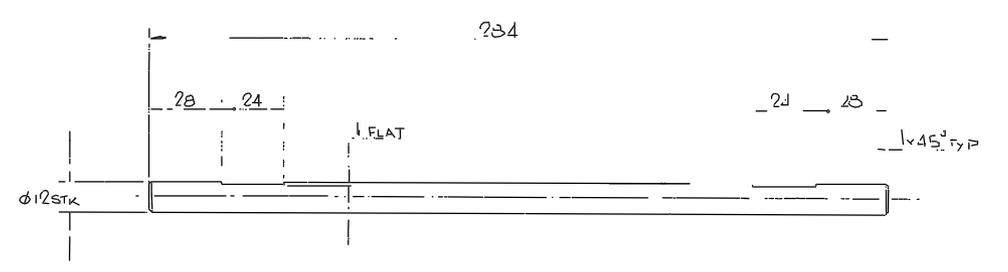
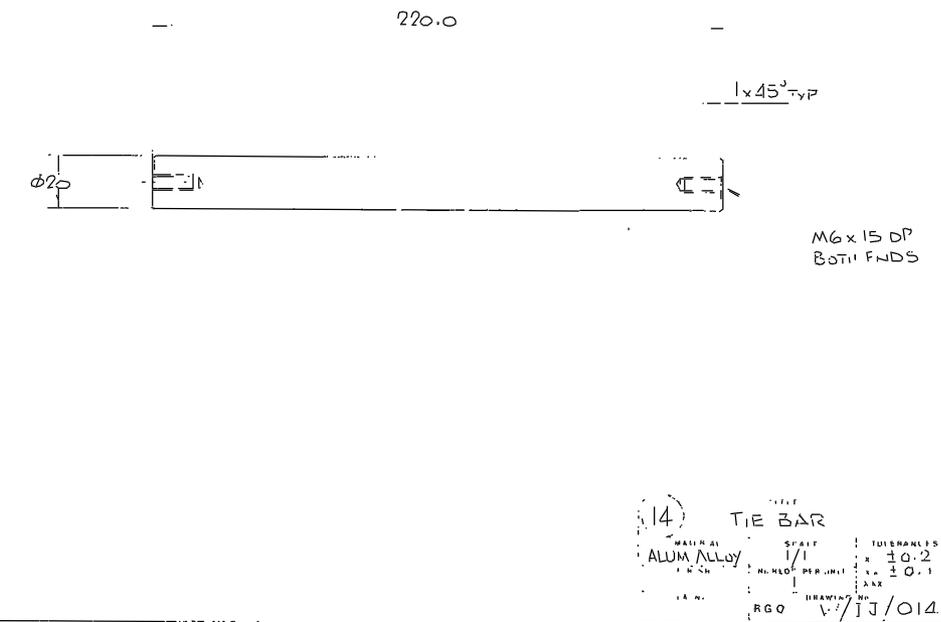
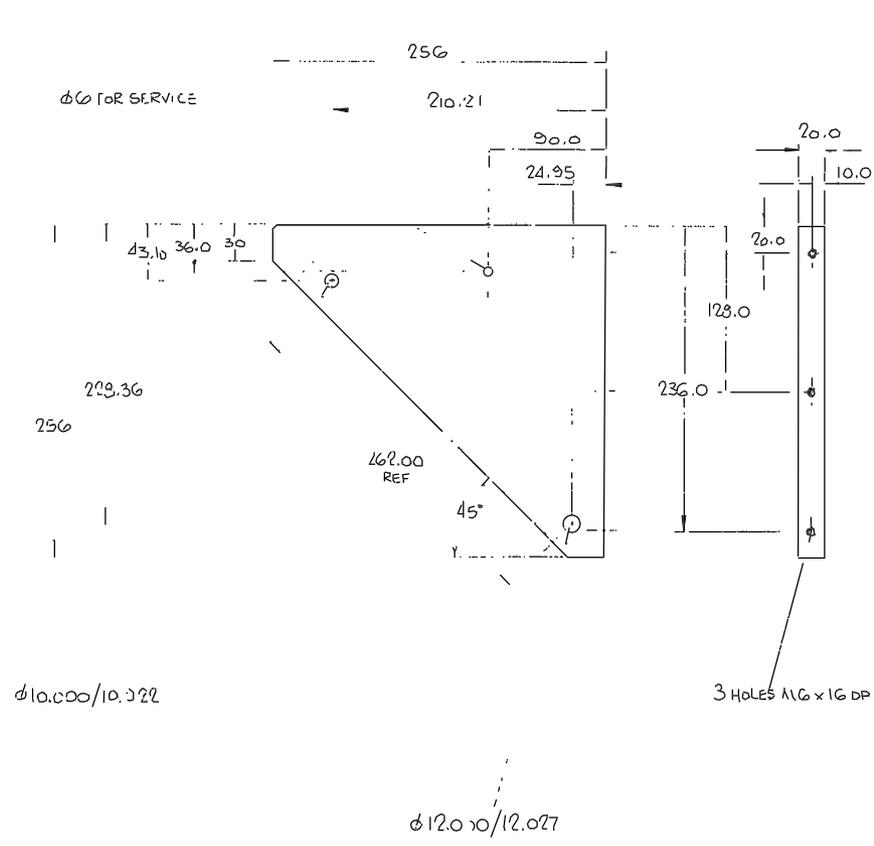


