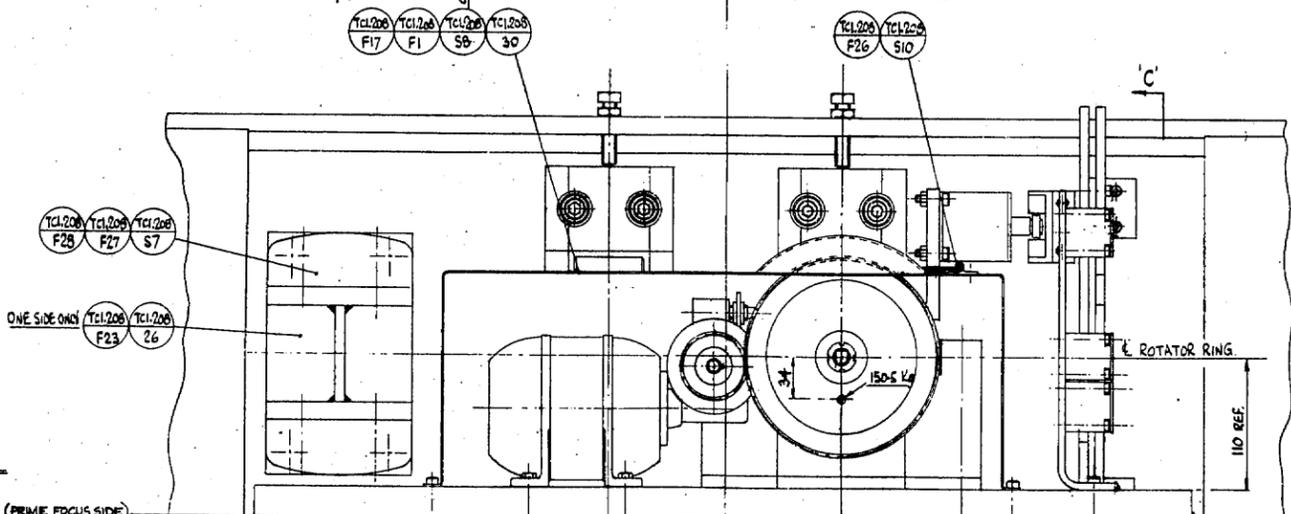
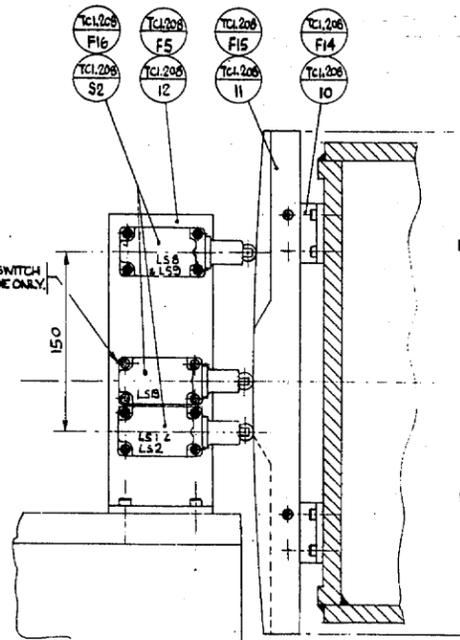


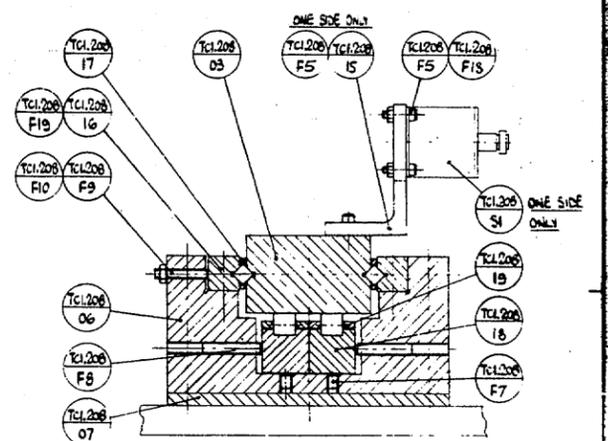
SECTION 'B-B'



SECTION 'A-A'



PART SECTION 'C-C'



