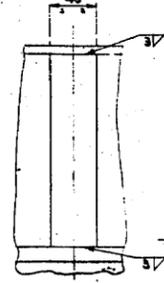
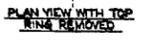
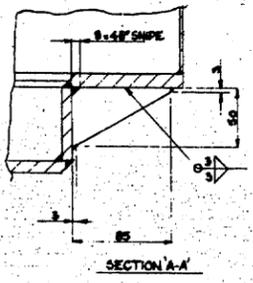


WHEN MACHINING THIS DIA. CONTINUE FOR A LENGTH OF 20mm AS SHOWN TO CLEAR 2-TRUNNION BLOCKS



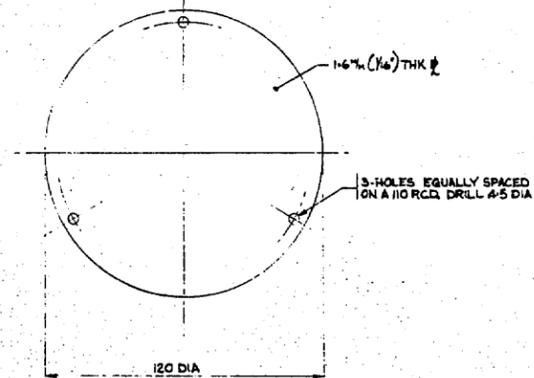
- NOTES**
- 1/ TO BE STRESS RELIEVED TO BS 1500-1958, SECTION 4.0. AND GRIT BLASTED WITH POWER IMMEDIATELY AFTER GRT BLASTING.
  - 2/ ALL WELD SURFACES ARE TO BE CLEAN AND FREE FROM SCALE, LAMINATIONS AND INCLUSIONS
  - 3/ ALL WELDS TO BE CONTINUOUS
  - 4/ TO PURCHASE SPEC. N° 1 ISSUE 2
  - 5/ QUALITY CONTROL SCHEDULE Q.C.S. 1/4
  - 6/ PRIMA PAINT INSIDE WHITE GLOSS & OUTSIDE EGGSHELL BLACK

DRESS OFF SHARP EDGE  
DRESS OFF WELDS

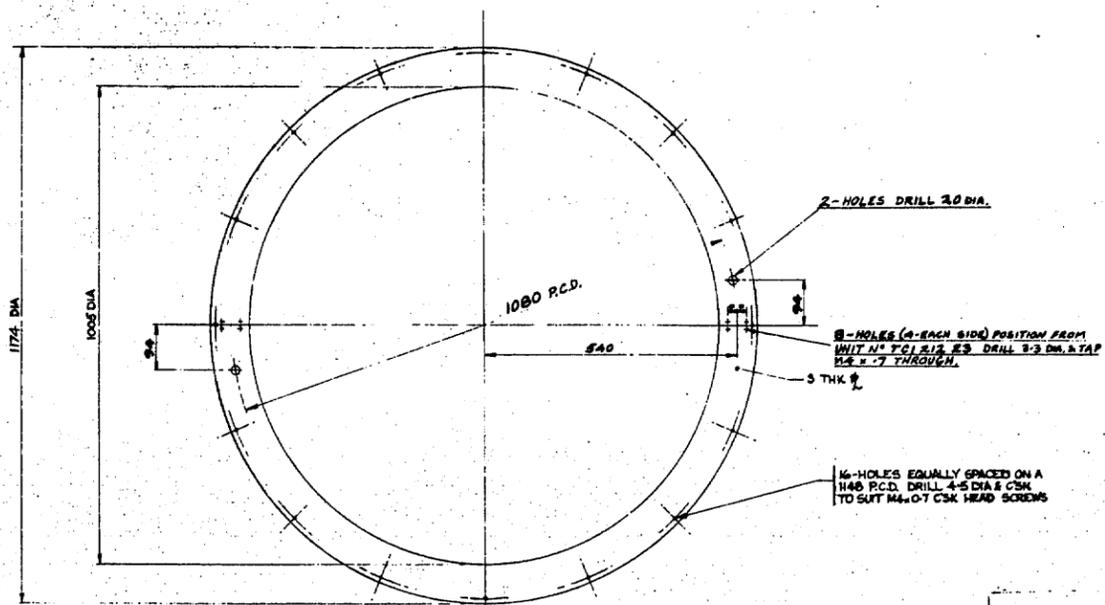
- 946 DIA
- 970 DIA
- 976 DIA
- 1140 DIA