Drawing No
W/IJ/013
TO
015



M6 2OFF AS MATCHING PAIR

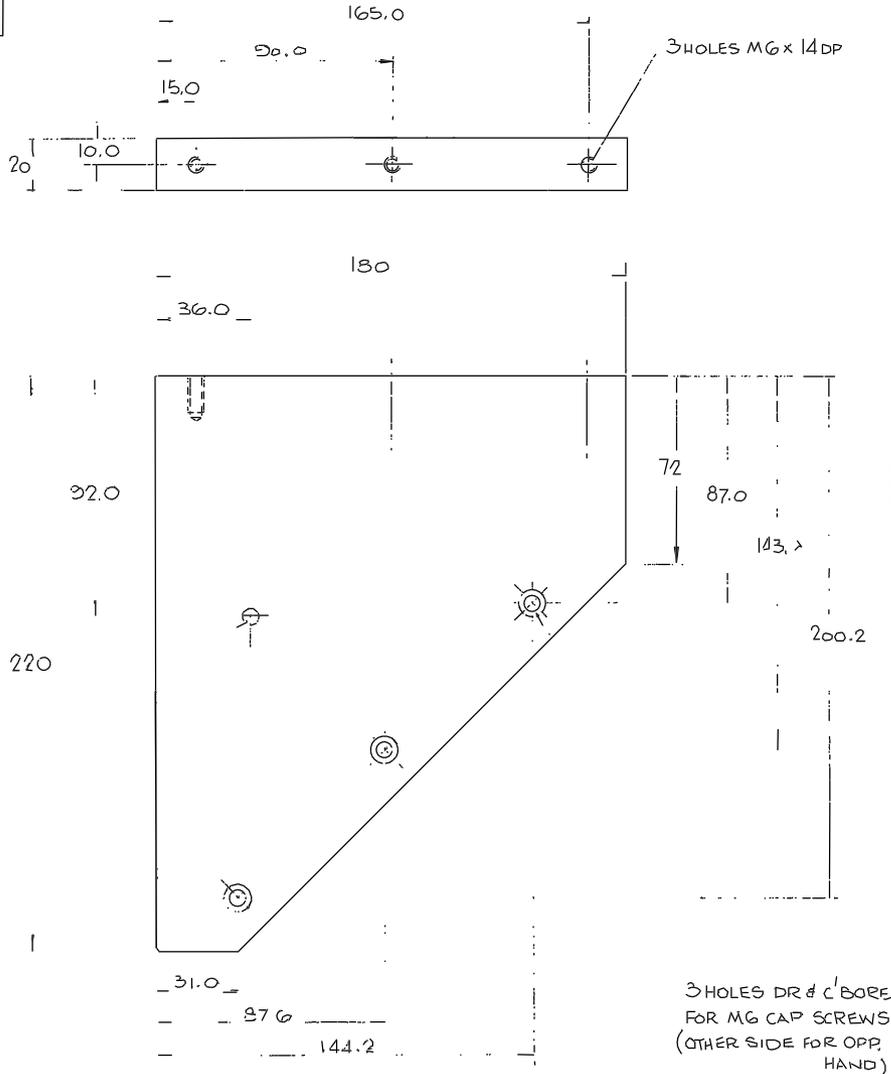
13		TITLE SIDE PLATE	
MATERIAL ALUM ALLOY	SCALE 1/2	TOLERANCES x ±0.2 xx ±0.1 xxx ±0.1	
FINISH	NO. REQ. PER UNIT 2	DRAWING NO. RGO W/IJ/013	
C.A. No.		DRAWING NO.	

