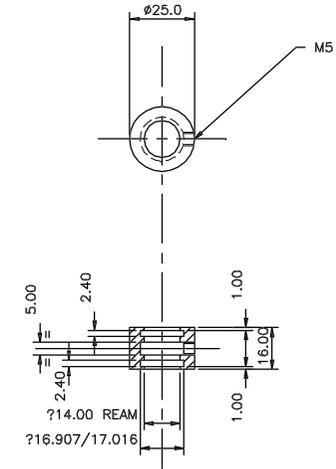
REMOVE ALL SHARP EDGES



6		TITLE	
MATERIAL		SCALE	
AISI 321		1:1	
FINISH		TOLERANCES	
CLEAN		x 0.5	
No. REQD. PER UNIT		xx 0.3	
1		xxx 0.1	
G.A. No.		DRAWING No.	
V/BL/400		W/BL/406	

NOTE 1 WAS W/GG/006

REMOVE ALL SHARP EDGES

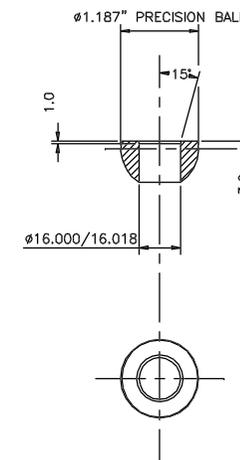


'O' RING 2 x "DOWTY" No. 015

7		TITLE	
MATERIAL		SCALE	
BRASS		1:1	
FINISH		TOLERANCES	
CLEAN		x 0.5	
No. REQD. PER UNIT		xx 0.3	
1		xxx 0.1	
G.A. No.		DRAWING No.	
V/BL/400		W/BL/407	

NOTE 1 WAS W/GG/005

REMOVE ALL SHARP EDGES



8		TITLE	
MATERIAL		SCALE	
AISI316 or 304		1:1	
FINISH		TOLERANCES	
CLEAN		x 0.5	
No. REQD. PER UNIT		xx 0.3	
1		xxx 0.1	
G.A. No.		DRAWING No.	
V/BL/400		W/BL/408	

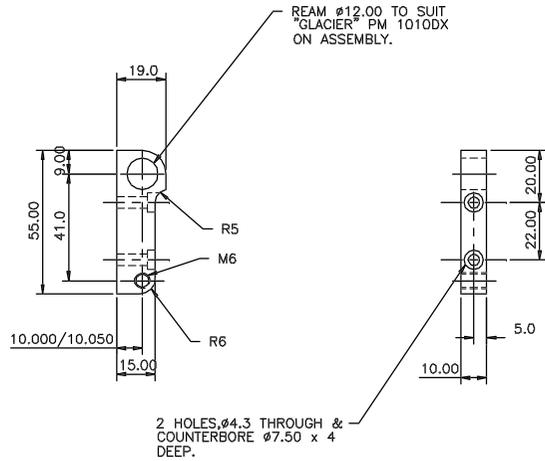
NOTE 1 WAS W/GG/006

NOTE 1 WAS W/GG/004

Tolerance (Unless stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
X +/-				Finish		Drg.No.		ROYAL GREENWICH OBSERVATORY		Title		Drawing No.	
X.X +/-				Used on		No.Reg.		MADINGLEY ROAD		DETAILS		W/BL/406-408	
X.XX +/-								CAMBRIDGE CB3 0EZ					
ANG. +/-													

Drawing No.
W/BL/413-416

REMOVE ALL SHARP EDGES



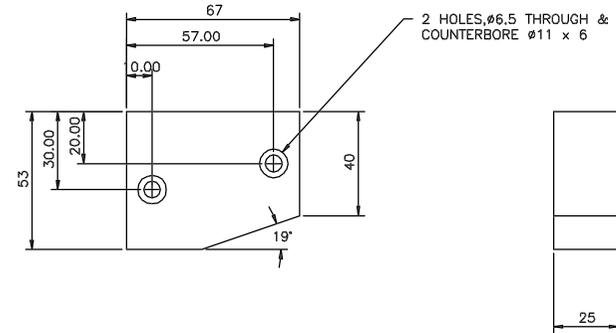
2 HOLES, #4.3 THROUGH & COUNTERBORE #7.50 x 4 DEEP.

REAM #12.00 TO SUIT "GLACIER" PM 1010DX ON ASSEMBLY.

13 CLAMP & CYLINDER PIVOT			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.3
FINISH	No. REQD. PER UNIT	xx	0.5
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/413	

NOTE 1 WAS W/GG/011

REMOVE ALL SHARP EDGES



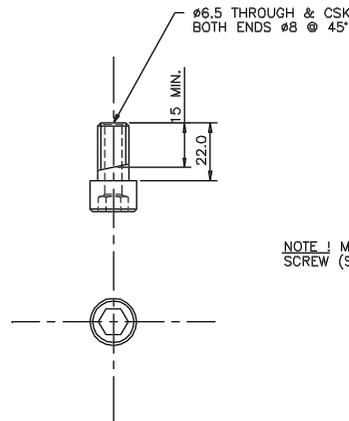
2 HOLES, #6.5 THROUGH & COUNTERBORE #11 x 6

NOTE 1 ALL EDGES & CORNERS CAN HAVE R2 MAX.

15 COUNTER BALANCE WEIGHT			
MATERIAL	SCALE	TOLERANCES	
LEAD	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	4	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/415	

NOTE 1 WAS W/GG/013

REMOVE ALL SHARP EDGES

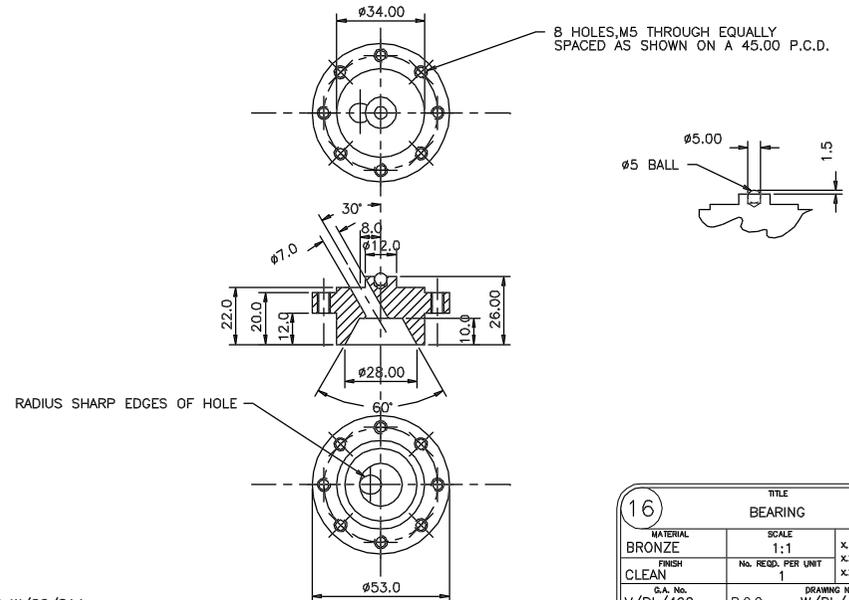


NOTE 1 MODIFY A M12 x 25 SOC HD CAP SCREW (STAINLESS STEEL)

14 SCREW			
MATERIAL	SCALE	TOLERANCES	
ST. STEEL	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/414	

NOTE 1 WAS W/GG/012

REMOVE ALL SHARP EDGES



8 HOLES, M5 THROUGH EQUALLY SPACED AS SHOWN ON A 45.00 P.C.D.

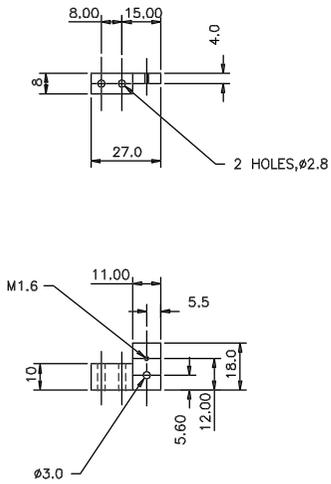
NOTE 1 WAS W/GG/014

16 BEARING			
MATERIAL	SCALE	TOLERANCES	
BRONZE	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/416	

Tolerance (Unless otherwise stated)						Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
X	+	-													
XX	+	-													
XXX	+	-													
ANG.	+	-													
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	JUNE 01	PROMEC	Drg.No.	No.Req.	ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ		Title DETAILS	
														Drawing No. W/BL/413-416	

Drawing No.
W/BL/417-421

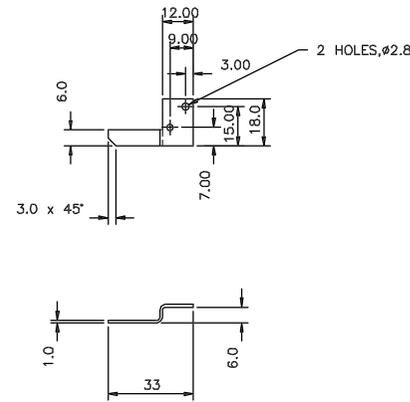
REMOVE ALL SHARP EDGES



TITLE			
17 PROXIMITY SWITCH BRACKET			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	2	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/417	

WAS W/GG/015

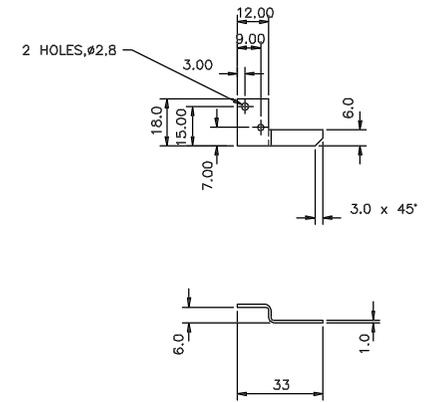
REMOVE ALL SHARP EDGES



TITLE			
19 PROXIMITY SWITCH FLAG			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/419	

NOTE 1 WAS W/GG/017

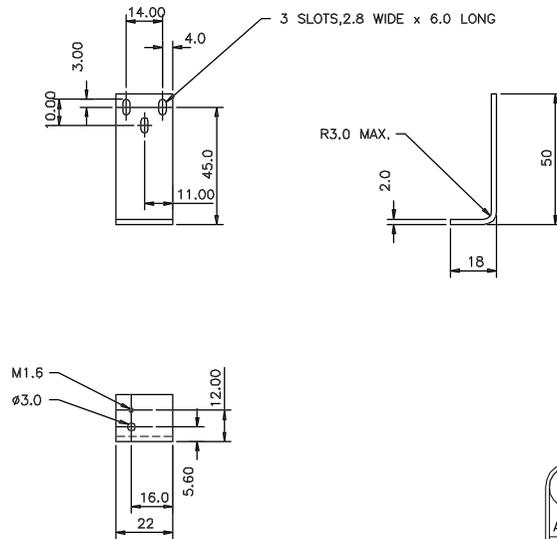
REMOVE ALL SHARP EDGES



TITLE			
20 PROXIMITY SWITCH FLAG			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/420	

NOTE 1 WAS W/GG/017

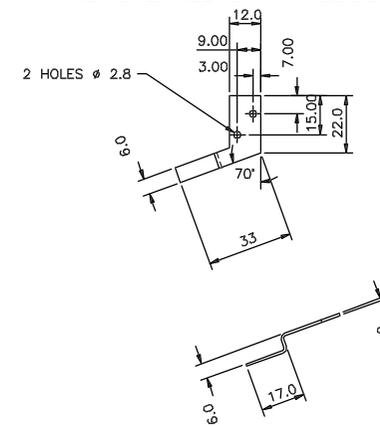
REMOVE ALL SHARP EDGES



TITLE			
18 PRXIMITY SWITCH BRACKET			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/418	

NOTE 1 WAS W/GG/016

REMOVE ALL SHARP EDGES



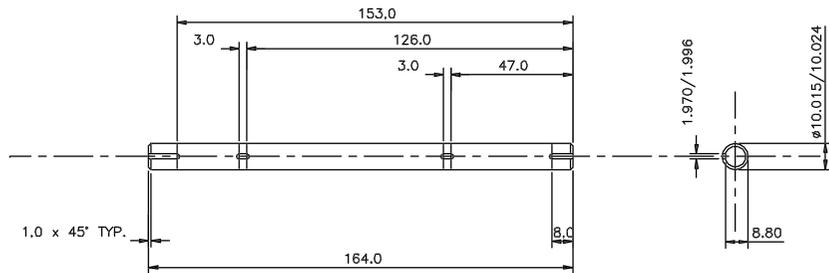
TITLE			
21 PROXIMITY SWITCH FLAG			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/421	

NOTE 1 WAS W/GG/018

Tolerance (Unless otherwise stated)						Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
X +/-						ALUMINIUM		ROYAL GREENWICH OBSERVATORY		1:1		Title		Drawing No.	
XX +/-						Finish		MADINGLEY ROAD		CB3 0EZ		DETAILS		W/BL/417-421	
XXX +/-						Drg.No.		No. Req.							
ANG. +/-						Used on									

Drawing No.
W/BL/422-426

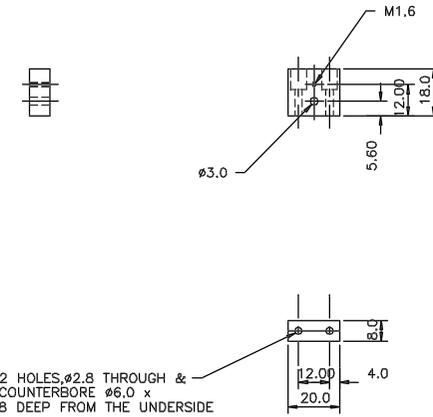
REMOVE ALL SHARP EDGES



22		TITLE		CLAMP SPINDLE	
MATERIAL	SCALE	TOLERANCES			
ST. ST. 321	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
CLEAN	1	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	R.G.O. W/BL/422				

NOTE J WAS W/GG/019

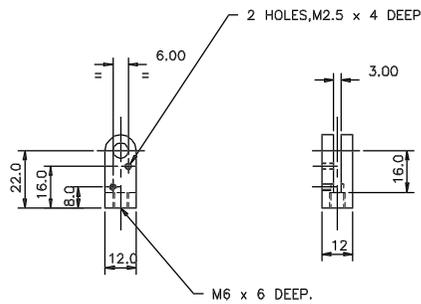
REMOVE ALL SHARP EDGES



25		TITLE		PROXIMITY SWITCH BRACKET	
MATERIAL	SCALE	TOLERANCES			
ALUMINIUM	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	2	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	R.G.O. W/BL/425				

NOTE J WAS W/GG/021

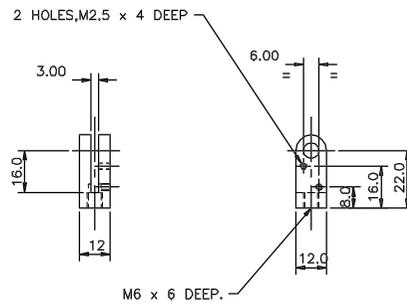
REMOVE ALL SHARP EDGES



23		TITLE		CLEVIS	
MATERIAL	SCALE	TOLERANCES			
BRASS	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK NICKEL PLT	2	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	R.G.O. W/BL/423				

NOTE J WAS W/GG/020

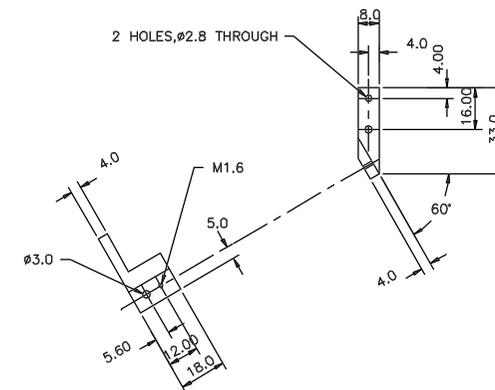
REMOVE ALL SHARP EDGES



24		TITLE		CLEVIS	
MATERIAL	SCALE	TOLERANCES			
BRASS	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK NICKEL PLT	1	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	R.G.O. W/BL/424				

