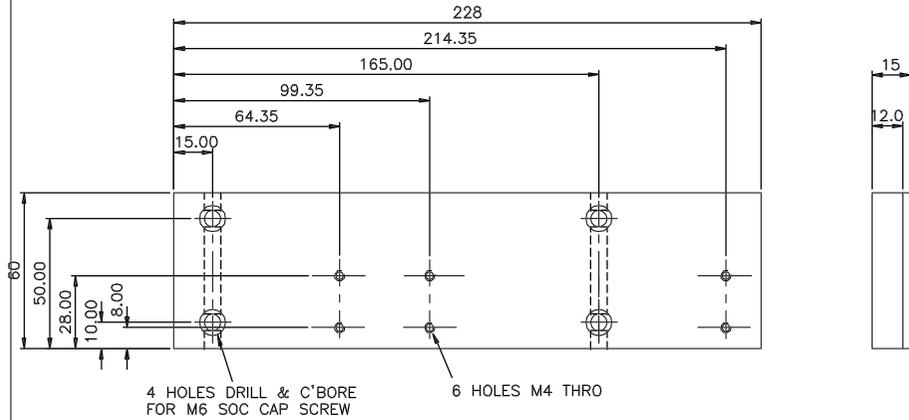


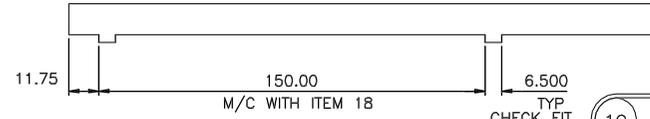
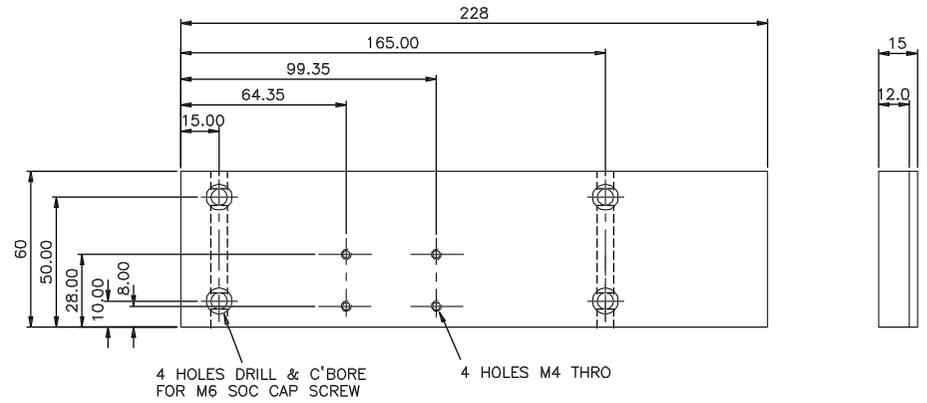
Drawing No. 1622
W/BL/1618

REMOVE ALL SHARP EDGES



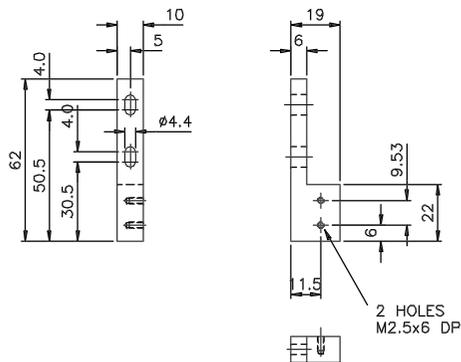
TITLE		
18 SUPPORT STRAP		
MATERIAL	SCALE	TOLERANCES
ALUM ALLOY	FULL	X ±0.5
FINISH	No. RECD. PER UNIT	XX ±0.3
BLK ANODISE	4	XXX ±0.1
G.A. No.	DRAWING No.	
V/BL/1600	R.G.O.	W/BL/1618

REMOVE ALL SHARP EDGES



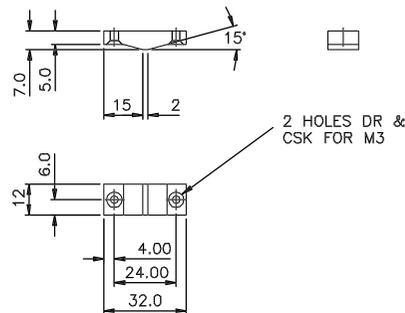
TITLE		
19 SUPPORT STRAP		
MATERIAL	SCALE	TOLERANCES
ALUM ALLOY	FULL	X ±0.5
FINISH	No. RECD. PER UNIT	XX ±0.3
BLK ANODISE	2	XXX ±0.1
G.A. No.	DRAWING No.	
V/BL/1600	R.G.O.	W/BL/1618

REMOVE ALL SHARP EDGES



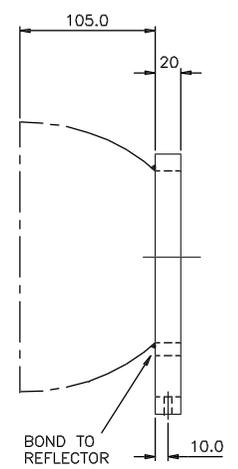
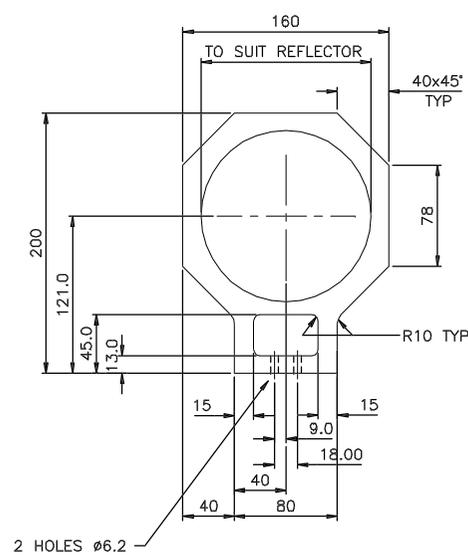
TITLE		
20 SWITCH PLATE		
MATERIAL	SCALE	TOLERANCES
ALUM ALLOY	FULL	X ±0.5
FINISH	No. RECD. PER UNIT	XX ±0.3
BLK ANODISE	16	XXX ±0.1
G.A. No.	DRAWING No.	
V/BL/1600	R.G.O.	W/BL/1618

REMOVE ALL SHARP EDGES



TITLE		
21 SWITCH CAM		
MATERIAL	SCALE	TOLERANCES
ST STEEL	FULL	X ±0.5
FINISH	No. RECD. PER UNIT	XX ±0.3
BLK NIC PLT	3	XXX ±0.1
G.A. No.	DRAWING No.	
V/BL/1600	R.G.O.	W/BL/1618

REMOVE ALL SHARP EDGES



TITLE		
22 REFLECTOR SUPPORT BRKT		
MATERIAL	SCALE	TOLERANCES
ALUM ALLOY	1/2	X ±0.5
FINISH	No. RECD. PER UNIT	XX ±0.3
BLK ANODISE	4	XXX ±0.1
G.A. No.	DRAWING No.	
V/BL/1600	R.G.O.	W/BL/1618

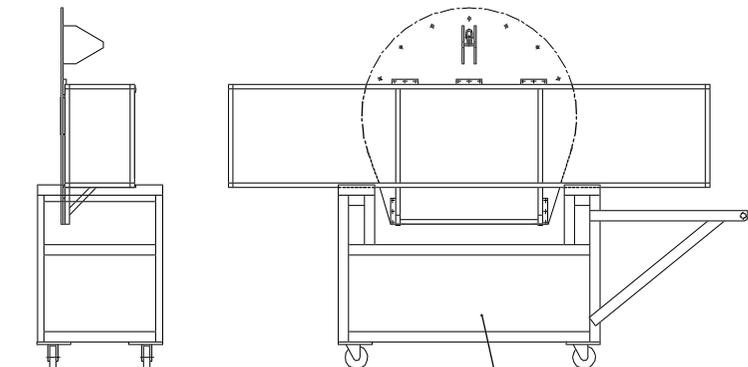
PART REDESIGNED 04/03/97

Material		Dimns. in m.m.		Scale	THIRD ANGLE PROJECTION		GA No.
Issue	Mod.No	Drg.No.	No.Req.	ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ	Title		Drawing No. 1622 W/BL/1618
04/03/97					DETAILS		
Drawn by		Used on					FILE BL1618A

