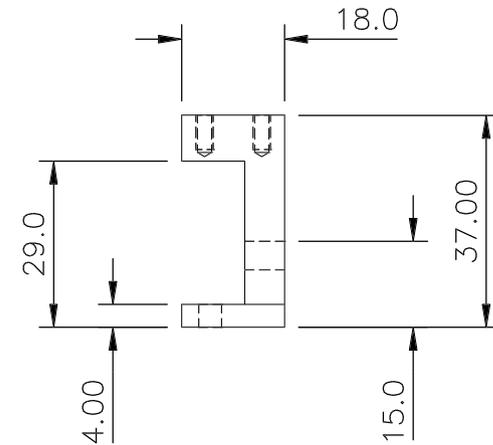
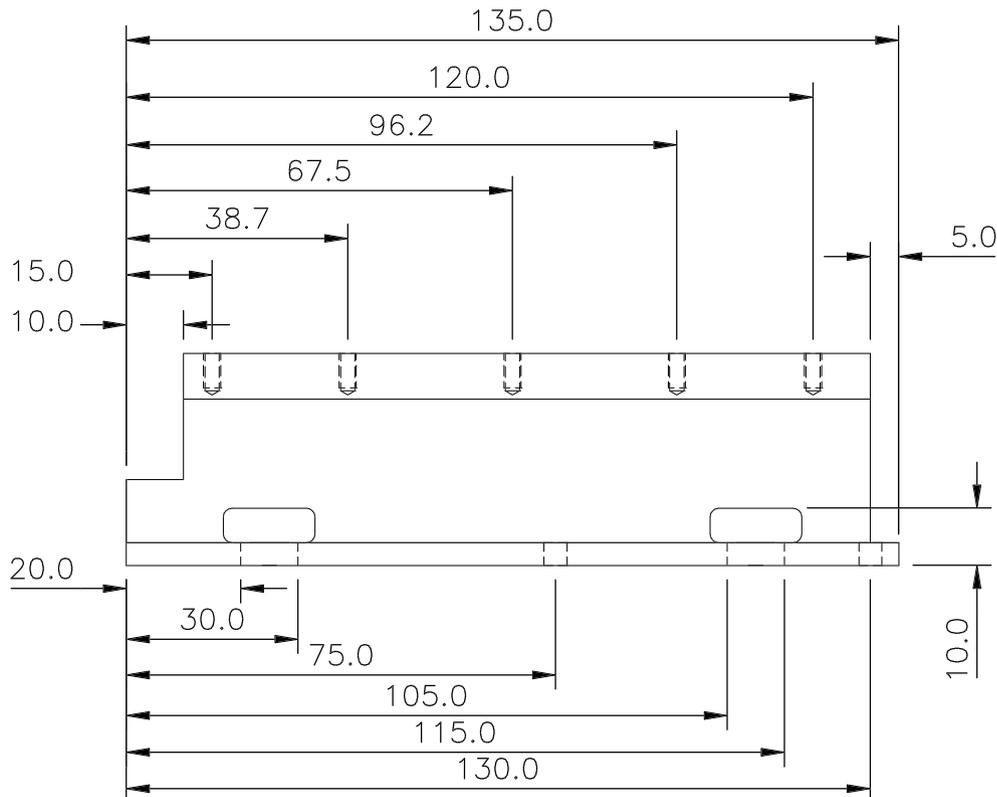
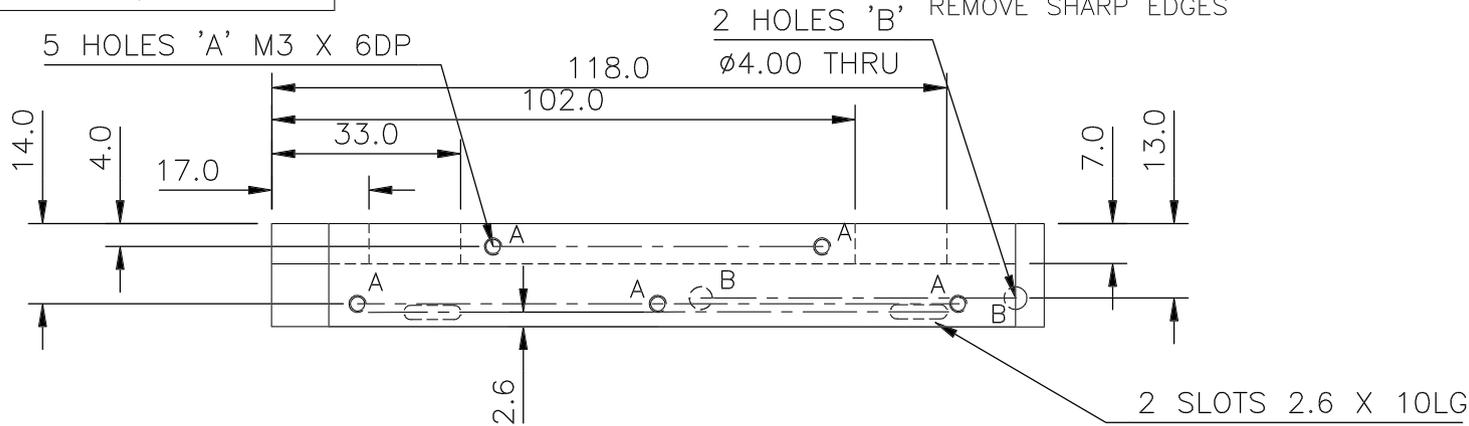




DRG NO.  
BI/003

DO NOT SCALE

REMOVE SHARP EDGES



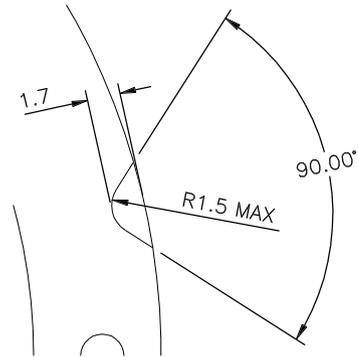
NOTE: ALL RADII 1.5

			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	BI/001	
			X ±	AL. ALLOY		ROYAL GREENWICH OBSERVATORY		TITLE			
1	31/08/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD		HWP SIDE SUPPORT			
ISSUE	DATE	DRAWN	X.XX ± 0.05	BLK	1	CAMBRIDGE CB3 0EZ		ISIS POLARISATION UPGRADE			
			ANG. ±	ANODISE				DRG NO.	BI/003	SHT. 1	LOC'N BI

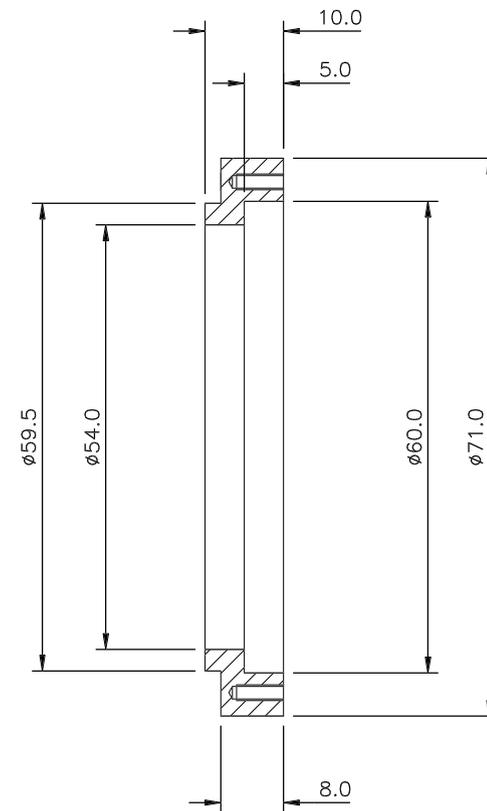
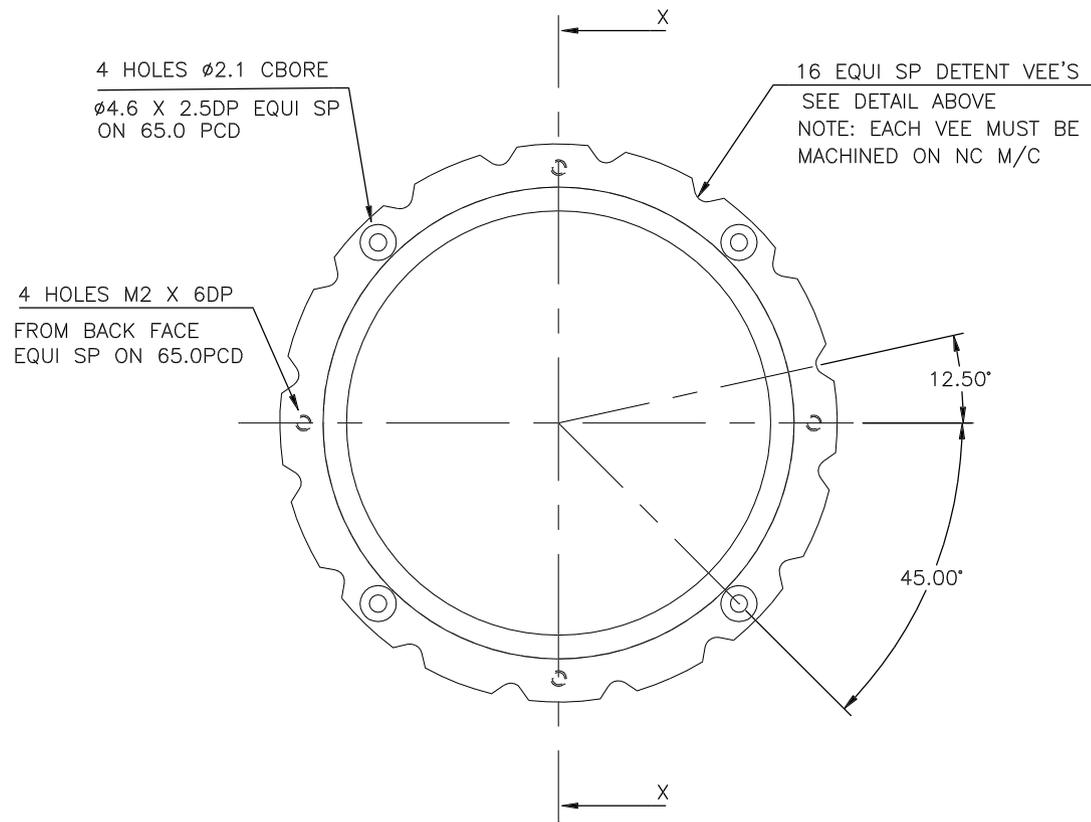
DRG NO.