NOTE J WAS W/GG/022

REMOVE ALL SHARP EDGES



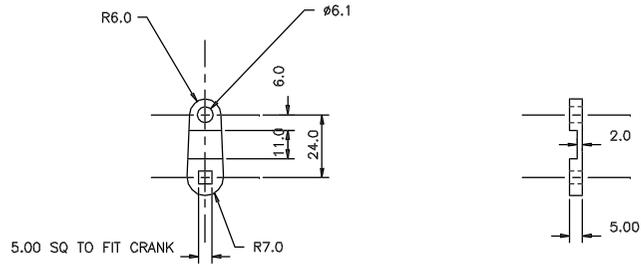
26		TITLE		PROXIMITY SWITCH BRACKET	
MATERIAL	SCALE	TOLERANCES			
ALUMINIUM	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	1	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	R.G.O. W/BL/426				

NOTE J WAS W/GG/020

Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
X	+/-							Title		Drawing No.	
X,X	+/-	Finish		Drg.No. No.Req.		ROYAL GREENWICH OBSERVATORY		DETAILS		W/BL/422-426	
X,XX	+/-			Used on		MADINGLEY ROAD					
ANG.	+/-					CAMBRIDGE CB3 0EZ					

Drawing No.
W/BL/427-429

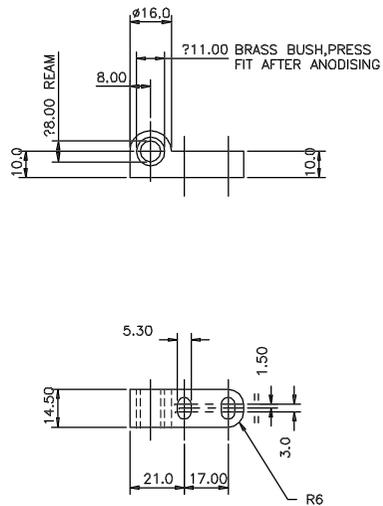
REMOVE ALL SHARP EDGES



NOTE J WAS W/GG/023

27		TITLE	
		CRANK ARM	
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/427	

REMOVE ALL SHARP EDGES

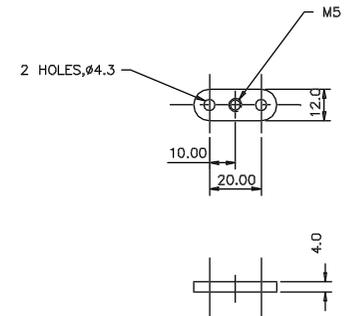


NOTE J WAS W/GG/024

28		TITLE	
		PRE-LOAD CRANK BEARING	
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/428	

NOTE J WAS W/GG/026

REMOVE ALL SHARP EDGES

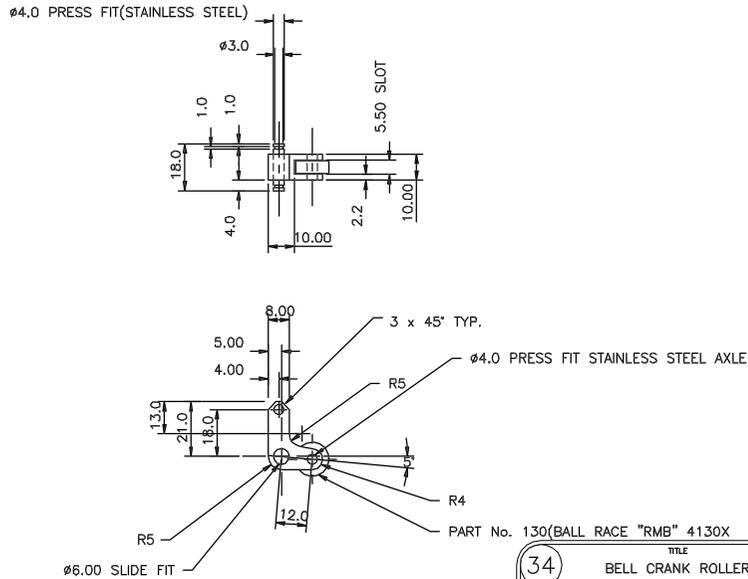


29		TITLE	
		LOCK NUT	
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	3	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/429	

				Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-		Finish		Drg.No.		No. Req.		Title		Drawing No.	
JUNE 91 PROMEC				X.X +/-		ROYAL GREENWICH OBSERVATORY		MADINGLEY ROAD		CAMBRIDGE		CB3 0EZ		W/BL/427-429	
Issue Mod.No Date Drawn by Issue Mod.No Date Drawn by				X.XX +/-		Used on						DETAILS			
				ANG. +/-											

Drawing No.
W/BL/434-437

REMOVE ALL SHARP EDGES

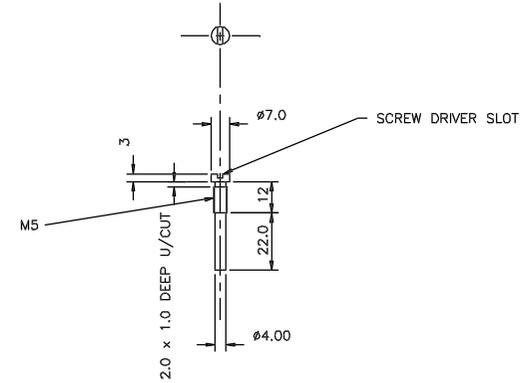


NOTE 1 WAS W/GG/031

34 BELL CRANK ROLLER			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	2	xxx	0.1
G.A. No.	R.G.O.	DRAWING No.	
V/BL/400		W/BL/434	

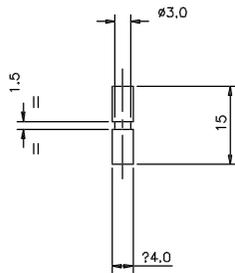
NOTE 1 WAS W/GG/033

REMOVE ALL SHARP EDGES



36 STOP SCREW			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT.	2	xxx	0.1
G.A. No.	R.G.O.	DRAWING No.	
V/BL/400		W/BL/436	

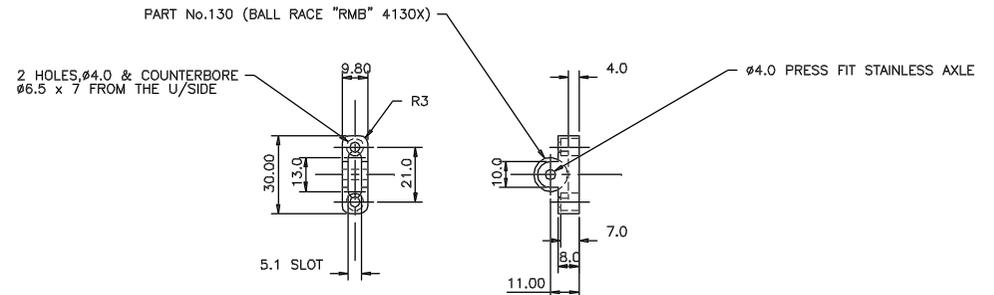
REMOVE ALL SHARP EDGES



35 SPRING RETAINER			
MATERIAL	SCALE	TOLERANCES	
STAINLESS ST.	2:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	4	xxx	0.1
G.A. No.	R.G.O.	DRAWING No.	
V/BL/400		W/BL/435	

NOTE 1 WAS W/GG/032

REMOVE ALL SHARP EDGES



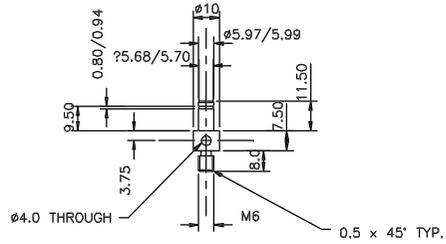
NOTE 1 WAS W/GG/034

37 SIDE ROLLER			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT.	1	xxx	0.1
G.A. No.	R.G.O.	DRAWING No.	
V/BL/400		W/BL/437	

Tolerance (Unless otherwise stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	Drg.No.	No.Req.	ROYAL GREENWICH OBSERVATORY	Title	Drawing No.	
										MADINGLEY ROAD	DETAILS	W/BL/434-437	
										CAMBRIDGE			
										CB3 0EZ			

Drawing No.
W/BL/438-442

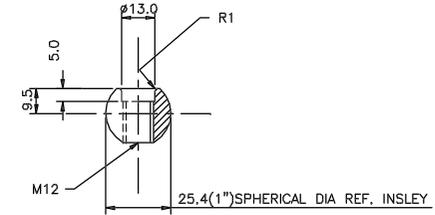
REMOVE ALL SHARP EDGES



38			
TITLE CYLINDER PIVOT			
MATERIAL	SCALE	TOLERANCES	
AISI 321	1:1	x	0.5
FINISH	No. RECD. PER UNIT	x,x	0.3
CLEAN	3	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/438		

NOTE 1 WAS W/GG/035

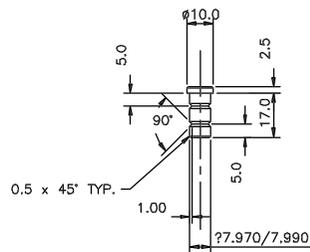
REMOVE ALL SHARP EDGES



40			
TITLE BALL			
MATERIAL	SCALE	TOLERANCES	
AISI 316 OR 304	1:1	x	0.5
FINISH	No. RECD. PER UNIT	x,x	0.3
CLEAN	1	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/440		

NOTE 1 WAS W/GG/037

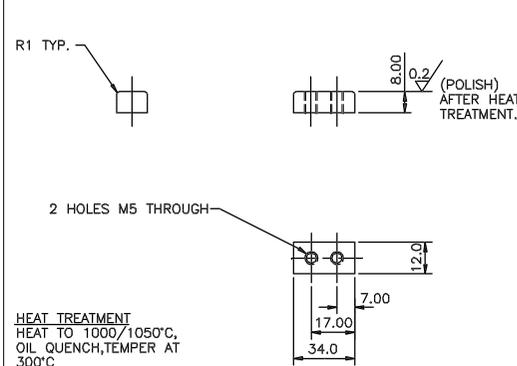
REMOVE ALL SHARP EDGES



39			
TITLE CATCH			
MATERIAL	SCALE	TOLERANCES	
AISI 321	1:1	x	0.5
FINISH	No. RECD. PER UNIT	x,x	0.3
CLEAN	3	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/439		

NOTE 1 WAS W/GG/036

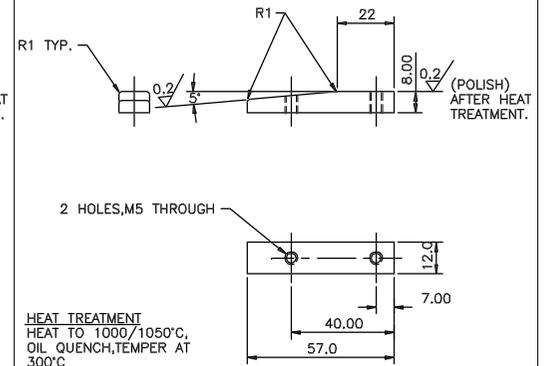
REMOVE ALL SHARP EDGES



41			
TITLE LOCATION PAD			
MATERIAL	SCALE	TOLERANCES	
AISI 440C	1:1	x	0.5
FINISH	No. RECD. PER UNIT	x,x	0.3
CLEAN	1	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/441 ISSUE A		

NOTE 1 WAS W/GG/038

REMOVE ALL SHARP EDGES



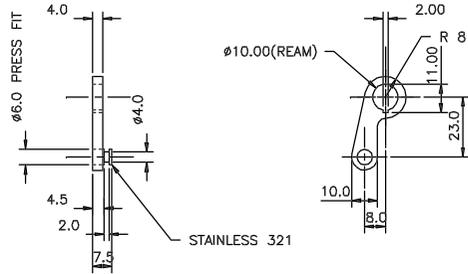
42			
TITLE LOCATION PAD			
MATERIAL	SCALE	TOLERANCES	
AISI 440C	1:1	x	0.5
FINISH	No. RECD. PER UNIT	x,x	0.3
CLEAN	2	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/442		

NOTE 1 WAS W/GG/038

Material				Scale				Title			
Tolerance (Unless otherwise stated)				ROYAL GREENWICH OBSERVATORY				THIRD ANGLE PROJECTION			
x +/-				MADINGLEY ROAD				DETAILS			
x,x +/-				CAMBRIDGE CB3 0EZ				GA No.			
x,xx +/-				Drg.No. No.Req. Used on				Drawing No.			
ANG. +/-								W/BL/438-442			

Drawing No.
W/BL/443-446

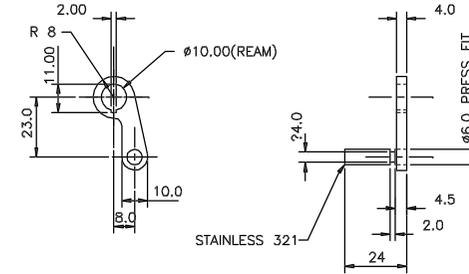
REMOVE ALL SHARP EDGES



43 TITLE			
SPRING ANCHOR			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/443	

NOTE 1 WAS W/GG/039

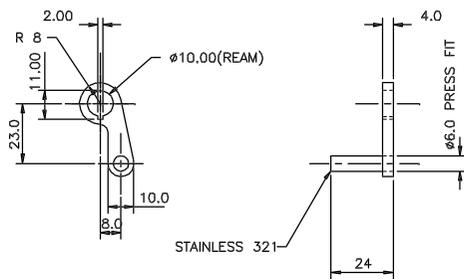
REMOVE ALL SHARP EDGES



45 TITLE			
SPRING ANCHOR			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/445	

NOTE 1 WAS W/GG/039

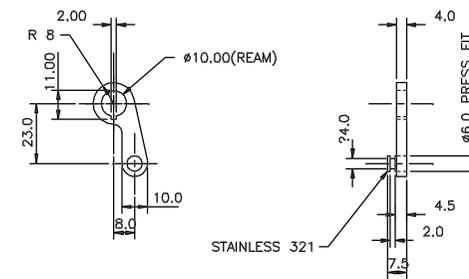
REMOVE ALL SHARP EDGES



44 TITLE			
SPRING ANCHOR			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/444	

NOTE 1 WAS W/GG/039

REMOVE ALL SHARP EDGES



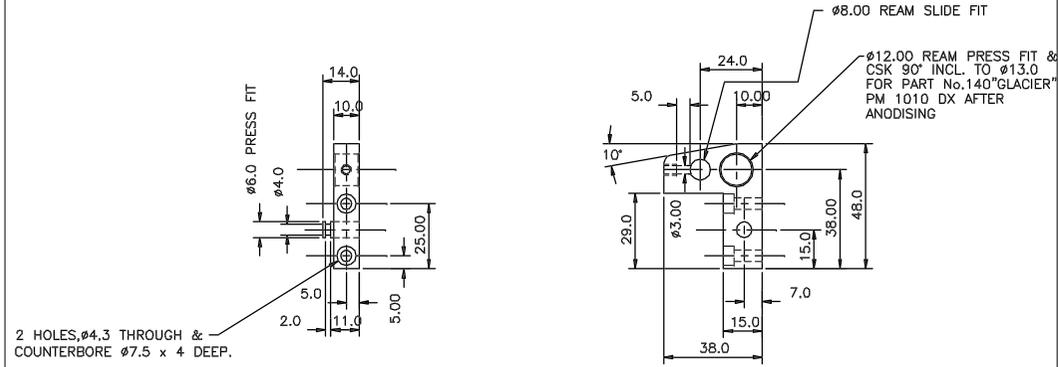
46 TITLE			
SPRING ANCHOR			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/446	