FILE BL1618A

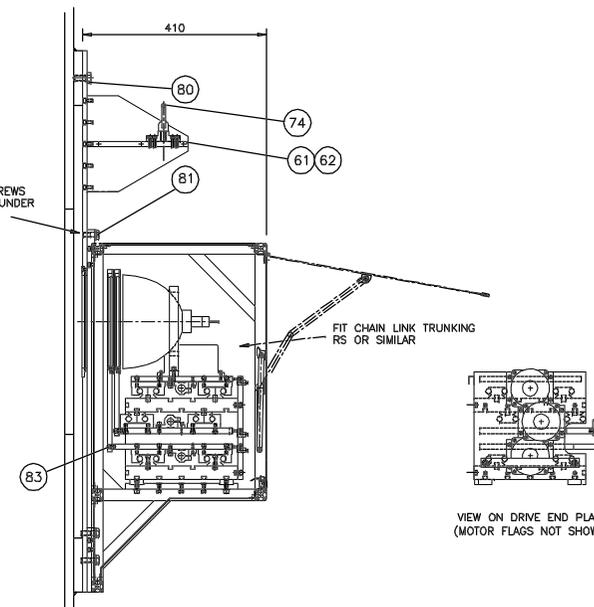
DRAWING NUMBER	No. OF SHEETS	GA ITEM No.	DRAWING TITLE OR COMPONENT NAME	No. OFF	MATERIAL STOCK OR ORDER No. AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE	
/ /		38	WASHER	6						
/ /		39	SWITCH BLOCK	2						
/ /		40	NUT PLATE	2						
/ /		41	NUT PLATE	12						
/ /		42	NUT PLATE	5						
/ /		43	MOTOR PACKER	3						
W/ BL / 1644	1	44	NUT PLATE	2						
/ /		45	NUT PLATE	10						
/ /		46	NUT PLATE	4						
/ /		47	FILTER HOLDER	10						
/ /		48	FILTER PLATE	10						
W/ BL / 1649	1	49	BRACKET	2						
/ /		50	LAMP & REFLECTOR ASSY (TYPICAL)	4						
/ /		51	GUIDE RAIL	1						
/ /		52	GUIDE RAIL	1						
/ /		53	STOP	2						
/ /		54	PULL BAR	2						
/ /		55	PULL ROD	4						
W/ BL / 1656	1	56	TROLLEY ASSY	1						
W/ BL / 1657	1	57	MOTOR SUPPORT BRKT - SHORT	2						
/ /		58	MOTOR SUPPORT BRKT - LONG	1						
W/ BL / 1659	1	59	CONN. SHAFT - SHORT	2						
/ /		60	CONN. SHAFT - LONG	1						
W/ BL / 1659	1	61	WEB	2						
/ /		62	PLATE	1		(UNIMATIC LTD)				
/ /		63	BALL SCREW $\phi 16-5 \times 1530$	3	211-134-2153	TECHNOISEL				
/ /		64	BALL NUT $\phi 16-5$ PITCH	3	213001	TECHNOISEL				
/ /		65	STEPPING MOTOR 300Ncm	3	CODE 398002	TECHNOISEL				
/ /		66	DOUBLE RAIL GUIDE 1750	6	HL4222M0011750	TECHNOISEL				
/ /		67	NUT STRIP	3	HL6100M209012	TECHNOISEL				
/ /		68	CARRIAGE	12	HL46D0M223001	TECHNOISEL				
/ /		69	BEARING	6	INA-7200BE2RSG					
/ /		70	BEARING	3	NMB-R2210ZZ					
/ /		71	MICRO SWITCH BURGESS-V4 ROLLER	16	V42T6Y1					
/ /		72	MICRO SWITCH BURGESS-V4 LEVER	2	V42T6Y1					
/ /		73	BUSH MOUNT RS 688-329	2						
/ /		74	SWIVEL HOIST RING M10 HR-125M	1	BS	500kg				
/ /		75	REFLECTOR	4	ORIEL 45337	SEE DRG 1650				
JOB TITLE	WYFFOS WAVELENGTH CALIB ASSY					ASS'Y DRG No. V/BL/1600	SHEET No. 2 of 3	DRAWN BY PROMECH DATE 04/03/97		
ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE										

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	
/ /		76	PSU & LAMP TYPE AS REQUIRED	4	ORIEL	SEE DRG 1650				
/ /		77	FAIL SAFE BRAKE FS 60/1L	3	CLARK ELEC CLUTCH LTD					
/ /		78	COUPLING AC075-ø6-ø6	3	HELICAL					
/ /		79	COUPLING (3/8") AC100-12	3	HELICAL					
/ /		80	HEX HEAD SCREW M12 x 30	12		ALL ITEMS TO BE				
/ /		81	HEX HEAD SCREW M10 x 30	15		STAIN LESS STEEL				
/ /		82	SOC HEAD CAP SCREW M6 x 18	66						
/ /		83	SOC HEAD CAP SCREW M6 x 12	66						
/ /		84	SOC HEAD CAP SCREW M6 x 25	68						
/ /		85	SOC HEAD CAP SCREW M6 x 30	24						
/ /		86	SOC HEAD CAP SCREW M4 x 12	74						
/ /		87	SOC HEAD CAP SCREW M4 x 16	16						
/ /		88	SOC HEAD CAP SCREW M3 x 8	9						
/ /		89	SOC HEAD CAP SCREW M3 x 10	9						
/ /		90	SOC HEAD CAP SCREW M2.5 x 10	36						
/ /										
/ /										
/ /		93	SOC HEAD CAP SCREW M5 x 12	14						
/ /		94	CSK HEAD SCREW M6 x 12	18						
/ /		95	CSK HEAD SCREW M3 x 10	78						
/ /		96	CSK HEAD SCREW M4 x 6	4						
/ /		97	CSK HEAD SCREW M4 x 8	48						
/ /		98	SOC HEAD CAP SCREW M8 x 20	8						
/ /		99	WASHER PLAIN M10	15						
/ /		100	WASHER PLAIN M6	8						
/ /		101	WASHER PLAIN M4	38						
/ /		102	WASHER PLAIN M8	8						
/ /		103	SOC HEAD CAP SCREW M6 x 15	16						
/ /		104	HEX NYLOC NUT M4	14						
/ /		105	HEX LOCK NUT M8	10						
/ /		106	DOWEL ø4 x 16	6						
/ /										
/ /		108	DOWEL ø6 x 16	4						
/ /										
/ /										
/ /										
/ /		112	PROXIMITY SWITCH M5	3	RS 633-458					
/ /										
JOB TITLE	WYFFOS WAVELENGTH CALIB ASSY					ASS'Y DRG No. V/BL/1600	SHEET No. 3 of 3	DRAWN BY PROMECH DATE 04/03/97		
ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE										



TRANSPORT SYSTEM
SCALE 1/10

ENSURE ALL SCREWS
ARE FLUSH OR UNDER
REAR FACE



VIEW ON DRIVE END PLATE
(MOTOR FLAGS NOT SHOWN)

ASSEMBLY PROCEDURE

ASSEMBLE THE FRAME LESS PANELS AND BACK PLATE ITEM 24 ENSURING ALL M6 NUTS ARE ASSEMBLED (OR CAN BE LATER ASSEMBLED) IN 'PROFILE' SLOTS. CHECK ANGLE POSITIONS WITH PANEL FIXING.

ASSEMBLE LOWER FILTER CARRIAGE ETC INCL. SLIDE RAILS ON TO LOWER TABLE ITEM 8 (NOT FILTER PLATE ITEM 7 OR CELLS)

ASSEMBLE UPPER FILTER CARRIAGE ETC. TO UNDER SIDE OF UPPER TABLE ITEM 8 (NOT FILTER PLATE ITEM 6 OR CELLS)

ASSEMBLE TOP LAMP ASSY CARRIAGE ETC. TO TOPSIDE OF UPPER TABLE ITEM 8 (NOT REFLECTORS OR P.U.'S)

SUPPORT TOP LAMP AND FILTER ASSY'S ON THE LOWER FILTER ASSY WITH 23.0 PACKERS WHILE FITTING THE SIDE STRAPS ITEMS 18 & 19 TO THE TABLES.

WITH THRUST BEARINGS ALREADY ASSEMBLED TO LEAD SCREWS OFFER UP (BUT LEAVING CLEAR FOR ACCESS) THE MOTOR PLATE ITEM 9 AND SECURE THE 3 HOUSINGS ITEM 13 AND MOTOR PLATE TO ENDS OF THE TABLES.

FIT RAIL END SUPPORT PLATE ITEM 10 ADJUSTING PACKERS AS REQUIRED.

BUILD BRAKES AND MOTORS AS SEPARATE SUB ASSEMBLIES BEFORE ATTACHING TO THE MOTOR PLATE.

FIT ALL EXTERNAL ITEMS - FILTER PLATES, LAMPS AND P.U.'S ETC.

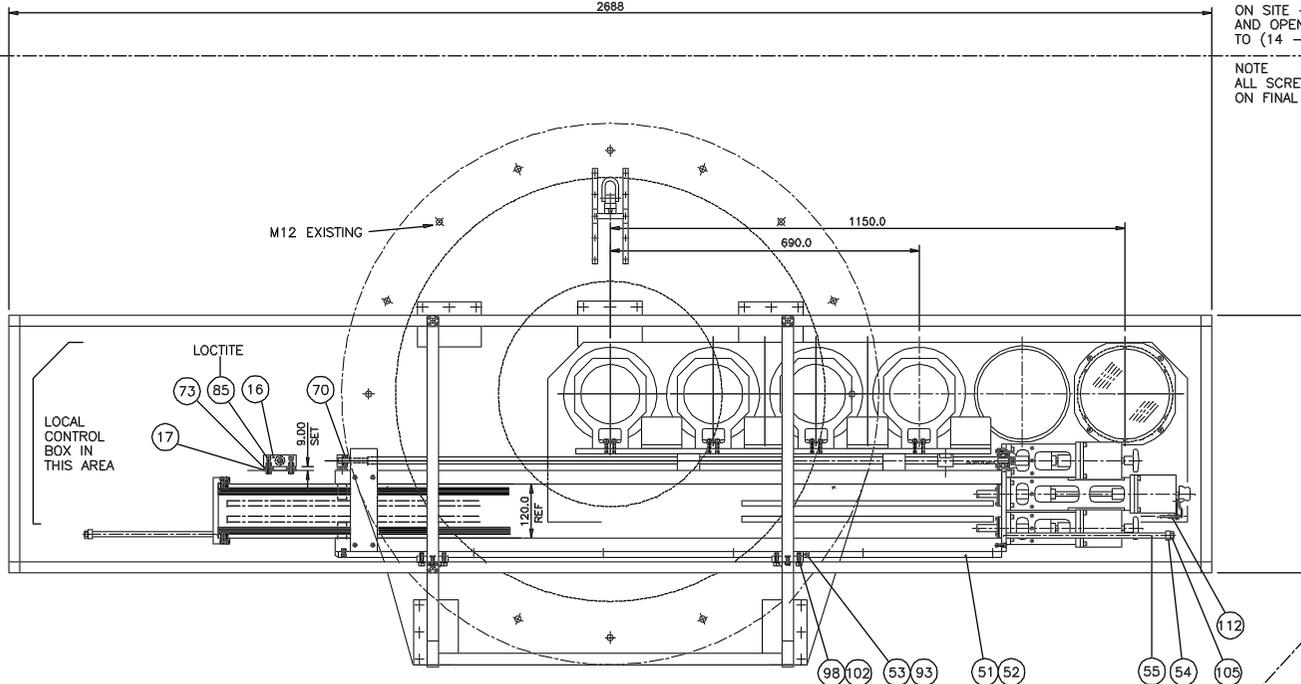
SLIDE COMPLETE MECHANISM AS AN ASSEMBLY THRO' THE END OF THE FRAME LOCATING RAILS IN SLOTS TO LINE UP 8-MB FIXING HOLES.