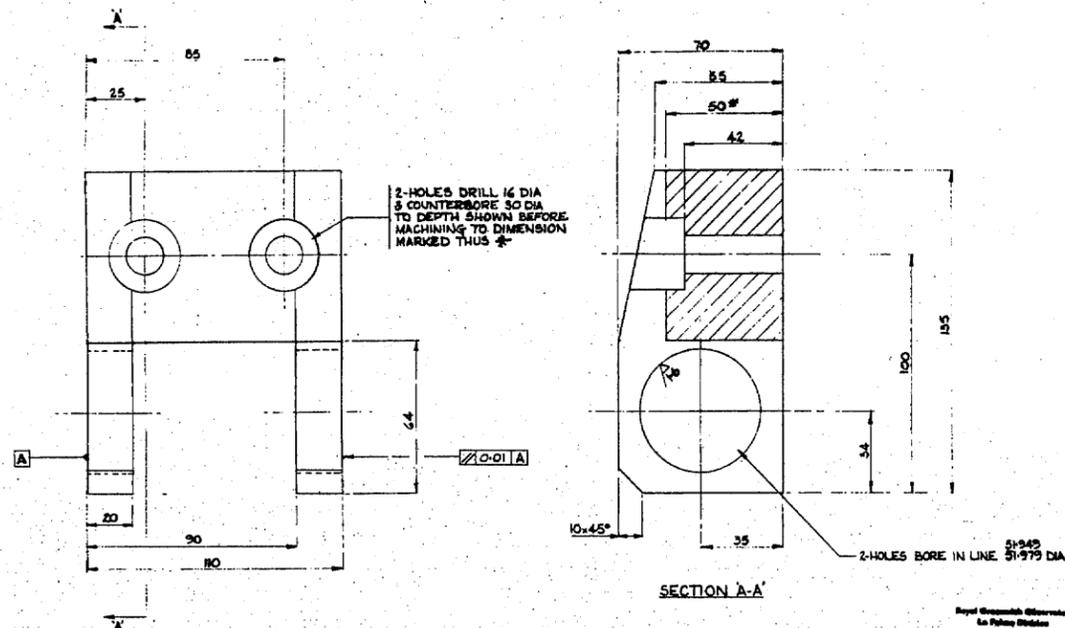
SECTION 'D-D'

LIMIT SWITCH FUNCTION

- LS 1 - PRIME FOCUS STOP
- LS 2 - SECONDARY STOP
- LS 3 - UNBALANCE DETECTOR (PRIME FOCUS SIDE)
- LS 4 - BOLT OUT (PRIME FOCUS SIDE)
- LS 5 - BOLT OUT (SECONDARY MIRROR SIDE)
- LS 6 - BOLT IN (PRIME FOCUS SIDE)
- LS 7 - BOLT IN (SECONDARY MIRROR SIDE)
- LS 8 - PRIME FOCUS PRE LIMIT (SLOW ROTATION)
- LS 9 - SECONDARY PRE LIMIT (SLOW ROTATION)
- LS 10 - BOLT MOVING (PRIME FOCUS SIDE)
- LS 11 - BOLT MOVING (SECONDARY MIRROR SIDE)
- LS 15 - PRIME FOCUS SET

AS BUILT DRAWINGS
The drawing shows all conditions in this work.

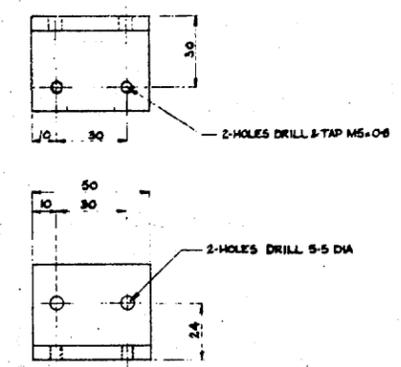
ASSEMBLY PROCEDURE NUMBER - TC1.208.API



NOTES
 1/ MACHINE ∇ ALL OVER EXCEPT WHERE STATED OTHERWISE
 2/ REMOVE ALL SHARP EDGES & CORNERS.

APPROVED
 TCI 208 13 A
 16-6-81

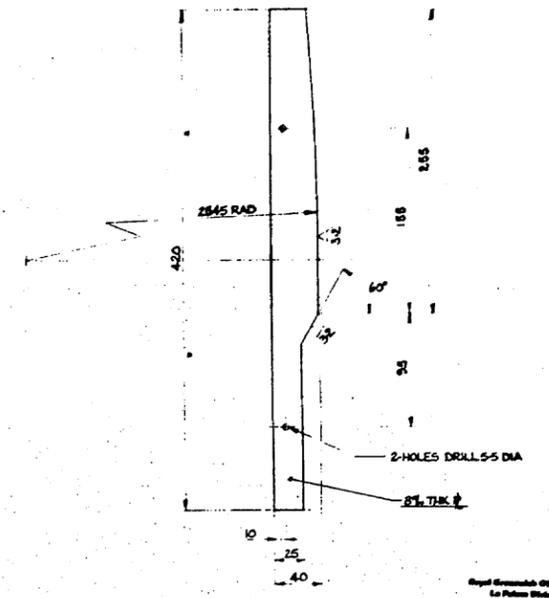
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| DATE OF MODIFIED BY |
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MAKE FROM 40x40.6THK ANGLE

APPROVED
 TCI 208 14 A
 16-6-81

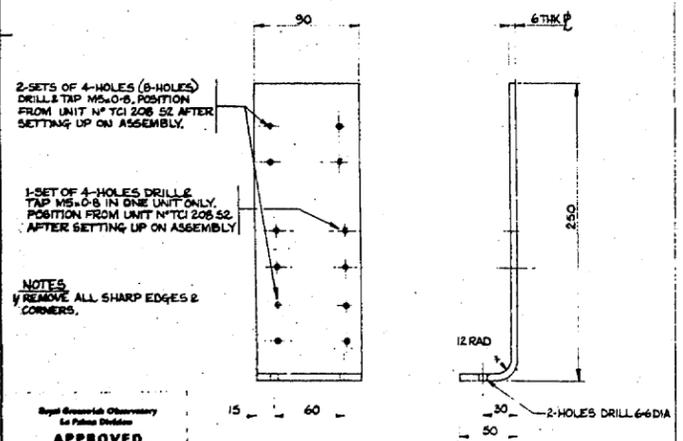
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REMOVE ALL SHARP EDGES & CORNERS