BI/017

DO NOT SCALE  
REMOVE SHARP EDGES



DETENT VEE DETAIL SCALE 5:1

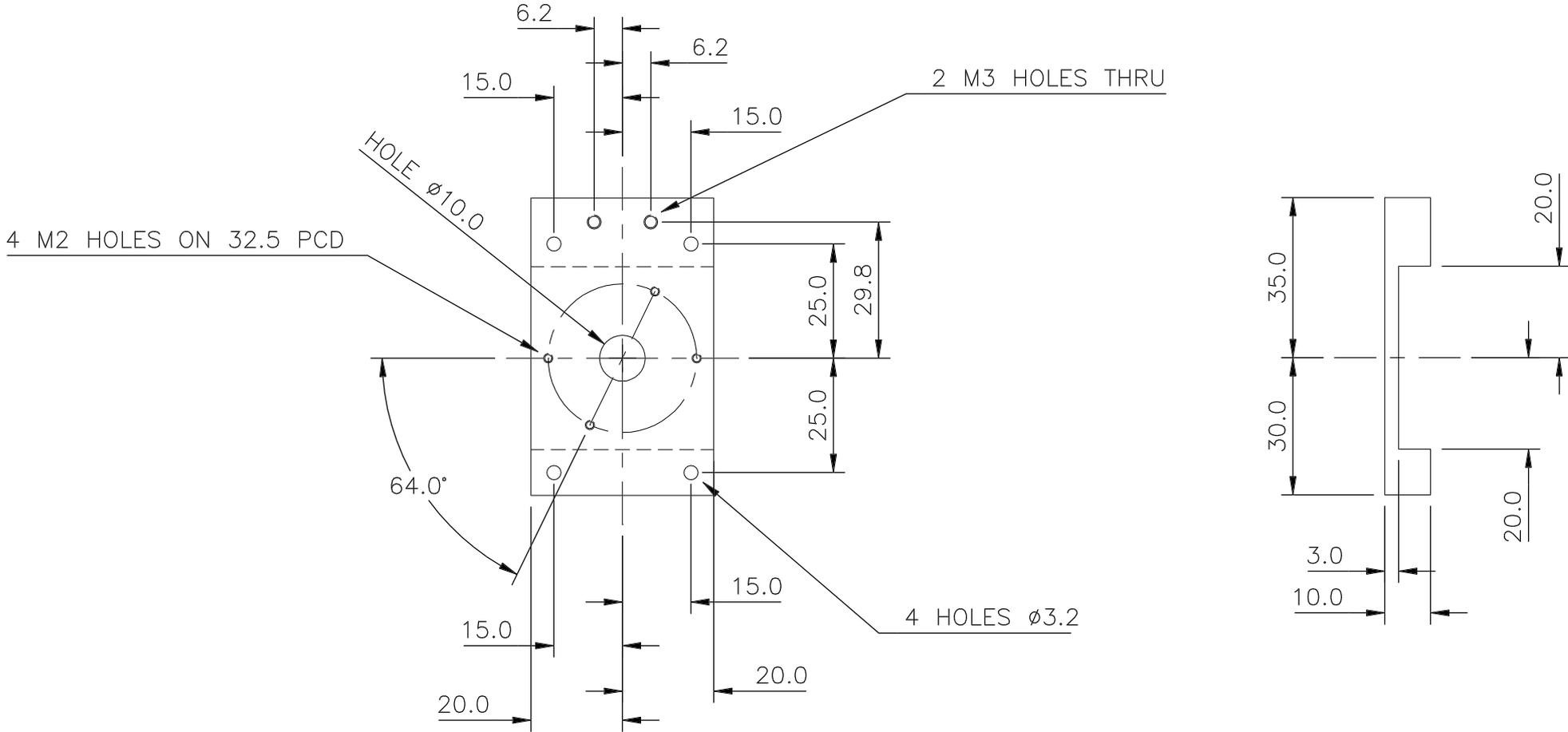


SECTION ON X-X

				TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL BRASS	THIRD ANGLE PROJECTION 	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A2		G.A. NO. BI/036			
				X ±			ROYAL GREENWICH OBSERVATORY	TITLE	HWP RETAINER		LOC'N.	BI	SHT.	1
				X.X ± 0.1	FINISH NICKLE PLATED	NO. REQ'D PER ASS'Y	MADINGLEY ROAD	ISIS POLARISATION UPGRADE		DRG NO.		BI/017		
ISSUE	MOD. NO.	DATE	DRAWN BY	ANG. ± 0.1		1	CAMBRIDGE	CB3 0EZ						
1		11/09/95	PDJ											

DRG NO.  
BI/019

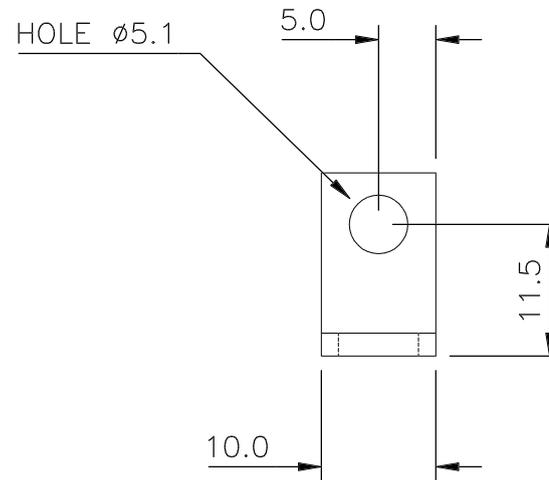
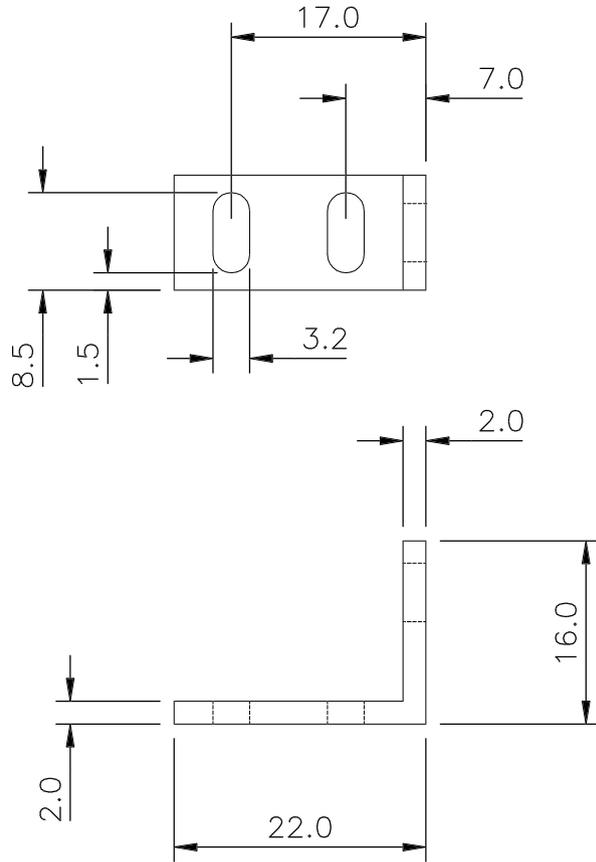
DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/036
			X ±	AL. ALLOY		ROYAL GREENWICH OBSERVATORY	TITLE	HWP ENCODER SUPPORT	
1	12/09/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE		
ISSUE	DATE	DRAWN	X.XX ±	BLK ANODISE	2	CAMBRIDGE CB3 0EZ	DRG NO. BI/019	SHT. 1	LOC'N BI
			ANG. ± 0.1						

DRG NO.  
BI/020

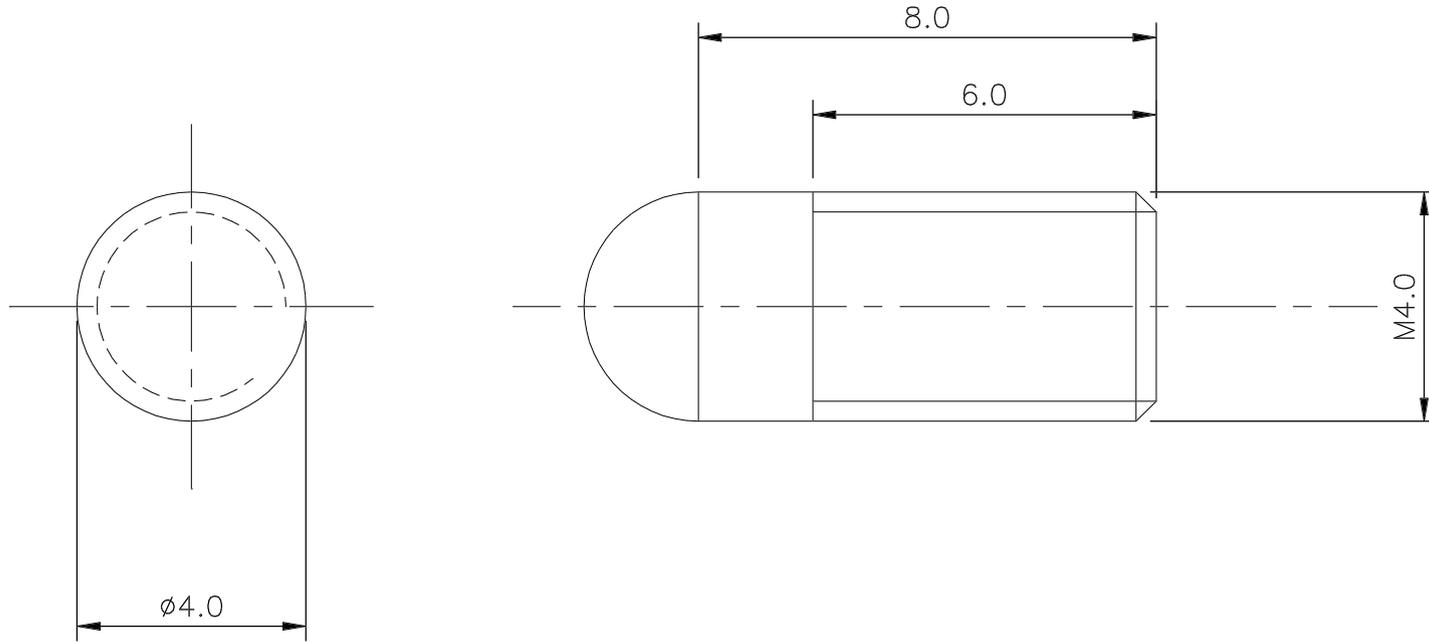
DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/036	
			X ±	AL. ALLOY		ROYAL GREENWICH OBSERVATORY	TITLE	ZERO PROXIMITY SWITCH BRACKET		
1	12/09/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE			
ISSUE	DATE	DRAWN	X.XX ±	BLK	2	CAMBRIDGE CB3 0EZ	DRG NO.	BI/020	SHT. 1	LOC'N BI
			ANG. ±	ANODISE						

