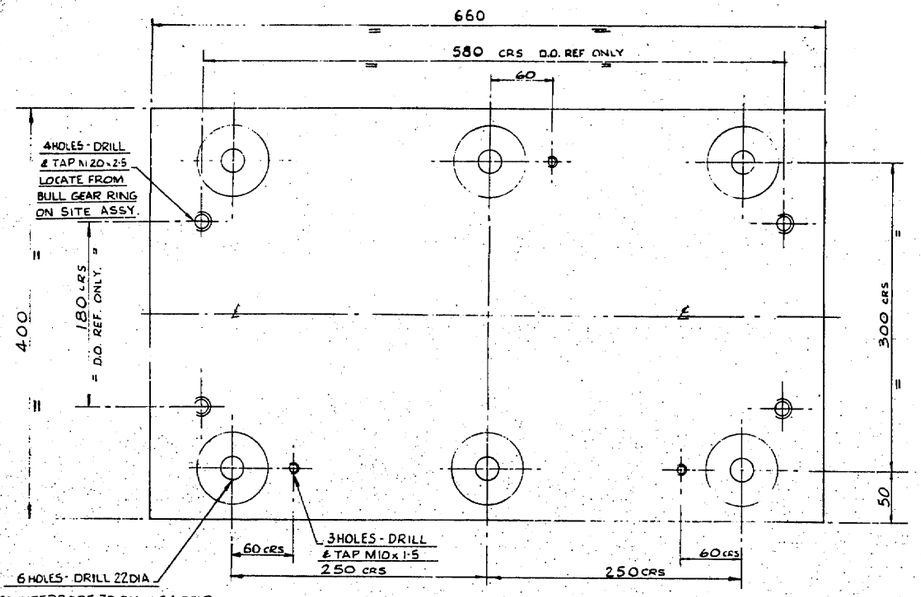
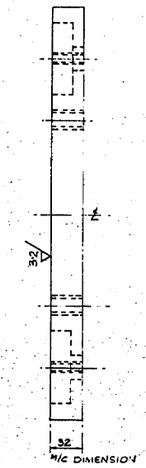
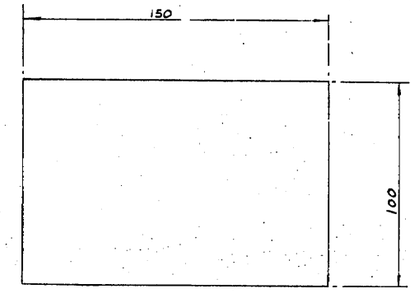
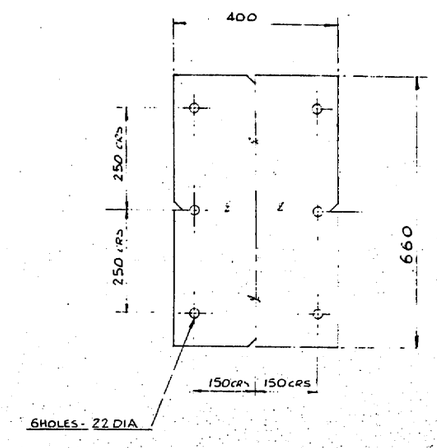
101







UNIT Nº	MATERIAL	THICKNESS	Nº OFF
TCI 144 04	20' CARBON ST.	0"·375	4
TCI 144 05	BRASS	0"·001	8
TCI 144 06	BRASS	0"·003	8
TCI 144 07	BRASS	0"·005	8
TCI 144 08	BRASS	0"·006	16
TCI 144 09	BRASS	0"·010	16
TCI 144 10	BRASS	0"·018	16
TCI 144 11	BRASS	0"·025	16



FREEMAN FOX & PARTNERS
APPROVED
No. TCI 144.04 TO 11 Iss. A
Date 26-5-1982 by J.L.

FREEMAN FOX & PARTNERS
APPROVED
No. TCI 144.12 Iss. A
Date 25-5-1982 by J.L.

FREEMAN FOX & PARTNERS
APPROVED
No. TCI.144.03 Iss. A
Date 25-5-1982 by J.L.

DATE OF MOD / MODIFIED BY	DATE OF MOD / MODIFIED BY
DATE OF MOD / MODIFIED BY	DATE OF MOD / MODIFIED BY
FIRST MADE ORD No. 118764	MATERIAL 25mm THICK M.S. PLATE
FIRST ISSUE DATE	FINISH 26-5-82
COST ACCOUNT 144	PATT No.
TITLE AZIMUTH GEAR HUB BASEPLATE	
WEIGHT / No. OFF PER SET 4	SCALE 1:2 / UNIT No. TCI 144 03 / ISSUE A

DATE OF MOD / MODIFIED BY	DATE OF MOD / MODIFIED BY
DATE OF MOD / MODIFIED BY	DATE OF MOD / MODIFIED BY
FIRST MADE ORD No. 118764	MATERIAL SEE ABOVE
FIRST ISSUE DATE 26-5-82	FINISH
COST ACCOUNT 144	PATT No.
TITLE SHIMS	
WEIGHT / No. OFF PER SET	SCALE 1:1 / UNIT No. TCI 144 04-11 / ISSUE A

DATE OF MOD / MODIFIED BY	DATE OF MOD / MODIFIED BY
DATE OF MOD / MODIFIED BY	DATE OF MOD / MODIFIED BY
FIRST MADE ORD No. 118764	MATERIAL 1/2" THK. M.S. SHEET.
FIRST ISSUE DATE 26-5-82	FINISH
COST ACCOUNT 144	PATT No.
TITLE TEMPLATE FOR AZIMUTH GEAR HUB BASEPLATE	
WEIGHT / No. OFF PER SET 1	SCALE 1:5 / UNIT No. TCI 144 12 / ISSUE A

AS BUILT DRAWINGS
This drawing shows all revisions to this work
CPS

4·2 METRE MILLIMETRE TELESCOPE

NEI
A merger of Clarke Chapman and Reyrolle Parsons

SURFACE FINISH EQUIVALENTS							
MICROINCHES	4	8	16	32	63	125	250	500
MICROMETRES	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 1969

FABRICATION TOLERANCES
DIMENSIONS UP TO 250 ± 2·0
DIMENSIONS FROM 250 TO 2500 ± 3·0
ANGLES ± 1 : 600
STRAIGHTNESS/FLATNESS 1 : 600

THIS DRAWING IS THE PROPERTY OF NEI PARSONS LTD. AND MUST NOT BE COPIED OR DISCLOSED TO A THIRD PARTY WITHOUT GRUBB PARSONS WRITTEN CONSENT.

GENERAL MACHINING TOLERANCES (EXCEPT WHERE STATED OTHERWISE)
UNSPECIFIED DIMENSIONS ± ·1
DIMENSIONS WITH - OVER ± ·
AND DECIMAL SIGN
DIMENSIONS WITH - OVER ± 0·1
AND DECIMAL SIGN.

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
CHECKED
APPROVED 13-5-82
DRAWN N. MANN
DATE 26-4-82

GRUBB PARSONS NEWCASTLE UPON TYNE NE6 2YB

TITLE 4·2M TELESCOPE
DETAILS FOR ASSY. OF AZ. MAIN BULL GEAR

SCALE —
SHEET OF
DRAWING NUMBER TCI 144 03-12