AS BUILT DRAWING

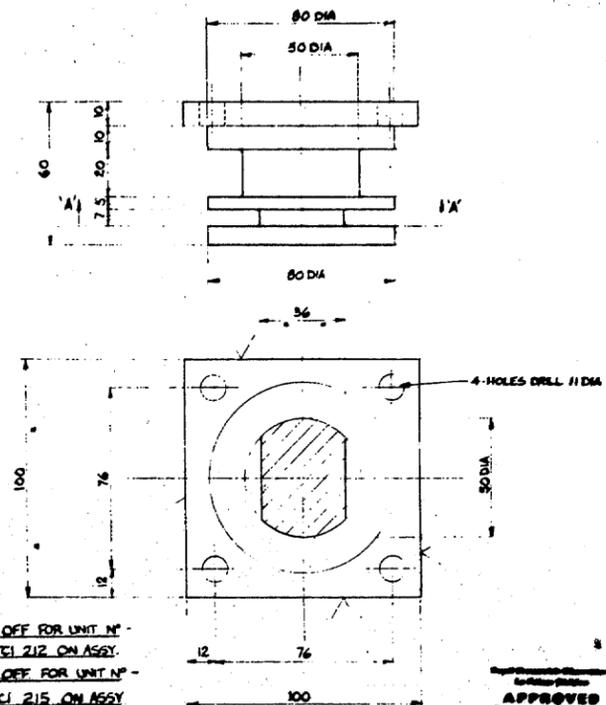
<p><b>SURFACE FINISH EQUIVALENTS</b></p> <p>THIS DRAWING CONFORMS TO B.S. 208</p>	<p><b>SURFACE FINISH SYMBOLS</b></p> <p>✓ DENOTES NOT NECESSARILY MACHINED</p> <p>▽ DENOTES MACHINED</p>	<p><b>WELD SYMBOLS</b></p> <p>TO BS 499 PART 2 1969</p>	<p><b>FABRICATION TOLERANCES</b></p> <p>DIMENSIONS UP TO 250 ± 0.20</p> <p>DIMENSIONS FROM 250 TO 2500 ± 0.30</p> <p>ANGLES ± 1' 00"</p> <p>STRAIGHTNESS/FLATNESS 1: 600</p>	<p>THIS DRAWING IS THE PROPERTY OF HSI PARSONS LTD. AND MUST NOT BE COPIED OR DISCLOSED TO A THIRD PARTY WITHOUT HSI PARSONS WRITTEN CONSENT.</p>	<p>ALL DIMENSIONS ARE IN MILLIMETRES</p> <p>ANGLES &amp; BEVELS UNLESS OTHERWISE SPECIFIED TO BS 2643 PART 2</p> <p>BEVELS FIT MACHINERY DIA CONFORMING TO D17.12</p>	<p>APPROVED</p> <p>12-12-80</p>	<p><b>GAUGER PARSONS</b></p> <p>RENEWABLE SPECIAL TYPE FOR 2ND</p> <p>DETAILS FOR 611</p>
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APPROVED  
 10-10-51