DRG NO.  
BI/023

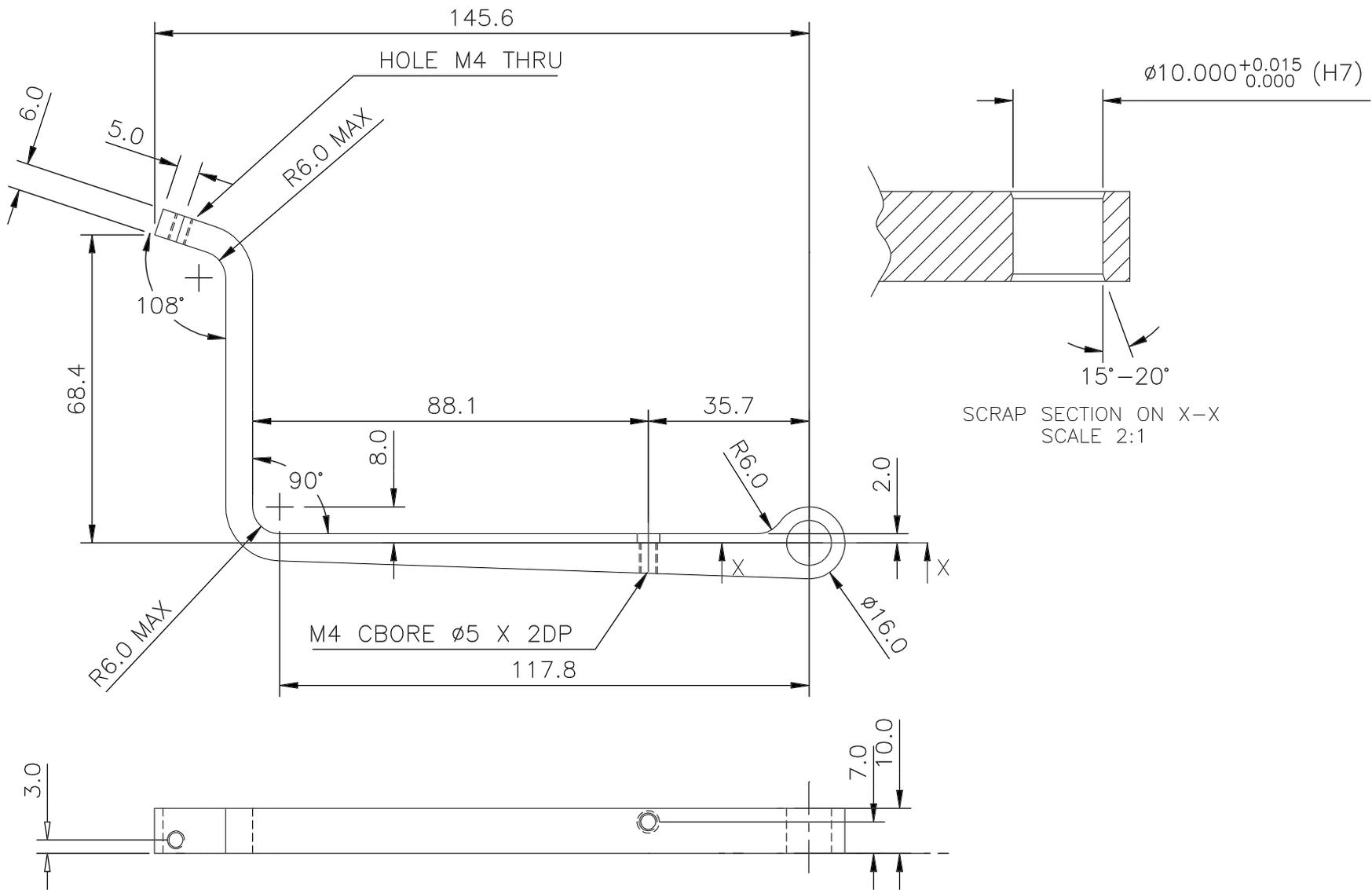
DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 10:1	ORIGINAL SHEET SIZE A3	G.A. NO.	BI/026	
			X $\pm$	NYLON		TITLE ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ					
1	13/09/95	PDJ	X.X $\pm 0.1$	FINISH	No. REQ'D						DETENT PEG ISIS POLARISATION UPGRADE
ISSUE	DATE	DRAWN	X.XX $\pm$	CLEAN	2	DRG NO.			BI/023	SHT. 1	LOC'N BI
			ANG. $\pm$								

DRG NO.  
BI/025

DO NOT SCALE  
REMOVE SHARP EDGES



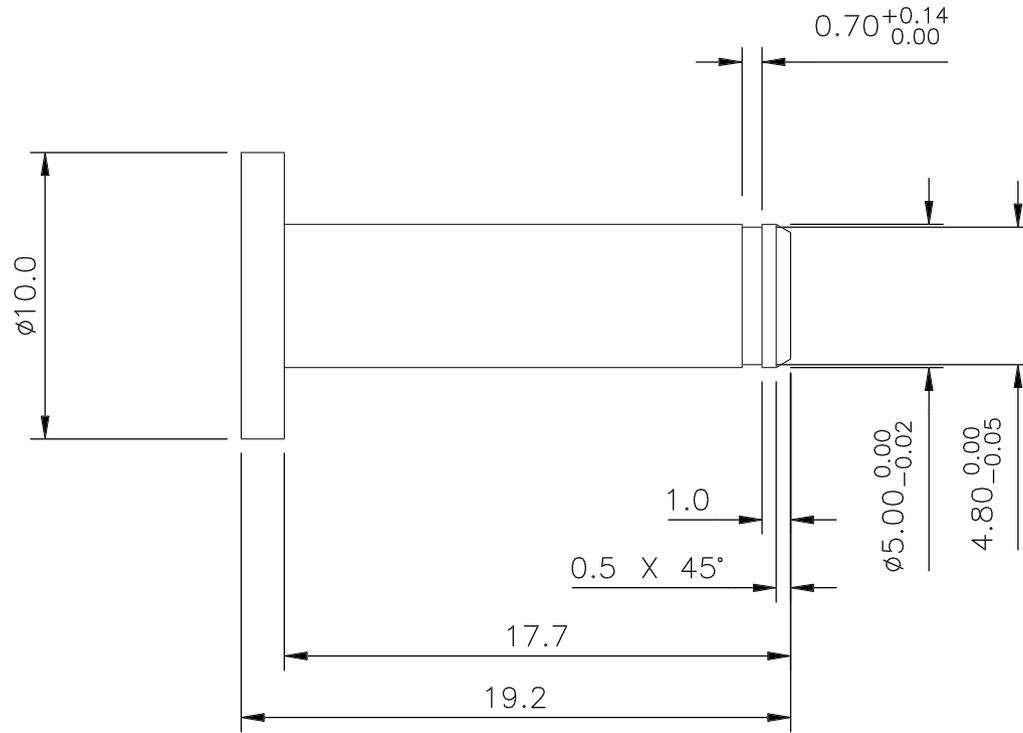
			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL ST. ST.	THIRD ANGLE PROJECTION 	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/0026
			X ±			ROYAL GREENWICH OBSERVATORY	TITLE	HWP DETENT ARM	
2	14/09/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE		
ISSUE	DATE	DRAWN	X.XX ±	CLEAN	1	CAMBRIDGE CB3 0EZ	DRG NO. BI/025	SHT. 1	LOC'N BI
			ANG. ± 0.1						

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	
BI/036			GENERAL ASSEMBLY							
		1	SMC PIN CYLINDER	1	CJPB6-15H4					
BI/027		2	DETENT CYLINDER BRACKET	1	ST.ST					
BI/010		3	CYLINDER COUPLING	1	AL. ALLOY					
		4	SMC FLOATING JOINT	1	JA10-4-070					
		5	INDUCTIVE PROXIMITY SWITCH	1	RS 285-201					
BI/028		6	HWP DETENT FLAG	1	ST. ST.					
BI/011		7	PROXIMITY SWITCH FLAG	1	ST. ST.					
BI/019		8	ENCODER SUPPORT	1	AL. ALLOY					
		9	INDUCTIVE PROXIMITY SWITCH	1	RS 633-458					
BI/020		10	ZERO PROXIMITY SWITCH BRACKET	1	AL. ALLOY					
BI/021		11	ZERO SWITCH FLAG	1	ST. ST.					
BI/024		12	DETENT PIVOT PIN	1	ST. ST.					
		13	CIRCLIP	1	SIZE CODE 0060 (TO DIN 471)					
BI/026		14	HWP DETENT ARM SUB-ASSEMBLY	1						
BI/038		15	DETENT ARM SUPPORT	1	NYLON					
		16	MOTOR GEAR	1	RELIANCE C10A1B5	F4A-16 A				
		17	GEAR CLAMP	1	RELIANCE CGM1-5					
		18	PORTESCAPP MOTOR	1	P520					
BI/022		19	ENCODER SHAFT	1	RELIANCE SMI-6A					
		20	GEAR CLAMP	1	RELIANCE CGM1-6					
		21	ENCODER ANTIBACKLASH GEAR	1	RELIANCE AC10A1B6	F35A-35 A				
		22	KAYDON FOUR POINT CONTACT BRG	1	KA 025XP6					
BI/018		23	LOAD GEAR	1	RELIANCE P10A 1B12	F12A-84 A				
BI/017		24	HWP RETAINER	1	BRASS					
BI/016		25	HWP RETAINER CAP	1	AL. ALLOY					
		26	HEIDENHAIN ENCODER	1	ERO 1421					
BI/012		27	HWP CYLINDER STOP	1	AL. ALLOY					
BI/029		28	HWP MAIN SLIDE PLATE	1	MILD STEEL					
BI/014		29	HWP CYLINDER BRACKET	1	ST. ST.					
			M3 X 16LG CAP HD SCREWS	3	ST. ST.					
			M3 X 8LG CAP HD SCREWS	7	ST. ST.					
			M2.5 X 15LG CAP HD SCREWS	3	ST. ST.					
			M2.5 X 10LG CAP HD SCREWS	3	ST. ST.					
			M2 X 15LG CSK HD SCREWS	4	ST. ST.					
			M2 X 6LG CSK HD SCREWS	2	ST. ST.					
			M2 X 8LG CAP HD SCREWS	5	ST. ST.					
			M2 X 6LG CAP HD SCREWS	3	ST. ST.					
TITLE	HWP ASSEMBLY - PARTS LIST ISIS POLARISATION UPGRADE				LOC'N.	ISSUE	ASS'Y DRG. NO.	SHEET NO.	DRAWN BY	PDJ
	ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE				BI	1	BI/036	1	DATE	30/10/95
									DRG. NO.	BI/036/PL

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	
BI/037			GENERAL ASSEMBLY							
		1	SMC PIN CYLINDER	1	CJPB6-15H4					
BI/027		2	DETENT CYLINDER BRACKET	1	ST.ST					
BI/010		3	CYLINDER COUPLING	1	AL. ALLOY					
		4	SMC FLOATING JOINT	1	JA10-4-070					
		5	INDUCTIVE PROXIMITY SWITCH	1	RS 285-201					
BI/030		6	QWP DETENT FLAG	1	ST. ST.					
BI/011		7	PROXIMITY SWITCH FLAG	1	ST. ST.					
BI/019		8	ENCODER SUPPORT	1	AL. ALLOY					
		9	INDUCTIVE PROXIMITY SWITCH	1	RS 633-458					
BI/020		10	ZERO PROXIMITY SWITCH BRACKET	1	AL. ALLOY					
BI/033		11	QWP ZERO SWITCH FLAG	1	ST. ST.					
BI/024		12	DETENT PIVOT PIN	1	ST. ST.					
		13	CIRCLIP	1	SIZE CODE 0060 (TO DIN 471)					
BI/032		14	QWP DETENT ARM SUB-ASSEMBLY	1						
BI/038		15	DETENT ARM SUPPORT	1	NYLON					
		16	MOTOR GEAR	1	RELIANCE C10A1B5	F4A-16 A				
		17	GEAR CLAMP	1	RELIANCE CGM1-5					
		18	PORTESCAPP MOTOR	1	P520					
BI/022		19	ENCODER SHAFT	1	RELIANCE SMI-6A					
		20	GEAR CLAMP	1	RELIANCE CGM1-6					
		21	ENCODER ANTIBACKLASH GEAR	1	RELIANCE AC10A1B6	F35A-35 A				
		22	KAYDON FOUR POINT CONTACT BRG	1	KA 025XP6					
BI/018		23	LOAD GEAR	1	RELIANCE P10A 1B12	F12A-84 A				
BI/034		24	QWP RETAINER	1	BRASS					
		25								
		26	HEIDENHAIN ENCODER	1	ERO 1421					
BI/013		27	QWP CYLINDER STOP	1	AL. ALLOY					
BI/035		28	QWP MAIN SLIDE PLATE	1	MILD STEEL					
BI/015		29	QWP CYLINDER BRACKET	1	ST. ST.					
			M3 X 16LG CAP HD SCREWS	3	ST. ST.					
			M3 X 8LG CAP HD SCREWS	7	ST. ST.					
			M2.5 X 15LG CAP HD SCREWS	2	ST. ST.					
			M2.5 X 10LG CAP HD SCREWS	4	ST. ST.					
			M2 X 15LG CSK HD SCREWS	4	ST. ST.					
			M2 X 6LG CSK HD SCREWS	2	ST. ST.					
			M2 X 8LG CAP HD SCREWS	5	ST. ST.					
			M2 X 6LG CAP HD SCREWS	3	ST. ST.					
TITLE	QWP ASSEMBLY - PARTS LIST ISIS POLARISATION UPGRADE				LOC'N.	ISSUE	ASS'Y DRG. NO.	SHEET NO.	DRAWN BY	PDJ
					BI	1	BI/037	1	DATE	31/10/95
ROYAL GREENWICH OBSERVATORY, MADINGLEY ROAD, CAMBRIDGE									DRG. NO.	BI/037/PL