APPROVED
 TCI 208 15 A
 16-6-81

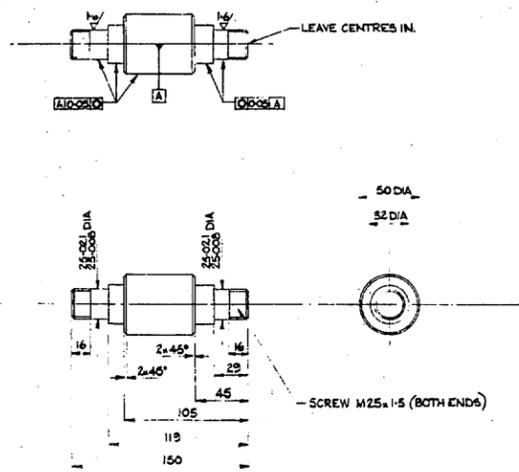
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NOTES
 1/ REMOVE ALL SHARP EDGES & CORNERS.

APPROVED
 TCI 208 12 A
 16-6-81

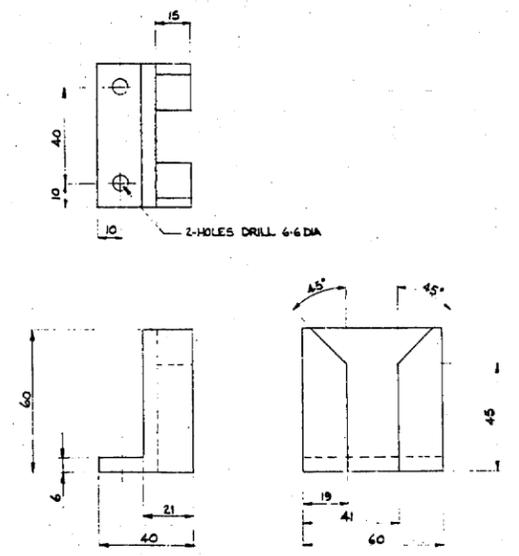
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| DATE OF MODIFIED BY |
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MACHINE ∇ ALL OVER EXCEPT WHERE SHOWN OTHERWISE

APPROVED
 TCI 208 13 A
 16-6-81

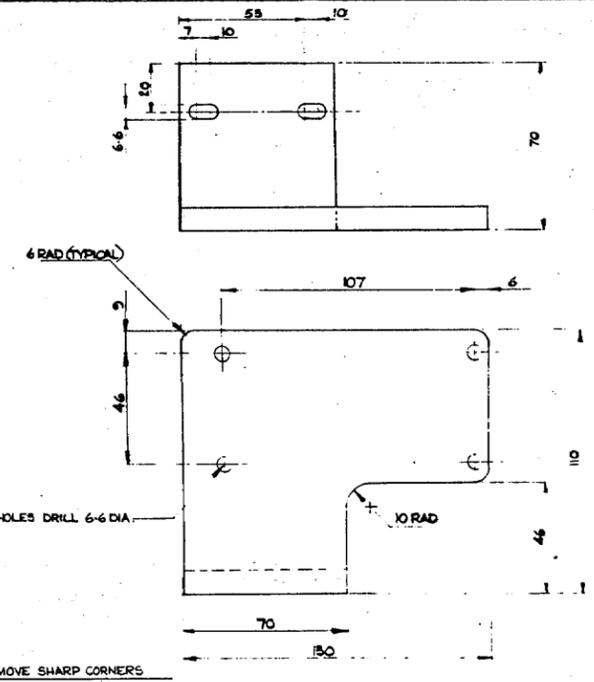
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| DATE OF MODIFIED BY |
| | | | |
| | | | |
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MACHINE ∇ ALL OVER

APPROVED
 TCI 208 14 A
 16-6-81

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| DATE OF MODIFIED BY |
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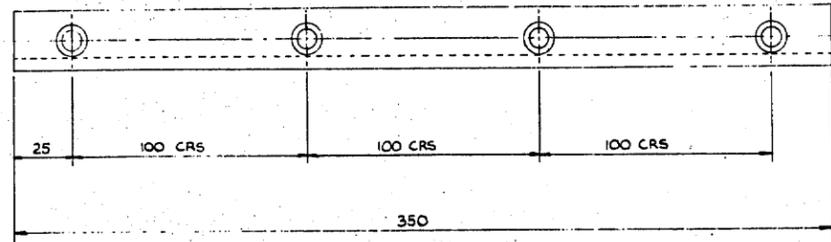
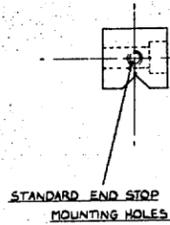


REMOVE SHARP CORNERS

AS BUILT DRAWINGS
 This drawing shows all changes to the work.