15		TITLE PIVOT ROD	
MATERIAL SIL STL	SCALE 1/1	TOLERANCES x ±0.2 xx ±0.1 xxx ±0.1	
FINISH	NO. REQ. PER UNIT 1	DRAWING NO. RGO W/IJ/015	
C.A. No.		DRAWING NO.	

						Tolerances: Unless otherwise stated		Material		Dimensions in m.m.		Scale		THIRD ANGLE PROJECTION		C.A. No.	
						X +		Finish		ROYAL GREENWICH OBSERVATORY, HERSFORCEUX CASTLE, HAILSHAM SUSSEX.		Title		DETAILS		Drawing No.	
						XX +		Used on								W/IJ/013	
						XXX t										015	
Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By										

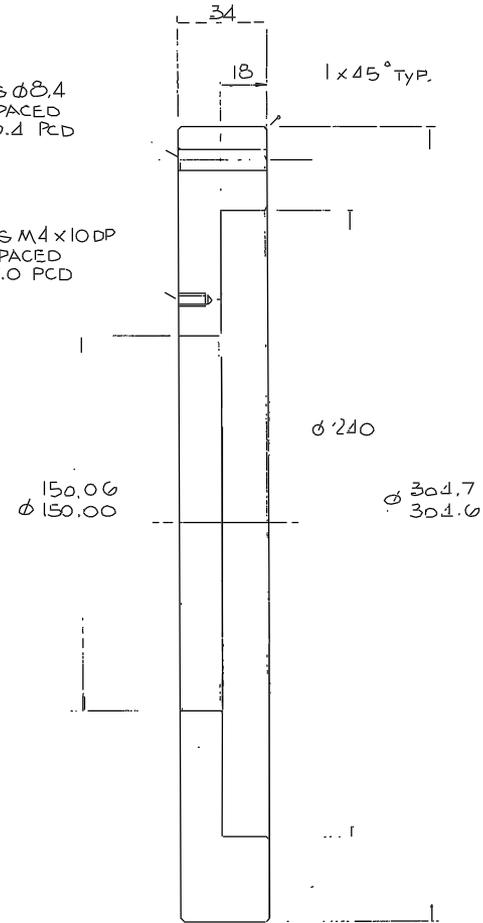
DRAWING NUMBER	No. of Sheets	G.A. Item No.	DRAWING TITLE OR COMPONENT NAME	No. of	MATERIAL STOCK OR ORDER No. AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE
V/IJ/000	1	-	GENERAL ASSY	-					
/ /									
W/IJ/001	1	1	UPPER PLATE	1					
W/IJ/002	1	2	LOWER PLATE	1					
W/IJ/003	1	3	SUPPORT PLATE	1					
/ / 004		4	BACKING PLATE	1					
/ / 005		5	SIDE PLATE	1					
/ / 006		6	" "	1					
/ / 007		7	MIRROR CELL	1					
/ / 008		8	SPACER	1					
W/IJ/009	1	9	LOWER TARGET	1					
/ / 010		10	SPACER	4					
/ / 011		11	PLATE	1					
/ / 012		12	MICROSCOPE MOUNT BLOCK	1					
W/IJ/013	1	13	SIDE PLATE	2					
/ / 014		14	TIE BAR	1					
/ / 015		15	PIVOT ROD	1					
W/IJ/016	1	16	BALL	1					
/ / 017		17	SCREW	1					
/ / 018		18	WASHER	2					
/ / 019		19	COLLAR	2					
/ / 020		20	MIRROR CELL	1					
/ / 021		21	JIG PIN	2					
W/IJ/022	1	22	LOCATING RINGS	1					
/ /									
W/IJ/023	1	24	LOCK RING	2					
/ / 030		25	PIVOT	2					
W/IJ/013	1	26	LASER PLATE	1					
/ /									
/ /									
/ /									
/ /									
/ /									
/ /									
/ /									
/ /									
JOB TITLE	LDS502 ALIGNMENT JIG					ASSY DRG No.	SHEET No.	DRAWN BY	
	ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM, SUSSEX					VIIJ/000	1/2	DATE	