DRG NO.  
BI/039

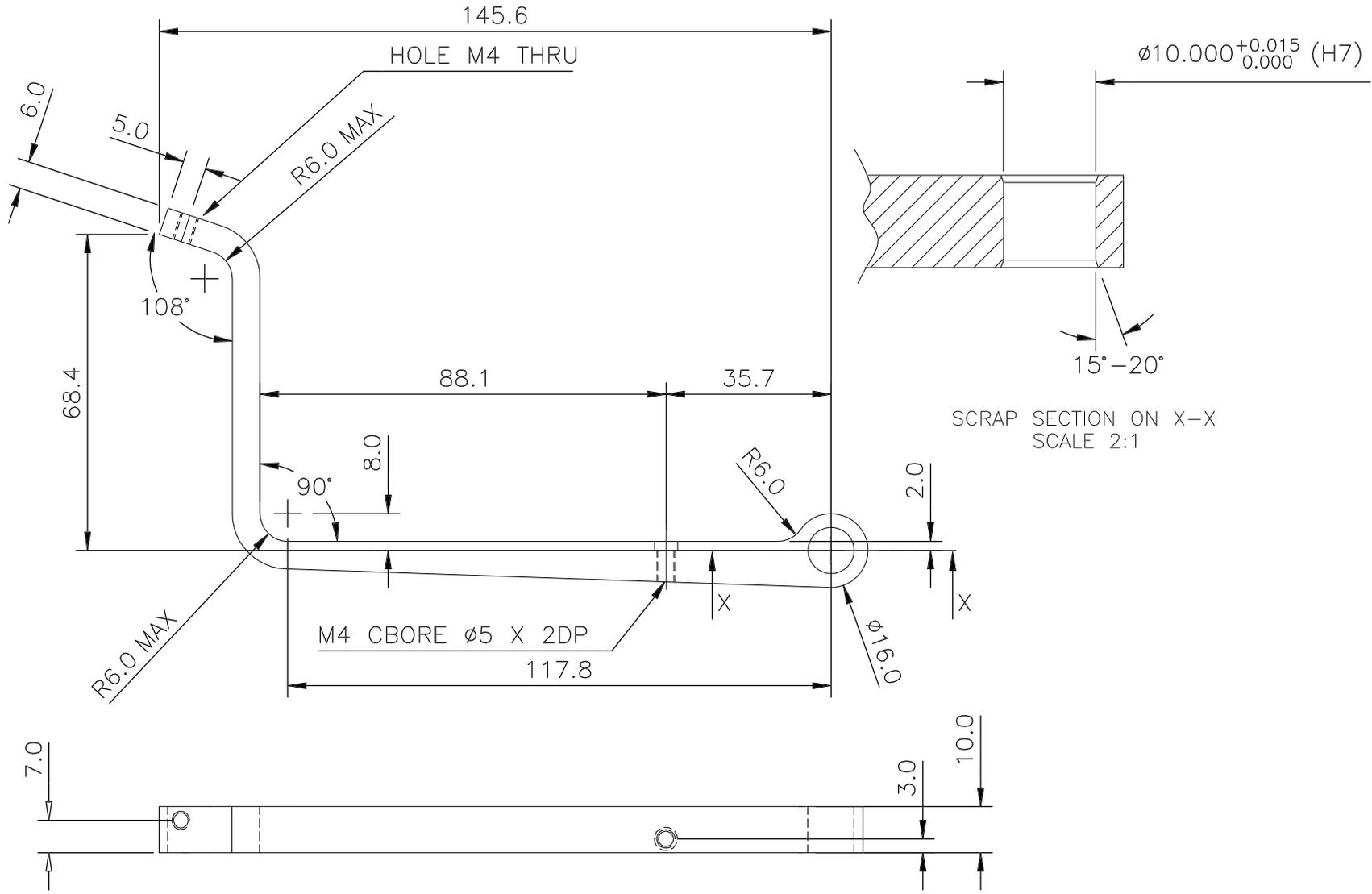
DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 5:1	ORIGINAL SHEET SIZE A3	G.A. NO.	BI/001
			X ±	ST. ST		ROYAL GREENWICH OBSERVATORY	TITLE	MAIN CYLINDER PIVOT PIN		
1	03/11/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE			
ISSUE	DATE	DRAWN	X.XX ±	CLEAN	2	CAMBRIDGE CB3 0EZ	DRG NO.	BI/039	SHT. 1	LOC'N BI
			ANG. ±							

DRG NO.  
BI/031

DO NOT SCALE  
REMOVE SHARP EDGES

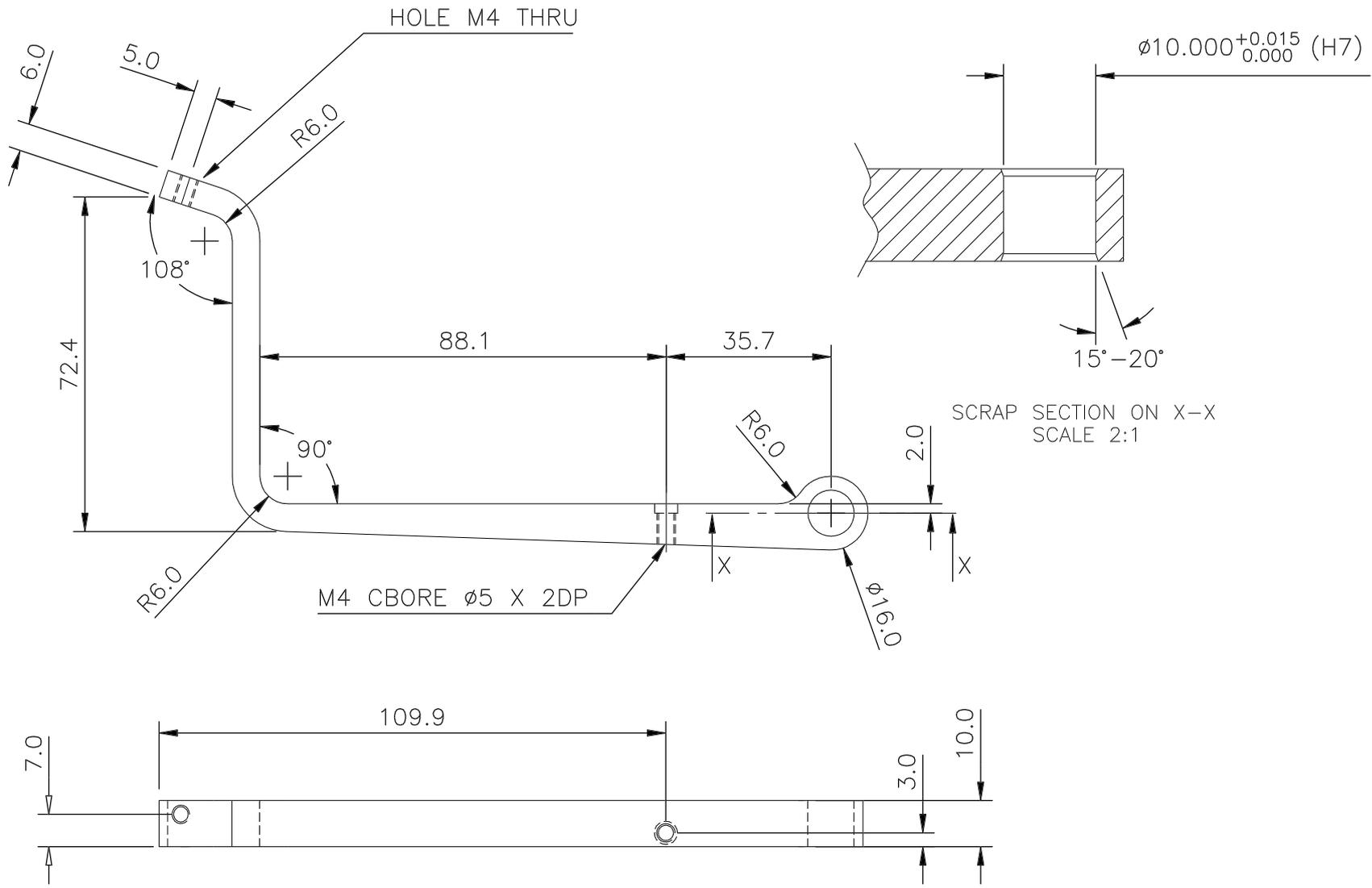


			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	
			X ±	ST. ST.		ROYAL GREENWICH OBSERVATORY	TITLE	QWP DETENT ARM		
2	16/11/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE			
ISSUE	DATE	DRAWN	X.XX ±	CLEAN	1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/031	SHT. 1	LOC'N BI
			ANG. ± 0.1							



DRG NO.  
BI/031

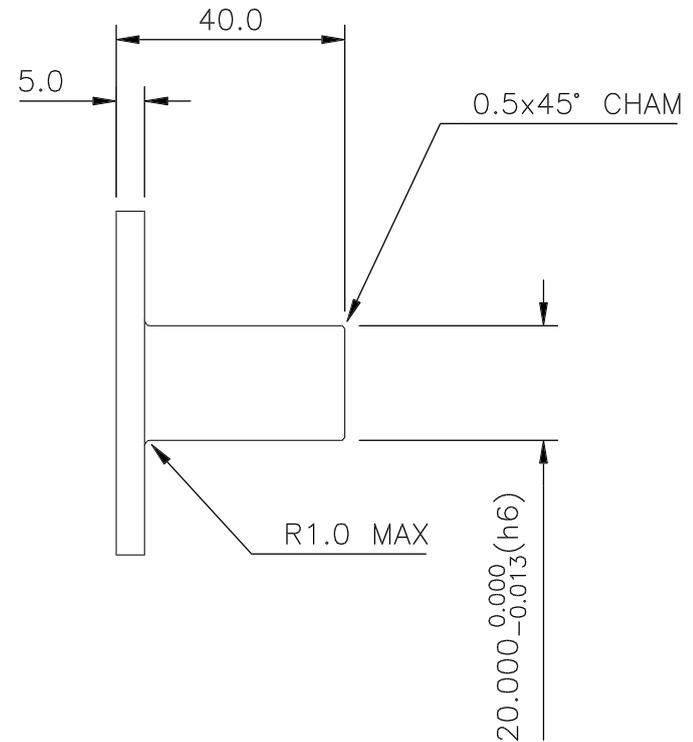
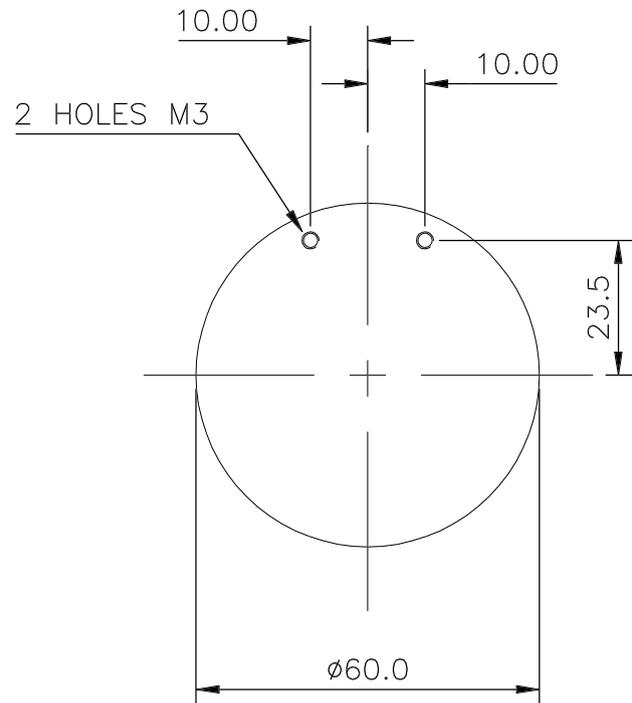
DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	
			X ±	ST. ST.		ROYAL GREENWICH OBSERVATORY	TITLE	QWP DETENT ARM		
1	24/10/95	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION UPGRADE			
ISSUE	DATE	DRAWN	X.XX ±	CLEAN	1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/031	SHT. 1	LOC'N BI
			ANG. ± 0.1							