APPROVED
 TCI 208 15 A
 16-6-81

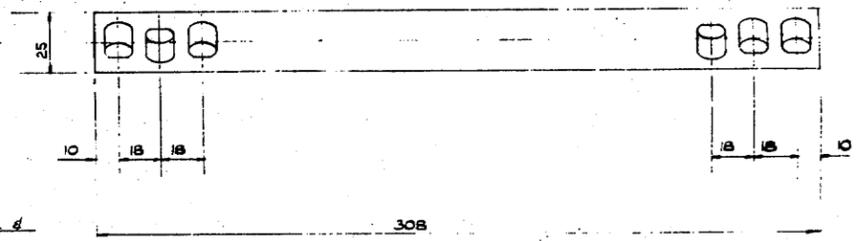
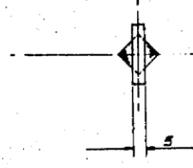
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|---------------------|---------------------|---------------------|---------------------|
| DATE OF MODIFIED BY |
| | | | |
| | | | |
| | | | |



STANDARD CROSS ROLLER TRACK (FOR 12 DIA ROLLERS) EXCEPT FOR SPECIAL LENGTH
 4 TRACKS (2 PAIR) REQD
 MATERIAL TOLERANCES SURFACE FINISH TO SUPPLIERS STANDARD PRACTICE

Royal Greenwich Observatory
 La Palma Division
APPROVED
 TCI 208 16 Rev. A
 Date 16-6-81 by J.P.

| | | | |
|---------------------------|-------------------------|---------------------------|---------------------|
| DATE OF MOD RECORDED BY | DATE OF MOD RECORDED BY | FIRST MADE ORD NO. 118660 | MATERIAL |
| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| TITLE CROSS ROLLER TRACK. | | | |
| WEIGHT | | SCALE 1:1 | UNIT No. TCI 208 16 |
| No. OFF PER SET | | | A |



ROLLER CAGE FOR VERTICAL & HORIZONTAL APPLICATION
 ROLLER GRAVITY CAPTIVE

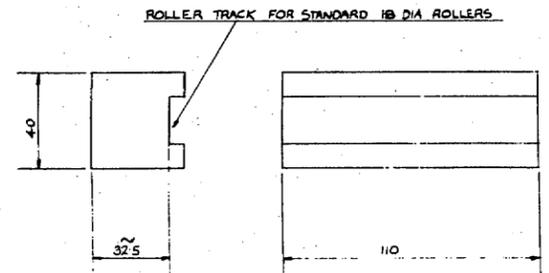
12mm DIA ROLLERS (6 ROLLERS PER CAGE 2 CAGES AS SHOWN & 2 OPPOSITE HAND)

MATERIALS TOLERANCES SURFACE FINISH TO SUPPLIERS STANDARD PRACTICE

Royal Greenwich Observatory
 La Palma Division
APPROVED
 TCI 208 17 Rev. A
 Date 16-6-81 by J.P.

FOR USE WITH UNITS TCI 208 03 & 16

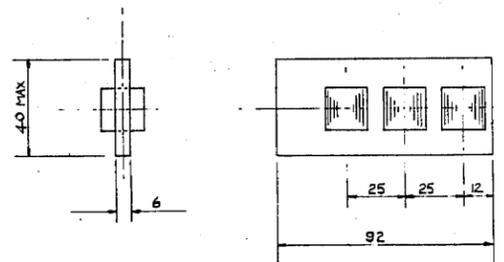
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| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| TITLE ROLLER CAGE. | | | |
| WEIGHT | | SCALE 1:1 | UNIT No. TCI 208 17 |
| No. OFF PER SET | | | A |



ROLLER TRACK FOR STANDARD 18 DIA ROLLERS
 LINEAR BEARING TRACK (4 OFF)
 MATERIALS TOLERANCES SURFACE FINISH TO SUPPLIERS STANDARD PRACTICE

Royal Greenwich Observatory
 La Palma Division
APPROVED
 TCI 208 18 Rev. A
 Date 16-6-81 by J.P.

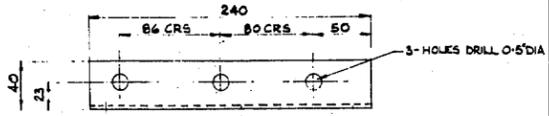
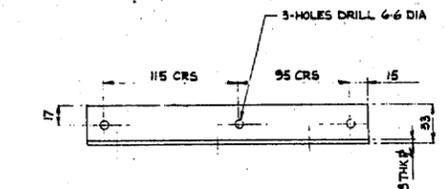
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| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| TITLE LINEAR BEARING TRACK. | | | |
| WEIGHT | | SCALE 1:1 | UNIT No. TCI 208 18 |
| No. OFF PER SET | | | A |



LINEAR BEARING CAGE 18 DIA ROLLERS
 (4 OFF CAGES)
 MATERIALS TOLERANCES SURFACE FINISH TO SUPPLIERS STANDARD PRACTICE

Royal Greenwich Observatory
 La Palma Division
APPROVED
 TCI 208 19 Rev. A
 Date 16-6-81 by J.P.