APPROVED  
 10-10-51

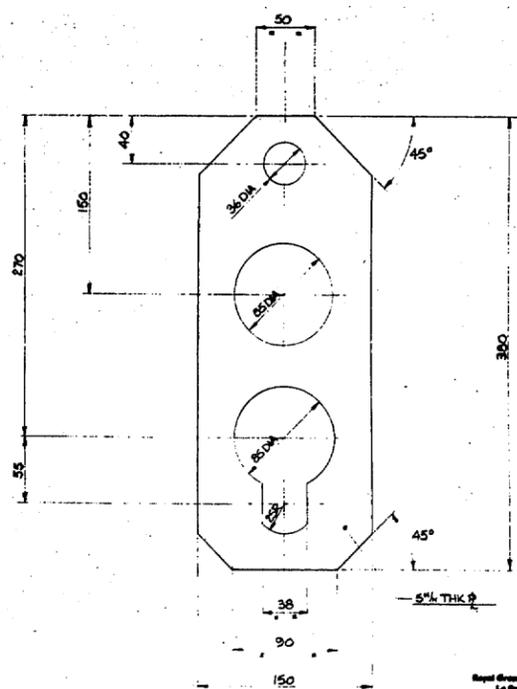


2 OFF FOR UNIT N° TCI 212 ON ASSY

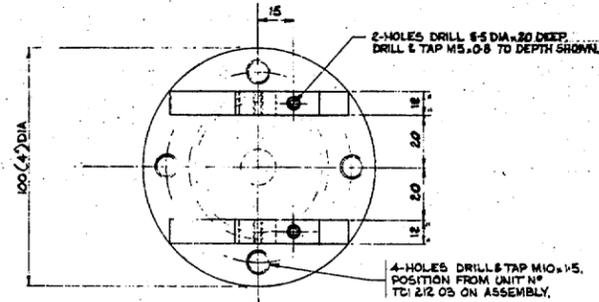
2 OFF FOR UNIT N° TCI 215 ON ASSY

APPROVED  
 10-10-51

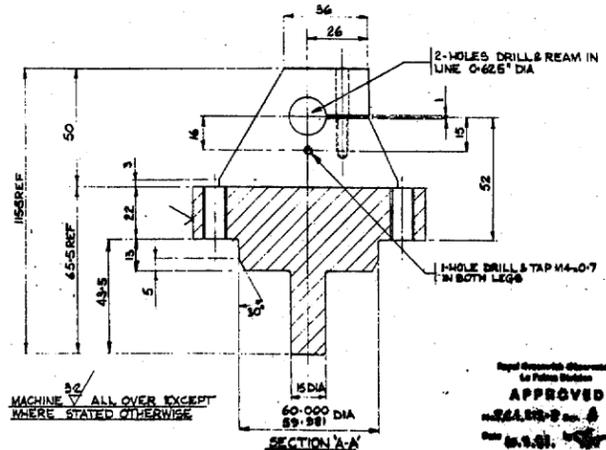
MACHINE  $\nabla$  ALL OVER EXCEPT WHERE STATED OTHERWISE