DRG NO.  
BI/058

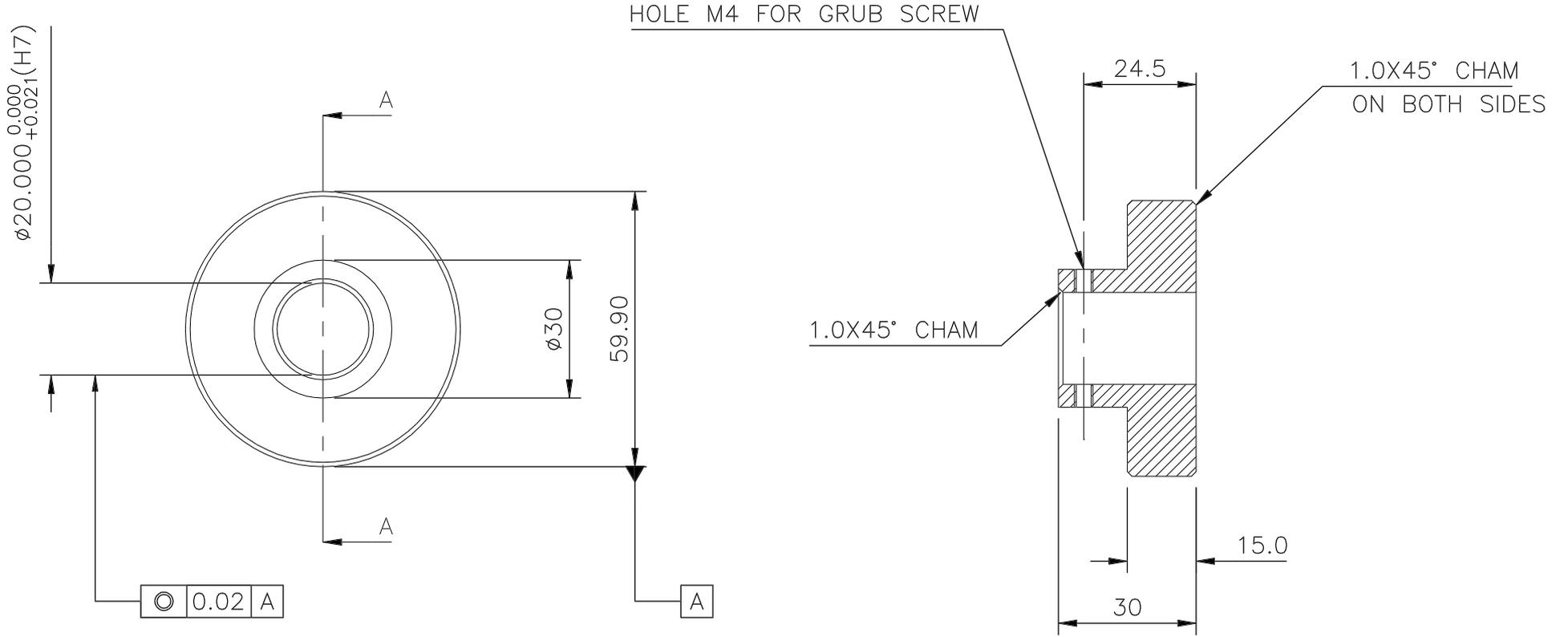
DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	BI/061
			X ±	AL ALLOY		ROYAL GREENWICH OBSERVATORY		TITLE		
1	24/01/96	PDJ	X.X ± 0.5	FINISH	No. REQ'D	MADINGLEY ROAD		MIRROR BASE PLATE		
ISSUE	DATE	DRAWN	X.XX ± 0.1	CLEAN	1	CAMBRIDGE CB3 0EZ		ISIS POLARISATION TEST RIG		
			ANG. ±			DRG NO.	BI/058	SHT.	1	LOC'N BI

DRG NO.  
BI/059

DO NOT SCALE  
REMOVE SHARP EDGES

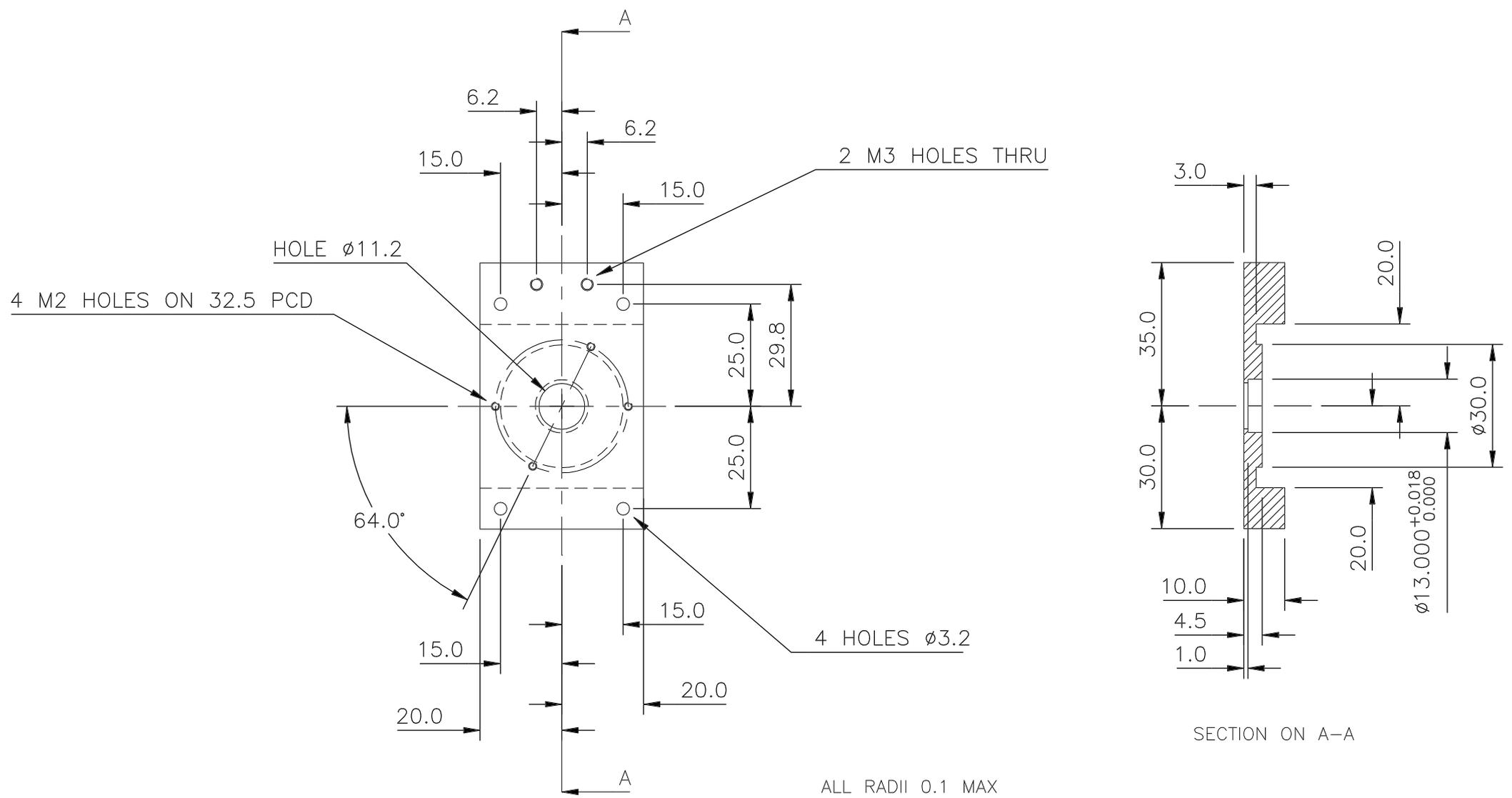


SECTION ON A-A

			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	
			X ± 0.5	AL. ALLOY		ROYAL GREENWICH OBSERVATORY	TITLE	WAVE PLATE BLANK		
1	24/01/96	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION TEST RIG			
ISSUE	DATE	DRAWN	X.XX ± 0.05	CLEAN	1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/059	SHT. 1	LOC'N BI
			ANG. ±							