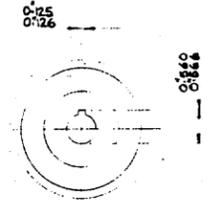
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| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| TITLE LINEAR BEARING CAGE | | | |
| WEIGHT | | SCALE 1:1 | UNIT No. TCI 208 19 |
| No. OFF PER SET | | | A |



REMOVE SHARP CORNERS

Royal Greenwich Observatory
 La Palma Division
APPROVED
 TCI 208 20 Rev. A
 Date 16-6-81 by J.P.

| | | | |
|-------------------------|-------------------------|---------------------------|---------------------|
| DATE OF MOD RECORDED BY | DATE OF MOD RECORDED BY | FIRST MADE ORD NO. 118660 | MATERIAL |
| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| TITLE SHAFT | | | |
| WEIGHT 0.85 kg | | SCALE 1:1 | UNIT No. TCI 208 20 |
| No. OFF PER SET 2 | | | A |

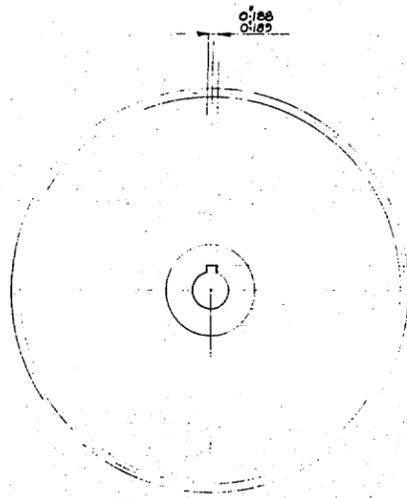


MODIFICATION TO MUFFET SPUR GEAR (STEEL)
 16 D.P., 55 TEETH-UNIT N° TCI 208 35

AS BUILT DRAWINGS
 This drawing shows all variations to the work

Royal Greenwich Observatory
 La Palma Division
APPROVED
 TCI 208 21 Rev. A
 Date 16-6-81 by J.P.

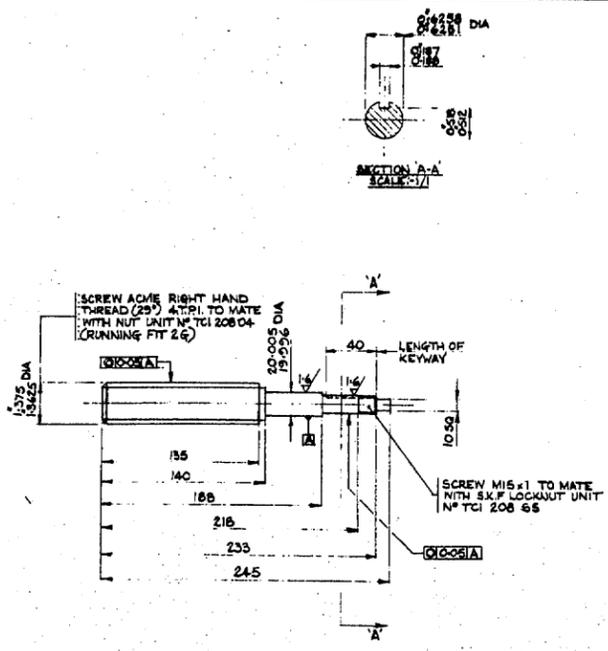
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| DATE OF MOD RECORDED BY | DATE OF MOD RECORDED BY | FIRST MADE ORD NO. 118660 | MATERIAL |
| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| TITLE MUFFET TO SPUR GEAR | | | |
| WEIGHT | | SCALE 1:1 | UNIT No. TCI 208 21 |
| No. OFF PER SET 2 | | | A |



MODIFICATION TO MUFFET SPUR GEAR (CAST IRON)
16 DP, 165 TEETH - UNIT N° TCI 208 94

APPROVED
16-6-81 by J.P.

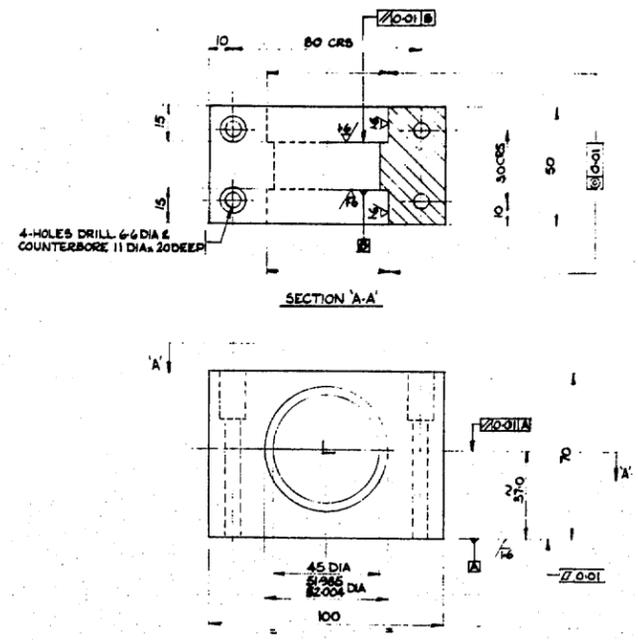
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| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | AS BUILT |
| | | 18660 | CAST IRON | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | Modification to Spur Gear | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 0.97 kg | 1/1 | Tci 208 22 |
| | | No. OFF PER SET | | |
| | | 2 | | |



MACHINE 32/ ALL OVER UNLESS OTHERWISE STATED

APPROVED
16-6-81 by J.P.

| | | | | |
|--------------------------|--------------------------|---------------------|----------|-------------|
| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | STEEL S20 B |
| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | Lock Screw | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 0.97 kg | 1/1 | Tci 208 23 |
| | | No. OFF PER SET | | |
| | | 2 | | |