NOTE 1 WAS W/GG/039

Issue				Date				Drawn by		Issue		Date		Drawn by		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				JUNE 01				PROMEC																W/BL/443-446	
																						ROYAL GREENWICH OBSERVATORY		Drawing No.	
																						MADINGLEY ROAD		W/BL/443-446	
																						CAMBRIDGE		CB3 0EZ	
																						DETAILS			

Drawing No.
W/BL/447-451

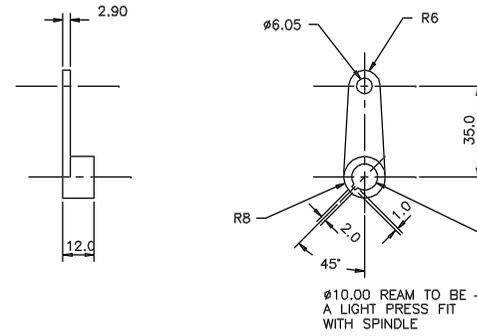
REMOVE ALL SHARP EDGES



47 PIVOT BLOCK			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/447	

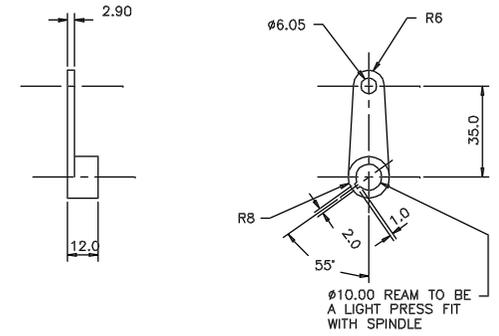
NOTE 1 WAS W/GG/040

REMOVE ALL SHARP EDGES



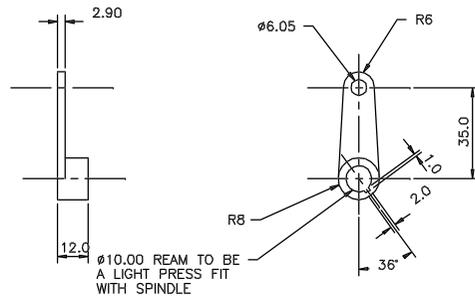
49 LEVER			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/449	

REMOVE ALL SHARP EDGES



50 LEVER			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/450	

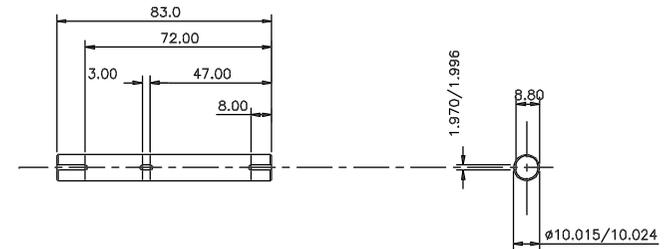
REMOVE ALL SHARP EDGES



48 LEVER			
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/448	

NOTE 1 WAS W/GG/041

REMOVE ALL SHARP EDGES

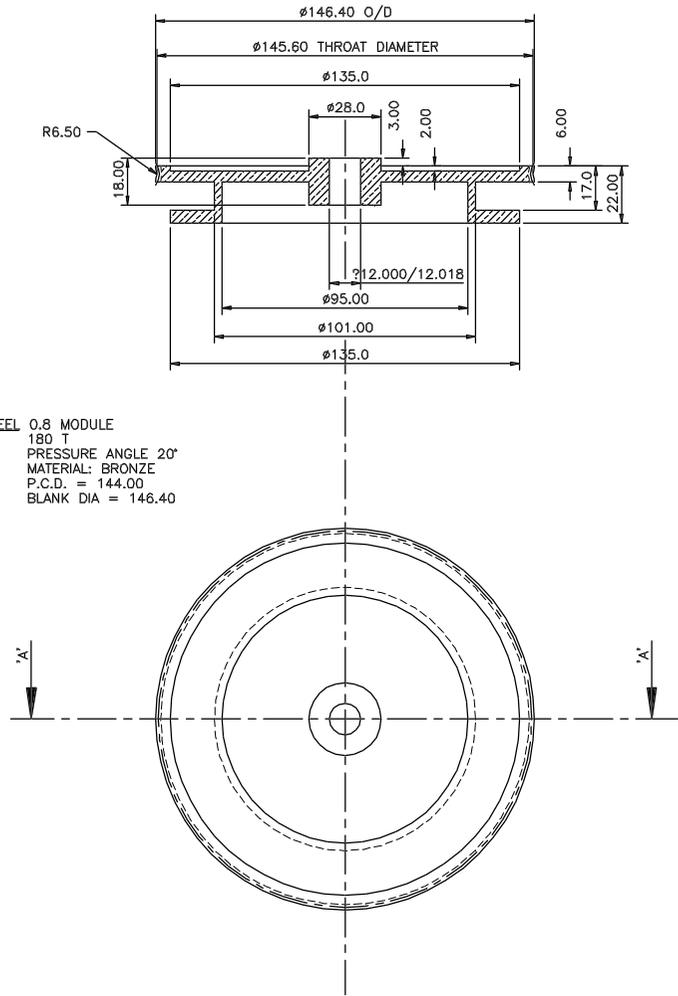


51 CLAMP SPINDLE			
MATERIAL	SCALE	TOLERANCES	
ST.ST. 321	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	2	xxx	0.1
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/451	

NOTE 1 WAS W/GG/042

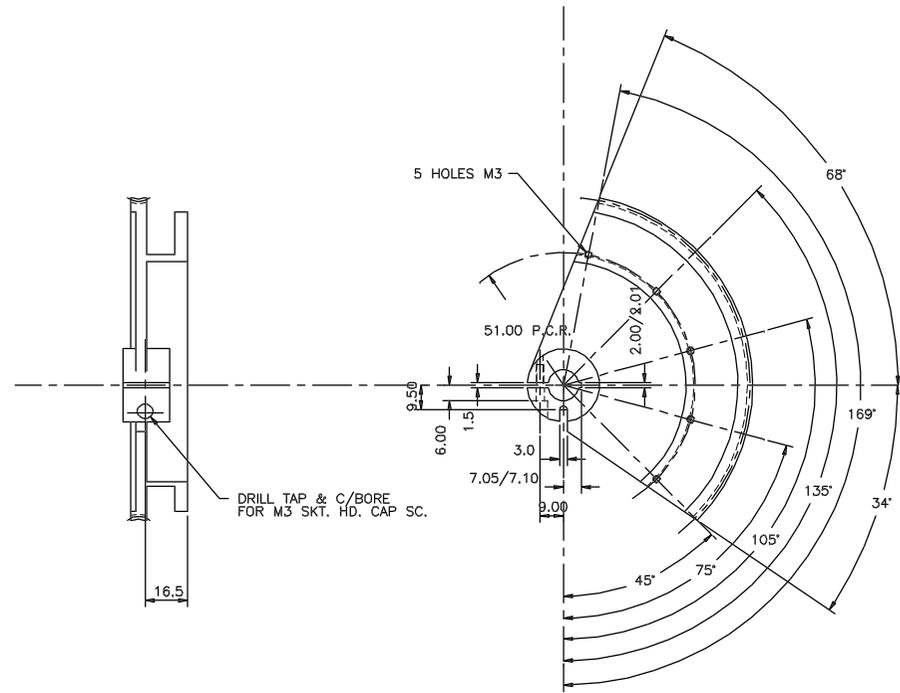
Tolerance (Unless otherwise stated)						Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.			
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	Drg.No.	No.Req.	ROYAL GREENWICH OBSERVATORY	MADINGLEY ROAD	CAMBRIDGE	CB3 0EZ	Title		Drawing No.	
														DETAILS		W/BL/447-451	

REMOVE ALL SHARP EDGES



WORM WHEEL 0.8 MODULE
180 T
PRESSURE ANGLE 20°
MATERIAL: BRONZE
P.C.D. = 144.00
BLANK DIA = 146.40

NOTE I INITIAL MACHING



DRILL TAP & C/BORE
FOR M3 SKT. HD. CAP SC.

NOTE J FINAL MACHING

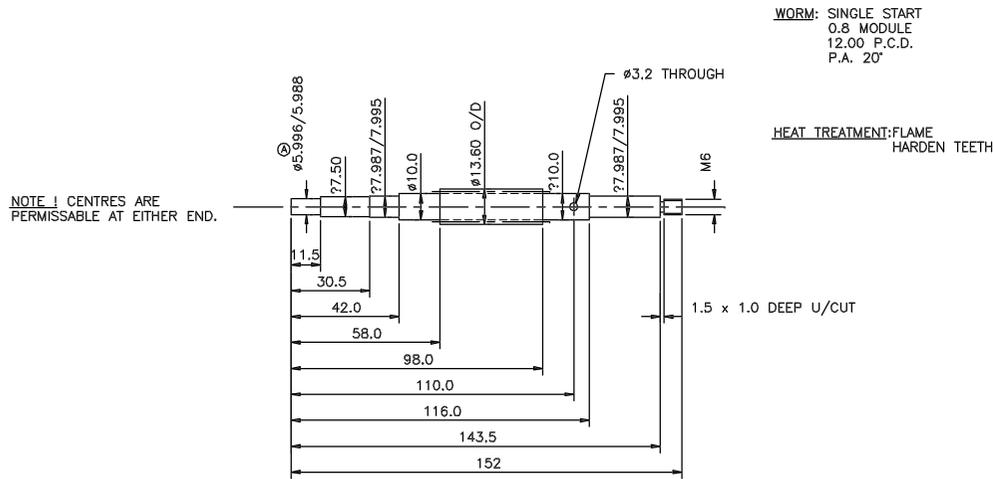
NOTE J WAS W/GG/049

				Tolerance (Unless otherwise stated)				Material	Dimns. in m.m.		Scale	THIRD ANGLE PROJECTION		GA No.
				X +/-				Finish	Drg.No.		ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ	Title		Drawing No. W/BL/456
				XX +/-					No. Req.			DETAIL		
				XXX +/-					Used on					
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by							
				JUNE 91 PROMEC										
				ANG. +/-										

56		TITLE WORM WHEEL	
MATERIAL	SCALE	TOLERANCES	
BRONZE	1:1	x	0.5
FINISH	No. REQ. PER UNIT	XX	0.3
CLEAN	1	XXX	0.1
D.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/456	

Drawing No.
W/BL/457-460

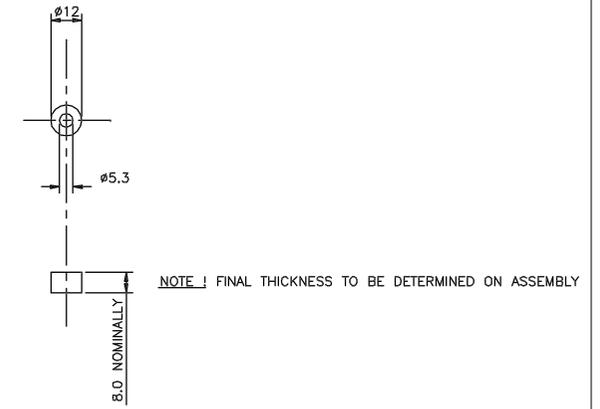
REMOVE ALL SHARP EDGES



57			
TITLE WORM			
MATERIAL	SCALE	TOLERANCES	
EN 24	1:1	x	0.5
FINISH	No. RECD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	B R.G.O. W/BL/457	ISS A	

NOTE 1 WAS W/GG/048

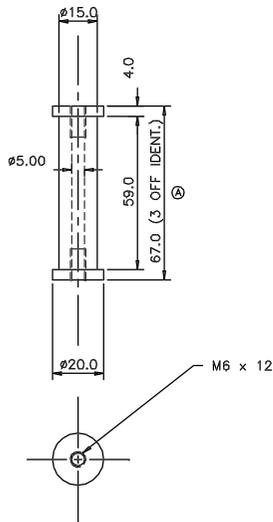
REMOVE ALL SHARP EDGES



59			
TITLE SPACER			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. RECD. PER UNIT	xx	0.3
BLK ANODISE	3	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	B R.G.O. W/BL/459		

NOTE 1 WAS W/GG/052

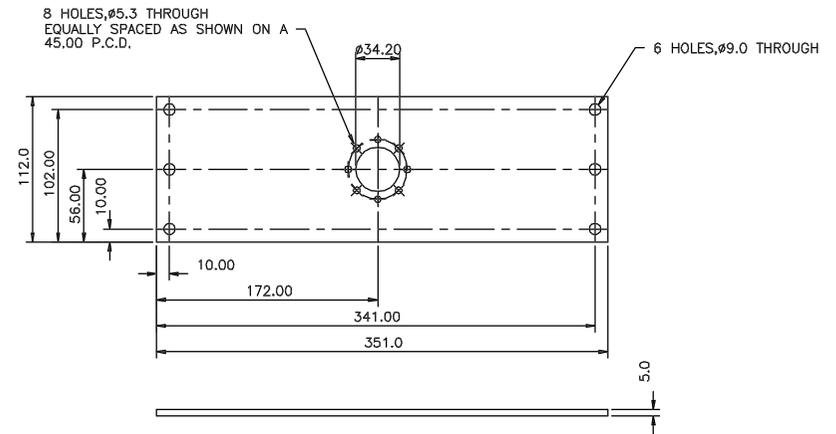
REMOVE ALL SHARP EDGES



58			
TITLE PILLAR			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. RECD. PER UNIT	xx	0.3
BLK ANODISE	3	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	B R.G.O. W/BL/458	ISS A	

NOTE 1 WAS W/GG/050

REMOVE ALL SHARP EDGES



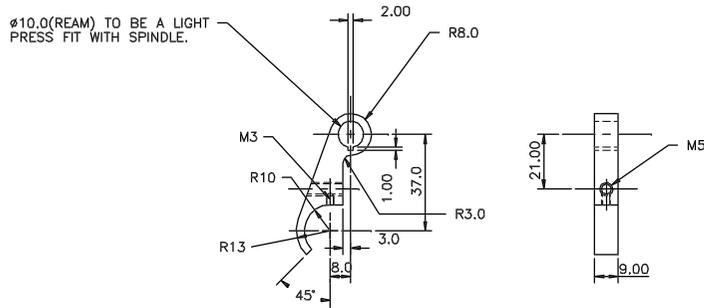
60			
TITLE DIAPHRAGM			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:2	x	0.5
HP-30-TF	No. RECD. PER UNIT	xx	0.3
FINISH	1	xxx	0.1
BLK ANODISE			
G.A. No.	DRAWING No.		
V/BL/400	B R.G.O. W/BL/460		

NOTE 1 WAS W/GG/053

Tolerance (Unless otherwise stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
x +/-				Finish		ROYAL GREENWICH OBSERVATORY		Title		DETAILS		Drawing No.	
xx +/-				Drg.No.		MADINGLEY ROAD		Used on		CAMBRIDGE CB3 0EZ		W/BL/457-460	
xxx +/-				No. Req.		CAMBRIDGE CB3 0EZ						FILE WBL457A	
ANG. +/-													

Drawing No.
W/BL/461-465

REMOVE ALL SHARP EDGES

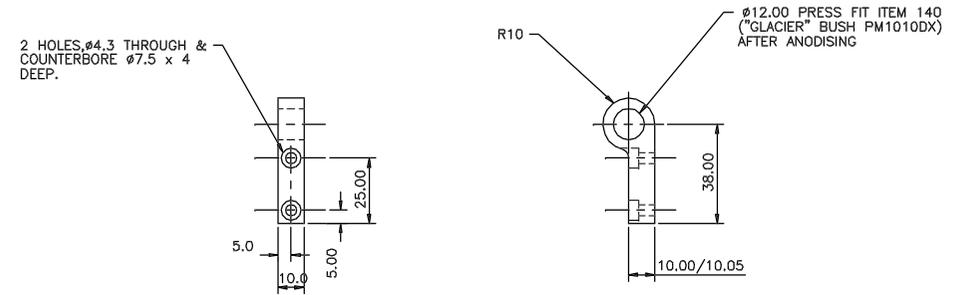


NOTE 1 WAS W/GG/054

61 CLAMP			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x,x	0.3
BLK ANODISE	3	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/461		

