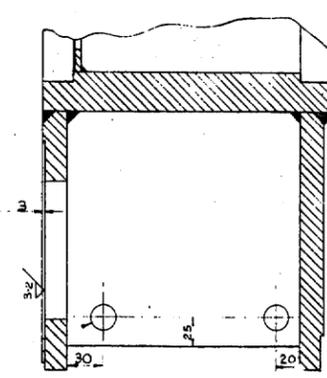


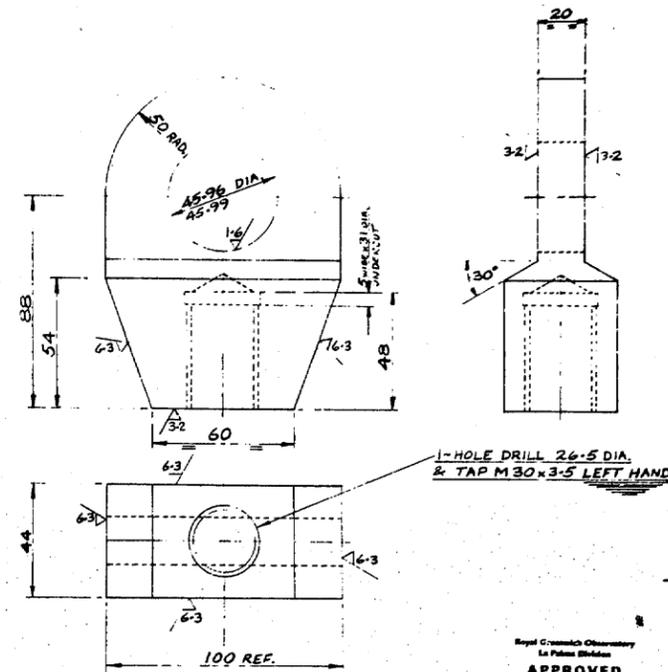
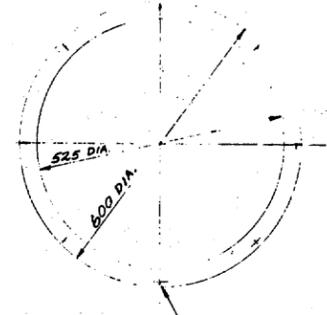
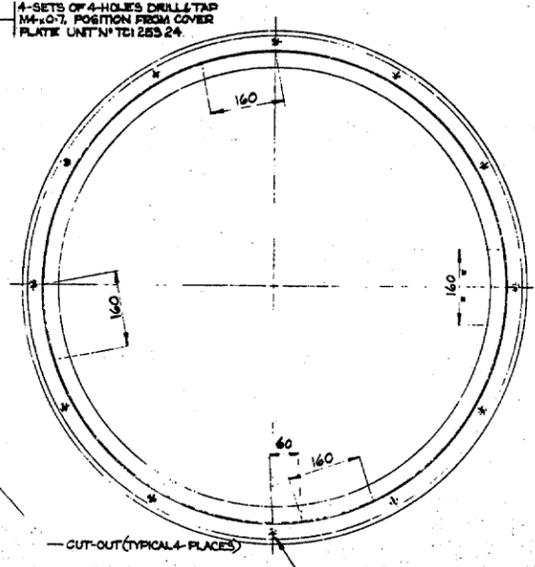
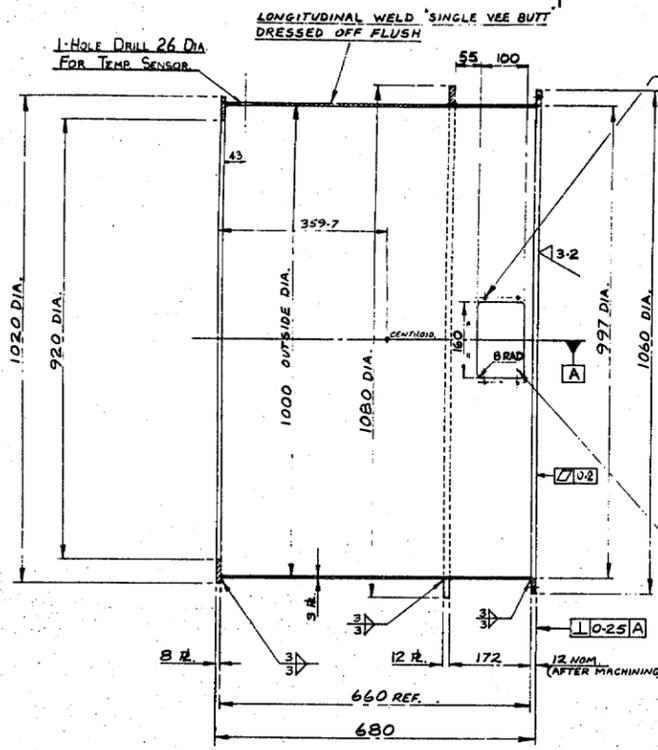
- 1 TO BE STRESS RELIEVED TO BS 1500-1958 SECTION 4 D & GRIT BLASTED
- 2 PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING
- 3 ALL WELD SURFACES ARE TO BE CLEAN AND FREE FROM SCALE LAMINATIONS AND INCLUSIONS
- 4 ALL WELDS TO BE CONTINUOUS
- 5 TO PURCHASE SPEC. N°1 ISSUE 2
- 6 TO QUALITY CONTROL SCHEDULE Q.C.S. 1/4
- 7 FINISH PAINT EGGSHELL BLACK