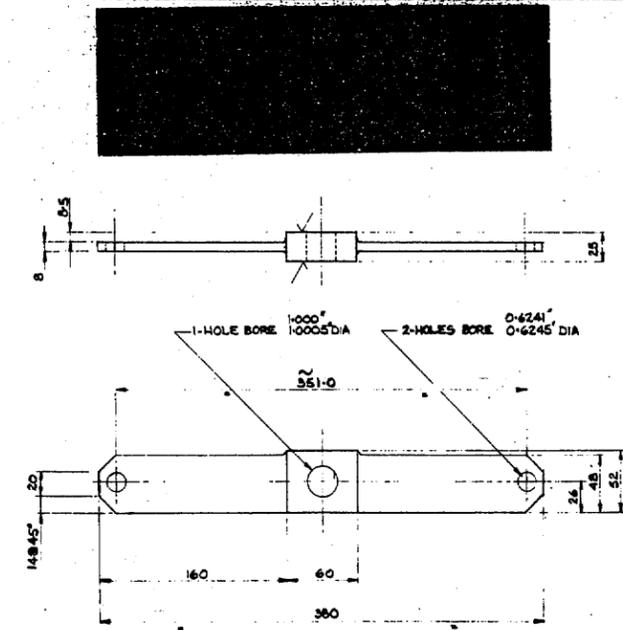
APPROVED  
 10-10-51



APPROVED  
 10-10-51

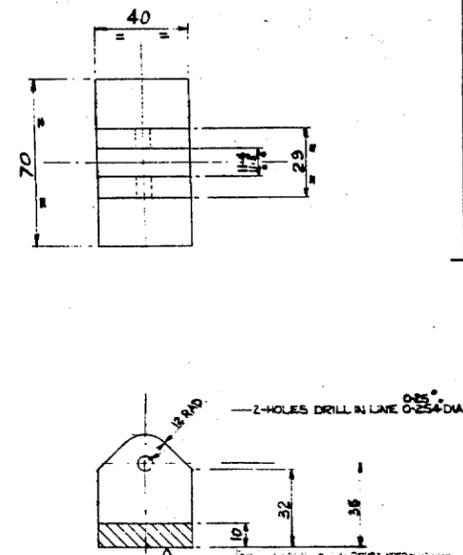


MACHINE  $\nabla$  ALL OVER EXCEPT WHERE STATED OTHERWISE



APPROVED  
 10-10-51

MACHINE  $\nabla$  ALL OVER EXCEPT WHERE STATED OTHERWISE



MACHINE  $\nabla$  ALL OVER EXCEPT WHERE STATED OTHERWISE

APPROVED  
 10-10-51

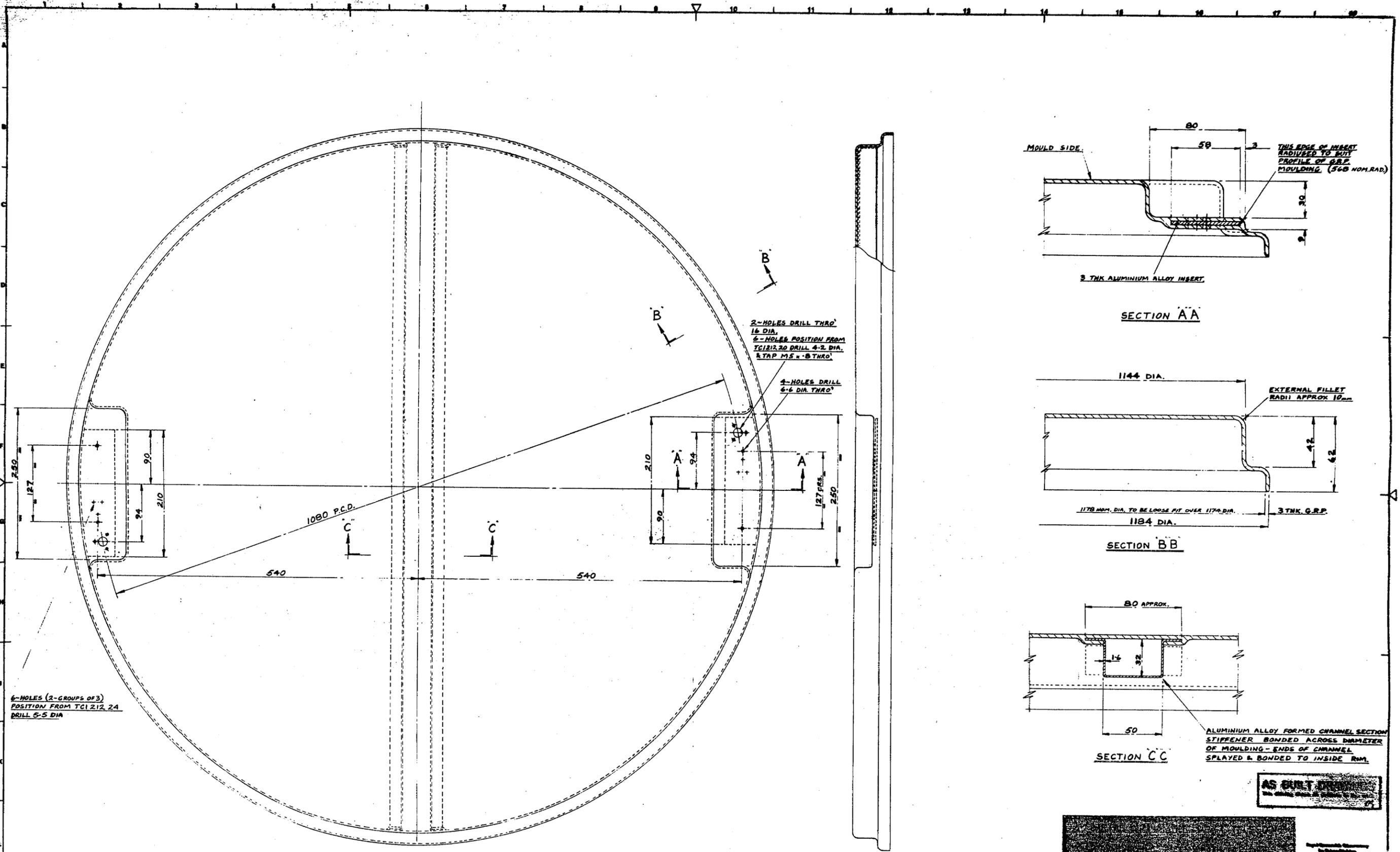
DESIGNED BY	10-10-51	MATERIAL	2d Carbon Steel
DATE OF ISSUE	10-10-51	FINISH	As Manufactured
CHECKED BY	10-10-51	QUANTITY	2
TITLE: Lyrain Part			
WEIGHT	1.66g	SCALE	1/2
NO. OFF PER SET	1/2	UNIT NO.	10-10-51

DESIGNED BY	10-10-51	MATERIAL	2d Carbon Steel
DATE OF ISSUE	10-10-51	FINISH	As Manufactured
CHECKED BY	10-10-51	QUANTITY	2
TITLE: Lyrain Part			
WEIGHT	1.66g	SCALE	1/2
NO. OFF PER SET	1/2	UNIT NO.	10-10-51

