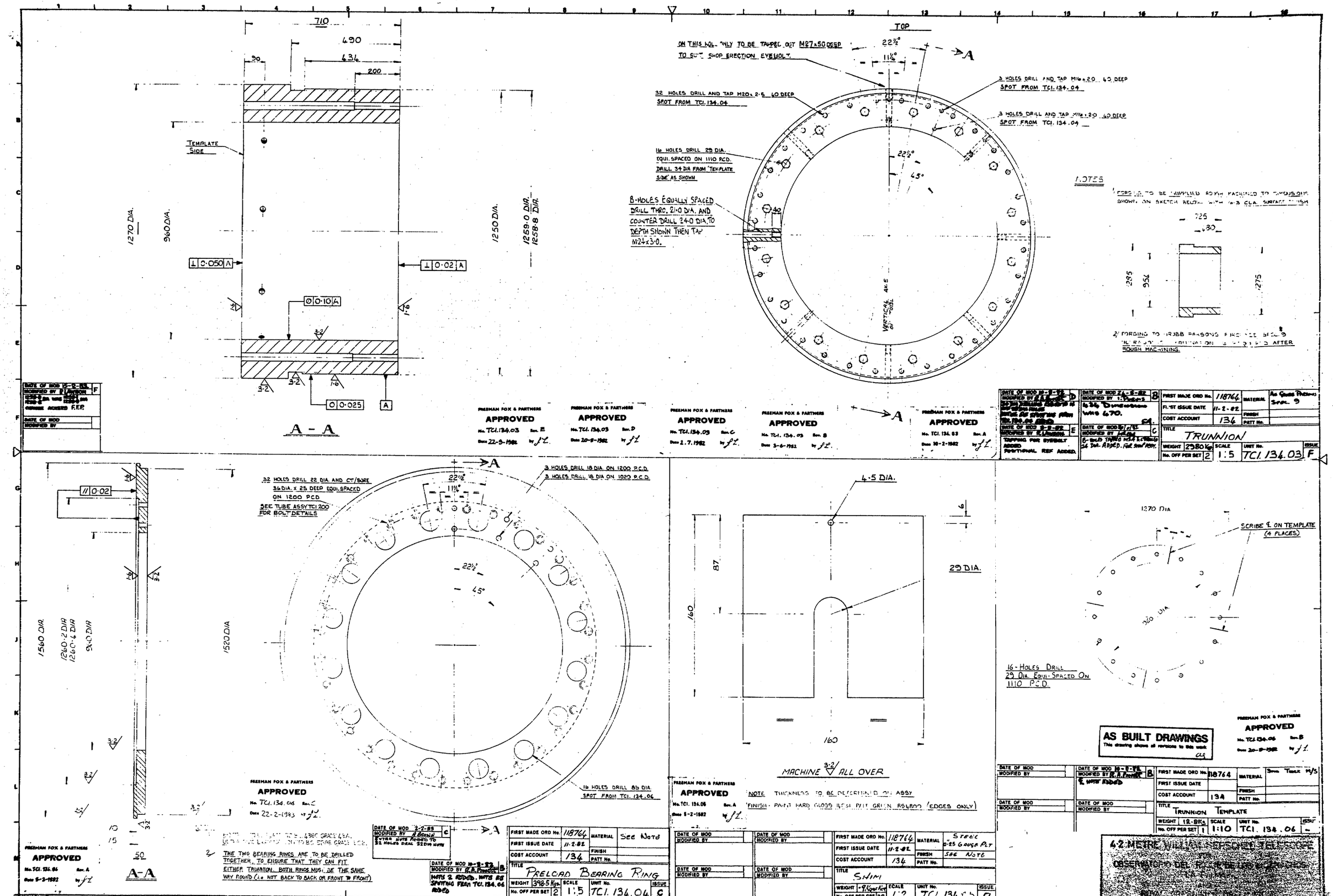
710
490
90
434
200
TEMPLATE SIDE
1270 DIA.
960 DIA.
1250 DIA.
1259·0 DIA.
1258·8 DIA.
⊥ 0·050 A
⊥ 0·02 A
⊙ 0·10 A
0 0·025 A
A - A
TOP
ON THIS HOL. ONLY TO BE TAPPED OUT M27×50 DEEP TO SUIT SHOP ERECTION EYEBOLT.