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



4-HOLES (2 IN EACH PLATE) DRILL 20 DIA & REMOVE ALL SHARP EDGES

DATE OF MODIFIED BY	DATE OF MODIFIED BY	FIRST MADE ORN. NO.	ISSUE NO.
DATE OF MODIFIED BY	DATE OF MODIFIED BY	FIRST ISSUE DATE	ISSUE NO.
TITLE		SCALE	
NASCYTH BEARINGS MOUNTING		1:2	
DRAWN BY		CHECKED BY	
T.C.I. 25303		C	



NOTE:-
FABRICATION TO BE WIRE BRUSHED TO REMOVE WELD SPATTER & SURFACE RUST & PRIMED WITH ANODITE BEFORE MACHINING.

APPROVED
No. TCI 253 04
Date 31.7.81 by 987

APPROVED
No. TCI 253 04
Date 31.7.81 by 987

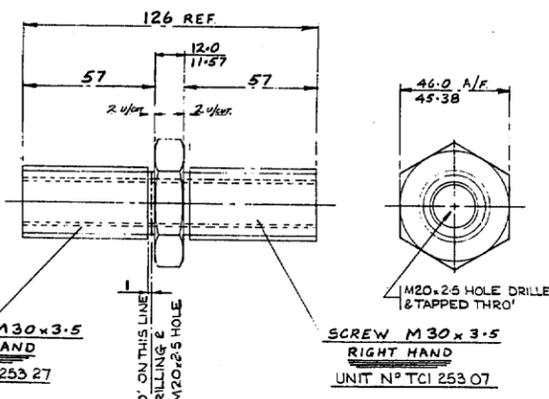
APPROVED
No. TCI 253 05
Date 31.7.81 by 987

APPROVED
No. TCI 253 06
Date 31.7.81 by 987

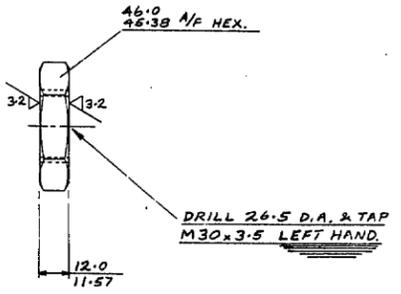
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE LIGHT Baffle	UNIT No. TCI 253 04
		WEIGHT 120.2 kg	SCALE 1:5
		No. OFF PER SET 1	ISSUE C