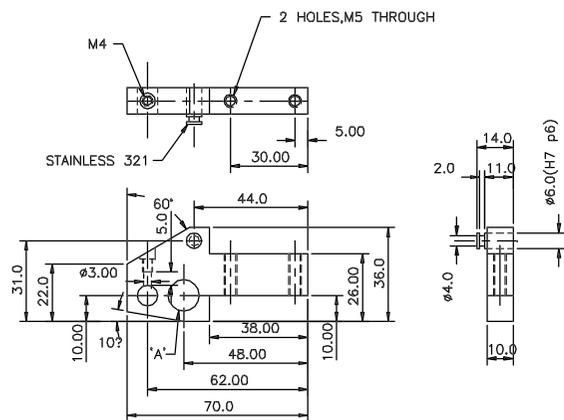
NOTE 1 WAS W/GG/056

REMOVE ALL SHARP EDGES



64 CLAMP PIVOT			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x,x	0.3
BLK ANODISE	1	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/464		

REMOVE ALL SHARP EDGES

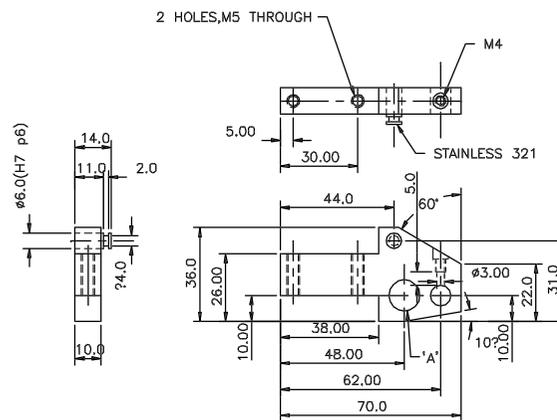


HOLE 'A':-REAM #12.00,PRESS FIT ITEM 140('GLACIER' BUSH PM1010DX) AFTER ANODISING

62 PIVOT BLOCK			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x,x	0.3
BLK ANODISE	1	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/462		

NOTE 1 WAS W/GG/055

REMOVE ALL SHARP EDGES

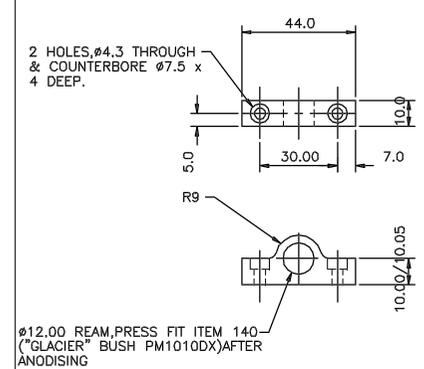


HOLE 'A':-REAM #12.00,PRESS FIT ITEM 140('GLACIER' BUSH PM1010DX) AFTER ANODISING

63 PIVOT BLOCK			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x,x	0.3
BLK ANODISE	1	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/463		

NOTE 1 WAS W/GG/057

REMOVE ALL SHARP EDGES



65 CLAMP PIVOT			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x,x	0.3
BLK ANODISE	1	x,xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/465		

NOTE 1 WAS W/GG/055

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

Tolerance (Unless otherwise stated)
x +/-
x,x +/-
x,xx +/-
ANG. +/-

Material

Drg.No.	No.Reg.	Used on

Dimns.in m.m.	Scale
ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ	

Title

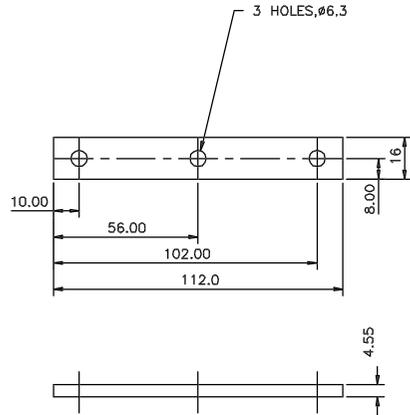
THIRD ANGLE PROJECTION

DETAILS

GA No.	Drawing No.
	W/BL/461-465

Drawing No.
W/BL/466-470

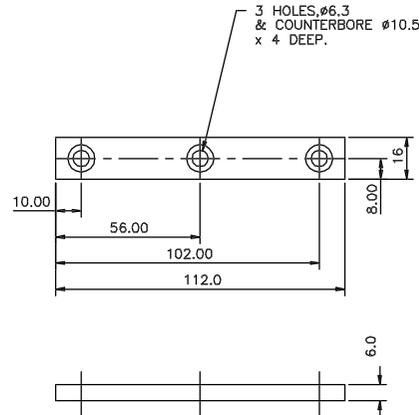
REMOVE ALL SHARP EDGES



66		TITLE		PLATE	
MATERIAL	SCALE	TOLERANCES			
HP-30-TF	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	2	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	W/BL/466				

NOTE 1 WAS W/GG/058

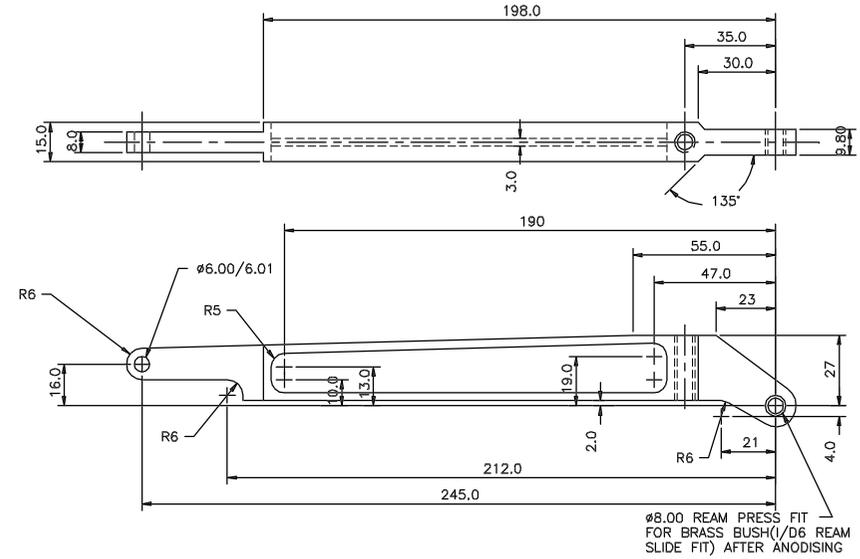
REMOVE ALL SHARP EDGES



67		TITLE		PLATE	
MATERIAL	SCALE	TOLERANCES			
HP-30-TF	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	2	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	W/BL/467				

NOTE 1 WAS W/GG/058

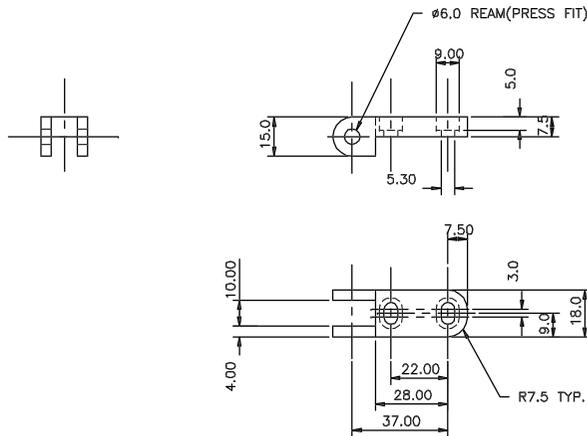
REMOVE ALL SHARP EDGES



69		TITLE		LEVER	
MATERIAL	SCALE	TOLERANCES			
HP-30-TF	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	1	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	W/BL/469				

NOTE 1 WAS W/GG/060

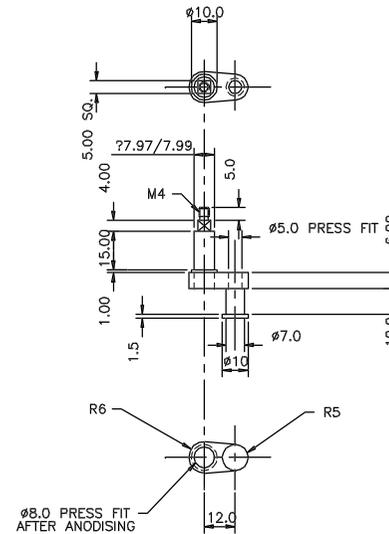
REMOVE ALL SHARP EDGES



68		TITLE		PIVOT	
MATERIAL	SCALE	TOLERANCES			
ALUMINIUM	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	1	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	W/BL/468				

NOTE 1 WAS W/GG/059

REMOVE ALL SHARP EDGES



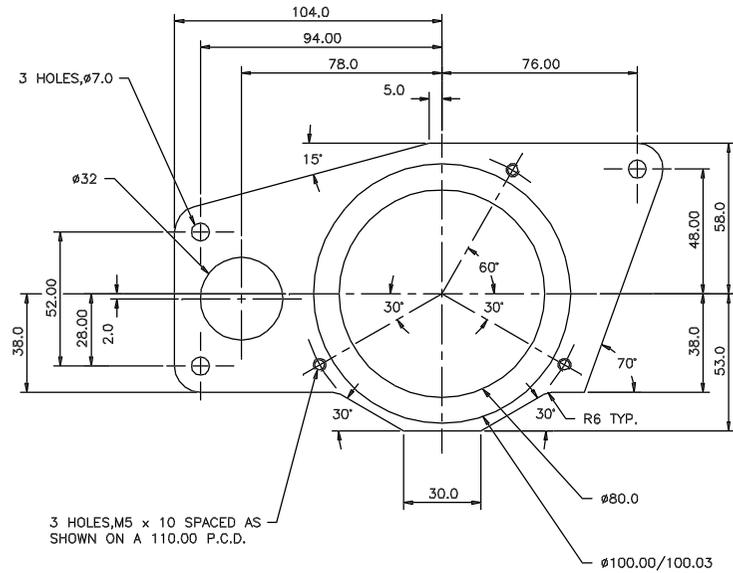
MATERIAL:- PINS: AISI 321 STAINLESS ST.
BODY: HP-30-TF ALUMINIUM

70		TITLE		CRANK	
MATERIAL	SCALE	TOLERANCES			
SEE ABOVE	1:1	x	0.5		
FINISH	No. REQD. PER UNIT	x,x	0.3		
BLK ANODISE	1	x,xx	0.1		
G.A. No.	DRAWING No.				
V/BL/400	W/BL/470				

NOTE 1 WAS W/GG/061

				Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-		ROYAL GREENWICH OBSERVATORY						Title		Drawing No.	
				X,X +/-		MADINGLEY ROAD						DETAILS		W/BL/466-470	
				X,XX +/-		CAMBRIDGE CB3 0EZ									
				ANG. +/-											
Issue		Mod.No		Date		Drawn by		Issue		Mod.No		Date		Drawn by	
				JUNE 91		PROMEC									

REMOVE ALL SHARP EDGES



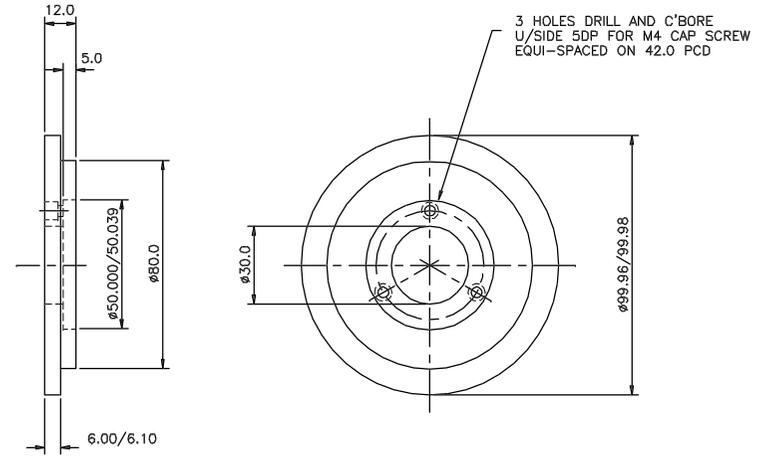
TITLE		SCALE		TOLERANCES	
71	ENCODER MOUNTING PLATE	1:1		x	0.5
MATERIAL				xx	0.3
ALUMINIUM				xxx	0.1
HP-30-TF		No. RECD. PER UNIT	1		
FINISH					
BLK ANODISE					
G.A. No.	DRAWING No.				
V/BL/400	W/BL/471				

NOTE 1 WAS W/GG/062

Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by
			A			1/2/93	PRDMECH

Material	Dimns. In m.m.	Scale	THIRD ANGLE PROJECTION		GA No.
Finish	Drg.No.	No.Req.	Title		Drawing No.
	Used on		ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ		W/BL/471-473

REMOVE ALL SHARP EDGES

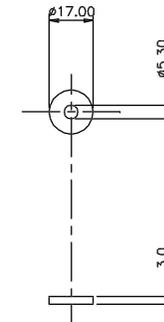


TITLE		SCALE		TOLERANCES	
72	ENCODER FLANGE	1:1		x	0.5
MATERIAL				xx	0.3
ALUMINIUM				xxx	0.1
HP-30-TF		No. RECD. PER UNIT	1		
FINISH					
BLK ANODISE					
G.A. No.	DRAWING No.				
V/BL/400	W/BL/472	ISS A			

Ⓐ PART REDESIGNED

NOTE 1 WAS W/GG/063

REMOVE ALL SHARP EDGES

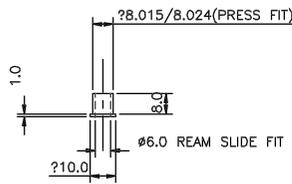
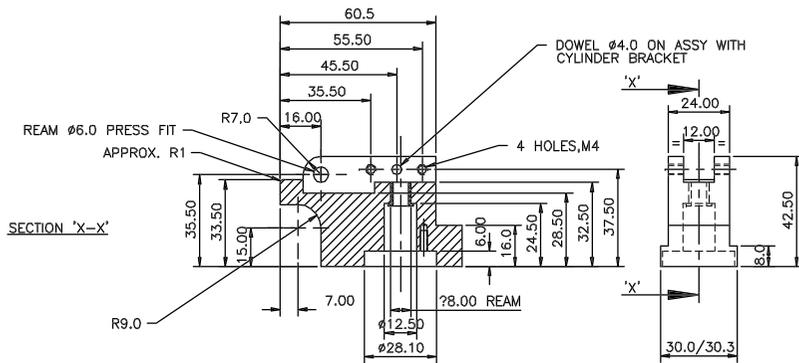
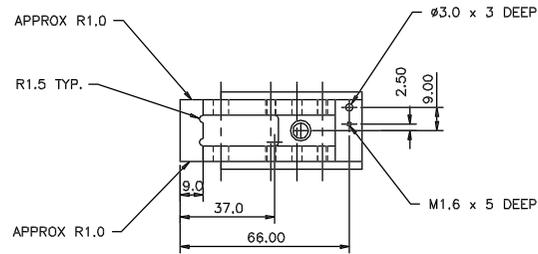


TITLE		SCALE		TOLERANCES	
73	ENCODER CLAMP	1:1		x	0.5
MATERIAL				xx	0.3
M.S.				xxx	0.1
FINISH		No. RECD. PER UNIT	3		
CAD & PASS					
G.A. No.	DRAWING No.				
V/BL/400	W/BL/473				

