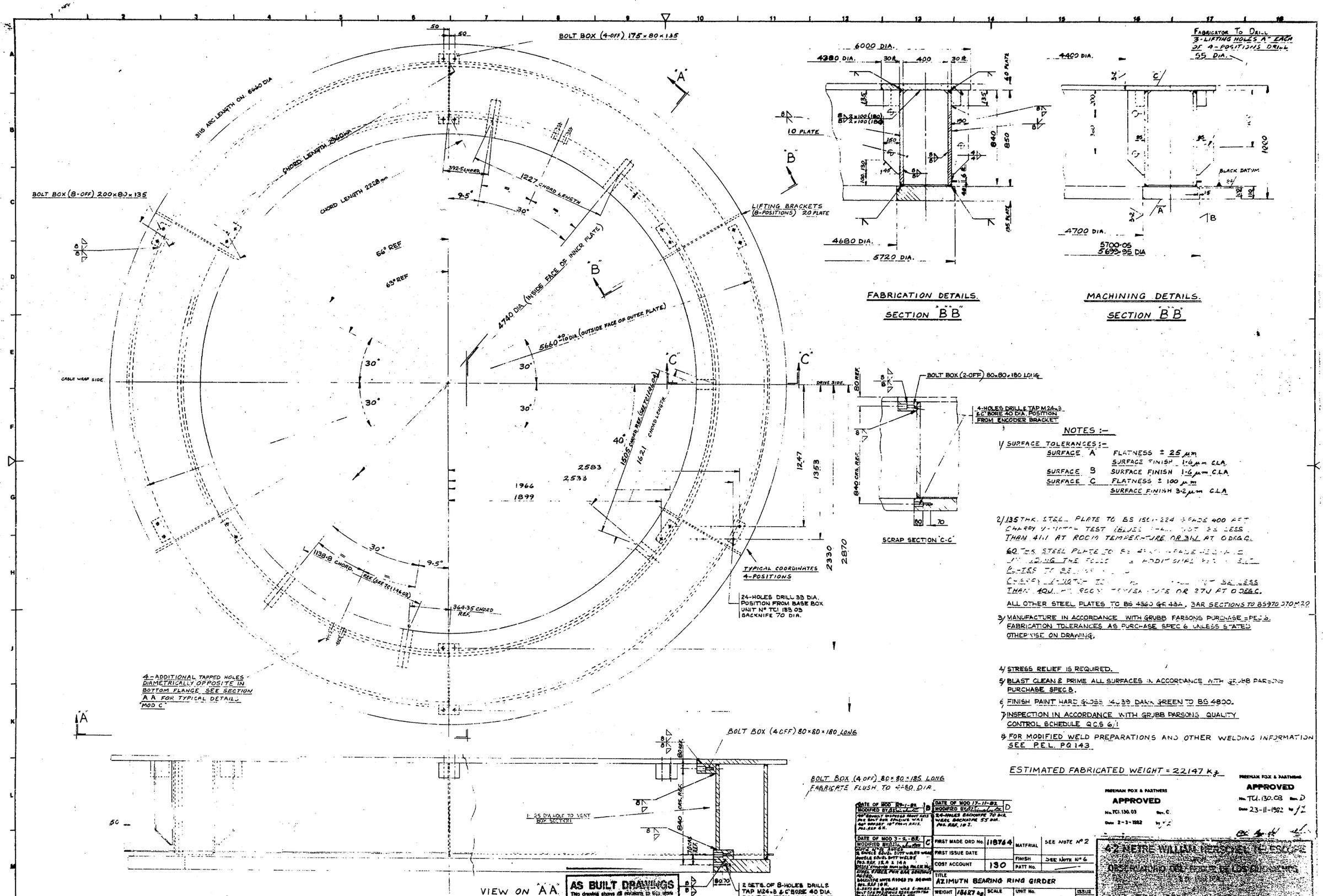

NOTES :-

1/ SURFACE TOLERANCES :-

SURFACE A	FLATNESS ± 25 μm	
	SURFACE FINISH 1·6 μm C.L.A.	
SURFACE B	SURFACE FINISH 1·6 μm C.L.A.	
SURFACE C	FLATNESS ± 100 μm	
	SURFACE FINISH 3·2 μm C.L.A.	