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL ALUMINIUM ALLOY 6061 T6
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE BEARING SHIELD	UNIT No. TCI 253 05
		WEIGHT 87 kg	SCALE 1:5
		No. OFF PER SET 1	ISSUE A

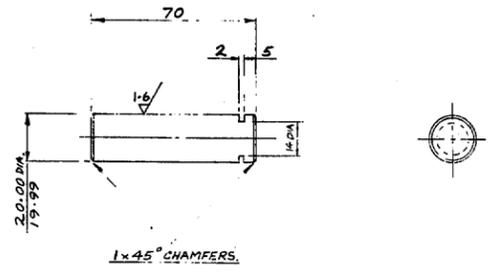
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE ROD END	UNIT No. TCI 253 06
		WEIGHT 2.4 kg	SCALE 1:1
		No. OFF PER SET 8	ISSUE A



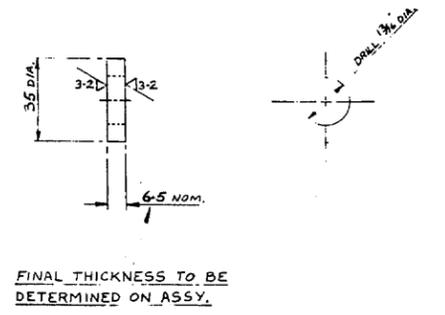
APPROVED
No. TCI 253 27
Date 31.7.81 by 987