DESIGNED BY	10-10-51	MATERIAL	2d Carbon Steel
DATE OF ISSUE	10-10-51	FINISH	As Manufactured
CHECKED BY	10-10-51	QUANTITY	2
TITLE: Lyrain Part			
WEIGHT	1.66g	SCALE	1/2
NO. OFF PER SET	1/2	UNIT NO.	10-10-51

DESIGNED BY	10-10-51	MATERIAL	2d Carbon Steel
DATE OF ISSUE	10-10-51	FINISH	As Manufactured
CHECKED BY	10-10-51	QUANTITY	2
TITLE: Lyrain Part			
WEIGHT	1.66g	SCALE	1/2
NO. OFF PER SET	1/2	UNIT NO.	10-10-51

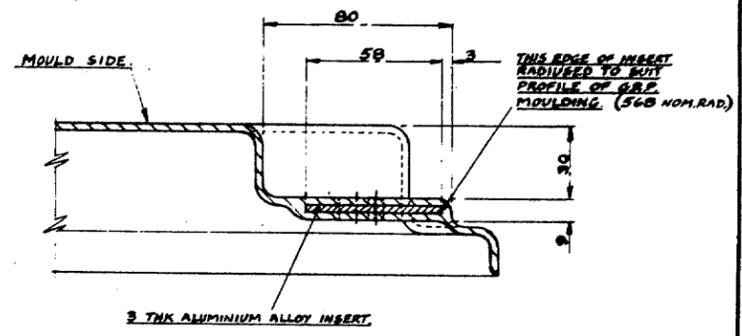




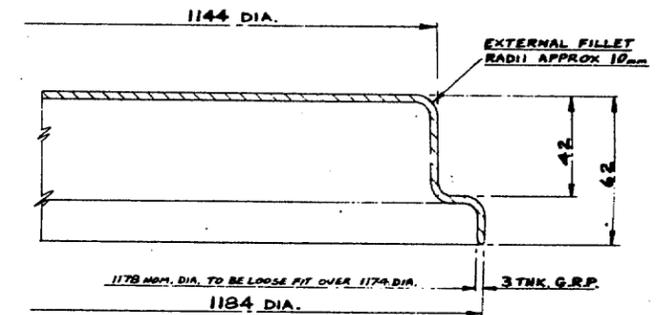
6-HOLES (2-GROUPS OF 3)  
POSITION FROM TCI 212, 24  
DRILL 5.5 DIA

2-HOLES DRILL THRO' 16 DIA.  
6-HOLES POSITION FROM TCI 212, 24 DRILL 4.2 DIA.  
STAP M5 x 8 THRO'

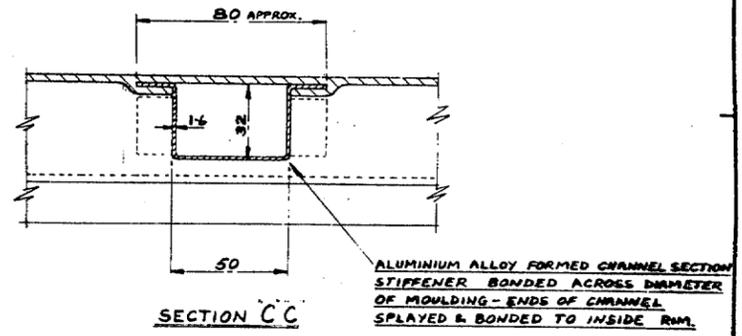
4-HOLES DRILL 6.6 DIA THRO'



SECTION AA



SECTION BB



SECTION CC

AS BUILT DRAWING

APPROVED  
26-3-81

A merger of Clark Chapman and Raylton Parsons	SURFACE FINISH EQUIVALENTS THIS DRAWING CONFORMS TO B.S. 208	SURFACE FINISH SYMBOLS DENOTES NOT NECESSARILY MACHINED DENOTES MACHINED	WELD SYMBOLS TO BS 499 PART 2 1969	FABRICATION TOLERANCES DIMENSIONS UP TO 250 ± 0.20 DIMENSIONS FROM 250 TO 2800 ± 0.30 DIMENSIONS FROM 2800 TO 10000 ± 0.50 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.	ALL DIMENSIONS ARE IN MILLIMETRES ANGLES & SCREEN THREADS TO B.S. 9645 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO 0.1 T.I.R.	PRODUCTION DRAWING DATE 26-3-81	GRUBB PARSONS NEWCASTLE UPON TYNE NEW ENGLAND DETAILS OF F11 SECONDARY MIRROR CELL TCI 212, 24
	APPROVED 26-3-81							