Drawing No
W/IJ/022



3 HOLES $\phi 8.4$ EQUI-SPACED ON 279.4 PCD

3 HOLES M4 x 10 DP EQUI-SPACED ON 162.0 PCD



$\phi 6$ FOR SERVICE

NOT REQD

ITEM AS DRAWN
ITEM OPP. HAND

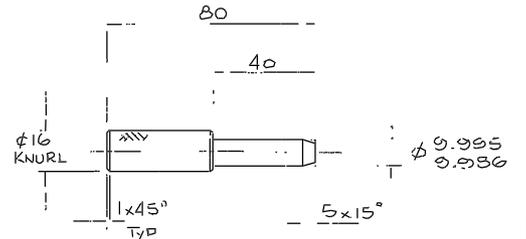
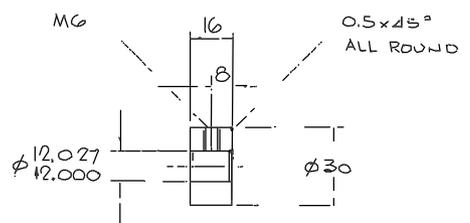
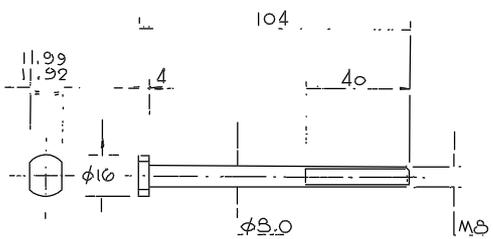
MATERIAL		SCALE		TOLERANCES	
ALUM. ALLOY		1/1		x ± 0.2	
FINISH		NONE FOR PER UNIT		xx ± 0.1	
G.A. No.		R.G.O.		DRAWING No.	

MATERIAL		SCALE		TOLERANCES	
ALUM. ALLOY		1/1		x ± 0.2	
FINISH		NONE FOR PER UNIT		xx ± 0.1	
G.A. No.		R.G.O.		DRAWING No.	

Tolerances (Unless otherwise stated)								Material		Dimas in m.m.		Scale		THIRD ANGLE PROJECTION		G.A. No.	
JUNE 84 PROMEC								Finish		ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM		SUSSEX		Title		Drawing No.	
Issue								Used on		Drq. No.		No. Req		DETAILS		W/IJ/022	

Drawing No. 016
W/IJ/021

∅25
∅10.0

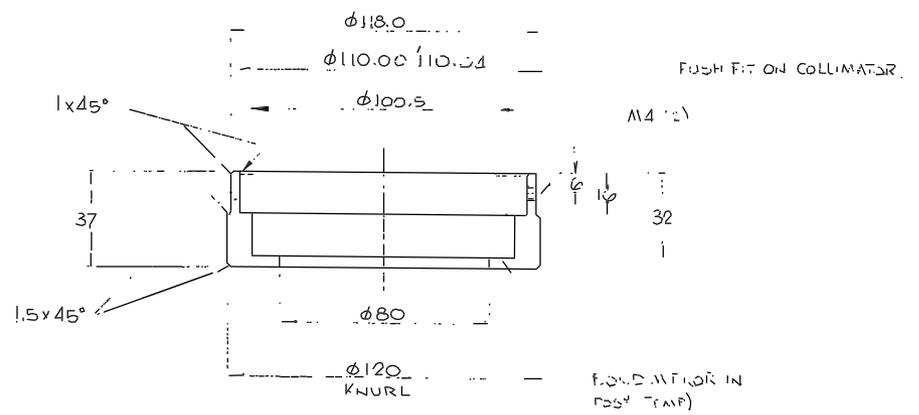
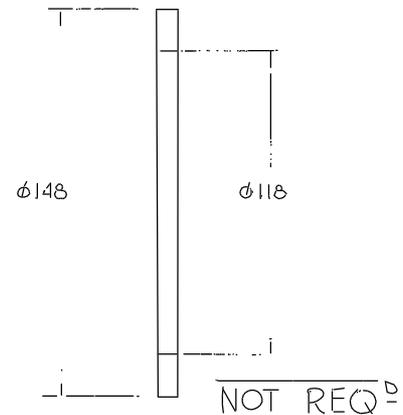
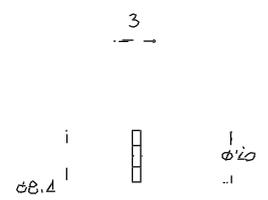