FINALLY CONNECT UP ELECTRICS TO LOCAL CONTROL BOX. FIX ON ALL PANELS AND DOORS AND BACK PLATE.

ON SITE - REMOVE LOWER UNDER SIDE FRONT PANEL AND OPEN BOTH FRONT DOORS FOR ACCESS TO FIXING TO (14 - M12 HEX SCREWS) TELESCOPE.

NOTE
ALL SCREWS AND NUTS TO BE BONDED WITH LOCTITE ON FINAL ASSEMBLY.

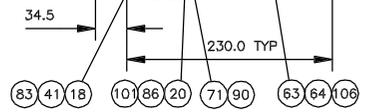
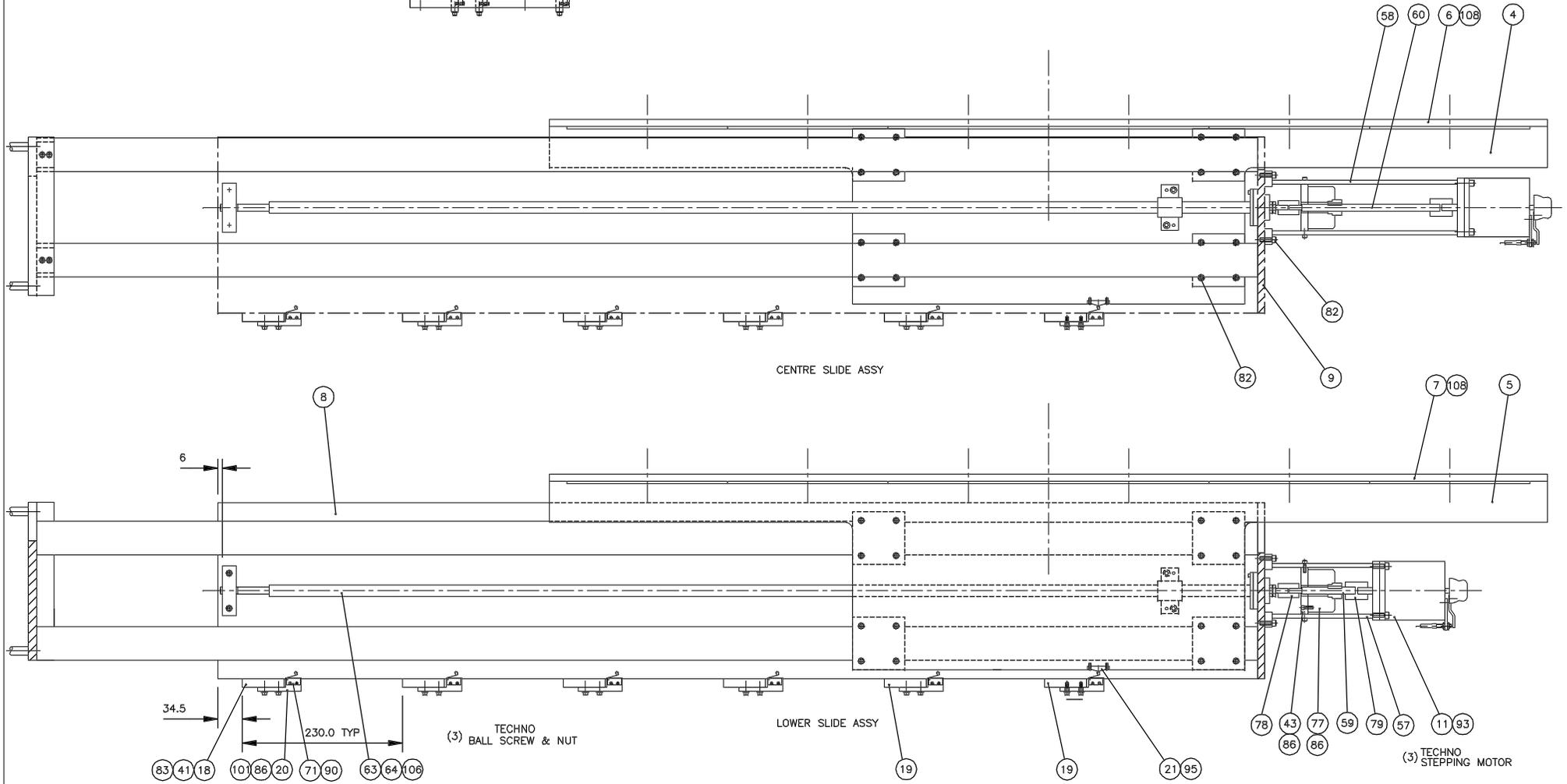
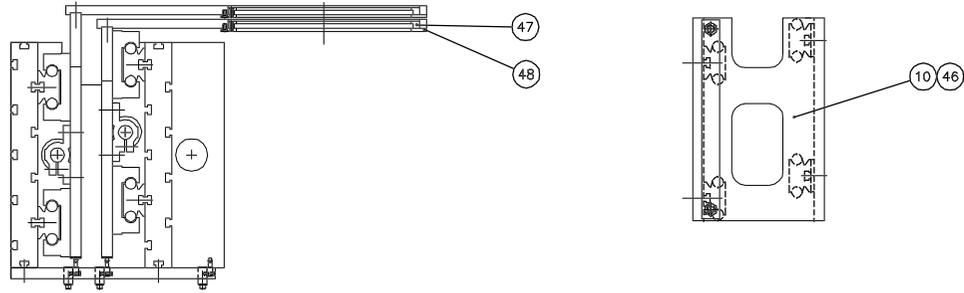
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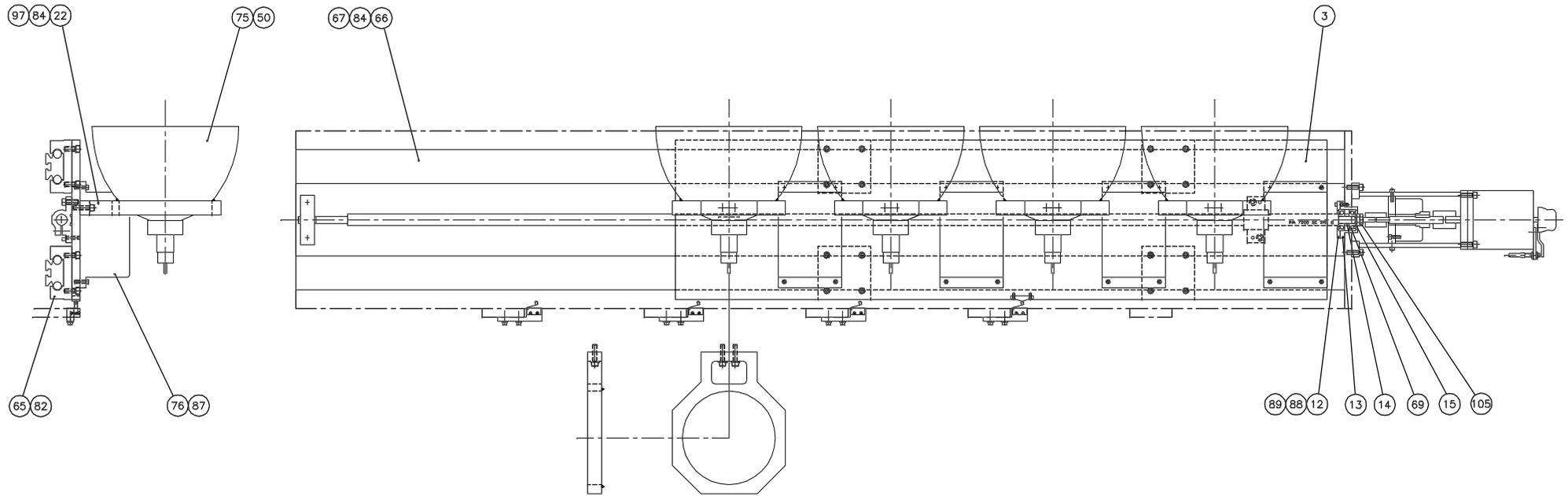
ESTIMATED WEIGHT < 300kg