2/ 135 THK. STEEL PLATE TO BS 1501-224 GRADE 400 A/T CHARPY V-NOTCH TEST VALUES SHALL NOT BE LESS THAN 41J AT ROOM TEMPERATURE OR 31J AT 0 DEG C.
60 THK STEEL PLATE TO BS [illegible] GRADE [illegible] A/T CHARPY V-NOTCH TEST VALUES SHALL NOT BE LESS THAN 40J AT ROOM TEMPERATURE OR 27J AT 0 DEG C.
ALL OTHER STEEL PLATES TO BS 4360 GR 43A, BAR SECTIONS TO BS970 070M20

3/ MANUFACTURE IN ACCORDANCE WITH GRUBB PARSONS PURCHASE SPEC 6. FABRICATION TOLERANCES AS PURCHASE SPEC 6 UNLESS STATED OTHERWISE ON DRAWING.

4/ STRESS RELIEF IS REQUIRED.

5/ BLAST CLEAN & PRIME ALL SURFACES IN ACCORDANCE WITH GRUBB PARSONS PURCHASE SPEC 8.

6/ FINISH PAINT HARD GLOSS 14C39 DARK GREEN TO BS 4800.

7/ INSPECTION IN ACCORDANCE WITH GRUBB PARSONS QUALITY CONTROL SCHEDULE Q.C.S 6/1

8/ FOR MODIFIED WELD PREPARATIONS AND OTHER WELDING INFORMATION SEE P.E.L. PQ 143

ESTIMATED FABRICATED WEIGHT = 22147 kg

DATE OF MOD 29-1-82 MODIFIED BY	B
108 EQUALLY DISPOSED SHOT PITS PER BOLT BOX SPACING WAS 84° NOW SET 18° FROM AXIS. POS. REF 6 A.	
DATE OF MOD 3-2-82 MODIFIED BY	C
NOTE 16 ADDED 8 SINGLE EQUAL BUTT WELDS WERE DOUBLE EQUAL BUTT WELDS POS. REF. 12 A & 16 A.	
DATE OF MOD 17-11-82 MODIFIED BY	D
24-HOLES BACKNIFE TO DIA. WERE BACKNIFE 55 DIA. POS. REF. 10 J.	

FIRST MADE ORD No.	118764	MATERIAL	SEE NOTE Nº 2
FIRST ISSUE DATE		FINISH	SEE NOTE Nº 6
COST ACCOUNT	130	PATT No.	—

TITLE AZIMUTH BEARING RING GIRDER

WEIGHT	SCALE	UNIT No.	ISSUE
18487 kg	1:10	TCI 130 03	D

No. OFF PER SET 1

FREEMAN FOX & PARTNERS
APPROVED
No. TCI. 130.03 Rev. C.
Date 2-3-1982 by

FREEMAN FOX & PARTNERS
APPROVED
No. TCI. 130.03 Rev. D
Date 23-11-1982 by

42 METRE WILLIAM HERSCHEL TELESCOPE
OBSERVATORY SITE, LOS DOS MUCHACHOS
LA PALMA
ROYAL GREENWICH OBSERVATORY

GRUBB PARSONS NEWCASTLE UPON TYNE NE8 3YB

TITLE AZIMUTH BEARING RING GIRDER

DATE 6-1-82

DRAWING NUMBER TCI 130.03

A merger of Clarke Chapman and Reyrolle Parsons

SURFACE FINISH EQUIVALENTS

MICRONS CLA	1	8	16	32	63	125	250	500
μ INCHES CLA	1	2	4	8	16	32	63	125

THIS DRAWING CONFORMS TO B.S. 308

SURFACE FINISH SYMBOLS
✓ DENOTES NOT NECESSARILY MACHINED
✓ DENOTES MACHINED

WELD SYMBOLS TO BS 499 PART 2 1980

FABRICATION TOLERANCES
DIMENSIONS UP TO 254 ± 2·0
DIMENSIONS FROM 254 TO 2600 ± 3·0
ANGLES ∠ 600
STRAIGHTNESS/FLATNESS 1:500

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ALL DIMENSIONS ARE IN MILLIMETRES
ANGLES ±
SCREW THREADS TO B.S. 3643 PART 2 MEDIUM FIT
MACHINED DIA CONCENTRIC TO 0·1 T.I.R.

PROJECTION 3rd ANGLE
DRAWN
DATE 6-1-82