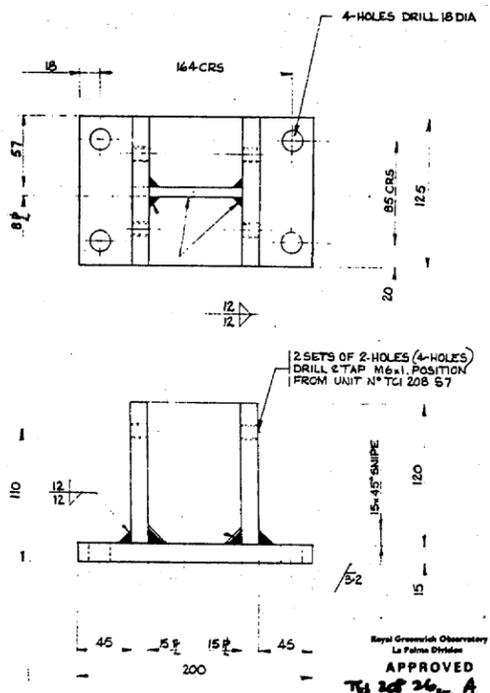


MACHINE 32/ ALL OVER UNLESS OTHERWISE STATED

APPROVED
16-6-81 by J.P.

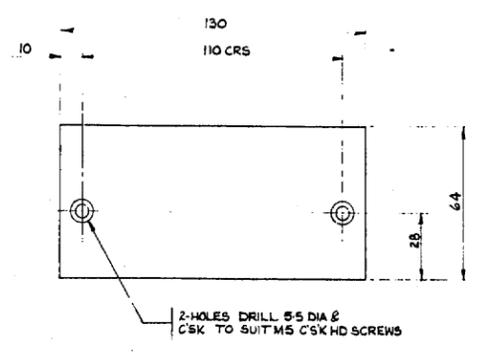
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| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | 2/ Casted Steel |
| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | 4-Hole Drill | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 2.20 kg | 1/1 | Tci 208 24 |
| | | No. OFF PER SET | | |
| | | 2 | | |

| | | | | |
|--------------------------|--------------------------|---------------------|----------|-----------------|
| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | 2/ Casted Steel |
| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | 4-Hole Drill | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 0.007 kg | 1/1 | Tci 208 25 |
| | | No. OFF PER SET | | |
| | | 2 | | |



APPROVED
16-6-81 by J.P.

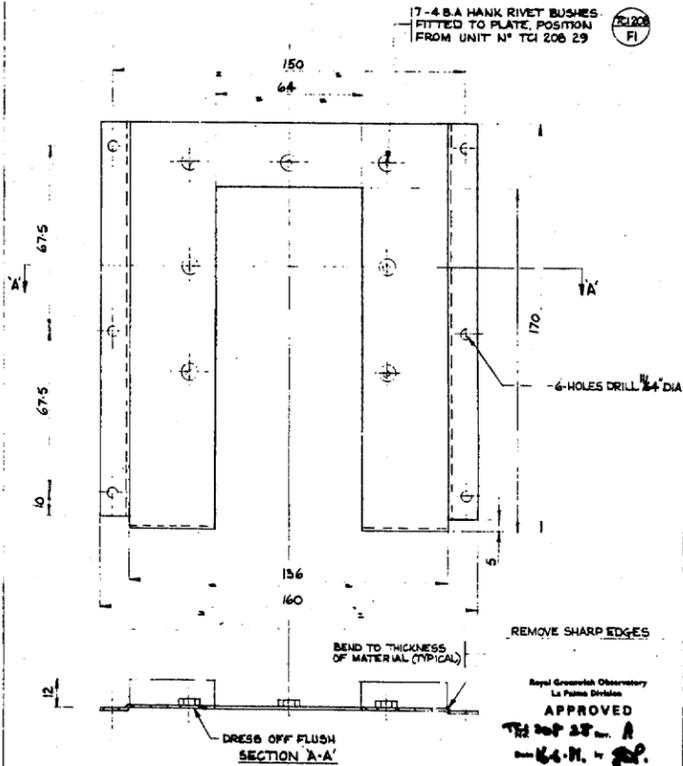
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| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | Bracket | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 7.1 kg | 1/1 | Tci 208 26 |
| | | No. OFF PER SET | | |
| | | 1 | | |



REMOVE SHARP CORNERS

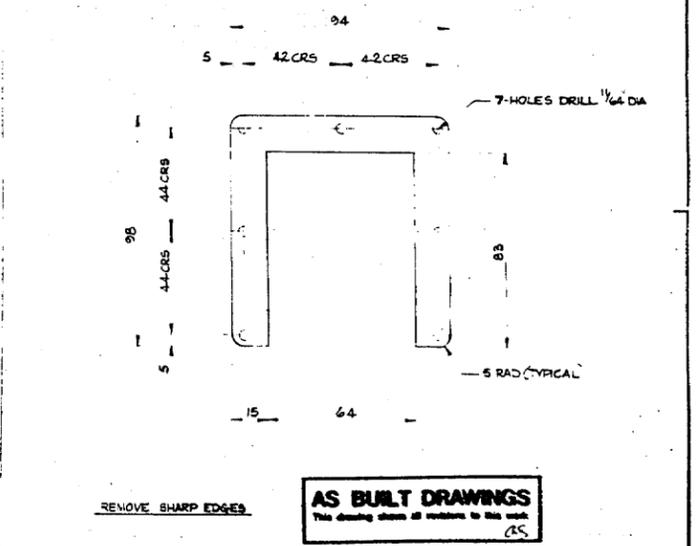
APPROVED
16-6-81 by J.P.

| | | | | |
|--------------------------|--------------------------|---------------------|----------|--------------------------|
| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | 1/2" THK STAINLESS PLATE |
| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | Linea Rinnale Sudo | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 0.41 kg | 1/1 | Tci 208 27 |
| | | No. OFF PER SET | | |
| | | 2 | | |



APPROVED
16-6-81 by J.P.