SEE SHT2 FOR CENTRE & LOWER SLIDE ASSYS
SEE SHT3 FOR TOP SLIDE ASSY
SEE SHT4 FOR FRAME & PANEL ASSYS

TOLERANCES (UNLESS OTHERWISE STATED)				MATERIAL		DIM IN MM		SCALE 1/4		THIRD ANGLE PROJECTION		G.A. NO. SHT 1 OF 22	
X	±0.1	±0.05	±0.02	FINISH	DRG NO.	NO REQ	USED ON	ROYAL GREENWICH OBSERVATORY	TITLE	WYFFOS WAVELENGTH CALIBRATION ASSY V/BL/1600			DRG NO.
X.X	±0.05	±0.02	±0.01					MADINGLEY ROAD					
ANG	±0.05	±0.02	±0.01					CAMBRIDGE CB3 0EZ					
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	04/03/97	PROMECH				

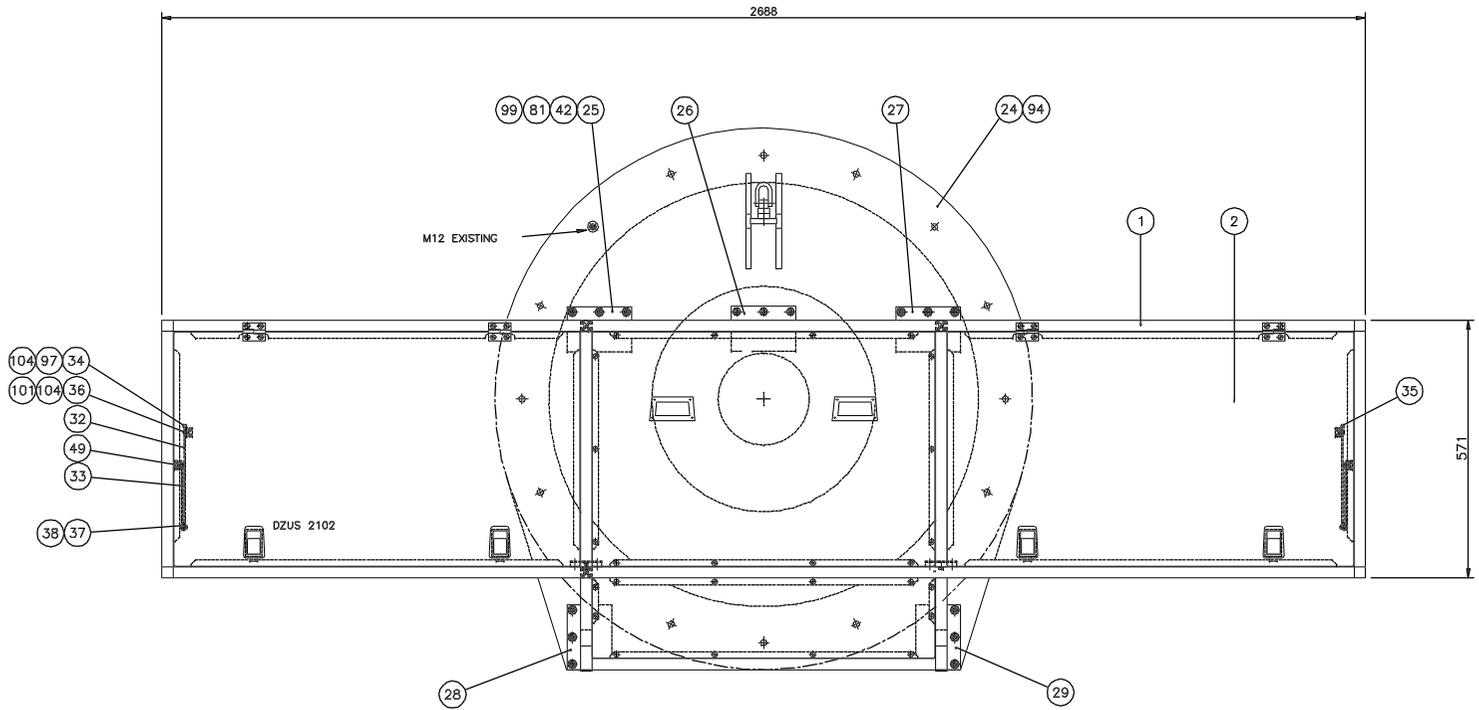
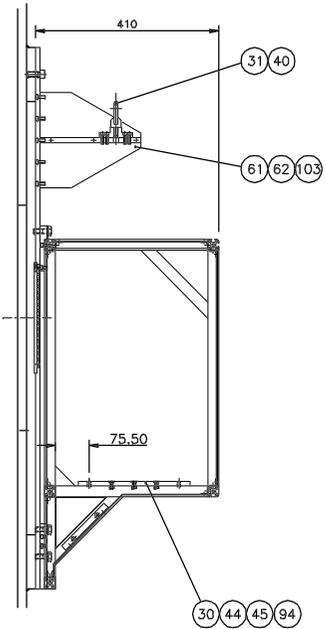
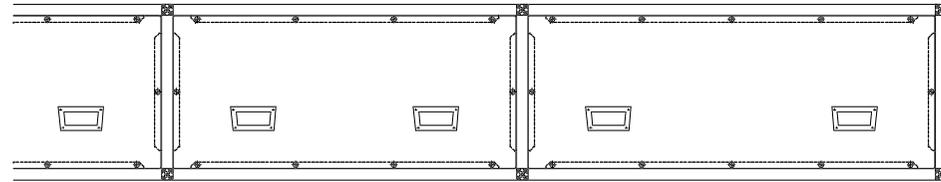
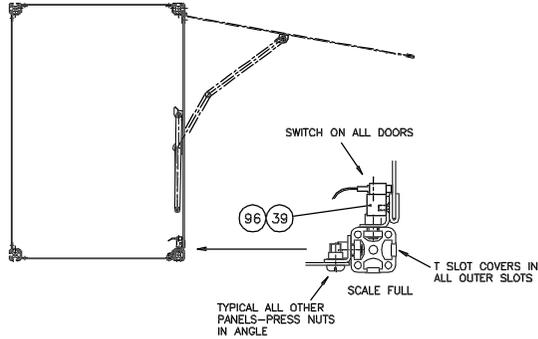
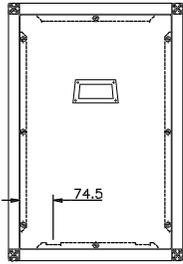


ISSUE				MATERIAL				DIM IN MM		SCALE	THIRD ANGLE PROJECTION		G.A. NO.	
27/02/97	PROMECH	TOLERANCES (UNLESS OTHERWISE STATED)		FINISH		ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ		1/2	TITLE		DRG NO.		SHT 2 OF 10	
34.5	230.0 TYP	X +/-		DRG NO. NO REQ		WYFFOS WAVELENGTH CALIBRATION ASSY		V/BL/1600		FILE BL1600S2				
63 41 18	101 86 20	71 90	63 64 106	USED ON										



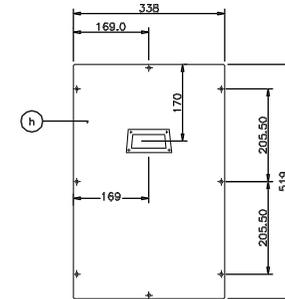
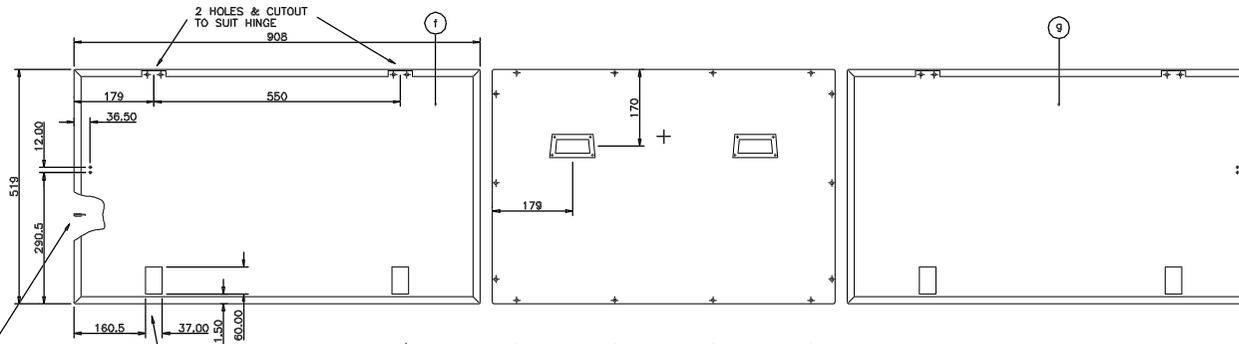
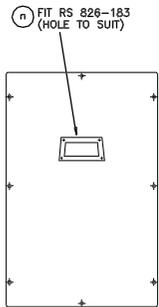
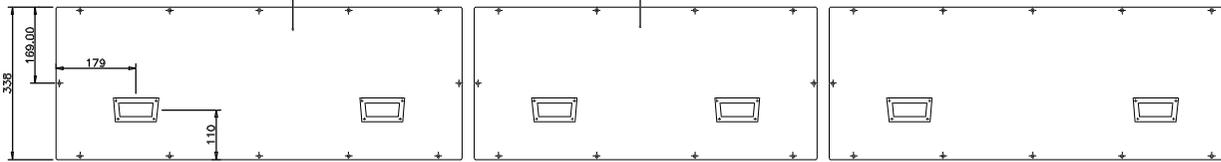
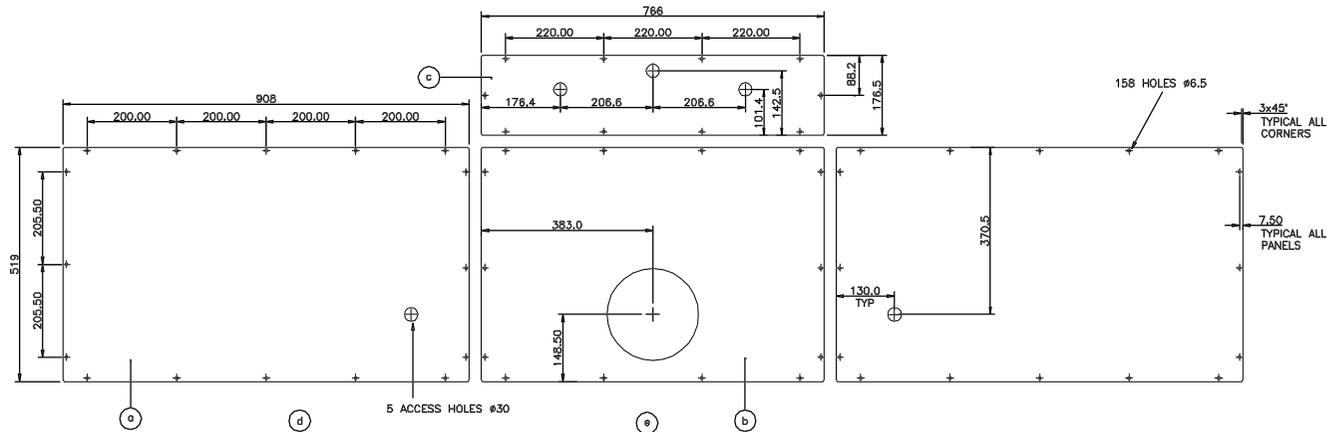
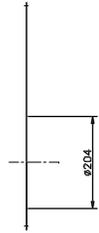
TOP SLIDE ASSY