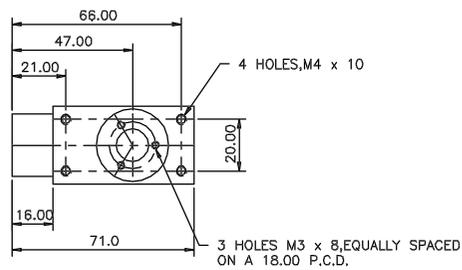
NOTE 1 WAS W/GG/064

DETAILS

REMOVE ALL SHARP EDGES



BUSH DETAIL
MATERIAL:-BRASS/BRONZE



NOTE 1 HOLE Ø8.0 REAM TO BE PRODUCED AFTER ANODISING

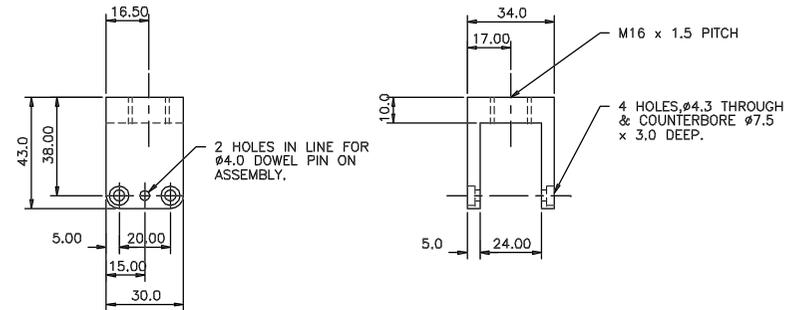
75 TITLE CLAMP BODY			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x 0.5	
FINISH	No. REQD. PER UNIT	xx 0.3	
BLK ANODISE	1	xxx 0.1	
D.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/475	

NOTE 1 WAS W/GG/067

Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by
	A	JUNE 91	PROMEC				

NOTE 1 WAS W/GG/066

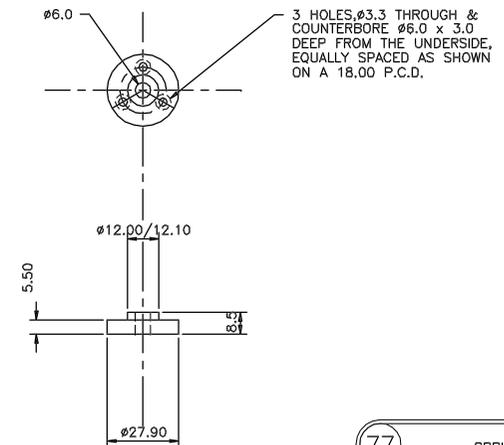
REMOVE ALL SHARP EDGES



76 TITLE CYLINDER BRACKET			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x 0.5	
FINISH	No. REQD. PER UNIT	xx 0.3	
BLK ANODISE	1	xxx 0.1	
D.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/476	

NOTE 1 WAS W/GG/067

REMOVE ALL SHARP EDGES



77 TITLE SPRING CAP			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x 0.5	
FINISH	No. REQD. PER UNIT	xx 0.3	
BLK ANODISE	1	xxx 0.1	
D.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/477	

NOTE 1 WAS W/GG/068

Dimns.	In	m.m.	Scale

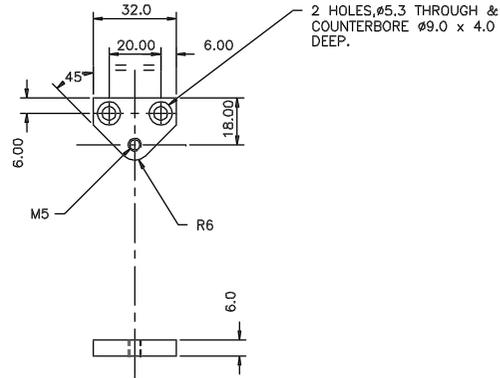
THIRD ANGLE PROJECTION		Title	

DETAILS

GA No.	

Drawing No.
W/BL/478-481

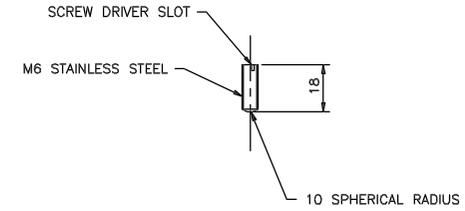
REMOVE ALL SHARP EDGES



TITLE			
78 ADJUSTER PLATE			
MATERIAL	SCALE	TOLERANCES	
HP-30-TF	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	2	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/478	

NOTE 1 WAS W/GG/069

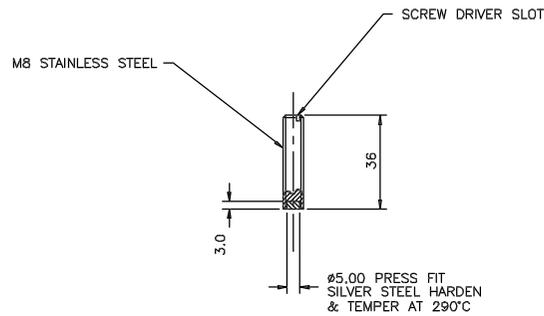
REMOVE ALL SHARP EDGES



TITLE			
80 GRATING CELL LOCATION SCREW			
MATERIAL	SCALE	TOLERANCES	
STAINLESS ST.	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
	3	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/480	

NOTE 1 WAS W/GG/471

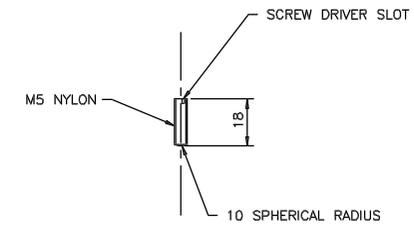
REMOVE ALL SHARP EDGES



TITLE			
79 PRE-LOAD SCREW			
MATERIAL	SCALE	TOLERANCES	
AS SHOWN	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/479	

NOTE 1 WAS W/GG/070

REMOVE ALL SHARP EDGES



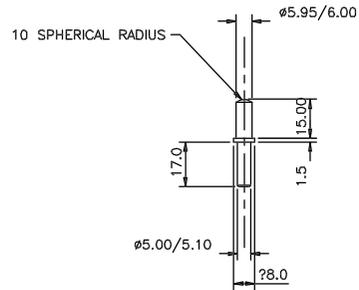
TITLE			
81 CLAMP SCREW			
MATERIAL	SCALE	TOLERANCES	
NYLON	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
	3	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/481	

NOTE 1 WAS W/GG/072

Tolerance (Unless otherwise stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
X	+	-											
xx	+	-											
xxx	+	-											
ANG.	+	-											
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	Drg.No.	No. Req.	Title		Drawing No.	
										ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ		W/BL/478-481	
										DETAILS			

Drawing No.
W/BL/482-485

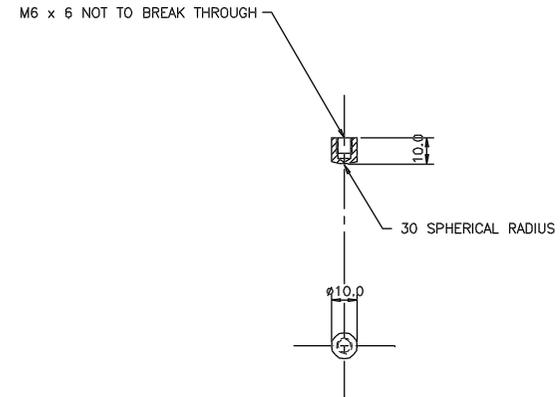
REMOVE ALL SHARP EDGES



82		TITLE	
		PLUNGER	
MATERIAL	SCALE	TOLERANCES	
AISI 321	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/482		

NOTE 1 WAS W/GG/073

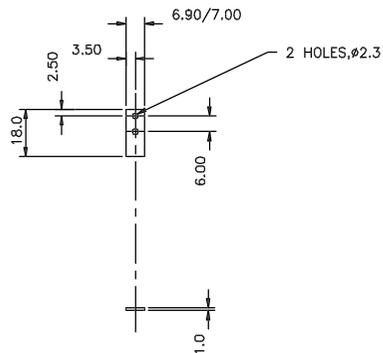
REMOVE ALL SHARP EDGES



84		TITLE	
		RAM CAP	
MATERIAL	SCALE	TOLERANCES	
BRASS	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK NICKEL PLT	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/484		

NOTE 1 WAS W/GG/075

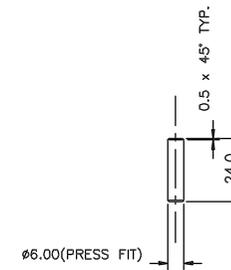
REMOVE ALL SHARP EDGES



83		TITLE	
		FLAG	
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/483		

NOTE 1 WAS W/GG/074

REMOVE ALL SHARP EDGES



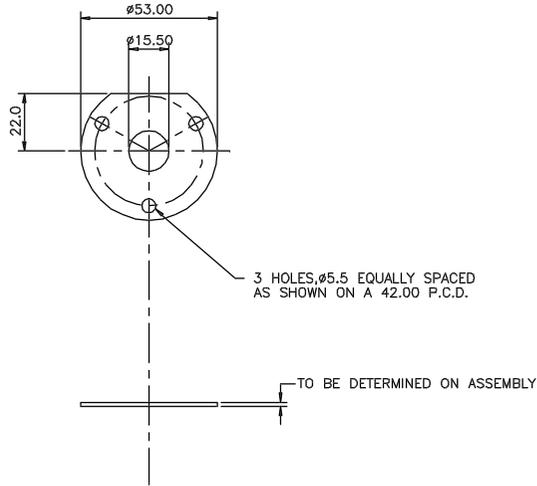
85		TITLE	
		PIVOT	
MATERIAL	SCALE	TOLERANCES	
SILVER STEEL	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/485		

NOTE 1 WAS W/GG/076

				Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-											
				X.X +/-		Finish		Drg.No.		No. Req.		Title		Drawing No.	
				X.XX +/-				Used on		ROYAL GREENWICH OBSERVATORY		DETAILS		W/BL/482-485	
				ANG. +/-						MADINGLEY ROAD					
										CAMBRIDGE		CB3 0EZ			

Drawing No.
W/BL/486-489

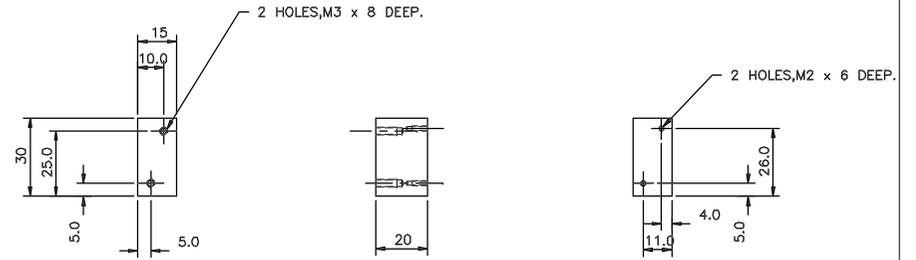
REMOVE ALL SHARP EDGES



86		TITLE	
SHIM			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM/PVC	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/486		

NOTE 1 WAS W/GG/077

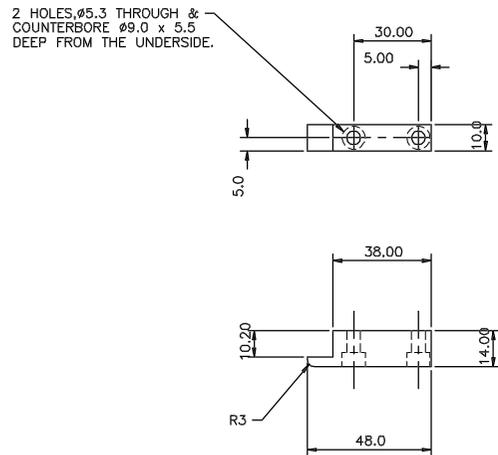
REMOVE ALL SHARP EDGES



88		TITLE	
SPACER BRACKET			
MATERIAL	SCALE	TOLERANCES	
AL. ALLOY	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	1	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/488		

NOTE 1 WAS W/GG/079

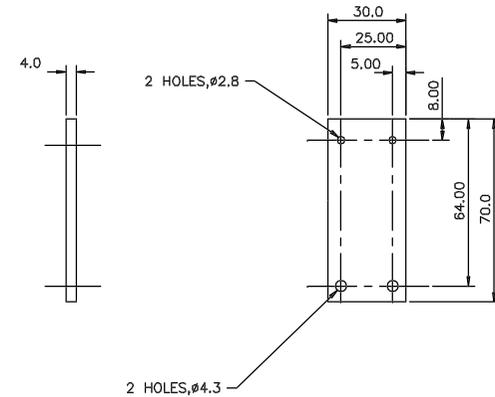
REMOVE ALL SHARP EDGES



87		TITLE	
GUIDE			
MATERIAL	SCALE	TOLERANCES	
STAINLESS ST.	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
CLEAN	2	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/487		

NOTE 1 WAS W/GG/077

REMOVE ALL SHARP EDGES

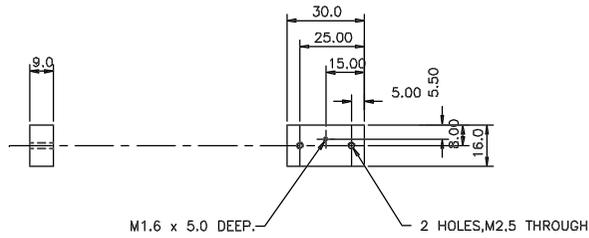


89		TITLE	
BRACKET			
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	xx	0.3
BLK ANODISE	2	xxx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/489		

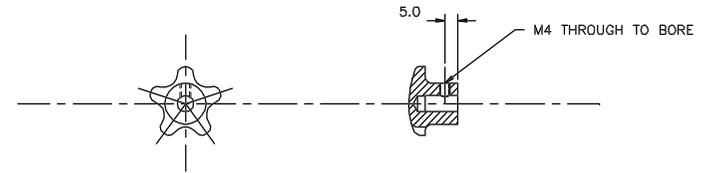
				Tolerance (Unless otherwise stated)		Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-											
				XX +/-		Finish		Drg.No.		No.Req.		Title		Drawing No.	
				XXX +/-				Used on		ROYAL GREENWICH OBSERVATORY		DETAILS		W/BL/486-489	
				ANG. +/-						MADINGLEY ROAD					
										CAMBRIDGE					
										CB3 0EZ					

Drawing No.
W/BL/490-492

REMOVE ALL SHARP EDGES



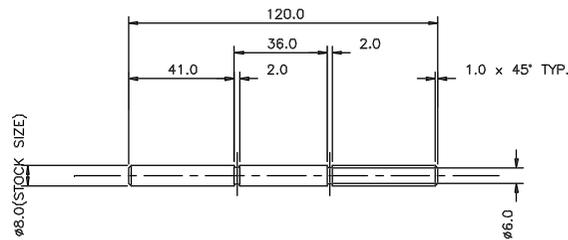
TITLE			
90	SPACER		
MATERIAL	SCALE	TOLERANCES	
ALUMINIUM	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x.x	0.3
BLK ANODISE	2	x.xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/490	



MATERIAL:- "WDS" ITEM No. 104-221

TITLE			
92	HAND KNOB		
MATERIAL	SCALE	TOLERANCES	
SEE NOTE	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x.x	0.3
CHEMI-BLK	1	x.xx	0.1
G.A. No.	DRAWING No.		
V/BL/400 B	R.G.O.	W/BL/492 ISS A	

REMOVE ALL SHARP EDGES



TITLE			
91	SPRING POST		
MATERIAL	SCALE	TOLERANCES	
SILVER STEEL	1:1	x	0.5
FINISH	No. REQD. PER UNIT	x.x	0.3
BLK ANODISE	1	x.xx	0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O.	W/BL/491	