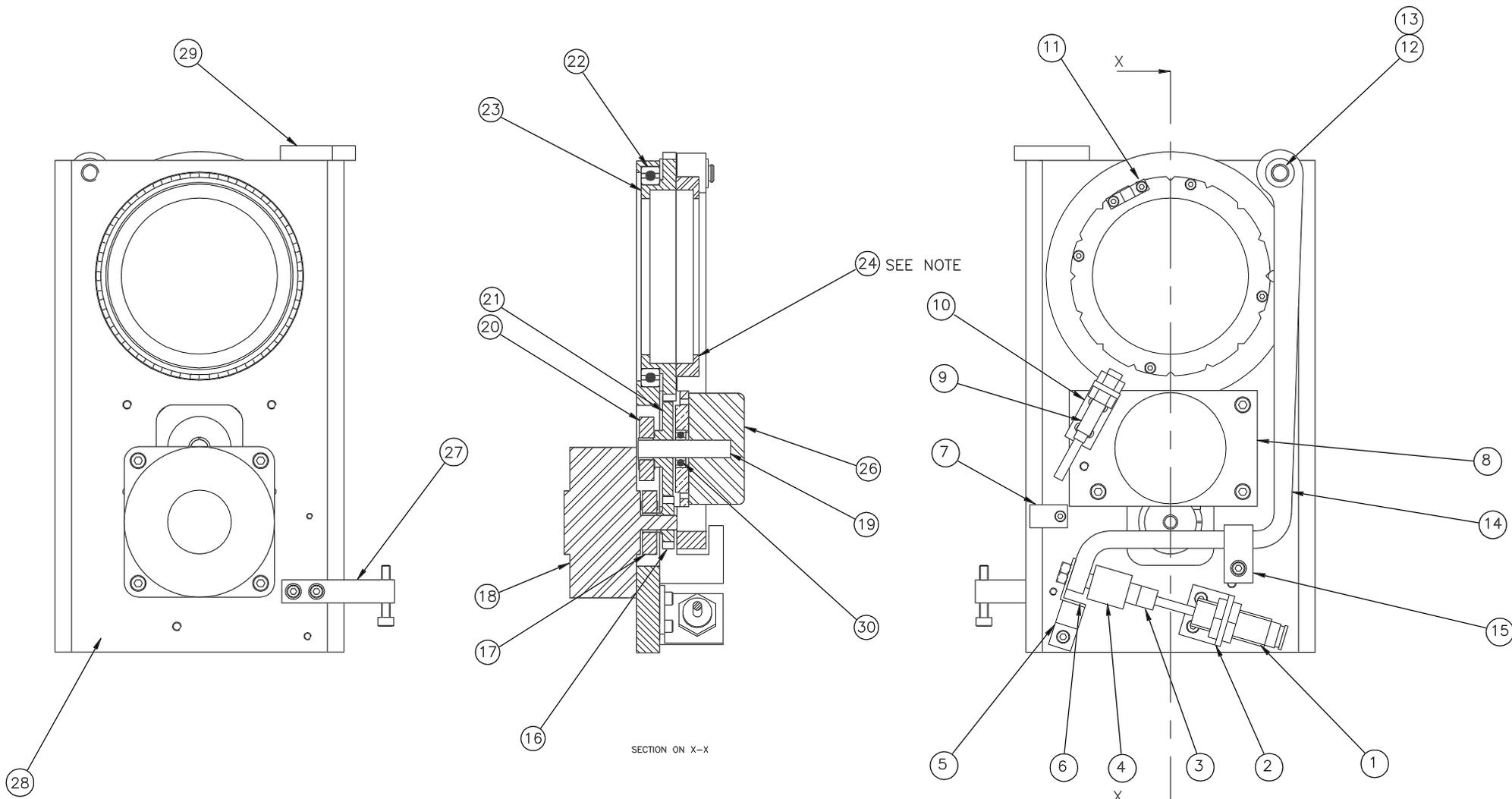
DRG NO.  
BI/019

DO NOT SCALE  
REMOVE SHARP EDGES



			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO. BI/036		
1	12/09/95	PDJ	X ±	AL. ALLOY		ROYAL GREENWICH OBSERVATORY		TITLE HWP ENCODER SUPPORT			
2	29/01/96	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD		ISIS POLARISATION UPGRADE			
ISSUE	DATE	DRAWN	X.XX ±	BLK ANODISE	2	CAMBRIDGE	CB3 OEZ	DRG NO.	BI/019	SHT. 1	LOC'N BI
			ANG. ± 0.1								





NOTE:  
 DURING ASSEMBLY, ENSURE NO BACKLASH EXISTS BETWEEN  
 ENCODER AND WAVEPLATE GEARS. ALLOW BACKLASH AT THE  
 DRIVE GEAR ONLY.  
 FIT BEARINGS WITH LOCTITE 361  
 PIN ITEM 24 TO 23 WITH MIN RUNOUT WRT BEARING  
 USING TWO #2.0 FINS

ISSUE	MOD NO.	DATE	DRAWN BY	ISSUE	MOD NO.	DATE	DRAWN BY
				1		09/10/95	PDJ
				2		29/01/96	PDJ

TOLERANCES (UNLESS OTHERWISE STATED)
X ±
XX ±
XXX ±
ANG. ±

<del>MATERIAL</del>	THIRD ANGLE PROJECTION
<del>FINISH</del>	NO. REQ'D PER ASSY

DIMS IN mm	ORIGINAL SCALE 2:1
ROYAL GREENWICH OBSERVATORY	TITLE
MADINGLEY ROAD	QWP ASSEMBLY
CAMBRIDGE CB3 0EZ	ISIS POLARISATION UPGRADE

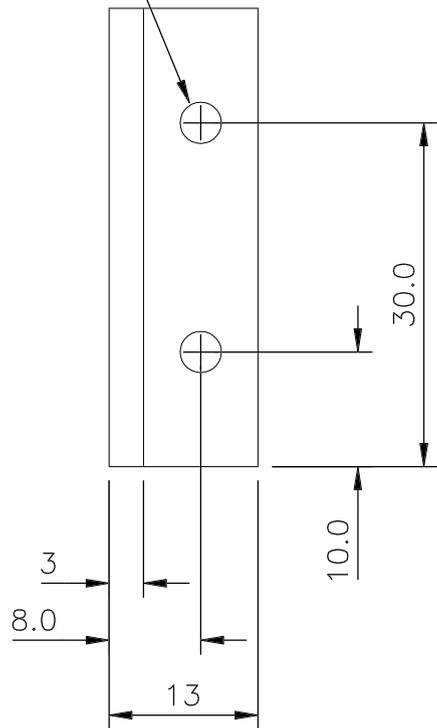
ORIGINAL SHEET SIZE A0
G.A. NO. BI/001
Loc'n. BI
DRG. NO. BI/037
SHT. NO. 1

ISSUE	MOD NO.	DATE	DRAWN BY	ISSUE	MOD NO.	DATE	DRAWN BY	TOLERANCES (UNLESS OTHERWISE STATED)	<del>MATERIAL</del>	THIRD ANGLE PROJECTION	<del>FINISH</del>	DIMS IN mm	ORIGINAL SCALE 2:1	TITLE	ORIGINAL SHEET SIZE A0	G.A. NO. BI/001	Loc'n. BI	DRG. NO. BI/037	SHT. NO. 1
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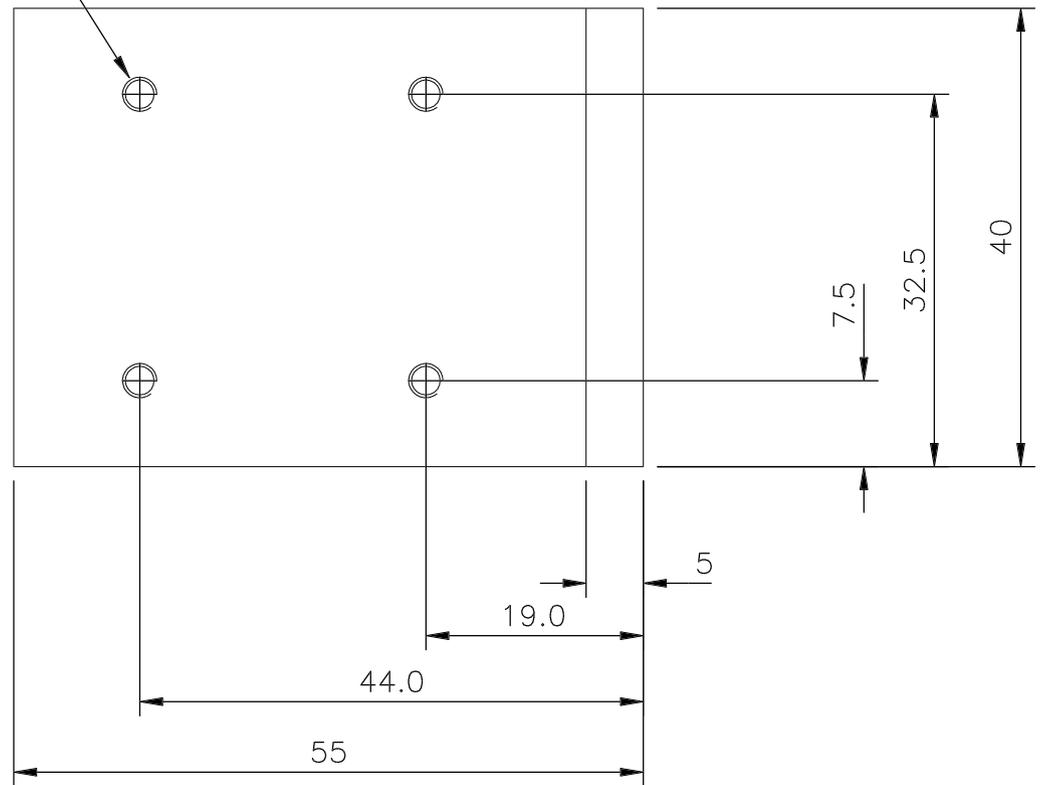
DRG NO.  
BI/060

DO NOT SCALE  
REMOVE SHARP EDGES

2 HOLES  $\phi 3.6$



4 HOLES M3



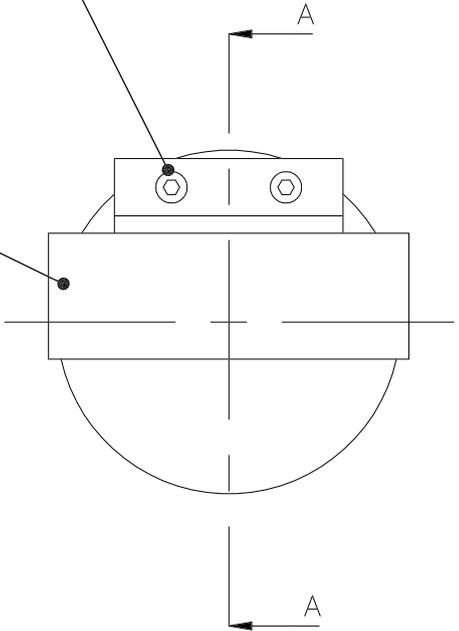
			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 2:1	ORIGINAL SHEET SIZE A3	G.A. NO.	BI/061
			X ± 0.5	AL ALLOY		ROYAL GREENWICH OBSERVATORY				
1	30/01/96	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MIRROR CELL SUPPORT				
ISSUE	DATE	DRAWN	X.XX ±	CLEAN	1	ISIS POLARISATION TEST RIG				
			ANG. ±			DRG NO.	BI/060	SHT.	1	LOC'N BI

DRG NO.  
BI/061

DO NOT SCALE  
REMOVE SHARP EDGES

6 M3 X 10 CAP HD SCREWS

MIRROR CELL

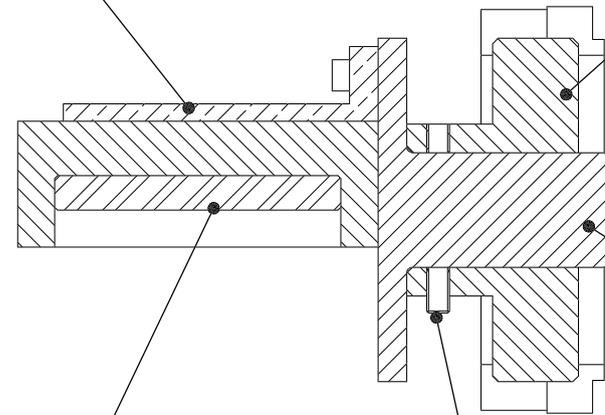


BI/060

BI/059

2" MIRROR

M4 X 8LG SET SCREW



SECTION ON A-A

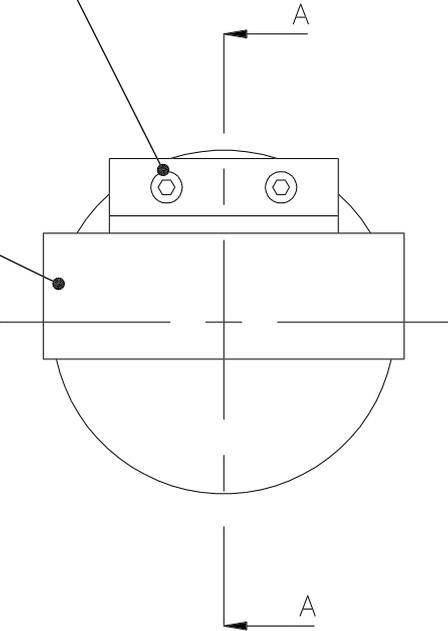
			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	
			X ±			ROYAL GREENWICH OBSERVATORY	TITLE	PART ASSEMBLY		
1	30/01/96	PDJ	X.X ±	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION TEST RIG			
ISSUE	DATE	DRAWN	X.XX ±		1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/061	SHT. 1	LOC'N BI
			ANG. ±							