ISSUE				MATERIAL				DIM IN MM		SCALE	THIRD ANGLE PROJECTION		G.A. NO.	
NO.	DATE	DRAWN BY	ISSUE	NO.	DATE	DRAWN BY	FINISH	DRG NO.	NO REQ	1/2	TITLE		SHT 3 OF 19	
											WYFFOS WAVELENGTH CALIBRATION ASSY		V/BL/1600	
											ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ		DRG NO.	



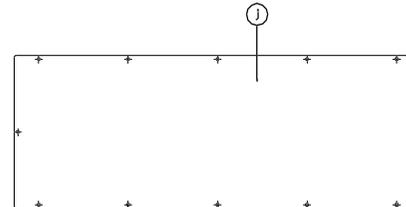
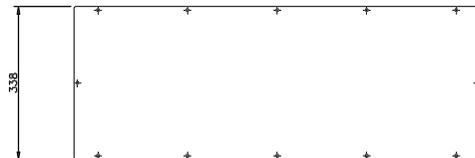
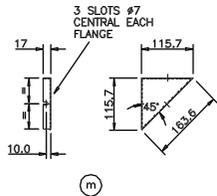
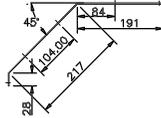
ISSUE				MATERIAL				DIM IN MM		SCALE	TITLE	G.A. NO.	
										1/4	THIRD ANGLE PROJECTION		SHT 4 OF 19
											ROYAL GREENWICH OBSERVATORY		
											MADINGLEY ROAD		
											CAMBRIDGE CB3 0EZ		
											WYFFOS WAVELENGTH CALIBRATION ASSY	V/BL/1600	
													FILE XXXXXXXX

DESCRIPTION	QTY
a PANEL REAR	2
b PANEL REAR	1
c PANEL REAR	1
d PANEL TOP	2
e PANEL TOP	1
f DOOR L/H	1
g DOOR R/H	1
h PANEL END	2
j PANEL LOWER	2
k PANEL LOWER	1
m PANEL FILL IN	1
n HANDLE RS826-183	10
p LATCH DZUS 2102	4
q	
r	



SUITABLE PLASTIC EDGING (CUT TO CLEAR HINGES)

p FIT DZUS 2102

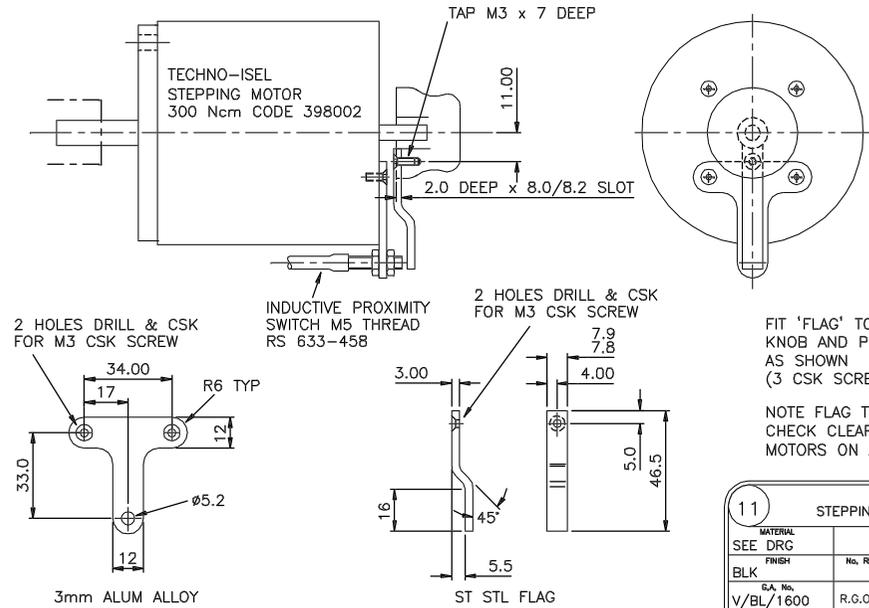


NOTE
ALL PANELS 1.5mm THICK ALUM ALLOY BLACK FINISH AND TO HAVE 1.0 CLEARANCE ALL ROUND CHECK SIZES WITH FINAL STRUCTURE
ALL PANELS TO BE MARKED CLEARLY ON THEIR INSIDE FACE THEIR RELATIVE POSITION ON THE STRUCTURE

PANEL ASSY DETAILS			
UNITS	SCALE	TOLERANCES	
ALUM ALLOY	1/4	x	±0.0
FINISH	BLK ANODISE	XX	±0.3
QTY	1 SET	XXX	±0.1
DRG NO.	R.C.C.	ISSUED TO	
V/BL/1600	V/BL/1602		

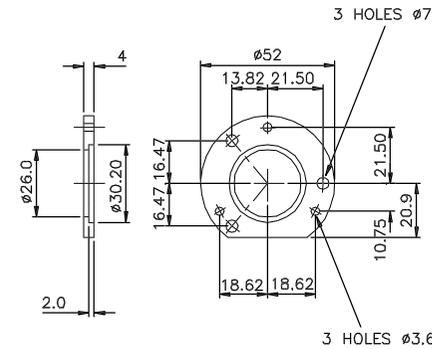
ISSUE	MOD. NO.	DATE	DRAWN BY	ISSUE	MOD. NO.	DATE	DRAWN BY	TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	FINISH	DRG NO.	NO REQ	USED ON	DIM IN MM	SCALE	TITLE	THIRD ANGLE PROJECTION	G.A. NO.	DRG NO.
						27/02/97	PROMECH	X XX XXX ANG						ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ	1/4	PANEL ASSY DETAILS			V/BL/1602

REMOVE ALL SHARP EDGES



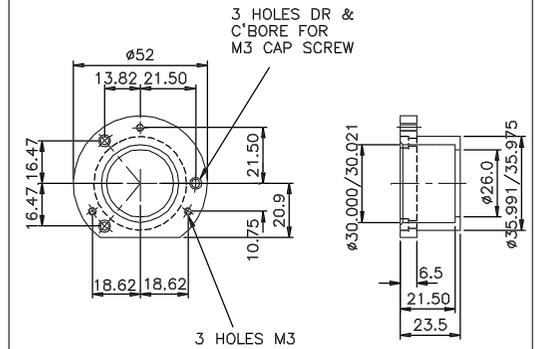
11			TITLE		
MATERIAL			SCALE		
SEE DRG	FULL	x ±0.5	STEPPING MOTOR DRIVE		
BLK	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	3	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1611		

REMOVE ALL SHARP EDGES



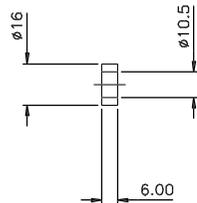
12			TITLE		
MATERIAL			SCALE		
ALUM ALLOY	FULL	x ±0.5	BRG PLATE		
BLK ANODISE	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	3	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1612		

REMOVE ALL SHARP EDGES



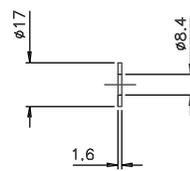
13			TITLE		
MATERIAL			SCALE		
ALUM ALLOY	FULL	x ±0.5	BRG HOUSING		
BLK ANODISE	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	3	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1613		

REMOVE ALL SHARP EDGES



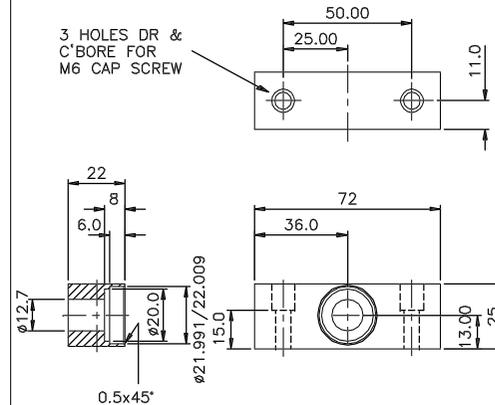
14			TITLE		
MATERIAL			SCALE		
ALUM ALLOY	FULL	x ±0.5	BRG SPACER		
BLK ANODISE	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	3	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1614		