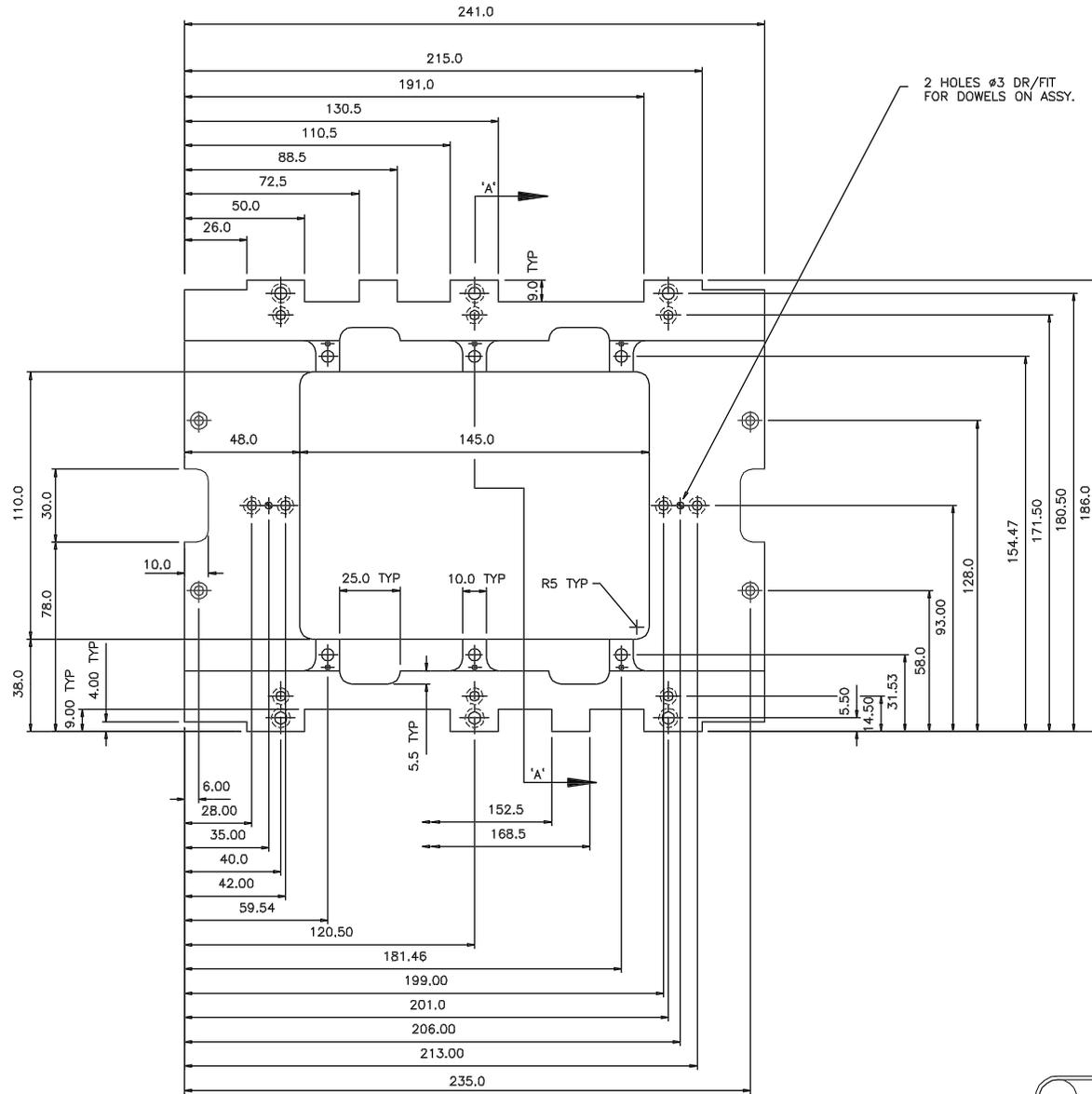
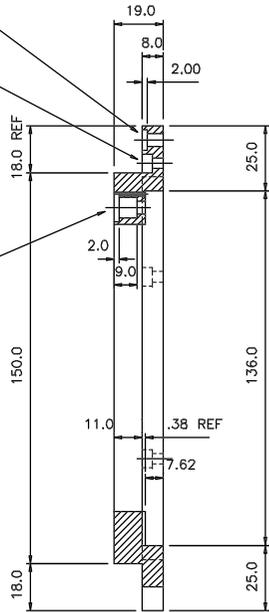
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	Tolerance (Unless otherwise stated)	Material	Finish	Drg.No.	No.Reg.	Used on	Dirns.In m.m.	Scale	THIRD ANGLE PROJECTION	Title	GA No.
				A		1/2/93	PROMECH	x +/- x.x +/- x.xx +/- ANG. +/-						ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ			DETAILS	W/BL/490-492

REMOVE SHARP EDGES

6 HOLES Ø5.000/5.012 THRO' & C'BORE Ø8.00

14 HOLES DRILL & C'BORE FOR M4 CAP SCREWS

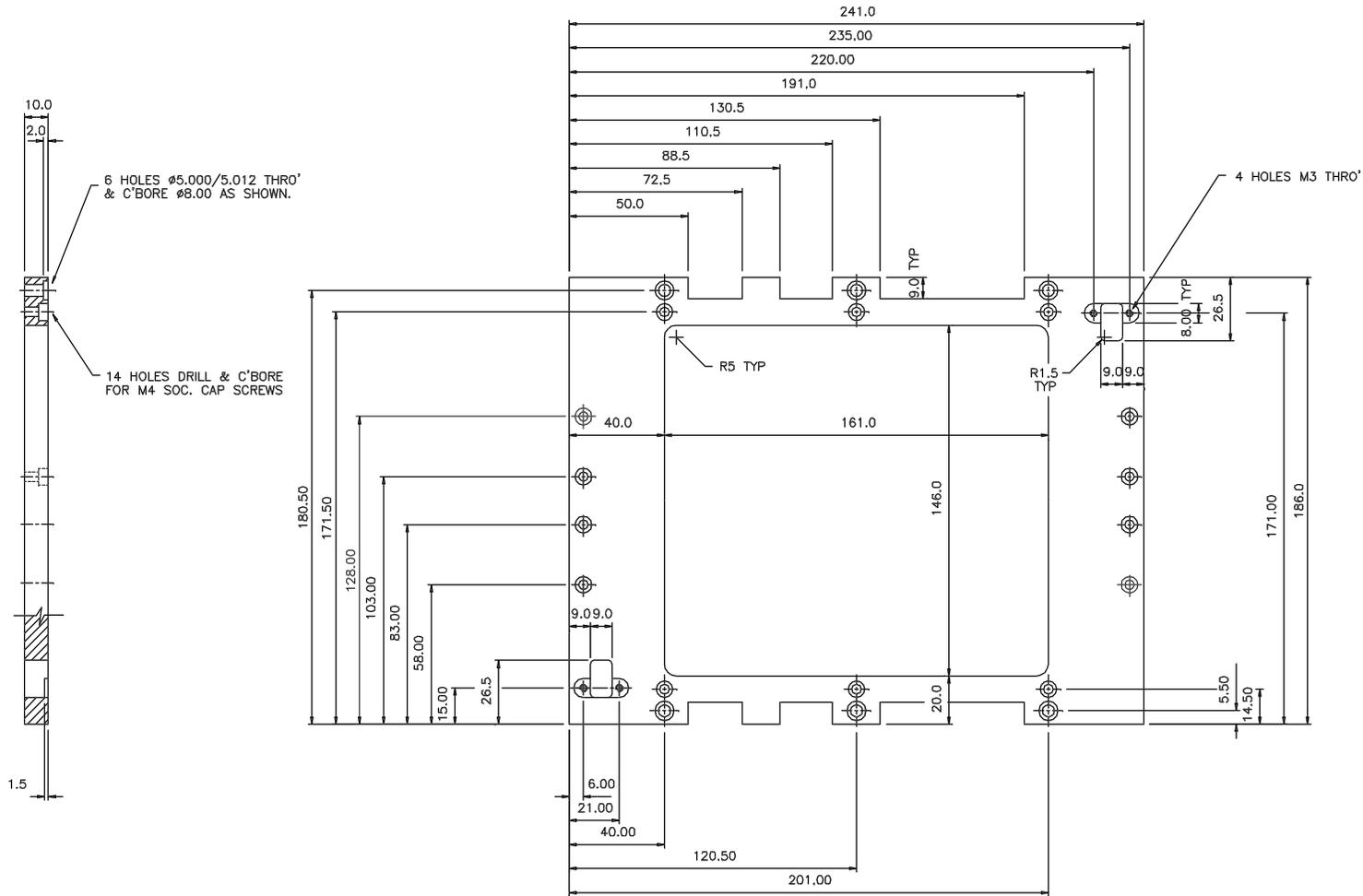
6 HOLES Ø5.0 THRO' & C'BORE Ø8.000/8.015 & Ø10.50 TO DEPTHS SHOWN. Ø1.5 DOWEL IN HEAD EDGE ON ASSY.



95		TITLE	
CELL FRONT PLATE			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
MATT BLK ANODISE	1	XXX	±0.1
GA. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/495		

				A		MAR.94		AJW		Tolerance (Unless otherwise stated) X +/- XX +/- XXX +/- ANG. +/-	Material	Dimns.in m.m.	Scale 1:1	THIRD ANGLE PROJECTION	GA No.
						JUNE 91		PROMECH							
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by			Finish	Drq.No.	No.Reg.	ROYAL GREENWICH OBSERVATORY	DETAIL	Drawing No. W/BL/495
											Used on	MADINGLEY ROAD CAMBRIDGE CB3 0EZ			

REMOVE SHARP EDGES



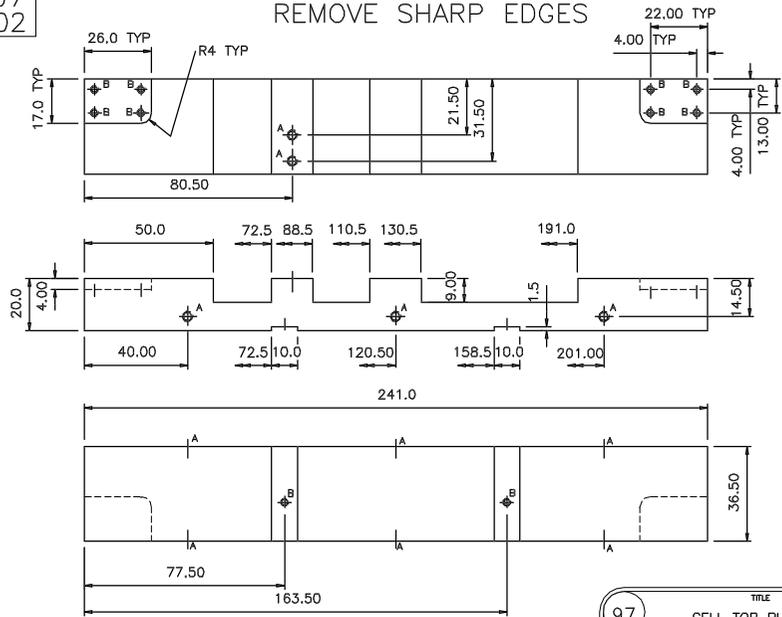
MACHINE WITH W/BL/495

96		TITLE CELL BACK PLATE	
MATERIAL ALCOA PLT.	SCALE FULL	TOLERANCES X ±0.5 XX ±0.3 XXX ±0.1	
FINISH MATT BLK ANODISE	No. REQD. PER UNIT 1		
G.A. No. V/BL/400	R.G.O.	DRAWING No. W/BL/496	

								Tolerance (Unless otherwise stated)		Material		Dimns.in m.m.		Scale 1:1		THIRD ANGLE PROJECTION		GA No.	
								X +/-											
								XX +/-		Finish		DRG.No.		No.Reg.		ROYAL GREENWICH OBSERVATORY		Title	
								XXX +/-				Used on				MADINGLEY ROAD		DETAIL	
								ANG. +/-								CAMBRIDGE CB3 0EZ		W/BL/496	
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by												

Drawing No. 497
W/BL/502

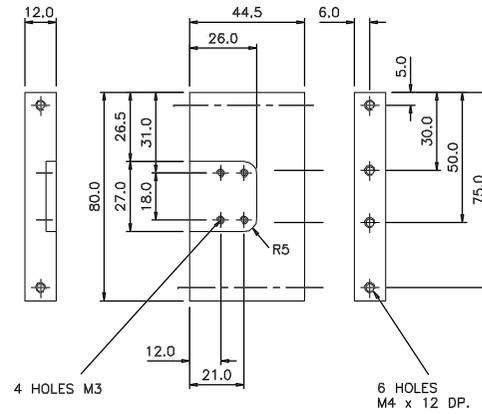
REMOVE SHARP EDGES



'A' HOLES 8-M4 x 12 DP.
'B' HOLES 10-M3 x 10 DP.

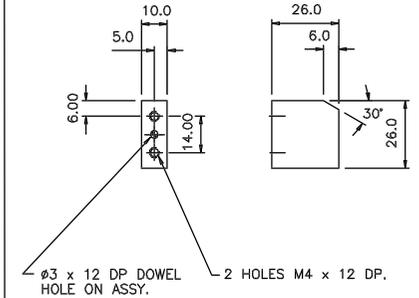
97 CELL TOP PLATE			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
MATT BLK ANODISE	1	x.x.x	±0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/497		

REMOVE SHARP EDGES



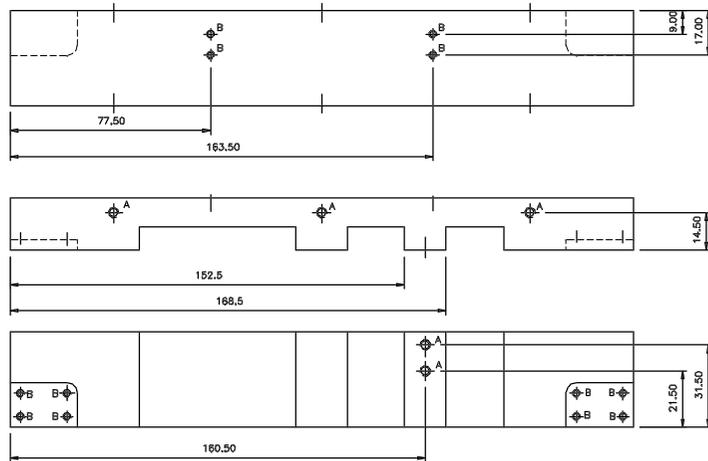
99 LATCH PLATE			
MATERIAL	SCALE	TOLERANCES	
AL ALLOY	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
MATT BLK ANODISE	2	x.x.x	±0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/499		

REMOVE SHARP EDGES



100 LOCATION PLATE			
MATERIAL	SCALE	TOLERANCES	
ST. STEEL	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
BLK NIC PLT	2	x.x.x	±0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/500		

REMOVE SHARP EDGES

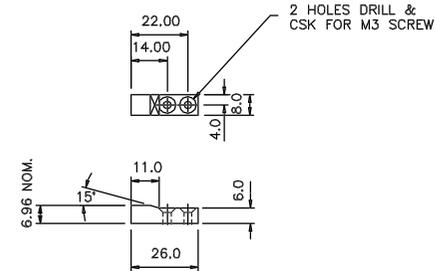


'A' HOLES 8-M4 x 12 DP.
'B' HOLES 12-M3 x 10 DP.