DRG NO.  
BI/061

DO NOT SCALE  
REMOVE SHARP EDGES

6 M3 X 10 CAP HD SCREWS

MIRROR CELL

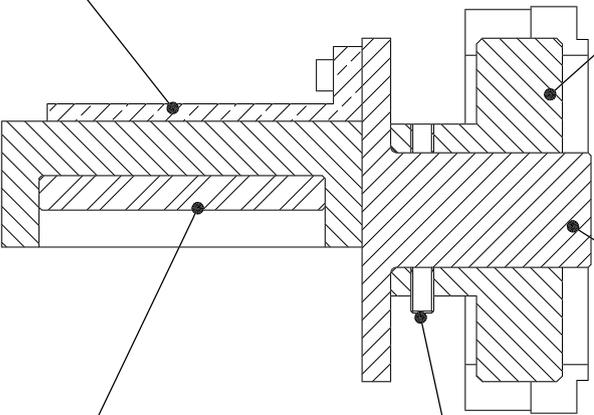


BI/060

BI/059

2" MIRROR

M4 X 8LG NYLON SET SCREW

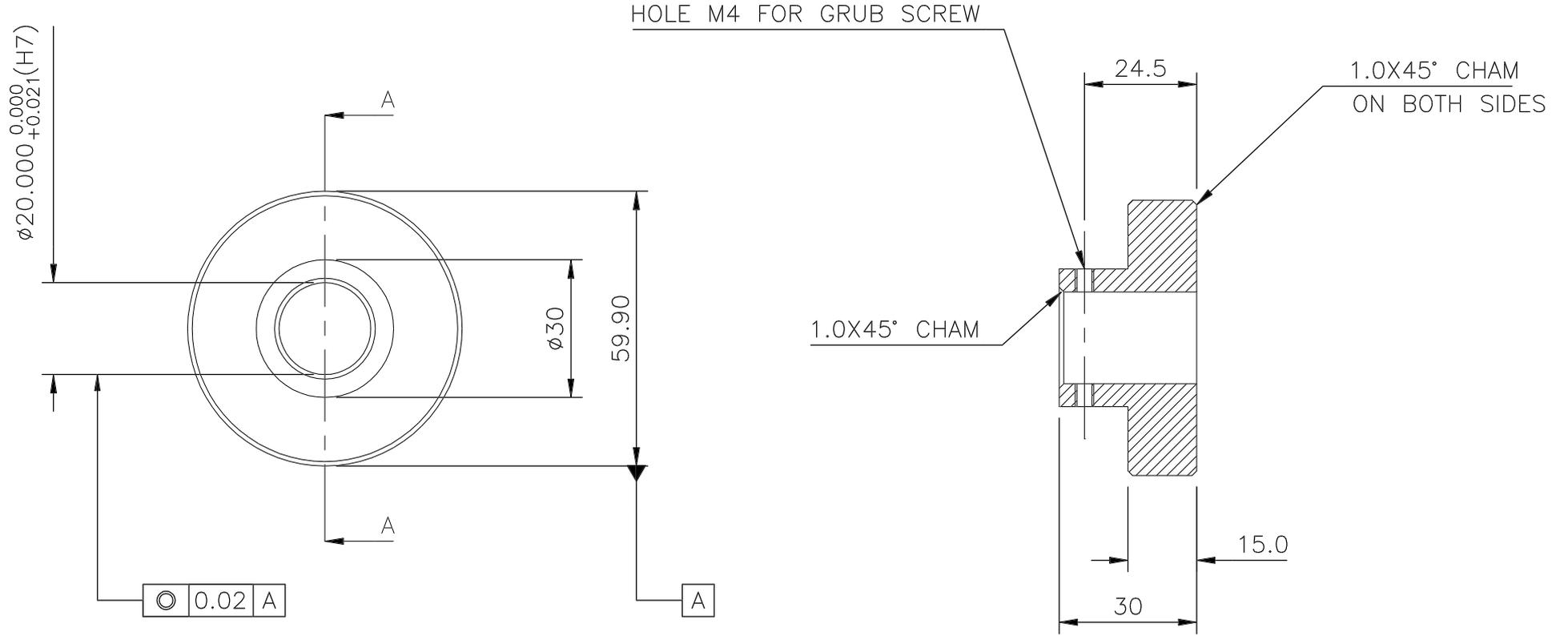


SECTION ON A-A

			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	
1	30/01/96	PDJ	X ±			ROYAL GREENWICH OBSERVATORY	TITLE	PART ASSEMBLY		
2	30/01/96	PDJ	X.X ±	FINISH	No. REQ'D	MADINGLEY ROAD	ISIS POLARISATION TEST RIG			
ISSUE	DATE	DRAWN	X.XX ±		1	CAMBRIDGE CB3 0EZ	DRG NO.	BI/061	SHT. 1	LOC'N BI
			ANG. ±							

DRG NO.  
BI/059

DO NOT SCALE  
REMOVE SHARP EDGES



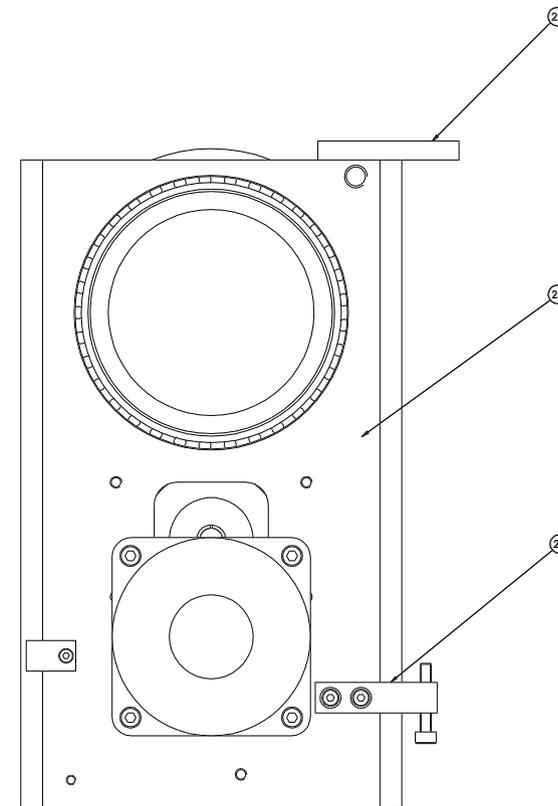
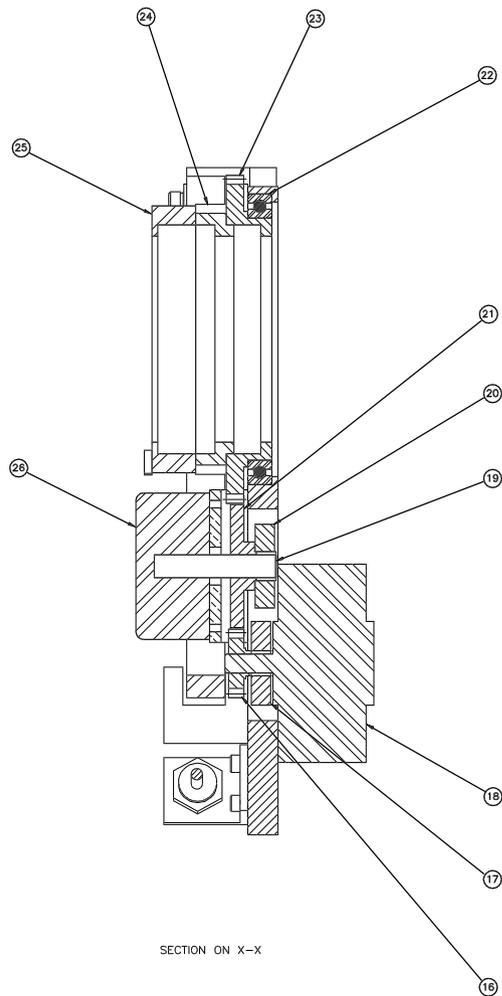
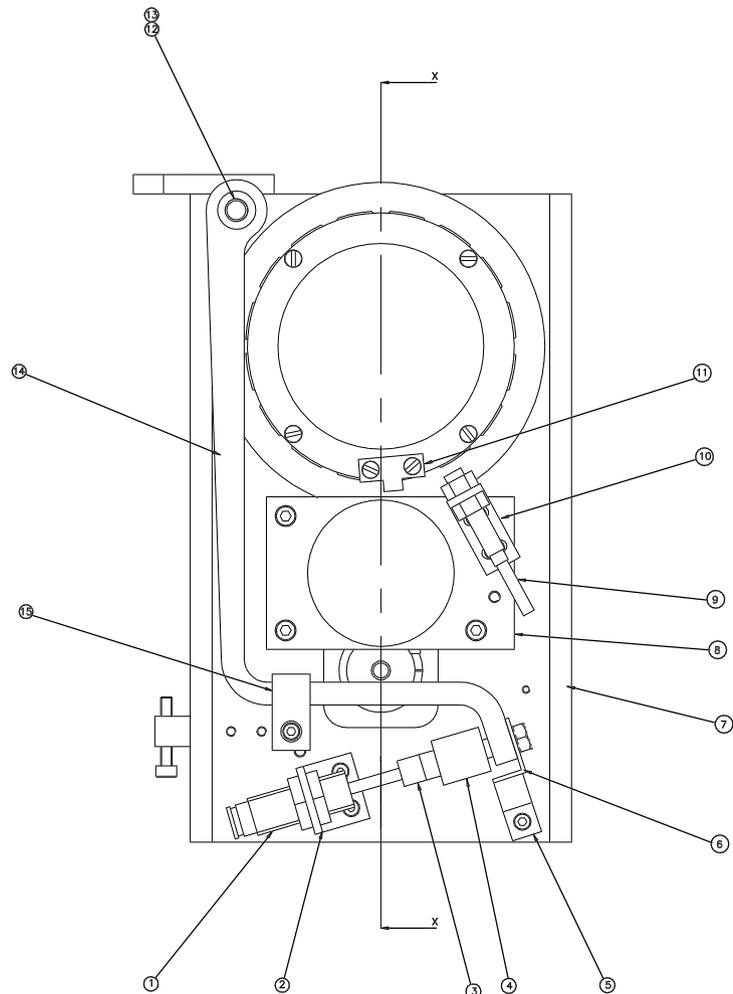
			TOLERANCES (UNLESS OTHERWISE STATED)	MATERIAL	THIRD ANGLE PROJECTION	DIMS IN mm	ORIGINAL SCALE 1:1	ORIGINAL SHEET SIZE A3	G.A. NO.	BI/061
1	30/01/96	PDJ	X ± 0.5	BRASS		ROYAL GREENWICH OBSERVATORY		TITLE		
2	30/01/96	PDJ	X.X ± 0.1	FINISH	No. REQ'D	MADINGLEY ROAD		WAVE PLATE BLANK		
			X.XX ± 0.05	CLEAN	1	CAMBRIDGE CB3 0EZ		ISIS POLARISATION TEST RIG		
ISSUE	DATE	DRAWN	ANG. ±			DRG NO.	BI/059	SHT.	1	LOC'N BI