REMOVE ALL SHARP EDGES



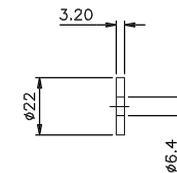
15			TITLE		
MATERIAL			SCALE		
ST STEEL	FULL	x ±0.5	WASHER		
BLK NIC PLT	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	3	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1615		

REMOVE ALL SHARP EDGES



16			TITLE		
MATERIAL			SCALE		
ALUM ALLOY	FULL	x ±0.5	BRG SUPPORT BLOCK		
BLK ANODISE	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	3	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1616		

REMOVE ALL SHARP EDGES

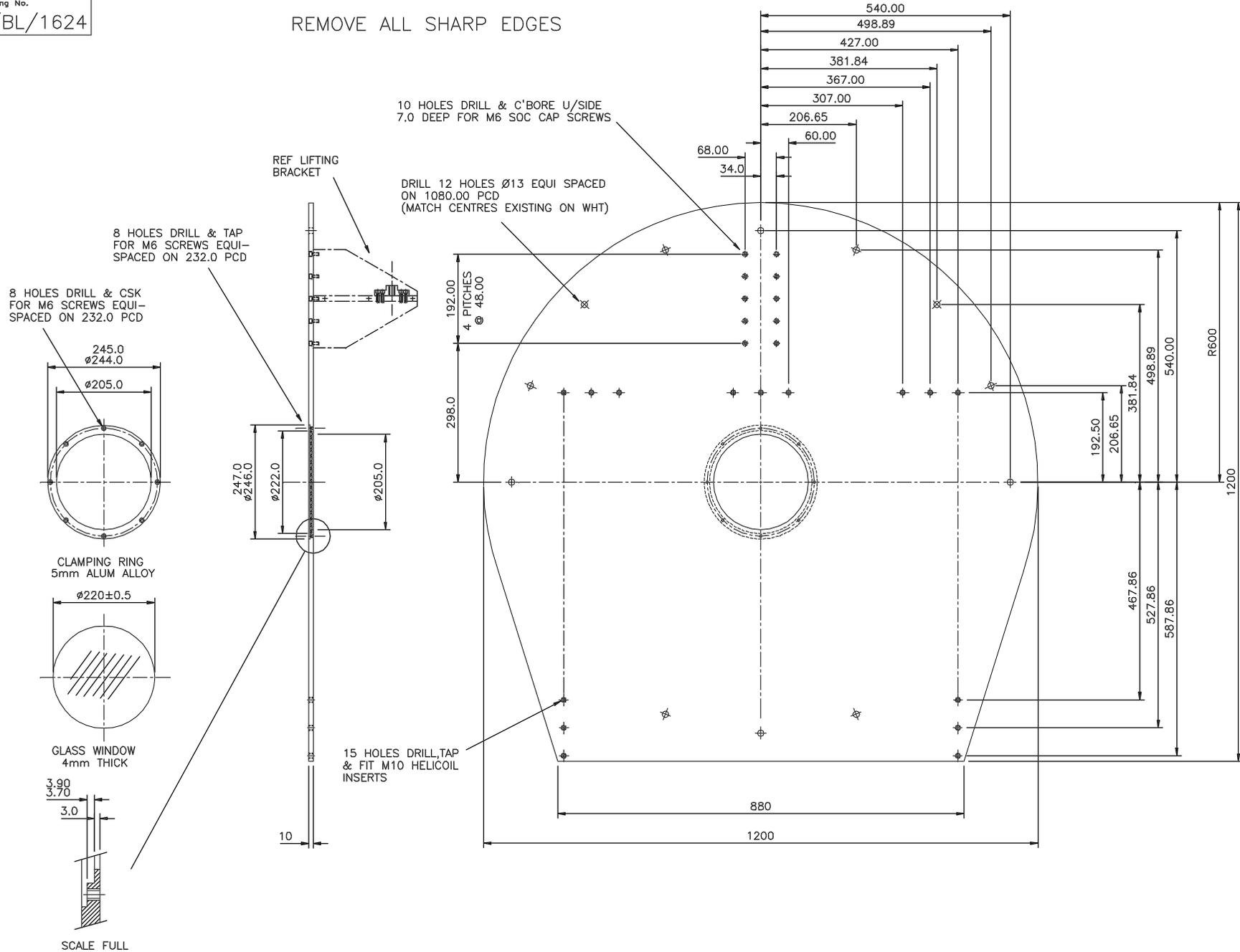


17			TITLE		
MATERIAL			SCALE		
ST STEEL	FULL	x ±0.5	SPECIAL WASHER		
BLK	FINISH	No. REQD. PER UNIT	x.x ±0.3		
V/BL/1600	R.G.O.	6	x.xx ±0.1		
D.A. No. V/BL/1600			DRAWING No. W/BL/1617		

Tolerance (Unless otherwise stated)										Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.			
27/02/97										PROMECH		ROYAL GREENWICH OBSERVATORY		Title		DETAILS		Drawing No. 1617			
Issue Mod.No Date Drawn by										Finish		Drg.No. No.Req.		MADINGLEY ROAD				W/BL/1611		FILE BL111	
												Used on		CAMBRIDGE CB3 0EZ							

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	
V / BL / 1600	4		GENERAL ASSY.							
V / BL / 1601	1	1	FRAME ASSY	1						
V / BL / 1602	1	2	PANELS ASSY	1						
W / BL / 1603	1	3	TOP PLATE	1						
W / BL / 1604	1	4	CENTRE PLATE	1						
W / BL / 1605	1	5	LOWER PLATE	1						
W / BL / 1606	1	6	CENTRE FILTER PLATE	1						
W / BL / 1607	1	7	LOWER FILTER PLATE	1						
W / BL / 1608	1	8	TABLE PLATE	2						
W / BL / 1609	1	9	MOTOR PLATE	1						
/ /		10	RAIL END PLATE	1						
W / BL / 1611	1	11	STOPPING MOTOR DRIVE	3						
/ /		12	BEARING PLATE	3						
/ /		13	BEARING HOUSING	3						
/ /		14	BEARING SPACER	3						
/ /		15	WASHER	3						
/ /		16	BEARING SUPPORT BLOCK	3						
/ /		17	SPECIAL WASHER	6						
W / BL / 1618	1	18	SUPPORT STRAP	4						
/ /		19	SUPPORT STRAP	2						
/ /		20	SWITCH PLATE	16						
/ /		21	SWITCH CAM	3						
/ /		22	REFLECTOR SUPPORT BRACKET	4						
/ /										
W / BL / 1624	1	24	BACK PLATE	1						
W / BL / 1625	1	25	L/H TOP PLATE	1						
/ /		26	CTR TOP PLATE	1						
/ /		27	R/H TOP PLATE	1						
/ /		28	L/H BOTTOM PLATE	1						
/ /		29	R/H BOTTOM PLATE	1						
W / BL / 1630	1	30	MOUNTING PLATE	2						
/ /		31	LIFTING BLOCK	1						
/ /		32	BAR	2						
/ /		33	BAR	2						
/ /		34	L/H BRACKET	1						
/ /		35	R/H BRACKET	1						
W / BL / 1636	1	36	SHOULDER SCREW	4						
/ /		37	SHOULDER SCREW	2						
JOB TITLE	WYFFOS WAVELENGTH CALIB ASSY					ASS'Y DRG No. V/BL/1600	SHEET No. 1 of 3	DRAWN BY PROMECH DATE 04/03/97		
ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE										

REMOVE ALL SHARP EDGES

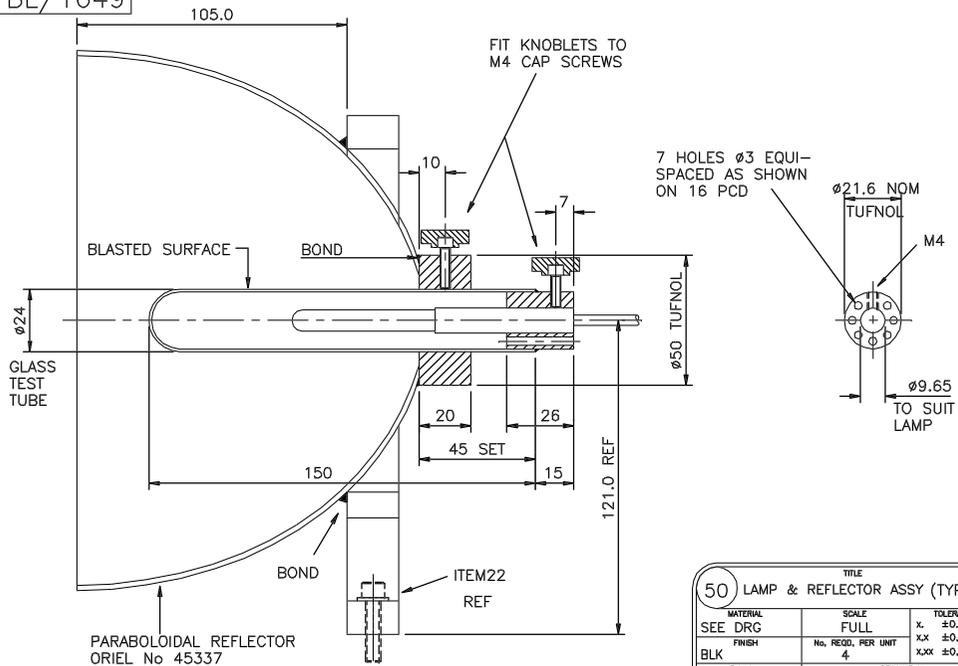


24		TITLE	
BACK PLATE			
MATERIAL	SCALE	TOLERANCES	
ALCOA PLT	1/4	x	±0.5
FINISH	No. RECD. PER UNIT	x.x	±0.3
BLK ANODISE	1	x.xx	±0.1
G.A. No.	DRAWING No.		
V/BL1600	R.G.O. W/BL/1624		