ALL OTHER DIMENSIONS AS FOR W/BL/497

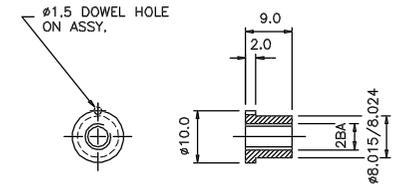
98 CELL BOTTOM PLATE			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
MATT BLK ANODISE	1	x.x.x	±0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/498		

REMOVE SHARP EDGES



101 LOCATION PLATE			
MATERIAL	SCALE	TOLERANCES	
ST. STEEL	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
BLK NIC PLT	2	x.x.x	±0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/501		

REMOVE SHARP EDGES



102 THREADED INSERT			
MATERIAL	SCALE	TOLERANCES	
STEEL	2/1	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
BLK NIC PLT	6	x.x.x	±0.1
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/502		

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

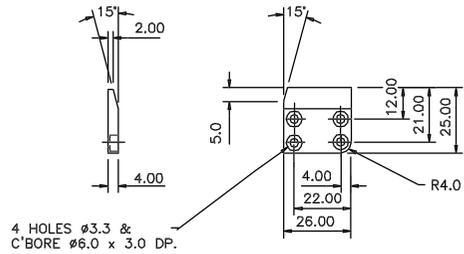
Material	Dimns. in m.m.	Scale	1:1
Finish	Drg.No.	No. Req.	
	Used on		

ROYAL GREENWICH OBSERVATORY	MADINGLEY ROAD	CAMBRIDGE	CB3 0EZ
THIRD ANGLE PROJECTION			
DETAIL			

G.A. No.
Drawing No. 497
W/BL/502

Drawing No. 503
W/BL/508

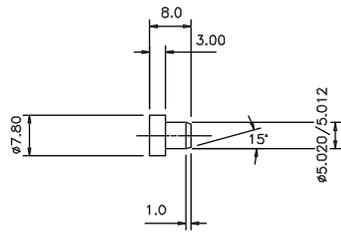
REMOVE SHARP EDGES



103 AS DRAWN
104 OPP. HAND

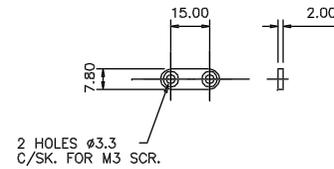
103/104 TITLE LOCATION PAD			
MATERIAL	SCALE	TOLERANCES	
ST. STL.	FULL	X	X.X
FINISH	No. RECD. PER UNIT	X.X	X.XX
BLK.NIC.PLT.	2 OFF EACH	X.XX	
G.A. No.	DRAWING No.		
W/BL/400	R.G.O. W/BL/503-504		

REMOVE SHARP EDGES



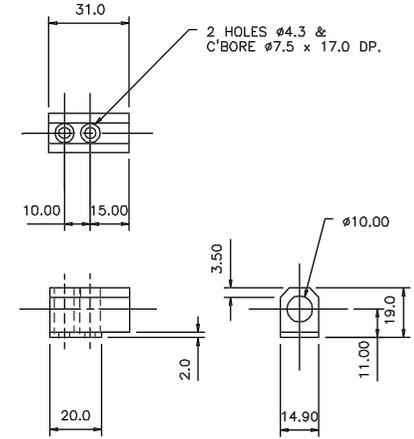
105 TITLE BUTTON			
MATERIAL	SCALE	TOLERANCES	
ST. STL.	2/1	X	X.X
FINISH	No. RECD. PER UNIT	X.X	X.XX
BLK.NIC.PLT.	12	X.XX	
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/505		

REMOVE SHARP EDGES



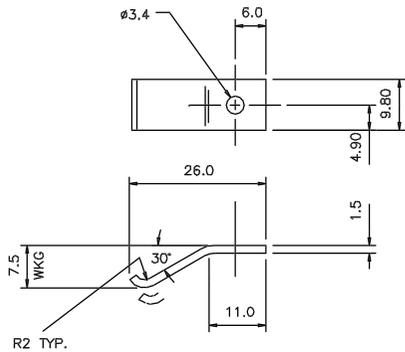
106 TITLE LATCH PLATE			
MATERIAL	SCALE	TOLERANCES	
ST. STL.	FULL	X	X.X
FINISH	No. RECD. PER UNIT	X.X	X.XX
BLK.NIC.PLT.	2	X.XX	
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/506		

REMOVE SHARP EDGES



107 TITLE TRANSPORTER LUGS			
MATERIAL	SCALE	TOLERANCES	
ALUM.ALLOY	1/1	X	X.X
FINISH	No. RECD. PER UNIT	X.X	X.XX
BLK.ANODISE	2	X.XX	
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/507		

REMOVE SHARP EDGES



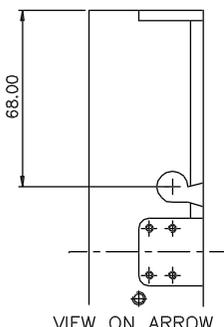
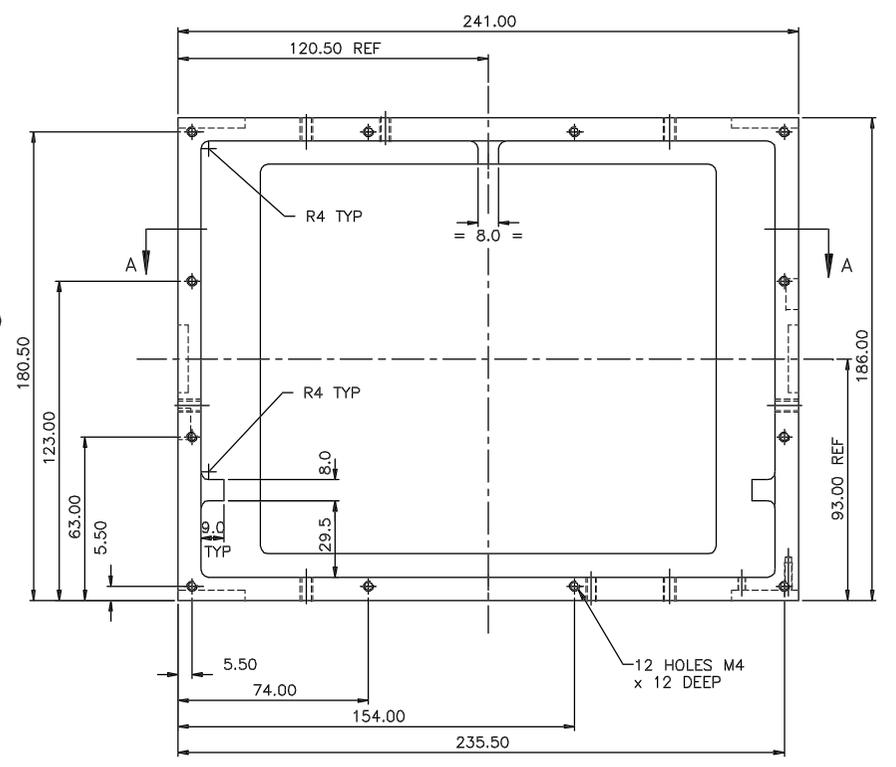
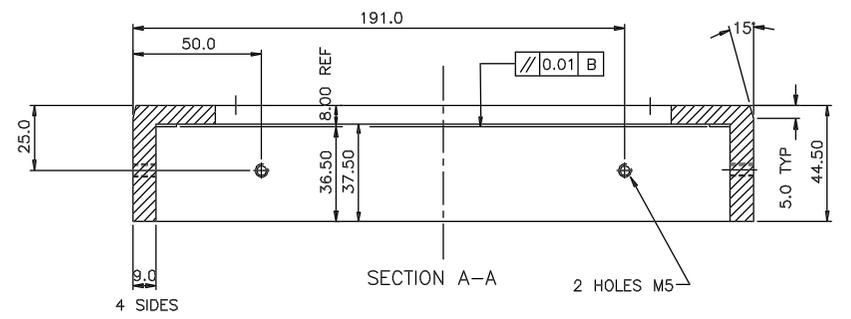
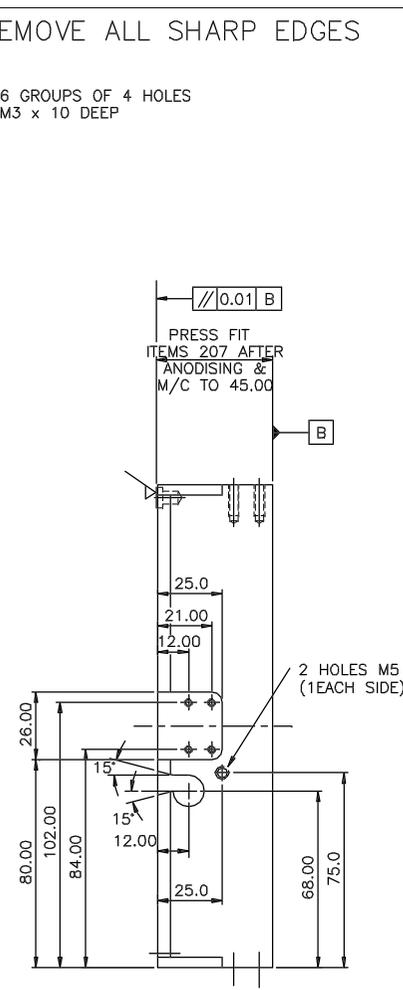
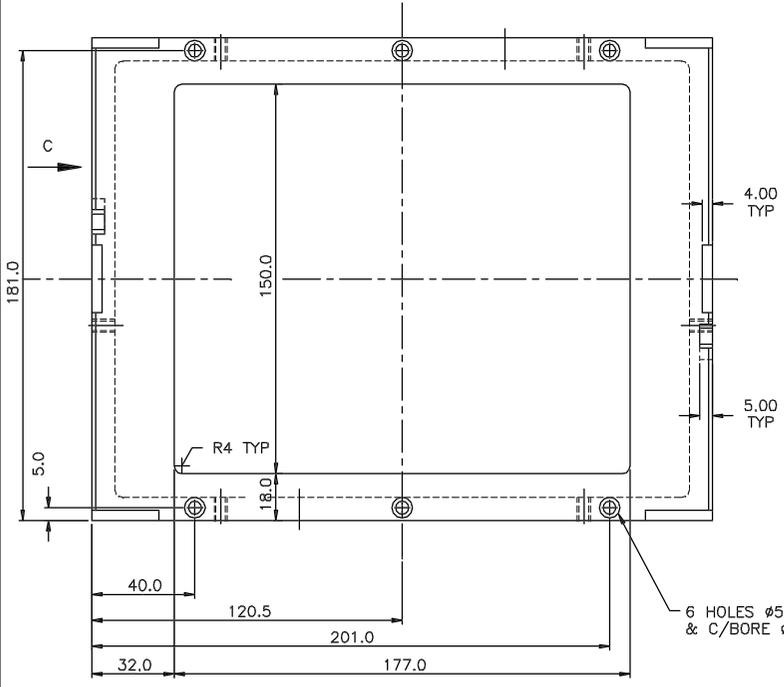
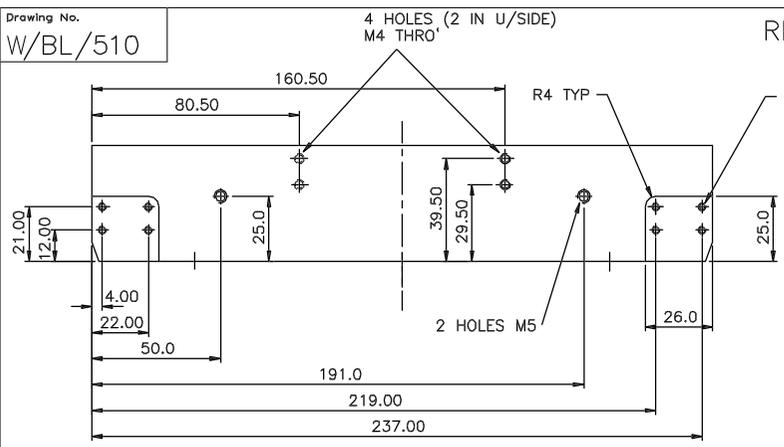
108 TITLE SPRING			
MATERIAL	SCALE	TOLERANCES	
BERYL. Cu.	2/1	X	X.X
FINISH	No. RECD. PER UNIT	X.X	X.XX
	2	X.XX	
G.A. No.	DRAWING No.		
V/BL/400	R.G.O. W/BL/508		

				Tolerance (Unless otherwise stated)		Material	Dimns.in m.m.		Scale	THIRD ANGLE PROJECTION		GA No.
				X +/-						Title		Drawing No.
				X.X +/-		Finish	Drg.No.	No.Req.	ROYAL GREENWICH OBSERVATORY		W/BL/ 503	
				X.XX +/-			Used on		MADINGLEY ROAD		508	
				ANG. +/-					CAMBRIDGE GB3 0EZ			

DETAILS

Drawing No.
W/BL/510

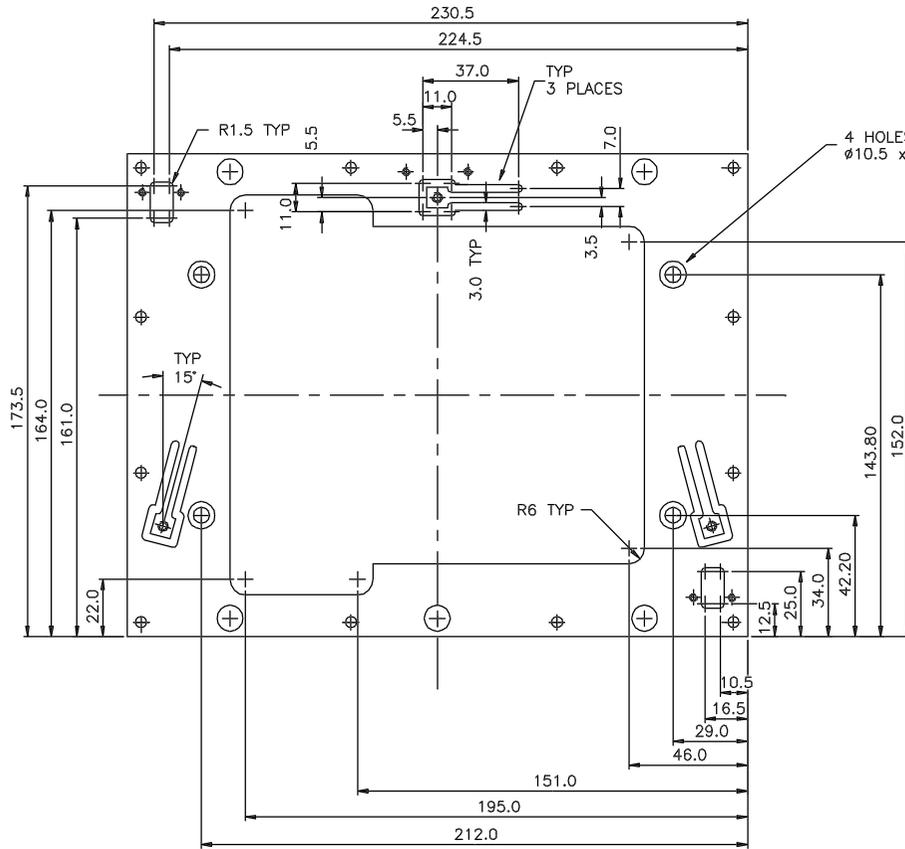
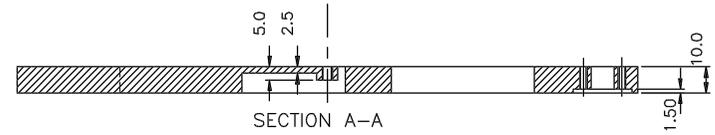
REMOVE ALL SHARP EDGES