APPROVED
No. TCI 253 08
Date 31.7.81 by 987

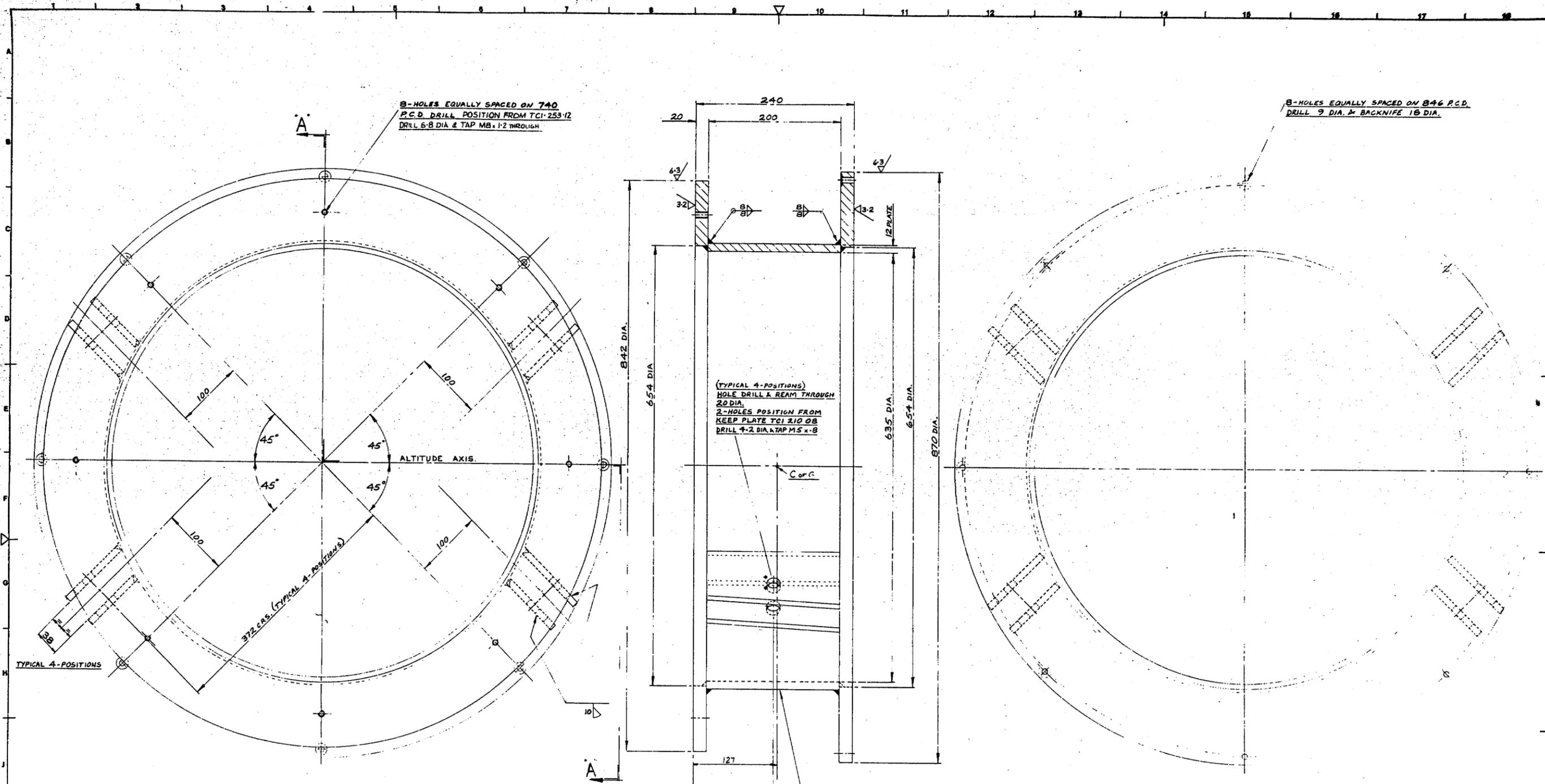


APPROVED
No. TCI 253 09
Date 31.7.81 by 987



APPROVED
No. TCI 253 10
Date 31.7.81 by 987

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE ADJUSTING SCREW	UNIT No. TCI 253 07
		WEIGHT 1.24 kg	SCALE 1:1
		No. OFF PER SET 8	ISSUE B



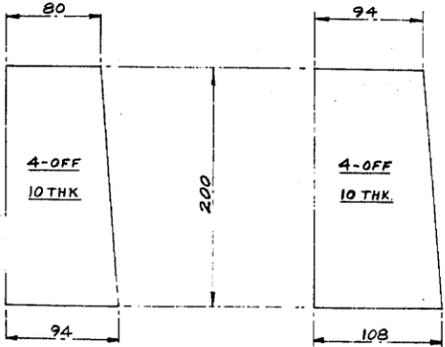
8-HOLES EQUALLY SPACED ON 740 P.C.D. DRILL POSITION FROM TCI 253-12
DRILL 6.8 DIA & TAP M8 x 1.2 THROUGH

8-HOLES EQUALLY SPACED ON 846 P.C.D. DRILL 9 DIA. & BACKKNIFE 16 DIA.

(TYPICAL 4-POSITIONS) HOLE DRILL & REAM THROUGH 20 DIA. 2-HOLES POSITION FROM KEEP PLATE TO 210 OB DRILL 4.2 DIA. & TAP M5 x 8

LONGITUDINAL WELD IN ROLLED PLATE TO BE FULL PENETRATION BUTT WELD DRESSED OFF FLUSH ON BOTH SIDES.

- 1 TO BE STRESS RELIEVED TO BS 1500-1958 SECTION 4D & GRIT BLASTED
- 2 PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING
- 3 ALL WELD SURFACES TO BE CLEAN & FREE FROM SCALE LAMINATIONS & INCLUSIONS
- 4 ALL WELDS TO BE CONTINUOUS
- 5 TO PURCHASE SPEC. NUMBER 1 ISSUE 2
- 6 TO QUALITY CONTROL SCHEDULE Q.C.S. 1/4
- 7 FINISH PAINT :- EGGSHELL BLACK

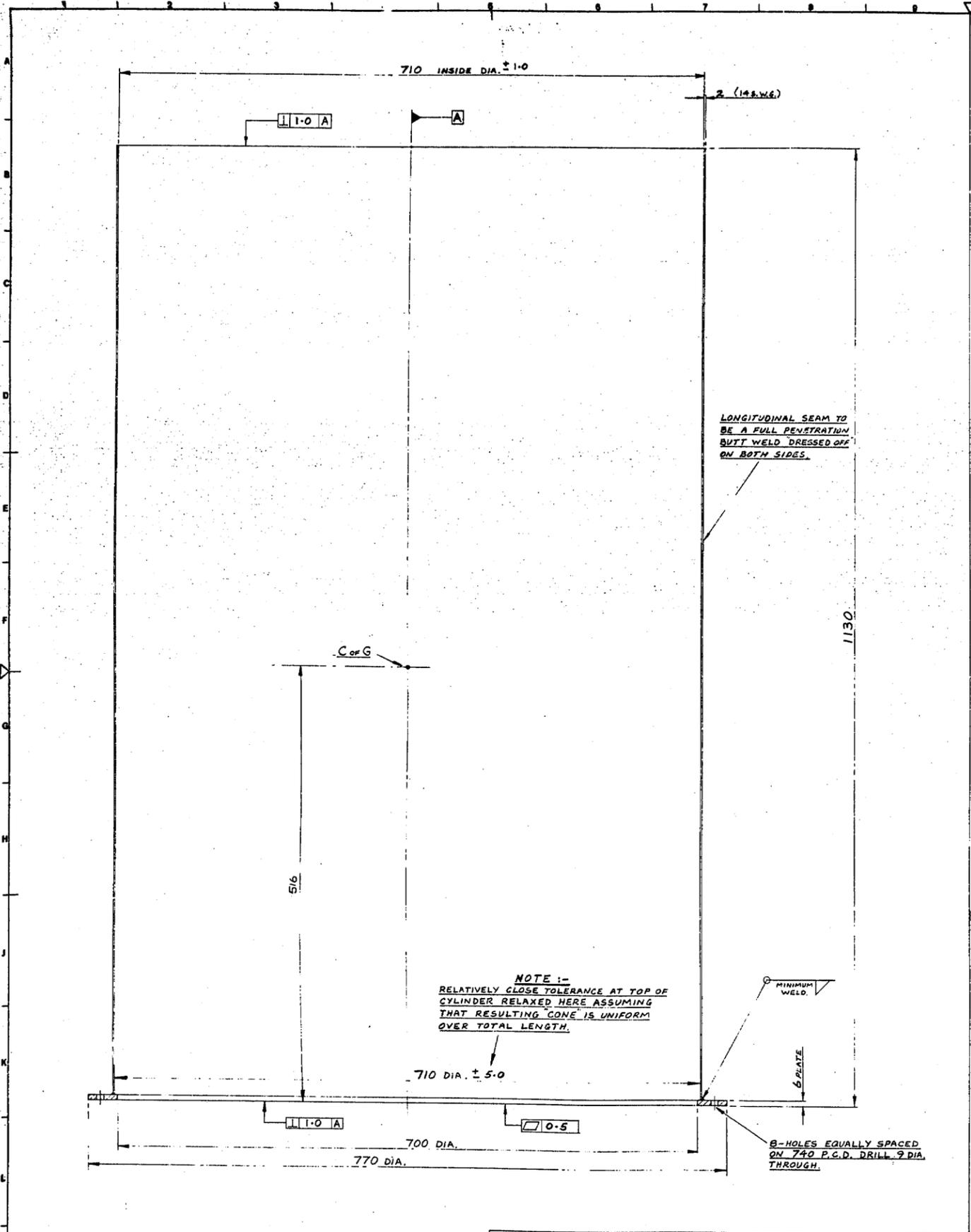


DETAILS OF PLATES FORMING CLEVIS

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

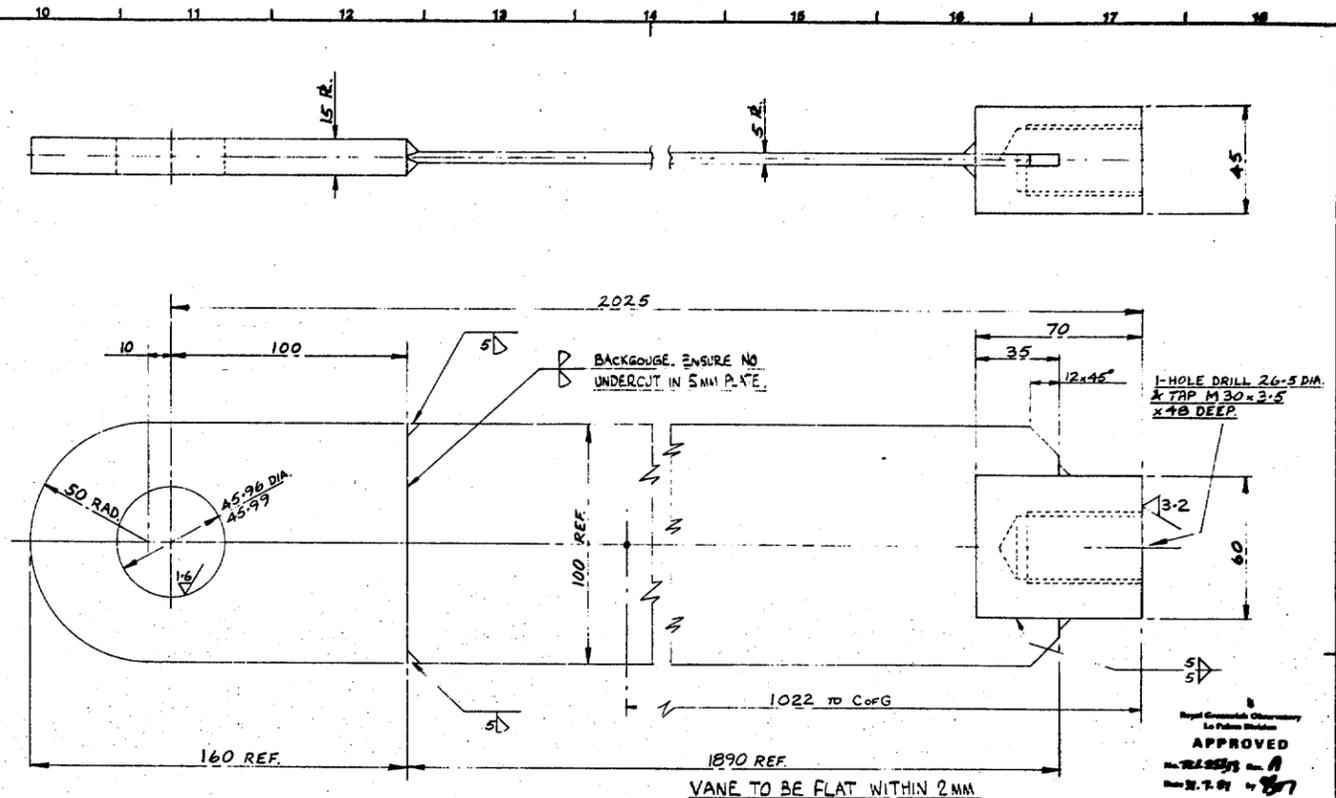
APPROVED
Royal Greenwich Observatory
La Palma Station
No. 201252 of ser. 8
Date 14.7.91

DATE OF MOD. MODIFIED BY	DATE OF MFG. MODIFIED BY	FIRST MADE ORG. No. 110660	MATERIAL STEEL
		FIRST ISSUE DATE	BS 4000-43
		COST ACCOUNT 253	FINISH PRIMER EGGSHELL BLACK
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE VANE TIE RING	ISSUE
		WEIGHT 33.5kg	SCALE 1:2
		No. OFF PER SET	TC1253 11 A



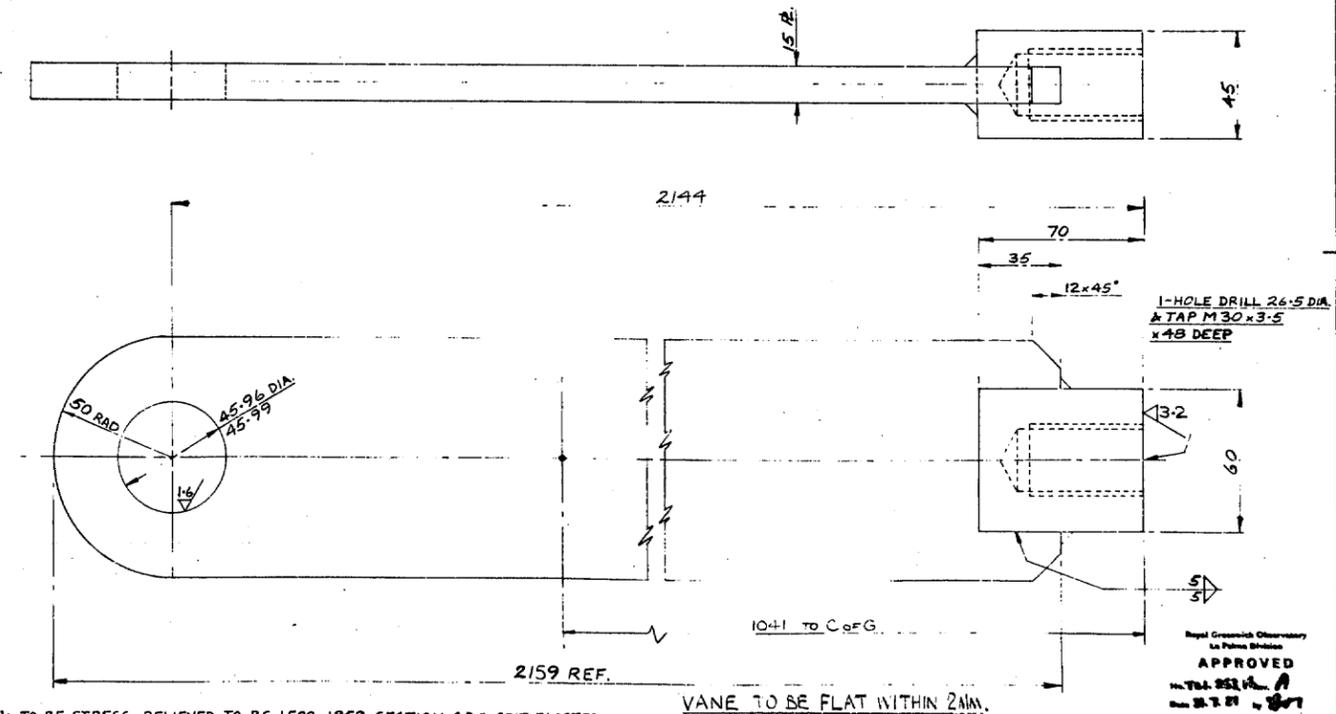
Royal Greenwich Observatory
La Palma Division
APPROVED
No. TEL 251.18 Rev. A
Date 21.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL SF5AL BS 4860-STA 2-30V R.R. SHRT.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST ISSUE DATE	FINISH PRINTEG EGGSHELL BLACK
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE FOG TUBE	UNIT No. TC1 253 12
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	WEIGHT 23.18 kg	SCALE 1:2
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	No. OFF PER SET 1	ISSUE A