				Tolerance (Unless otherwise stated)				Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
				X X.X X.XX ANG.										Title		Drawing 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		DETAIL		W/BL/1624	

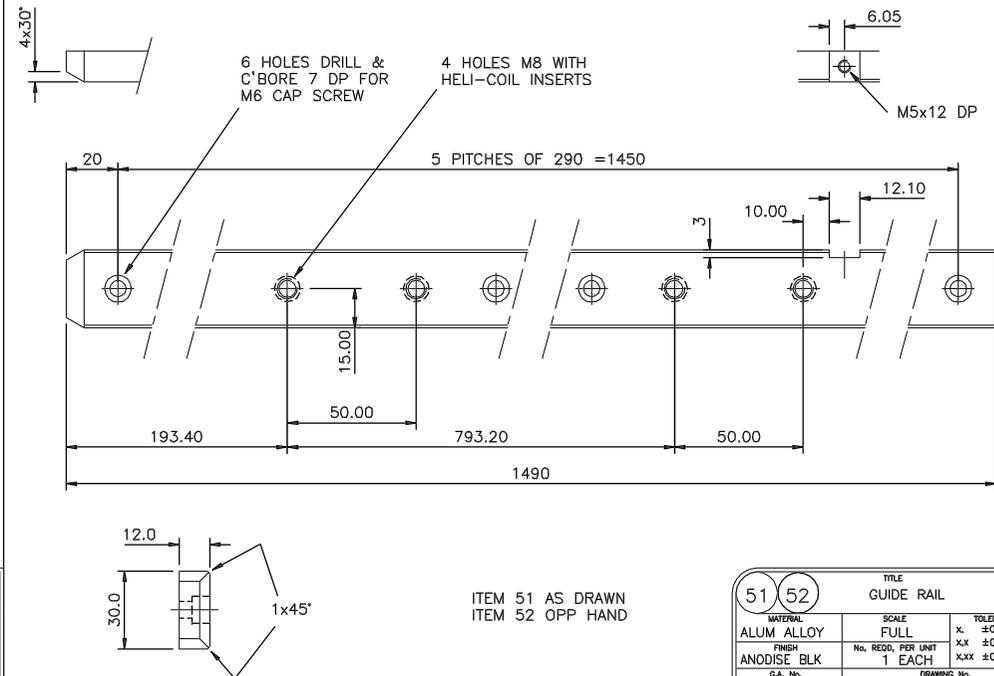
Drawing No. 1655
W/BL/1649

REMOVE ALL SHARP EDGES



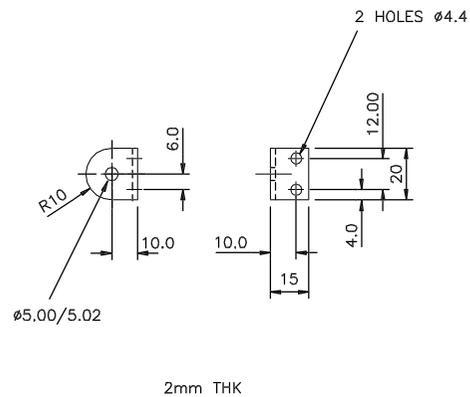
50 LAMP & REFLECTOR ASSY (TYPICAL)			
MATERIAL	SCALE	TOLERANCES	
SEE DRG	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
BLK	4	XXX	±0.1
G.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1650		

REMOVE ALL SHARP EDGES



51 52 GUIDE RAIL			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
ANODISE BLK	1 EACH	XXX	±0.1
G.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1651-2		

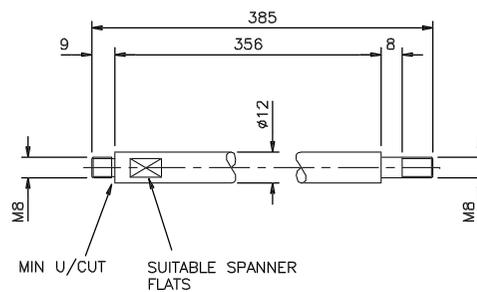
REMOVE ALL SHARP EDGES



2mm THK

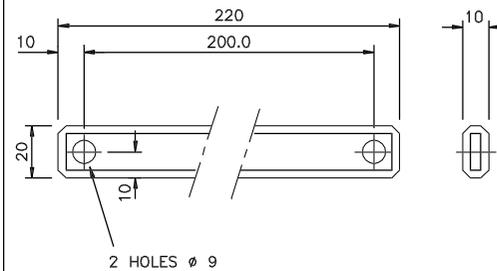
49 BRACKET			
MATERIAL	SCALE	TOLERANCES	
ST. STEEL	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
BLK NIC PLATE	2	XXX	±0.1
G.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1649		

REMOVE ALL SHARP EDGES



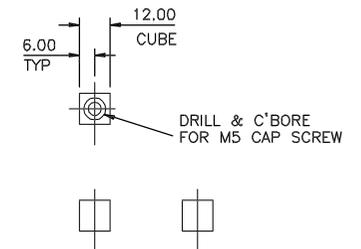
55 PULL ROD			
MATERIAL	SCALE	TOLERANCES	
ST. STEEL	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
BLK NIC PLATE	4	XXX	±0.1
G.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1655		

REMOVE ALL SHARP EDGES



54 PULL BAR			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
ANODISE BLK	2	XXX	±0.1
G.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1654		

REMOVE ALL SHARP EDGES

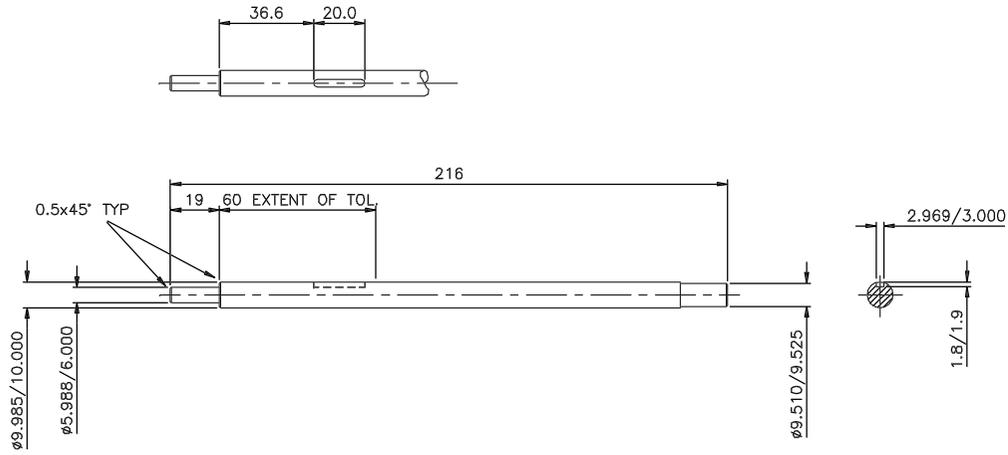


53 STOP			
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	X	±0.5
FINISH	No. RECD. PER UNIT	XX	±0.3
ANODISE BLK	2	XXX	±0.1
G.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1653		

Tolerance (Unless otherwise stated)										Material		Dimns. in m.m.		Scale		Title		THIRD ANGLE PROJECTION		GA No.		
X	XX	XXX	+/	-/	+/	-/	+/	-/	+/	-/	+	-	+	-	+	-	+	-	+	-	+	-
Issue	Mod.No	Date	Drawn by	Issue	Mod.No	Date	Drawn by	04/03/97	PROMECH	ANG.												
										Finish	Drg.No.	No.Req.	ROYAL GREENWICH OBSERVATORY	Title		DETAILS		Drawing No. 1655		W/BL/1649		
											Used on		MADINGLEY ROAD									
													CAMBRIDGE									