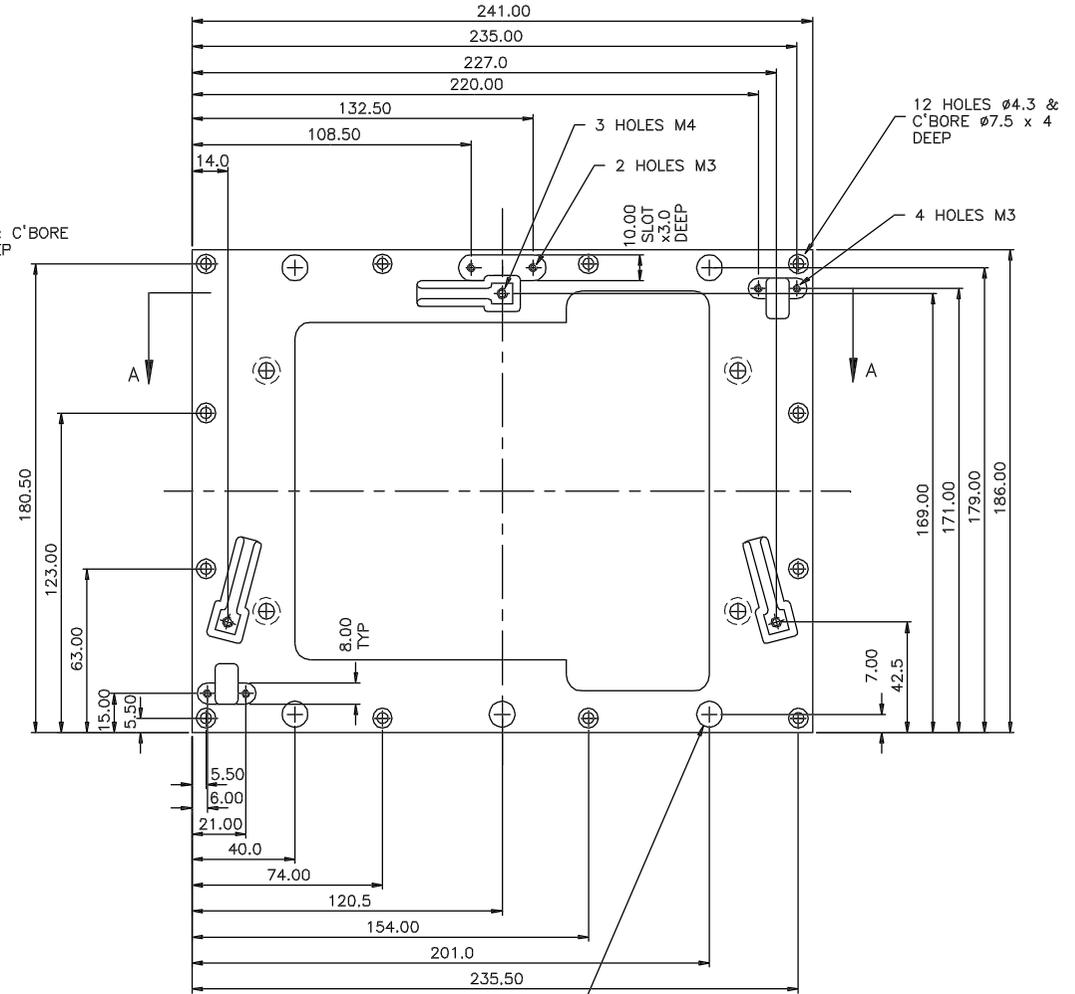
200		TITLE	
ALUM ALLOY		GRATING OUTER CELL	
FINISH	SCALE	TOLERANCES	
BLK ANODISE	FULL	x ±0.5	
	No. REQD. PER UNIT	x.x ±0.3	
	1	x.xx ±0.1	
G.A. No.	DRAWING No.		
V/BL/400	W/BL/510		

Tolerance (Unless otherwise stated)			Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
X +/-			Finish		ROYAL GREENWICH OBSERVATORY		Title		DETAIL		Drawing No.	
X.X +/-			Drg.No.		MADINGLEY ROAD						W/BL/510	
X.XX +/-			No.Req.		CAMBRIDGE CB3 0EZ							
ANG. +/-			Used on									

REMOVE ALL SHARP EDGES



4 HOLES $\phi 6.2$ & C'BORE
 $\phi 10.5 \times 7.0$ DEEP



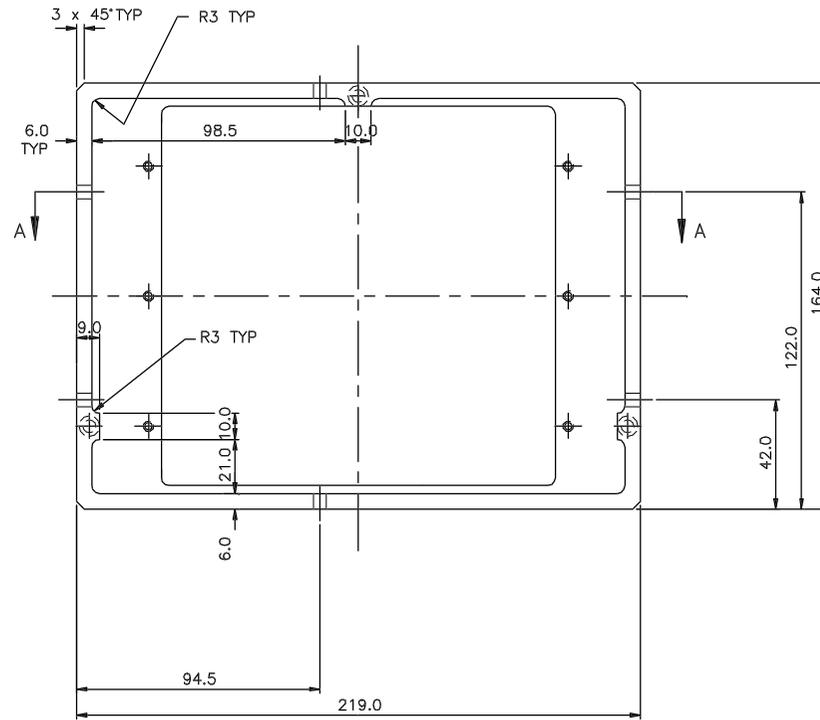
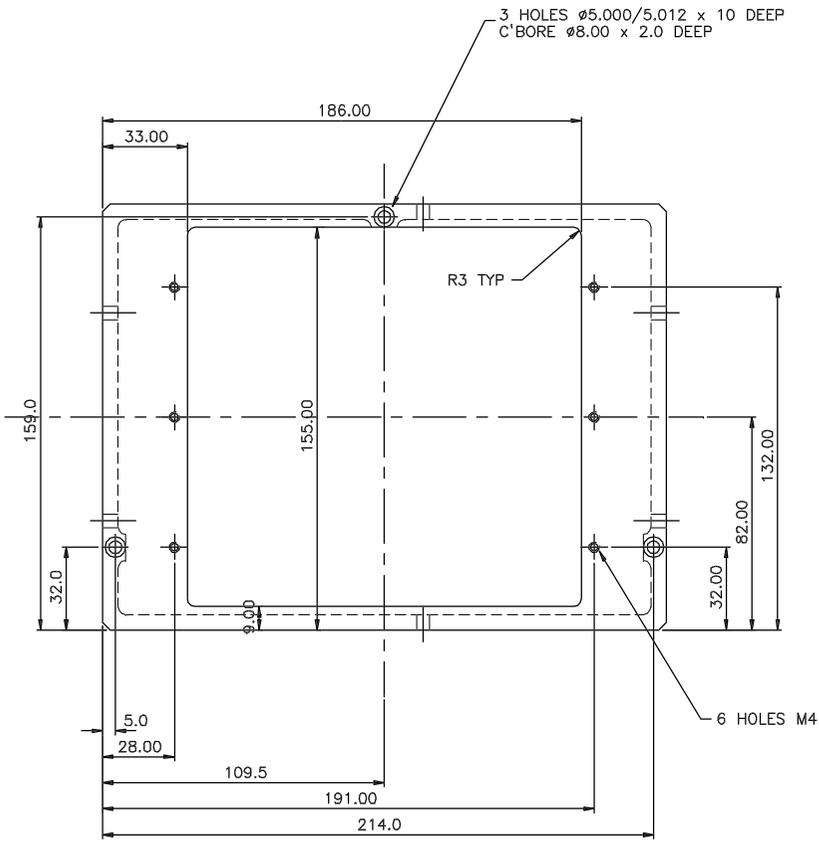
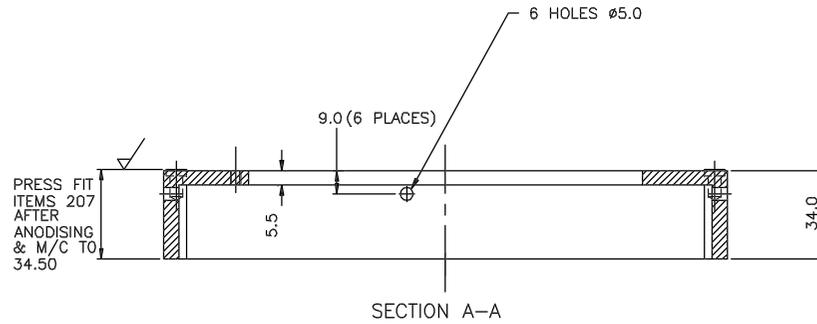
5 HOLES $\phi 10.00$ (REAM)H7 PRESS FIT $\phi 10.00$ (p6)
x 10.00 LONG STAINLESS STEEL PLUG FLUSH.
PLUG TO BE STAINLESS STEEL TYPE 440B
HARDEN AT 1000/1050°C & TEMPER AT 300°C.
POLISH OUTER FACE

201		TITLE	
CELL BACK PLATE			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	x	± 0.5
FINISH	No. RECD. PER UNIT	x.x	± 0.3
BLK ANODISE	1	x.xx	± 0.1
G.A. No.	DRAWING No.		
V/BL/400	W/BL/511		

				Tolerance (Unless otherwise stated)		Material		Dimns. In m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				x x.x x.xx x.xxx +/- +/- +/-		ROYAL GREENWICH OBSERVATORY		Title		DETAIL		Drawing No.		W/BL/511	
				ANG. +/-		MADINGLEY ROAD		Used on		CAMBRIDGE CB3 0EZ					
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by								

Drawing No.
W/BL/512

REMOVE ALL SHARP EDGES

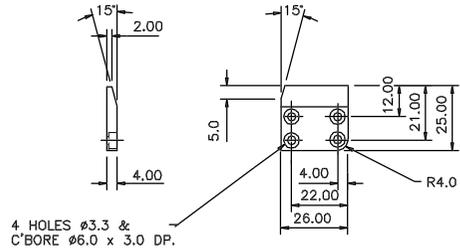


202		TITLE	
INNER HOUSING			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
BLK ANODISE	1	x.xx	±0.1
D.A. No.	DRAWING No.		
V/BL/400	W/BL/512		

				Tolerance (Unless otherwise stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X +/-				Finish		ROYAL GREENWICH OBSERVATORY		Title		DETAIL		Drawing No.	
				X.X +/-				Drg. No.		MADINGLEY ROAD						W/BL/512	
				X.XX +/-				No. Req.		CAMBRIDGE CB3 0EZ							
				ANG. +/-				Used on									
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by										
				27/5/93			PROMECH										

Drawing No. 514
W/BL/522

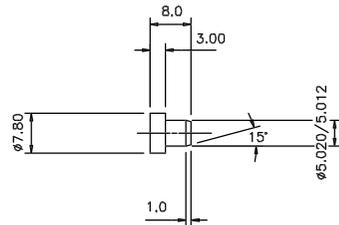
REMOVE SHARP EDGES



103 AS DRAWN
104 OPP. HAND

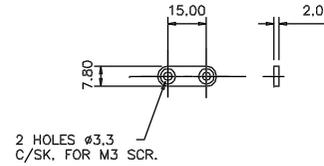
TITLE			TOLERANCES		
204/205	LOCATION PAD		SCALE	FULL	x
MATERIAL	ST. STL.	BLK.NIC.PLT.	No. REQD. PER UNIT	2	OFF EACH
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/514-515	

REMOVE SHARP EDGES



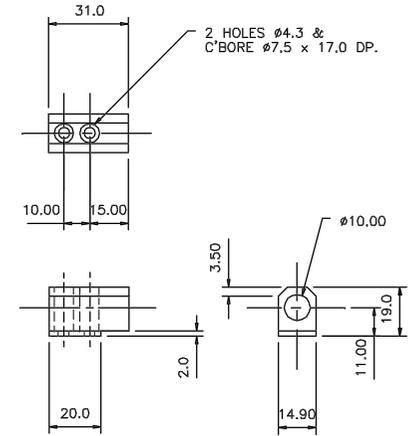
TITLE			TOLERANCES		
207	BUTTON		SCALE	FULL	x
MATERIAL	ST. STL.	BLK.NIC.PLT.	No. REQD. PER UNIT	6	
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/517	

REMOVE SHARP EDGES



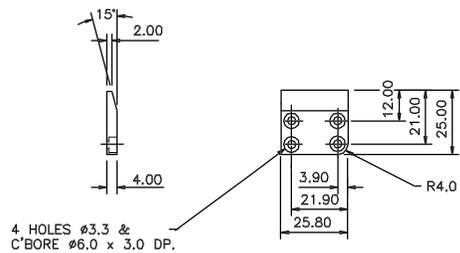
TITLE			TOLERANCES		
209	LATCH PLATE		SCALE	FULL	x
MATERIAL	ST. STL.	BLK.NIC.PLT.	No. REQD. PER UNIT	2	
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/519	

REMOVE SHARP EDGES



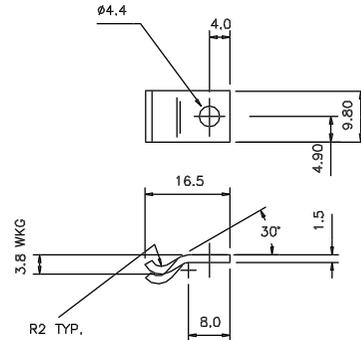
TITLE			TOLERANCES		
211	TRANSPORTER LUGS		SCALE	FULL	x
MATERIAL	ALUM.ALLOY	BLK.ANODISE	No. REQD. PER UNIT	2	
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/521	

REMOVE SHARP EDGES



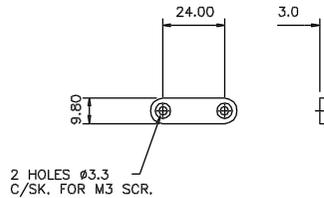
TITLE			TOLERANCES		
206	LOCATION PAD		SCALE	FULL	x
MATERIAL	ST. STL.	BLK.NIC.PLT.	No. REQD. PER UNIT	2	OFF
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/516	

REMOVE SHARP EDGES

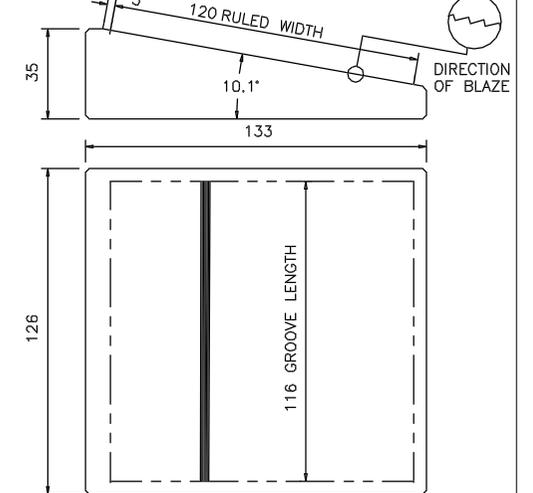


TITLE			TOLERANCES		
208	SPRING		SCALE	FULL	x
MATERIAL	BERYL. Cu.	BLK	No. REQD. PER UNIT	3	
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/518	

REMOVE SHARP EDGES



TITLE			TOLERANCES		
210	PAD		SCALE	FULL	x
MATERIAL	ST. STL.	BLK.NIC.PLT.	No. REQD. PER UNIT	1	
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/520	



PRISM SUPPLIED
BY R.G.O.
OHARA PBL 25W
(LF5W)

TITLE			TOLERANCES		
212	GRISM		SCALE	FULL	x ±1
MATERIAL	SEE DRG	SEE DRG	No. REQD. PER UNIT	1	
FINISH	G.A. No.		DRAWING No.	W/BL/400 R.G.O. W/BL/522	

Issue		Mod.No		Date		Drawn by		Issue		Mod.No		Date		Drawn by		Material		Dimns, in m.m.		Scale		THIRD ANGLE PROJECTION		G.A. No.	
																								Drawing No. 514	
																						W/BL/522		FILE WBL514	

DETAILS