16 BALL			
MATERIAL	SCALE	TOLERANCES	
ST. STL.	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/IJ/016	

17 SCREW			
MATERIAL	SCALE	TOLERANCES	
ST. STL.	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/IJ/017	

19 COLLAR			
MATERIAL	SCALE	TOLERANCES	
ALUM. ALLOY	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/LI/019	

21 JIG PIN			
MATERIAL	SCALE	TOLERANCES	
ST. STL.	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/IJ/021	



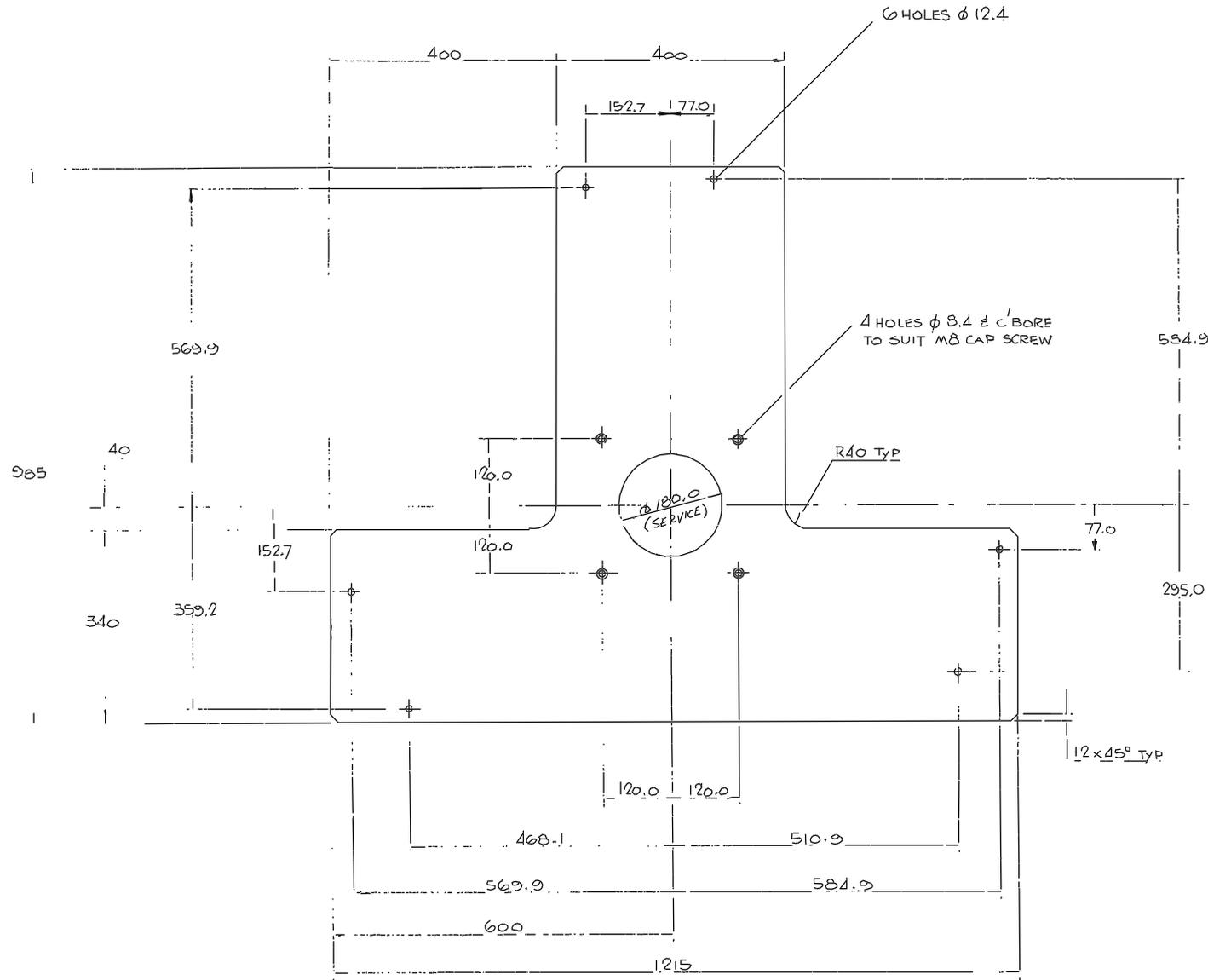
18 WASHER			
MATERIAL	SCALE	TOLERANCES	
ALUM. ALLOY	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/IJ/018	