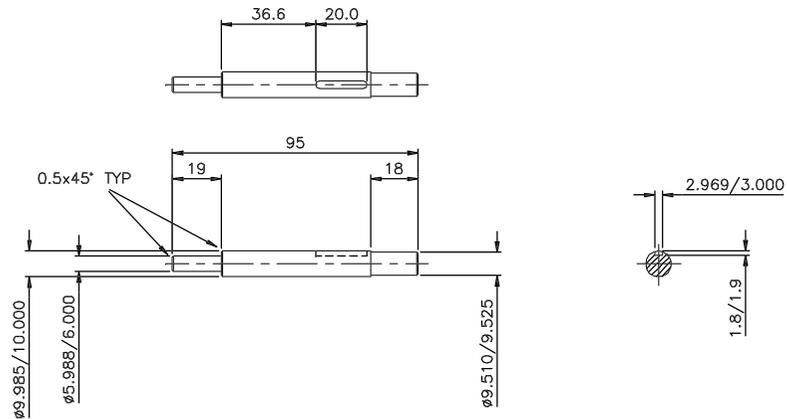
Drawing No. 1661
W/BL/1659

REMOVE ALL SHARP EDGES



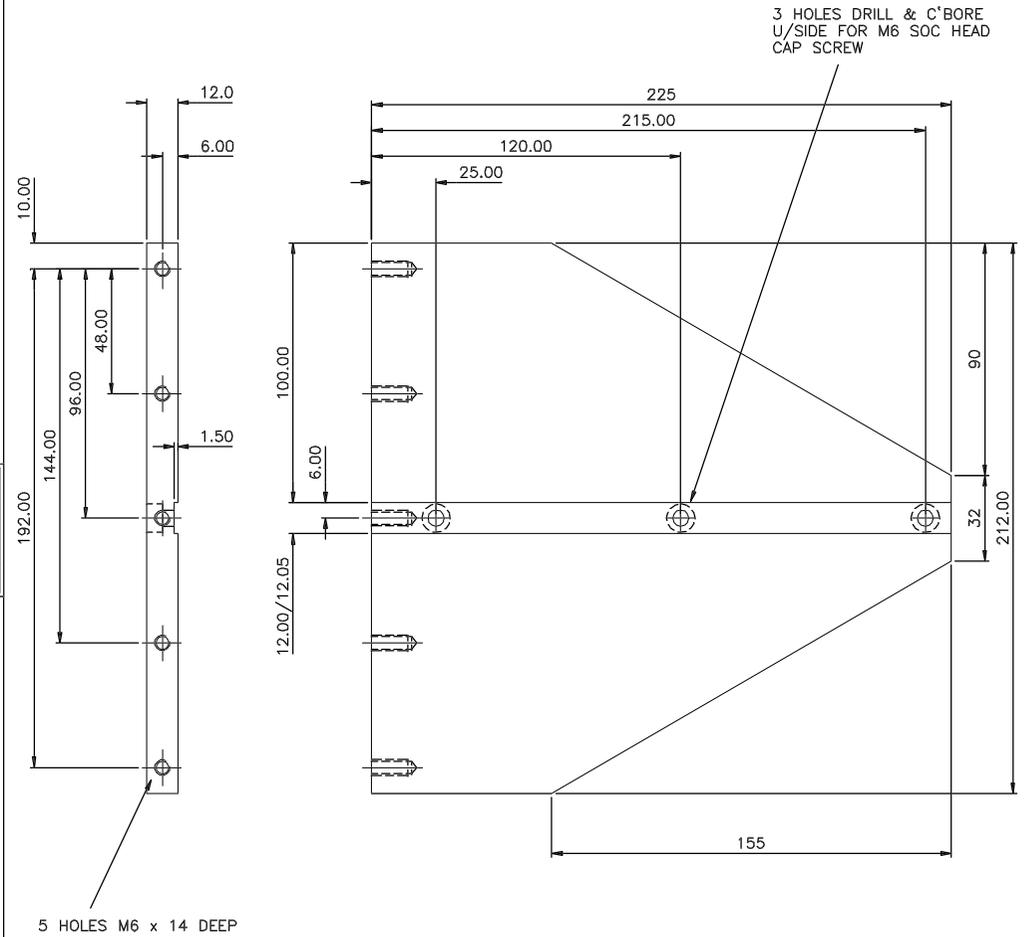
60			CONN. SHAFT - LONG		
MATERIAL	SCALE	TOLERANCES			
ST STEEL	FULL	X ±0.5			
FINISH	No. RECD. PER UNIT	XX ±0.3			
BLK	1	XXX ±0.1			
G.A. No.	DRAWING No.				
V/BL/1600	R.G.O. W/BL/1660				

REMOVE ALL SHARP EDGES



59			CONN. SHAFT - SHORT		
MATERIAL	SCALE	TOLERANCES			
ST STEEL	FULL	X ±0.5			
FINISH	No. RECD. PER UNIT	XX ±0.3			
BLK	2	XXX ±0.1			
G.A. No.	DRAWING No.				
V/BL/1600	R.G.O. W/BL/1659				

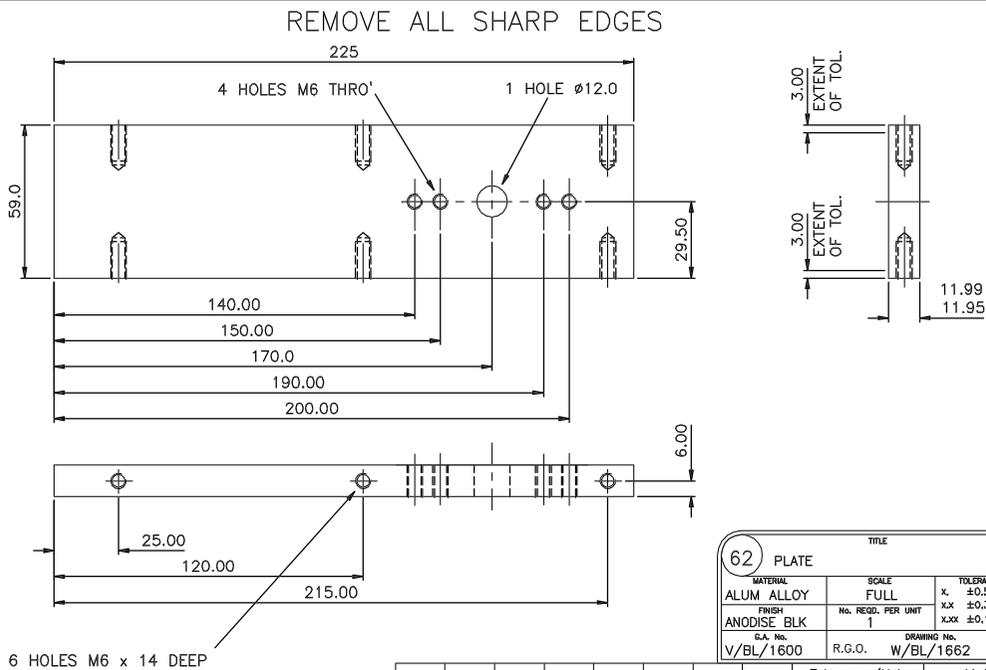
REMOVE ALL SHARP EDGES



61			WEB		
MATERIAL	SCALE	TOLERANCES			
ALUM ALLOY	FULL	X ±0.5			
FINISH	No. RECD. PER UNIT	XX ±0.3			
ANODISE BLK	2	XXX ±0.1			
G.A. No.	DRAWING No.				
V/BL/1600	R.G.O. W/BL/1661				

Material		Dimns. in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
Finish		Drg.No.		No. Req.		ROYAL GREENWICH OBSERVATORY		Drawing No. 1661	
Issue Mod.No Date Drawn by Issue Mod.No Date Drawn by		Used on				MADINGLEY ROAD		W/BL/1659	
						CAMBRIDGE CB3 0EZ		DETAILS	
								FILE BL1659	

Drawing No.
W/BL/1662



62 PLATE		TITLE	
MATERIAL	SCALE	TOLERANCES	
ALUM ALLOY	FULL	x	±0.5
FINISH	No. REQD. PER UNIT	x.x	±0.3
ANODISE BLK	1	x.xx	±0.1
E.A. No.	DRAWING No.		
V/BL/1600	R.G.O. W/BL/1662		

										Material		Dimns.in m.m.		Scale		THIRD ANGLE PROJECTION		GA No.	
										Finish		Drg.No.		No.Req.		ROYAL GREENWICH OBSERVATORY		Title	
										Used on		MADINGLEY ROAD		CAMBRIDGE CB3 0EZ		DETAILS		Drawing No.	
																W/BL/1662			

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
W/ BL / 1250	1		GENERAL ASSY.						
W/ BL / 1251	1	1	BRACKET ASSY.	1					
W/ BL / 1252	1	2	BASE PLATE	1					
/ /		3							
/ /		4							
/ /		5							
/ /		6							
/ /		7							
/ /		8							
W/ BL / 603	1	9	CLAMP LEG	3					
/ /604		10	CLAMP BUSH	3					
/ /605		11	CLAMP	3					
/ /606		12	SCREW CLAMP	2					
/ /607		13	BUTTON	3					
/ /608		14	SUPPORT BUSH(CONE)	1					
/ /609		15	ADJUSTER SCREW	3					
W/ BL / 610	1	16	SUPPORT BUSH(VEE)	1					
/ /611		17	SUPPORT BUSH(FLAT)	1					
/ /613		18	BASE CLAMP	3					
W/ BL / 307	1	19	SCREW CLAMP(OPPOSITE HAND)	1					
/ /		20							
/ /		21							
/ /		22	SOC HD CAP SCREW M5 x 20	12					
/ /		23	SOC HD CAP SCREW M10 x 90	3					
/ /		24	HEX HD SCREW M6 x 35	3					
/ /		25	HEX HD SCREW M5 x 20	3					
/ /		26	SOC HD CAP SCREW M5 x 12	3					
/ /		27	SOC HD CAP SCREW M4 x 16	6					
/ /		28	PLAIN WASHER M10	3					
/ /		29	SPRING WASHER M6	3					
/ /		30	SPRING WASHER M5	3					
/ /		31	DOWEL PIN ϕ 4 x 15 LONG	3					
/ /		32	ROLL PIN ϕ 3 x 10 LONG	3					
/ /									
/ /									
/ /									
/ /									
JOB TITLE WYFFOS WAVELENGTH CALIBRATION ASSY.						ASS'Y DRG No. W/BL/1250	SHEET No. 1 of 1	DRAWN BY PROMECH DATE 30/7/93	
ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE									