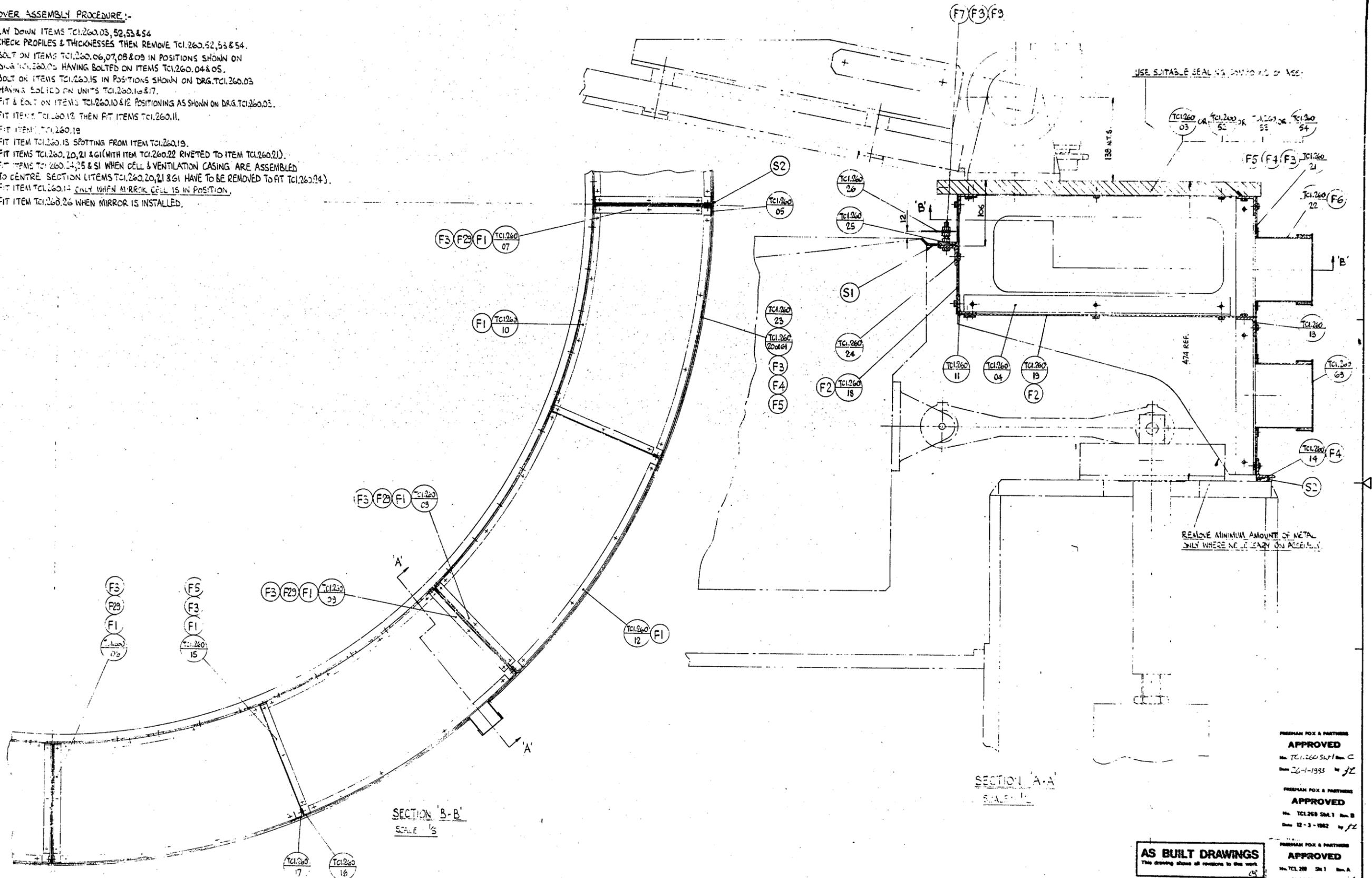


COVER ASSEMBLY PROCEDURE:-

1. LAY DOWN ITEMS TCl.260.03, S2, S3 & S4
CHECK PROFILES & THICKNESSES THEN REMOVE TCl.260.52, 53 & 54.
2. BOLT ON ITEMS TCl.260.06, 07, 08 & 09 IN POSITIONS SHOWN ON
DRG. TCl.260.03 HAVING BOLTED ON ITEMS TCl.260.04 & 05.
3. BOLT ON ITEMS TCl.260.15 IN POSITIONS SHOWN ON DRG. TCl.260.03
HAVING BOLTED ON UNITS TCl.260.1a & 17.
4. FIT & BOLT ON ITEMS TCl.260.10 & 12 POSITIONING AS SHOWN ON DRG. TCl.260.03.
5. FIT ITEMS TCl.260.13 THEN FIT ITEMS TCl.260.11.
6. FIT ITEM TCl.260.18
7. FIT ITEM TCl.260.13 SPOTTING FROM ITEM TCl.260.19.
8. FIT ITEMS TCl.260.20, 21 & 22 (WITH ITEM TCl.260.22 RIVETED TO ITEM TCl.260.21).
9. FIT ITEMS TCl.260.23, 24 & S1 WHEN CELL & VENTILATION CASING ARE ASSEMBLED
TO CENTRE SECTION (ITEMS TCl.260.20, 21 & 22 HAVE TO BE REMOVED TO FIT TCl.260.24).
10. FIT ITEM TCl.260.14 ONLY WHEN MIRROR CELL IS IN POSITION.
11. FIT ITEM TCl.260.26 WHEN MIRROR IS INSTALLED.



FREEMAN FOX & PARTNERS
APPROVED
 No. TCl.260.SL1 Rev. C
 Date 26-1-1982 by JZ

FREEMAN FOX & PARTNERS
APPROVED
 No. TCl.260.SL1 Rev. B
 Date 12-3-1982 by JZ

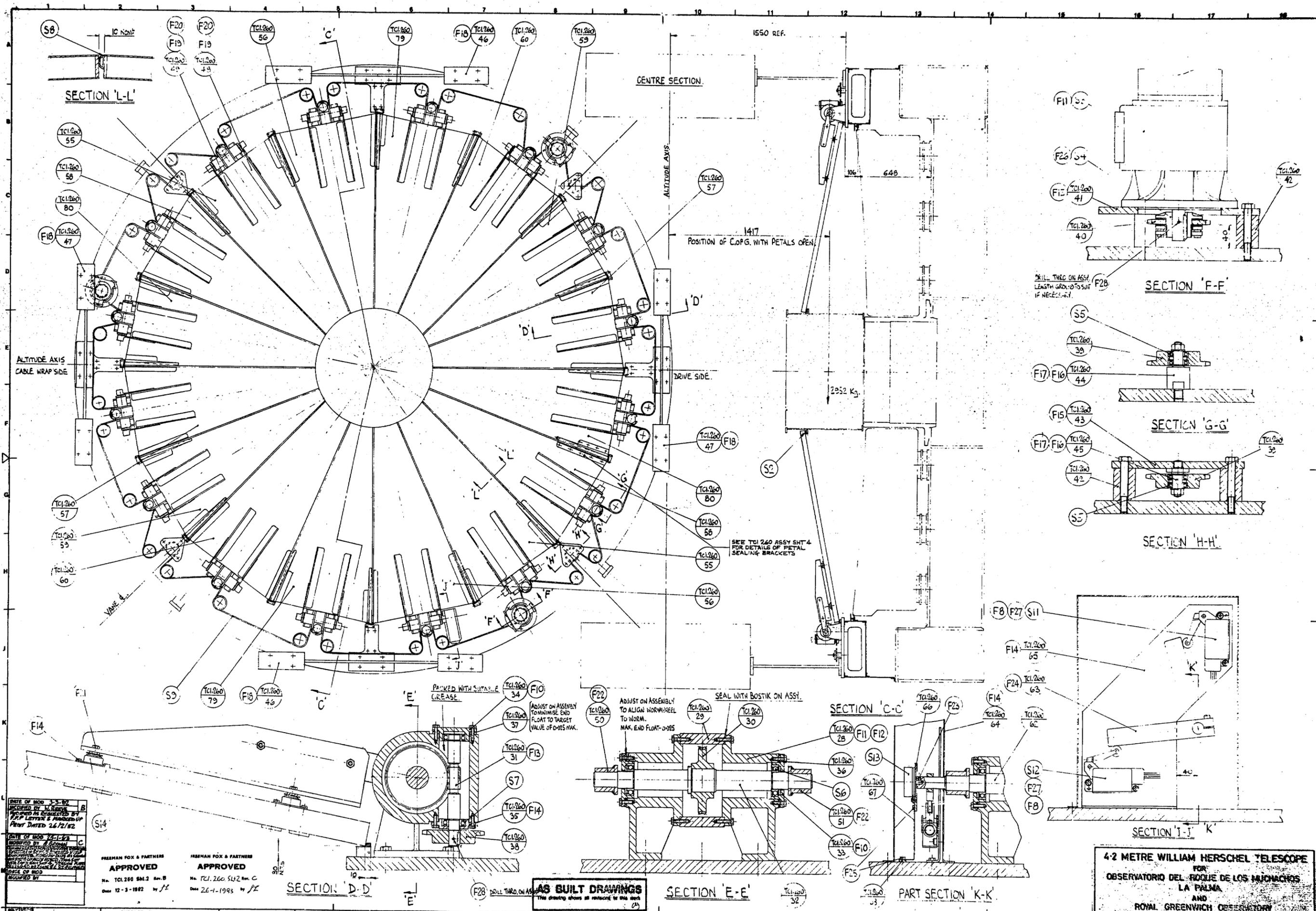
FREEMAN FOX & PARTNERS
APPROVED
 No. TCl.260.SL1 Rev. A
 Date 26.2.1982 by JZ

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

DATE OF MOD 1-3-82
 MODIFIED BY G. R. B. B
 TOLERANCES AS SHOWN
 REVISIONS AS SHOWN
 DATE OF MOD 17-1-82
 MODIFIED BY M. R. B. C
 TCl.260 BY CALLED
 TCl.260 BY CALLED
 TCl.260 BY CALLED

4.2 METRE WILLIAM HERSCHEL TELESCOPE
 FOR
 OBSERVATORIO DEL ROQUE DE LOS MUCHACHOS
 LA PALMA
 AND
 ROYAL GREENWICH OBSERVATORY

A member of Clarke Chapman and Reynolds Parsons	SURFACE FINISH EQUIVALENTS MICROMETRES 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 THIS DRAWING CONFORMS TO B.S. 308	SURFACE FINISH SYMBOLS DENY. ES. 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 2500 ± 0.30 DIMENSIONS OVER 2500 ± 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 : SCREW THREADS TO B.S. 3043 PAR. 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO 0.1 TIR.	PROJECTION CHECKED 3rd ANGLE DATE 2/1/82	DRAWN DATE 2/1/82	GRUBB PARSONS NEWCASTLE UPON TYNE NE8 2YB ASSEMBLY OF MAIN MIRROR VENTILATION.	SCALE TCl.260.
	DATE OF MOD 1-3-82 MODIFIED BY G. R. B. B TOLERANCES AS SHOWN REVISIONS AS SHOWN DATE OF MOD 17-1-82 MODIFIED BY M. R. B. C TCl.260 BY CALLED TCl.260 BY CALLED TCl.260 BY CALLED									



DATE OF MOD 3-5-82
 APPROVED BY M. HENRY
 APPROVED BY J. LAYTON & M. HENRY
 PRINT DATED 26/2/82

DATE OF MOD 12-1-83
 APPROVED BY J. LAYTON & M. HENRY
 APPROVED BY J. LAYTON & M. HENRY
 PRINT DATED 26/2/82

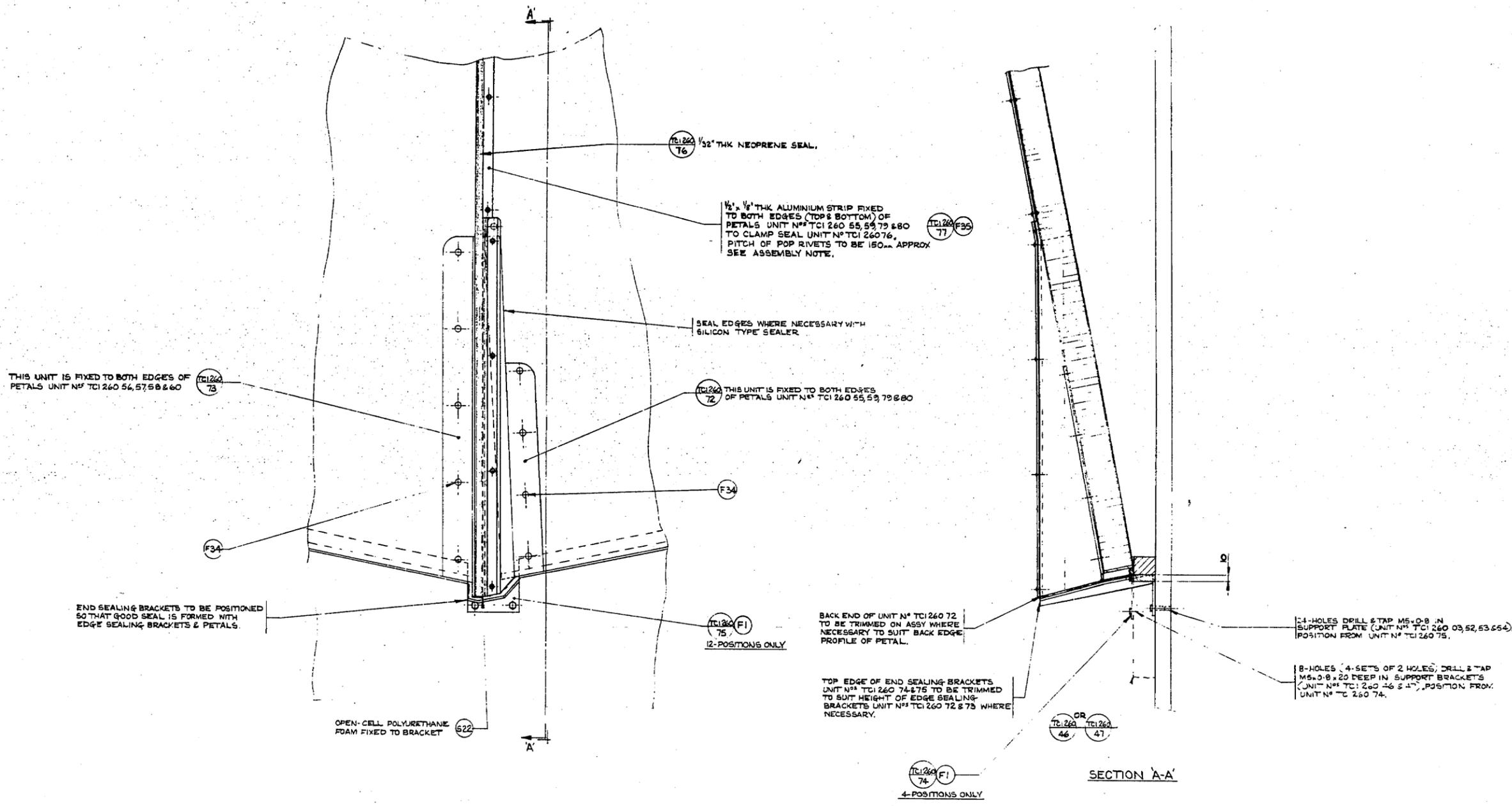
FRESHMAN FOX & PARTNERS
APPROVED
 No. TCl.260 SML2 Rev. B
 Date 12-3-1982 by JF

FRESHMAN FOX & PARTNERS
APPROVED
 No. TCl.260 SML2 Rev. C
 Date 26-1-1983 by JF

AS BUILT DRAWINGS
 This drawing shows all revisions to this work

4.2 METRE WILLIAM HERSCHEL TELESCOPE
 FOR
 OBSERVATORIO DEL BOSQUE DE LOS MUJICHOS
 LA PALMA
 AND
 ROYAL GREENWICH OBSERVATORY

SURFACE FINISH EQUIVALENTS DIMENSIONS UP TO 250 : 20 DIMENSIONS FROM 250 TO 2500 : 30 DIMENSIONS FROM 2500 TO 25000 : 40 DIMENSIONS FROM 25000 TO 250000 : 50 DIMENSIONS FROM 250000 TO 2500000 : 60 DIMENSIONS FROM 2500000 TO 25000000 : 70 DIMENSIONS FROM 25000000 TO 250000000 : 80 DIMENSIONS FROM 250000000 TO 2500000000 : 90 DIMENSIONS FROM 2500000000 TO 25000000000 : 100	SURFACE FINISH SYMBOLS DIMENTS NOT NECESSARILY MACHINED DIMENTS MACHINED	WELD SYMBOLS PART 2 1989	FABRICATION TOLERANCES DIMENSIONS UP TO 250 : 20 DIMENSIONS FROM 250 TO 2500 : 30 DIMENSIONS FROM 2500 TO 25000 : 40 DIMENSIONS FROM 25000 TO 250000 : 50 DIMENSIONS FROM 250000 TO 2500000 : 60 DIMENSIONS FROM 2500000 TO 25000000 : 70 DIMENSIONS FROM 25000000 TO 250000000 : 80 DIMENSIONS FROM 250000000 TO 2500000000 : 90 DIMENSIONS FROM 2500000000 TO 25000000000 : 100	THIS DRAWING IS THE PROPERTY OF NEI PARSONS LTD. AND MUST NOT BE COPIED OR DISCLOSED TO A THIRD PARTY WITHOUT G.UBB PARSONS WRITTEN CONSENT.	ALL DIMENSIONS ARE IN MILLIMETRES UNLESS OTHERWISE STATED ANGLES - SCREW THREADS TO B.S. 31-1 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO O.D. F.I.R.	PROJECTION ANGLED 3RD ANGLE DATE 09/11/82	DRAWN BY M. ROSE CHECKED BY J. LAYTON DATE 09/11/82	GRUBB PARSONS NEWCASTLE UPON TYNE NE6 2YB ASSEMBLY OF MAIN MIRROR VENTILATION SCALE 1:1 SHEET 2 OF 4 TCl.260
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THIS UNIT IS FIXED TO BOTH EDGES OF PETALS UNIT N° TCI 260 54, 57, 58 & 60

TCI 260 76 1/2" THK NEOPRENE SEAL.

1/2" x 1/8" THK ALUMINIUM STRIP FIXED TO BOTH EDGES (TOP & BOTTOM) OF PETALS UNIT N° TCI 260 55, 59, 79 & 80 TO CLAMP SEAL UNIT N° TCI 260 76. PITCH OF POP RIVETS TO BE 150mm APPROX. SEE ASSEMBLY NOTE.

SEAL EDGES WHERE NECESSARY WITH SILICON TYPE SEALER

TCI 260 72 THIS UNIT IS FIXED TO BOTH EDGES OF PETALS UNIT N° TCI 260 55, 59, 79 & 80

END SEALING BRACKETS TO BE POSITIONED SO THAT GOOD SEAL IS FORMED WITH EDGE SEALING BRACKETS & PETALS.

BACK END OF UNIT N° TCI 260 72 TO BE TRIMMED ON ASSY WHERE NECESSARY TO SUIT BACK EDGE PROFILE OF PETAL.

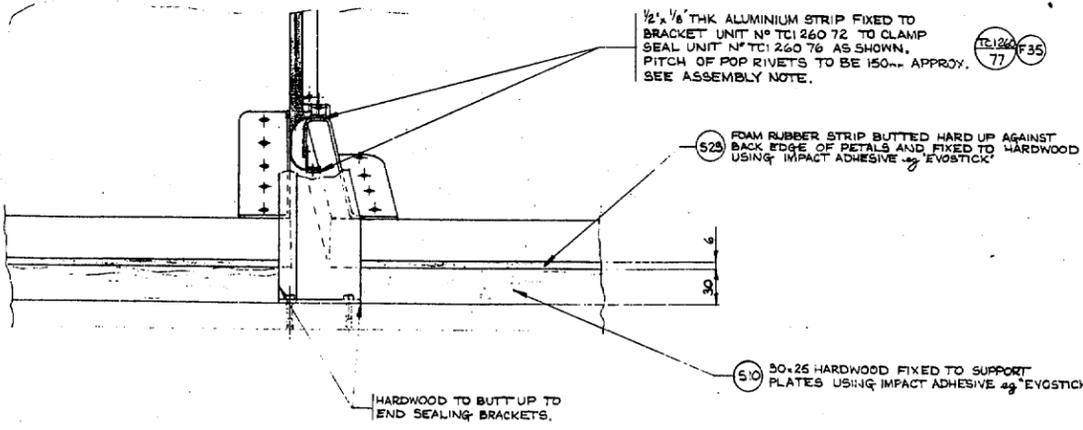
14 HOLES DRILL & TAP M5 x 0.8 IN SUPPORT PLATE (UNIT N° TCI 260 03, 52, 53, 55, 54). POSITION FROM UNIT N° TCI 260 75.

18 HOLES (4 SETS OF 2 HOLES) DRILL & TAP M5 x 0.8 x 20 DEEP IN SUPPORT BRACKETS (UNIT N° TCI 260 74 & 75). POSITION FROM UNIT N° TCI 260 74.

OPEN-CELL POLYURETHANE FOAM FIXED TO BRACKET

TOP EDGE OF END SEALING BRACKETS UNIT N° TCI 260 74 & 75 TO BE TRIMMED TO SUIT HEIGHT OF EDGE SEALING BRACKETS UNIT N° TCI 260 72 & 73 WHERE NECESSARY.

SECTION A-A



1/2" x 1/8" THK ALUMINIUM STRIP FIXED TO BRACKET UNIT N° TCI 260 72 TO CLAMP SEAL UNIT N° TCI 260 76 AS SHOWN. PITCH OF POP RIVETS TO BE 150mm APPROX. SEE ASSEMBLY NOTE.

525 FOAM RUBBER STRIP BUTTED HARD UP AGAINST BACK EDGE OF PETALS AND FIXED TO HARDWOOD USING IMPACT ADHESIVE eg EVOSTICK

510 50x25 HARDWOOD FIXED TO SUPPORT PLATES USING IMPACT ADHESIVE eg EVOSTICK

ASSEMBLY NOTE
ALL ASSEMBLY OF NEOPRENE SEAL & ALUMINIUM CLAMPING STRIPS TO BE CARRIED OUT IN ACCORDANCE WITH ASSEMBLY PROCEDURE N° TCI 260 AP1

AS BUILT DRAWINGS
This drawing shows all revisions to this work

APPROVED
TCI 260 Assy Section B
22-11-1983

APPROVED
TCI 260 Assy Section A
22-11-1983

DATE OF MOD 24-10-83
PREPARED BY Brown
TCI 260 58 CHECKED
TCI 260 76, 77 & F35 REVIEWED
ASSEMBLY NOTE ADDED.
DATE OF MOD
MODIFIED BY



SURFACE FINISH EQUIVALENTS DIMENSIONS UP TO 250 ± 0.20 DIMENSIONS FROM 250 TO 2500 ± 0.30 ANGLES ± 1: 600 STRAIGHTENERS/FLATNESS 1: 600	SURFACE FINISH SYMBOLS DENOTES NOT NECESSARILY MACHINED DENOTES MACHINED	WELD SYMBOLS TO BS 499 PART 2 1989	FABRICATION TOLERANCES DIMENSIONS UP TO 250 ± 0.20 DIMENSIONS FROM 250 TO 2500 ± 0.30 ANGLES ± 1: 600 STRAIGHTENERS/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 TOLERANCES UNLESS SPECIFIED (SEE DIMENSIONS) UNFINISHED DIMENSIONS ± 0.5 DIMENSIONS WITH OVER ± 0.5 DIMENSIONS WITH UNDER ± 0.5	ALL DIMENSIONS ARE IN MILLIMETRES ANGLES ± 1: 600 SCREW THREADS TO B.S. 3643 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO 0.1 T.I.R.	PROJECTION CHECKED 3RD ANGLE APPROVED	DRAWN BY BROWN DATE 25-1-83	GRUBB PARSONS NEWCASTLE UPON TYNE NEG 275 ASSEMBLY OF MAIN MIRROR VENTILATION SCALE 1:1 SHEET 4 OF 4 TCI 260 ASSY
							DATE OF MOD 24-10-83 PREPARED BY Brown TCI 260 58 CHECKED TCI 260 76, 77 & F35 REVIEWED ASSEMBLY NOTE ADDED. DATE OF MOD MODIFIED BY	APPROVED TCI 260 Assy Section B 22-11-1983	APPROVED TCI 260 Assy Section A 22-11-1983