20 MIRROR CELL			
MATERIAL	SCALE	TOLERANCES	
ALUM. ALLOY	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/IJ/020	

20 MIRROR CELL			
MATERIAL	SCALE	TOLERANCES	
ALUM. ALLOY	1/1	X	±0.2
FINISH	NO REQ PER UNIT	XX	±0.1
Q.A. No.	DRAWING No.	R.G.O. W/IJ/020	

Tolerances (Unless otherwise stated)				Material				Dinns in 1/16				Scale				THIRD ANGLE PROJECTION				Q.A. No.			
X ±				Finish				ROYAL GREENWICH OBSERVATORY,				Title				Drawing No.							
XX ±				Used on				HERSTMANCEUX CASTLE,				DETAILS				W/IJ/016							
XXX ±								HAILSHAM SUSSEX.								TO 021							

DRAWING NUMBER	No. of Sheets	G.A. Item No.	DRAWING TITLE OR COMPONENT NAME	No. off	MATERIAL STOCK OR ORDER No. AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE
/ /									
/ /		36	ROFIN CO-AXIAL LASER HEAD	1					
/ /		37	MIRROR FLAT $\phi 75 \times 14$	1	02 MFG 021	MELLES GRLOT			
/ /		38	" " $\phi 100 \times 14$	1	02 MFG 023	" "			
/ /		39	MICROSCOPE OBJECTIVE HOLDER WITH CENTRING ADJUSTMENT & FOCUSING OBJECTIVE LENS * 10 (APERTURE 12.5)	1	P.T.I. (2055)				
/ /		41	SPRING PLUNGER - WIXROYD	1	4M M8-HWN 2021				
/ /		42	ALT. SCREW - IVDS	2	G 15 201 x 35				
/ /									
/ /									
/ /		47	SPRING - TO SU	1					
/ /									
/ /		50	SOC HD CAP SCREW	M16 x 40	6				
/ /		51	" "	" "	6				
/ /		52	" "	M8 x 50	3				
/ /		53	" "	M8 x 25	8				
/ /		54	" "	M6 x 25	2				
/ /		55	" "	M6 x 20	2				
/ /		56	" "	M5 x 25	6				
/ /		57	" "	M4 x 25	3				
/ /		58	" "	M4 x 12	4				
/ /									
/ /		60	SOC CRIP SCREW	M8 x 45	2				
/ /		61	" "	M4 x 4	2	NYLON			
/ /		62	" "	M6 x 10	2				
/ /		63	CSK S. REW	M6 x 25	6				
/ /									
/ /		65	HFX LOCK NUT	M8	4				
/ /		66	" "	M12	2				
/ /									
/ /		68	WASHER	$\phi 6$	2				
JOB TITLE					ASSY DRG. No.		SHEET No.	DRAWN BY	
LD 55.2. ALIGNMENT JIG					V/J/000		2 of 2	PRCMEC	
ROYAL GREENWICH OBSERVATORY,					HERSTMONCEUX CASTLE,		HAILSHAM,		SUSSEX
							DATE		JULY 89