DRAWING NUMBER	No of Sheets	GA. Item No	DRAWING TITLE OR COMPONENT NAME	Job No	MATERIAL STOCK OR ORDER No AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE
/ /		38							
/ /		38							
/ /		40	STEPPING MOTOR	2	SLO-SYN M081				
/ /		41	BEARING - DEEP GROOVE BALL	2	SKF GPCA208 OR KAYDON KA025CPO				
/ /		42	JOURNAL ASSEMBLY	4 EACH	HEPCO MJ/107/E & MJ/187/C				
/ /		43	PROXIMITY SWITCH	2	HONEYWELL 92Z FS0.8-A4N-G				
/ /		44	SPRING PLUNGER	4	WIXROYD DMD HWN 2061				
/ /		45	PROXIMITY SWITCH	4	HETTICH SO05 A/R				
/ /		46	1/4 WAVE RETARDER PLATE	1	SEE OPTICAL SPEC. & W/GA/030				
/ /		47	1/2 WAVE RETARDER PLATE	1	SEE OPTICAL SPEC. & W/GA/031				
/ /		48	PNEUMATIC CYLINDER - D/A TYPE U	2	KUHNKE 37,280,100				

JOB TITLE 4.2m ISIS - POLARISATION ASSEMBLY ASSY DRG No V/GL/000 SHEET No 2 OF 2 DRAWN BY AJW DATE MAY 88  
 ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM, SUSSEX

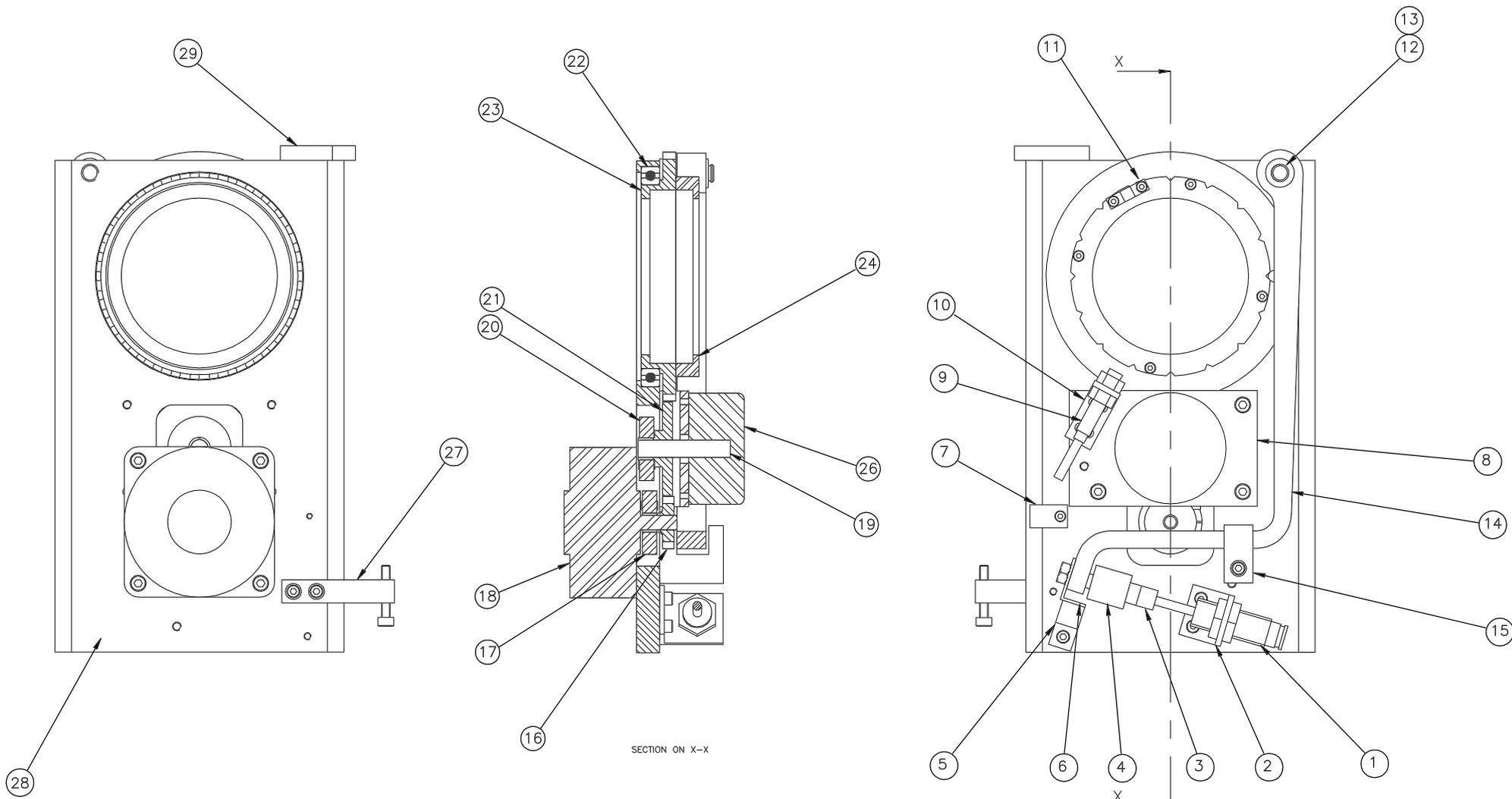
NOTE / THERE ARE NO HARD COPIES OF THESE DRGS. FILES HELD ON CAD DISKS.

DRAWING NUMBER	No of Sheets	GA. Item No	DRAWING TITLE OR COMPONENT NAME	No of	MATERIAL STOCK OR ORDER No AND DATE	REMARKS	ISSUE DATE	ISSUED TO	FINISH DATE
V/ GL / 000	1		ASSEMBLY						
V/ GL / 001	1	1	MOUNTING PLATE	1	AL. ALLOY				
W/ GL / 002	1	2	1/4 WAVE RETARDER PLATE SLIDE	1	SEE D.O.				
W/ GL / 003	1	3	1/2 WAVE RETARDER PLATE SLIDE	1					
W/ GL / 004	1	4	MOTOR PLATE	1	AL. ALLOY				
/ / 005	1	5	STOP BRACKET	2	AL. ALLOY				
/ / 006	1	6	DETENT BLOCK - 1/4 WAVE	1	AL. ALLOY				
W/ GL / 007	1	7	SWITCH FLAG - 1/4 WAVE	1	BRASS				
/ / 008	1	8	BRACKET - CYLINDER SUPPORT	1	AL. ALLOY				
/ / 009	1	9	CYLINDER SUPPORT	1	AL. ALLOY				
/ / 010	1	10	TRUNNION - CYLINDER SUPPORT	1	AL. ALLOY				
W/ GL / 011	1	11	GEAR - RETARDER PLATE HSG.	2	HPC HELICAL GEAR - PSHI-68 BRASS				
/ / 012	1	12	GEAR - DRIVER	2	HPC HELICAL GEAR - PSHI-85 BRASS				
W/ GL / 013	1	13	RETAINER - RETARDER PLATE	2	BRASS				
/ / 014	1	14	STOP COLLAR	2	AL. ALLOY				
W/ GL / 015	1	15	SIDE BRACKET - 1/4 WAVE	1	AL. ALLOY				
/ / 016	1	16	SIDE BRACKET - 1/4 WAVE	1	AL. ALLOY				
W/ GL / 017	1	17	SIDE BRACKET - 1/2 WAVE	1	AL. ALLOY				
/ / 018	1	18	SIDE BRACKET - 1/2 WAVE	1	AL. ALLOY				
W/ GL / 019	1	19	TRUNNION - CYLINDER SUPPORT	1	AL. ALLOY				
/ / 020	1	20	CYLINDER SUPPORT	1	AL. ALLOY				
/ / 021	1	21	BRACKET - PUSH/PULL	1	AL. ALLOY				
/ / 022	1	22	DETENT BLOCK - 1/2 WAVE	1	AL. ALLOY				
/ / 023	1	23	SWITCH FLAG - 1/2 WAVE	1	BRASS				
W/ GL / 024	1	24	MOTOR GASKET	2	2mm THK. BLK. NEOPRENE				
/ / 025	1	25	BEARING STUD	1	STL. STL.				
/ / 026	1	26	SPACER - BEARING	1	STL. STL.				
/ / 027	1	27	TARGET	2	MILD STEEL				
/ / 028	1	28	BRACKET PROXIMITY SWITCH	2	AL. ALLOY				
W/ GL / 029	1	29	MANIFOLD - SOLENOIDS	2	BRASS				
/ / 030	1	30	LEMO BRACKET	1	AL. ALLOY				
/ / 031	1	31	BRACKET-1/4 WAVE HONEYWELL SW	1	AL. ALLOY				
W/ GL / 032	1	32	SWITCH FLAG - 1/4 WAVE	1	MILD STEEL				
/ / 033	1	33	BRACKET-1/2 WAVE HONEYWELL SW	1	AL. ALLOY				
/ / 034	1	34	SWITCH FLAG - 1/2 WAVE	1	MILD STEEL				
W/ GL / 035	1	35	MOUNTING PLATE - PROX. SW.	1	AL. ALLOY				
/ /		36							
/ /		37							
JOB TITLE 4 x 2m ISIS - POLARISATION ASSEMBLY						ASSY DRG No V/GL/000	SHEET No 1 OF 2	DRAWN BY AJW DATE MAY 88	
ROYAL GREENWICH OBSERVATORY, HERSTMONCEUX CASTLE, HAILSHAM, SUSSEX									



NOTE:  
DURING ASSEMBLY, ENSURE NO BACKLASH EXISTS BETWEEN  
ENCODER AND WAVEPLATE GEARS. ALLOW BACKLASH AT THE  
DRIVE GEAR ONLY.

				TOLERANCES (UNLESS OTHERWISE STATED) X     ± XX   ± XXX   ± ANG.   ±				<del>MATERIAL</del> <del>FINISH</del>		THIRD ANGLE PROJECTION 	DIMS IN mm ORIGINAL SCALE 2:1	ROYAL GREENWICH OBSERVATORY MADINGLEY ROAD CAMBRIDGE CB3 0EZ	TITLE HWP ASSEMBLY ISIS POLARISATION UPGRADE	ORIGINAL SHEET SIZE A0	G.A. NO. BI/001 DRG. NO.	LOC'N. BI SHT. NO. 1
ISSUE	MOD NO.	DATE	DRAWN BY	ISSUE	MOD NO.	DATE	DRAWN BY									
				1		09/10/95	PDJ									



NOTE:  
DURING ASSEMBLY, ENSURE NO BACKLASH EXISTS BETWEEN  
ENCODER AND WAVEPLATE GEARS. ALLOW BACKLASH AT THE  
DRIVE GEAR ONLY.

ISSUE	MOD NO.	DATE	DRAWN BY	ISSUE	MOD NO.	DATE	DRAWN BY
				1		09/10/95	PDJ

TOLERANCES (UNLESS OTHERWISE STATED)  
X ±  
XX ±  
XXX ±  
ANG. ±

~~MATERIAL~~  
~~FINISH~~

THIRD ANGLE PROJECTION  
NO. REO'D PER ASS'Y

DIMS IN mm ORIGINAL SCALE 2:1  
ROYAL GREENWICH OBSERVATORY  
MADINGLEY ROAD  
CAMBRIDGE CB3 0EZ

TITLE

ORIGINAL SHEET SIZE A0  
QWP ASSEMBLY  
ISIS POLARISATION UPGRADE

G.A. NO.	BI/001	LOC'N.	BI
DRG. NO.		SHT. NO.	1