22½°
11¼°
32 HOLES DRILL AND TAP M20×2·5 40 DEEP SPOT FROM TCI. 134.04
3 HOLES DRILL AND TAP M16×2·0 40 DEEP SPOT FROM TCI. 134.04
3 HOLES DRILL AND TAP M16×2·0 40 DEEP SPOT FROM TCI. 134.04
16 HOLES DRILL 29 DIA. EQUI. SPACED ON 1110 P.C.D. DRILL 34 DIA FROM 'TEMPLATE SIDE' AS SHOWN
8-HOLES EQUALLY SPACED DRILL THRO. 21·0 DIA. AND COUNTER DRILL 24·0 DIA. TO DEPTH SHOWN THEN TAP M24×3·0.
45°
40
VERTICAL 4×5 DIA.
NOTES
1/ FORGING TO BE SUPPLIED ROUGH MACHINED TO DIMENSIONS SHOWN ON SKETCH BELOW WITH 6·3 CLA. SURFACE FINISH
725
30
285
954
275
2/ FORGING TO GRUBB PARSONS PROCESS SPEC. 9 TO BE HEAT TREATED AFTER ROUGH MACHINING.
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.03 Rev. E Date 22-9-1982
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.03 Rev. D Date 20-8-1982
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.03 Rev. C Date 2.7.1982
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.03 Rev. B Date 3-6-1982
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.03 Rev. A Date 10-2-1982
FIRST MADE ORD No. 118764
FIRST ISSUE DATE 11-2-82
COST ACCOUNT 134
TITLE TRUNNION
WEIGHT 2380 Kg
SCALE 1:5
UNIT No. TCI. 134.03
ISSUE F
No. OFF PER SET 2
A - A
32 HOLES DRILL 22 DIA. AND C'ST/BORE 34 DIA. × 25 DEEP EQUI. SPACED ON 1200 P.C.D.
SEE TUBE ASSY TCI 200 FOR BOLT DETAILS
3 HOLES DRILL 18 DIA. ON 1200 P.C.D.
3 HOLES DRILL 18 DIA. ON 1020 P.C.D.
22½°
11¼°
45°
1560 DIA.
1260·2 DIA
1260·4 DIA
960 DIA
1520 DIA
16 HOLES DRILL 85 DIA. SPOT FROM TCI. 134.04
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.04 Rev. C Date 22-2-1983
FIRST MADE ORD No. 118764
FIRST ISSUE DATE 11-2-82
COST ACCOUNT 134
TITLE PRELOAD BEARING RING
WEIGHT 398·5 Kgs
SCALE 1:5
UNIT No. TCI. 134.04
ISSUE C
No. OFF PER SET 2
4·5 DIA.
87
160
29 DIA.
MACHINE ∇ ALL OVER
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.06 Rev. A Date 5-2-1982
NOTE THICKNESS TO BE DETERMINED ON ASSY.
FINISH - PAINT HARD GLOSS ICI SIL PVF GREEN BS4800 (EDGES ONLY)
FIRST MADE ORD No. 118764
FIRST ISSUE DATE 11-2-82
COST ACCOUNT 134
TITLE SHIM
WEIGHT 9½ Kgs
SCALE 1:2
UNIT No. TCI. 134.05
ISSUE A
No. OFF PER SET 32
1270 DIA
SCRIBE ℄ ON TEMPLATE (4 PLACES)
960 DIA
16 - HOLES DRILL 29 DIA. EQUI-SPACED ON 1110 P.C.D.
AS BUILT DRAWINGS
This drawing shows all revisions to this week
FREEMAN FOX & PARTNERS APPROVED No. TCI. 134.06 Rev. B Date 20-9-1982
FIRST MADE ORD No. 118764
FIRST ISSUE DATE
COST ACCOUNT 134
TITLE TRUNNION TEMPLATE
WEIGHT 12·8 Kg
SCALE 1:10
UNIT No. TCI. 134.06
No. OFF PER SET 1
4·2 METRE WILLIAM HERSCHEL TELESCOPE
OBSERVATORIO DEL ROQUE DE LOS MUCHACHOS
LA PALMA
MAIN TRUSS ASSEMBLY
A merger of Clarke Chapman and Reyrolle Parsons
SURFACE FINISH EQUIVALENTS
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 250
DIMENSIONS FROM 250 TO 2500
ANGLES
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.
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
DRAWN I. FORNS
DATE 8-1-82
GRUBB PARSONS NEWCASTLE UPON TYNE NE6 2YB
TITLE TRUNNION DETAILS
TCI. 134