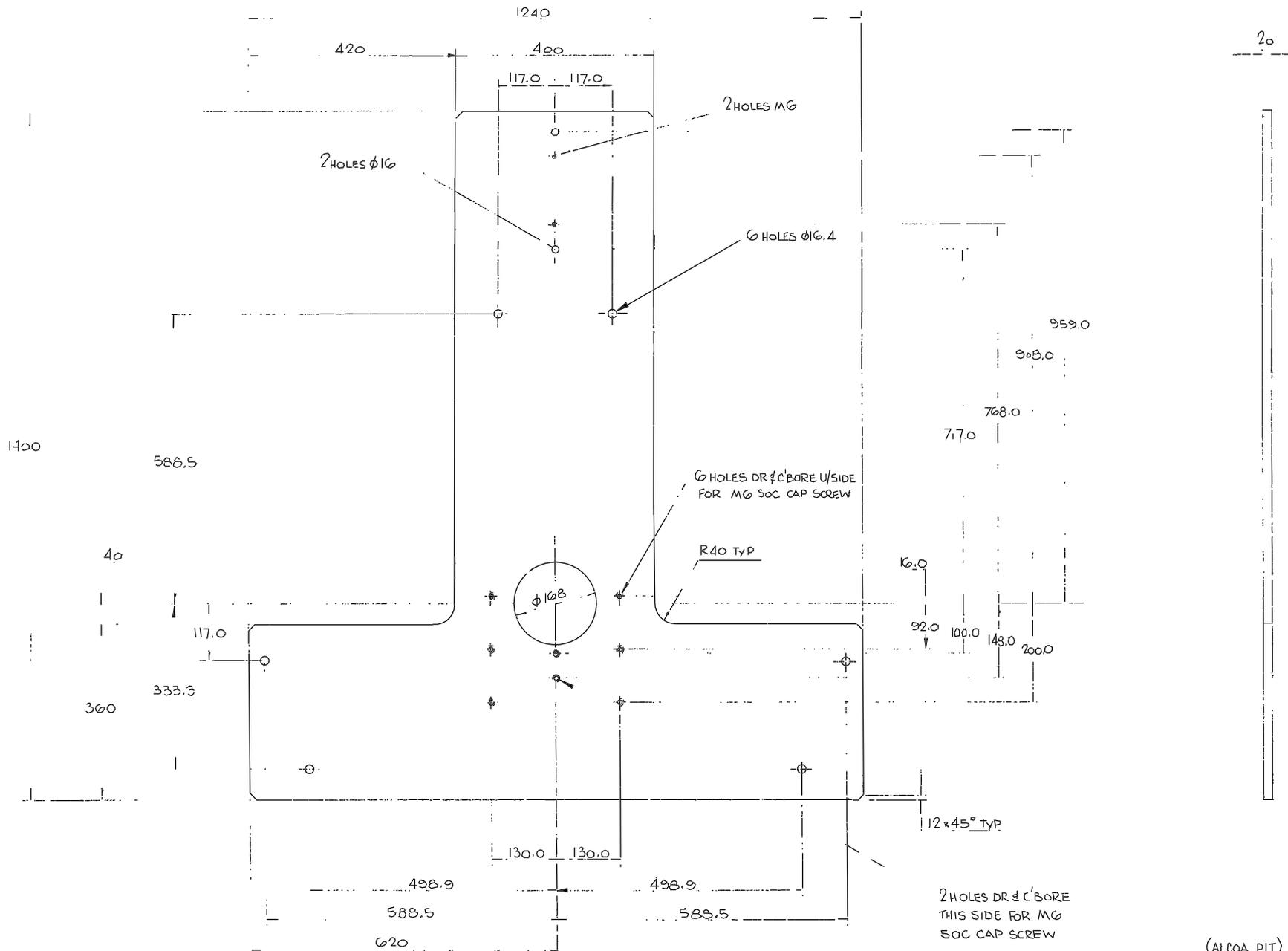
20

2 LOWER PLATE

(ALL A PLT)