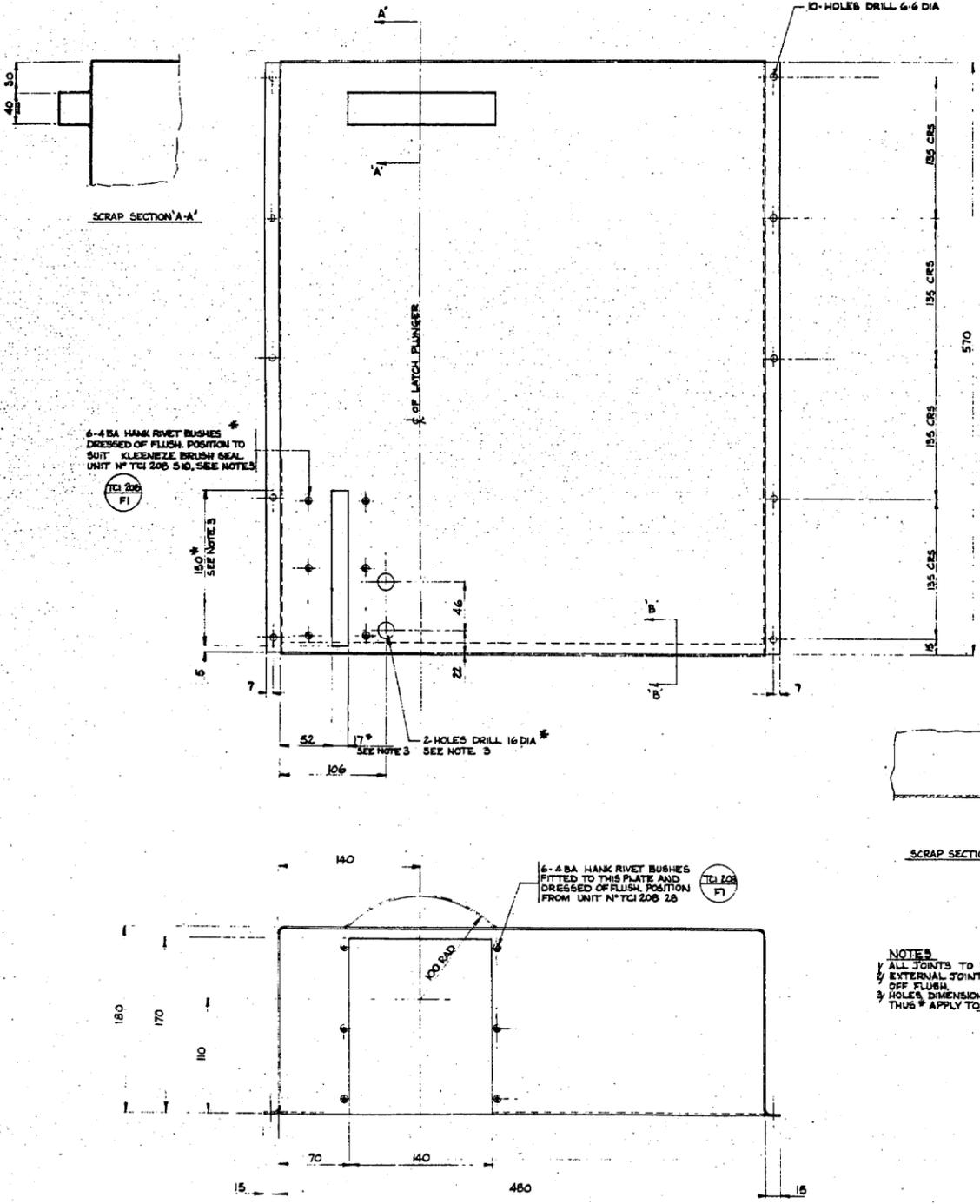
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| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | 1/2" S&W Mild Steel Sheet |
| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | Cover End Plate | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 0.88 kg | 1/1 | Tci 208 28 |
| | | No. OFF PER SET | | |
| | | 2 | | |



AS BUILT DRAWINGS
This drawing shows all variations to this work.