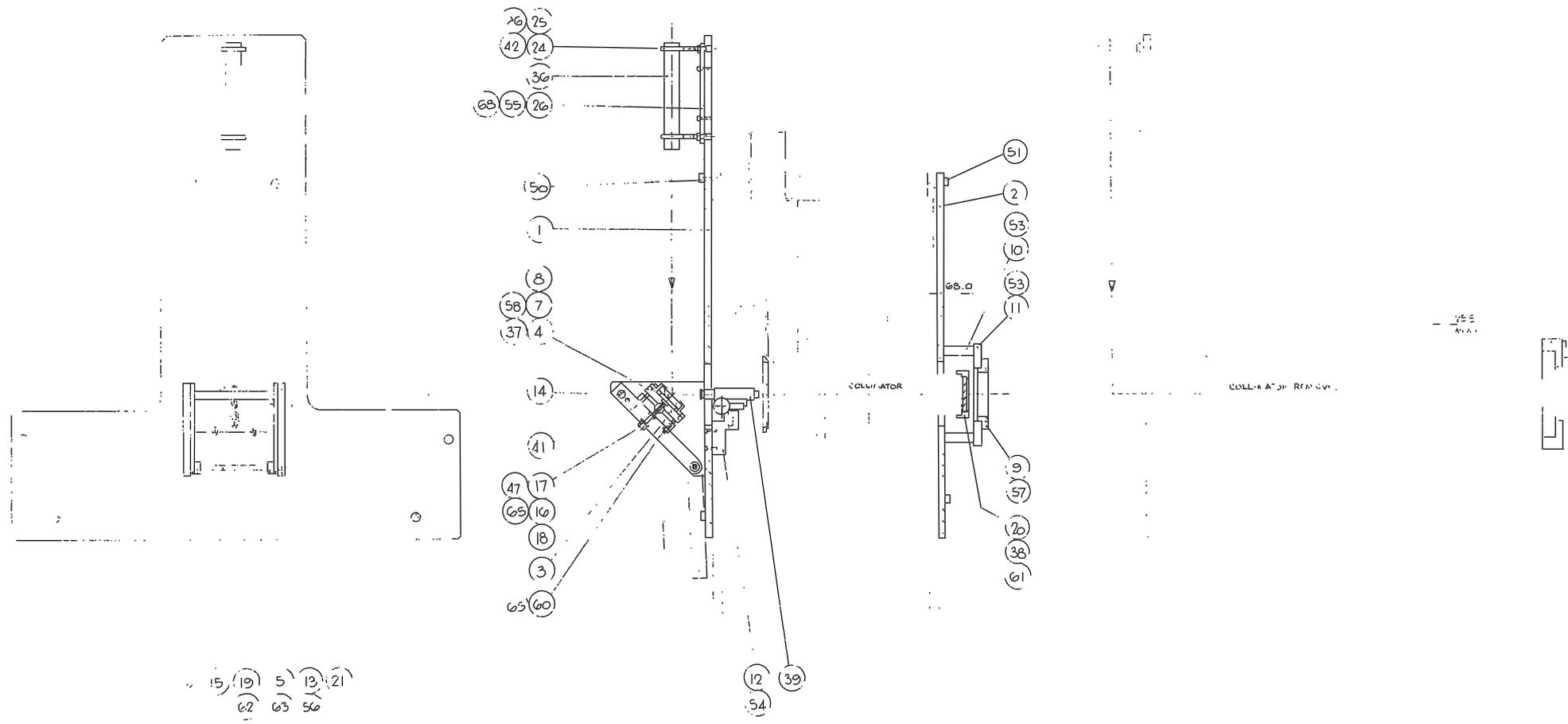
MATERIAL	ALUMINUM ALLOY	SCALE	1/4	TOLERANCES	X \pm 0.2
FINISH		NO REQD PER UNIT		XXX \pm 0.1	
D.A. No.	R.G.O.	DRAWING No.	W/IJ/002		

								Tolerances (Unless otherwise stated)		Material		Dimms in m.m.		Scale		THIRD ANGLE PROJECTION		Title		G.A. No.	
								X	I	Finish		ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM SUSSEX.				DETAIL		Drawing No.		W/IJ/002	
Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By	X.X	+	Used on	Drng. No.	No. Rev.									



FILE
UPPER PLATE
(ALCOA PLT)
MATERIAL: ALUM ALLOY
FINISH
SCALE: 1/4
TOLERANCES: XX ± 0.2, XXX ± 0.1
D.W. No. RGO
DRAWING No. W/IJ/001

Tolerances (Unless otherwise stated) X ± XX ± XXX ±							Material		Dimensions in m.m.		Scale 1/4L		THIRD ANGLE PROJECTION		G.A. No.		
JULY 89 PROMEC							Finish		ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM SUSSEX.		Title		DETAIL		Drawing No. W/IJ/001		
Issue	Mod. No.	Date	Drawn By	Issue	Mod. No.	Date	Drawn By	Drq. No.	No. Rev	Used on							



15, 19, 5, 13, 21
62, 63, 56

52
22

								Tolerances: H/linea ultra-precise standard	Material	Dimens in in in		Scale 1/4	THIRD ANGLE PROJECTION	W.A. No
								X 2 XX 1 XXX 1/2	Finish	Dwg No	No Ring		ROYAL GREENWICH OBSERVATORY, HERS MONCEUX CASTLE, HAILSHAM	ROYAL GREENWICH OBSERVATORY, HERS MONCEUX CASTLE, HAILSHAM
Issue	Mod No	Date	Drawn By	Issue	Mod No	Date	Drawn By	Weld on				LDSS.2. ALIGNMENT JIG	V 11	
JULY 89 PROMEC														