APPROVED
16-6-81 by J.P.

| | | | | |
|--------------------------|--------------------------|---------------------|----------|---------------------------|
| DATE OF MOD. APPROVED BY | DATE OF MOD. APPROVED BY | FIRST MADE ORD. No. | MATERIAL | 1/2" S&W Mild Steel Sheet |
| | | 18660 | | |
| | | FIRST ISSUE DATE | FRESH | |
| | | 17-6-81 | | |
| | | COST ACCOUNT | PART No. | |
| | | 208 | | |
| | | TITLE | | |
| | | Cast Plate | | |
| | | WEIGHT | SCALE | UNIT No. |
| | | 0.000 kg | 1/1 | Tci 208 29 |
| | | No. OFF PER SET | | |
| | | 2 | | |



6-4 BA HANK RIVET BUSHES DRESSED OF FLUSH POSITION TO SUIT KLEENETZLE BRUSH SEAL UNIT N° TCI 208 510, SEE NOTES.

100 DIA

150 SEE NOTES

6 OF LATCH PLUNGER

2 HOLES DRILL 16 DIA SEE NOTE 3

6-4 BA HANK RIVET BUSHES FITTED TO THIS PLATE AND DRESSED OF FLUSH POSITION FROM UNIT N° TCI 208 28

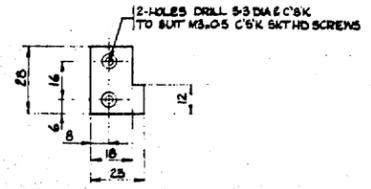
100 DIA

NOTES
 1 ALL JOINTS TO BE BRAZED
 2 EXTERNAL JOINTS TO BE DRESSED OFF FLUSH
 3 HOLES DIMENSIONS & NOTES MARKED THUS * APPLY TO ONE COVER ONLY

SCRAP SECTION B-B

Royal Greenwich Observatory
 La Palma Division
APPROVED
T. J. 208 20 A
22-5-81

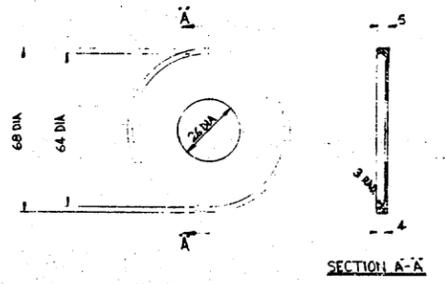
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| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | FIRST MADE ORD No. 118660 | MATERIAL 18 S.M. Mild Steel Sheet |
| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | TITLE LATCH COVER | |
| | | WEIGHT 6.88 KG | SCALE 1/1 |
| | | No. OFF PER SET 2 | UNIT No. TCI 208 30 |



Royal Greenwich Observatory
 La Palma Division
APPROVED
T. J. 208 20 A
22-5-81

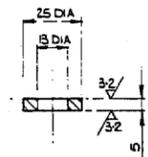
REMOVE SHARP CORNERS

| | | | |
|-------------------------|-------------------------|----------------------------|-----------------------------------|
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | FIRST MADE ORD No. 118660 | MATERIAL 18 S.M. Mild Steel Plate |
| | | FIRST ISSUE DATE 17-6-81 | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | TITLE REMOVE SHARP CORNERS | |
| | | WEIGHT 0.0000 KG | SCALE 1/1 |
| | | No. OFF PER SET 8 | UNIT No. TCI 208 31 |



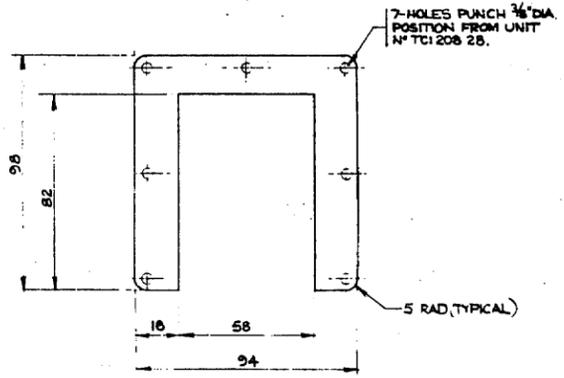
32/ ALL OVER

| | | | |
|-------------------------|-------------------------|---------------------------|-----------------------------|
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | FIRST MADE ORD No. 118660 | MATERIAL 18 S.M. Mild Steel |
| | | FIRST ISSUE DATE | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | TITLE CHIP SHIELD | |
| | | WEIGHT 0.044 KG | SCALE 1/1 |
| | | No. OFF PER SET 16 | UNIT No. TCI 208 32 |



AS FITTED DRAWING

| | | | |
|-------------------------|-------------------------|---------------------------|-----------------------------|
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | FIRST MADE ORD No. 118660 | MATERIAL 18 S.M. Mild Steel |
| | | FIRST ISSUE DATE | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | TITLE WASHER | |
| | | WEIGHT | SCALE 1/1 |
| | | No. OFF PER SET 16 | UNIT No. TCI 208 33 |



AS BUILT DRAWINGS
 This drawing shows all conditions in this work.

AS FITTED DRAWING

| | | | |
|-------------------------|-------------------------|---------------------------|-----------------------------|
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | FIRST MADE ORD No. 118660 | MATERIAL 18 S.M. Mild Steel |
| | | FIRST ISSUE DATE | FINISH |
| | | COST ACCOUNT 208 | PART No. |
| DATE OF MOD MODIFIED BY | DATE OF MOD MODIFIED BY | TITLE LATCH COVER SHIELD | |
| | | WEIGHT | SCALE 1/1 |
| | | No. OFF PER SET 2 | UNIT No. TCI 208 34 |