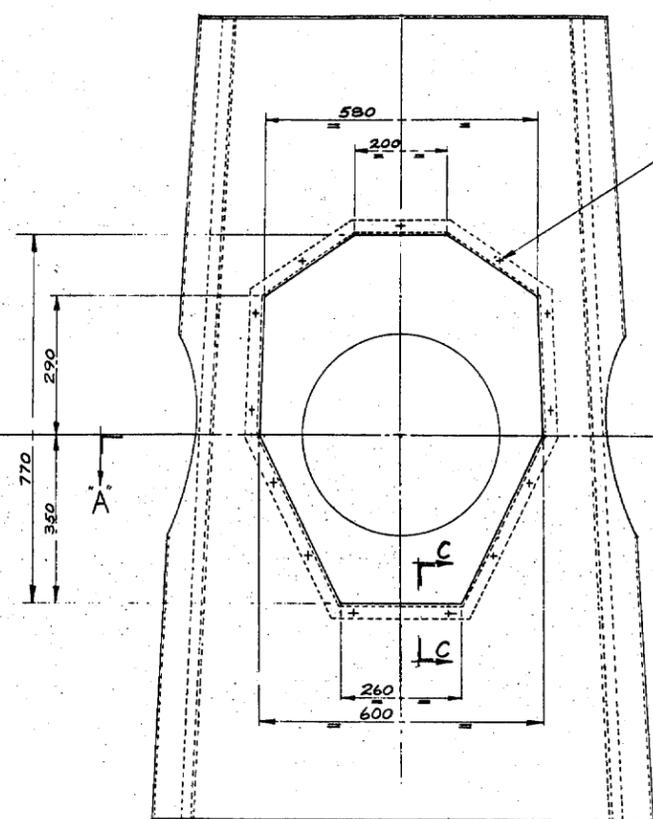
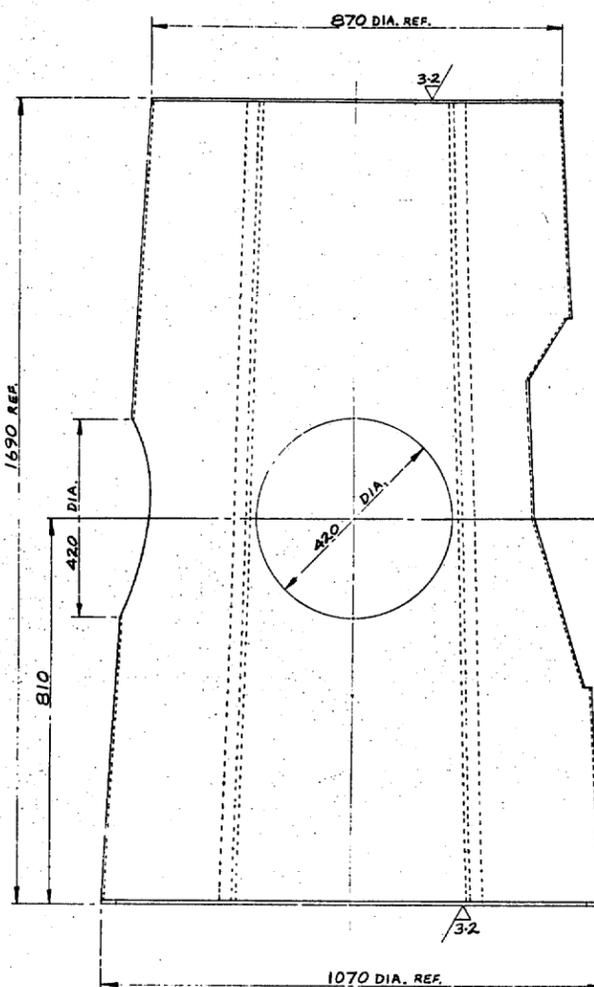
- 1 TO BE STRESS RELIEVED TO BS.1500-1958 SECTION 4 D & GRIT BLASTED
 - 2 PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING
 - 3 ALL WELD SURFACES TO BE CLEAN AND FREE FROM SCALE LAMINATIONS & INCLUSIONS
 - 4 ALL WELDS TO BE CONTINUOUS
 - 5 TO PURCHASE SPEC. N°1 ISSUE 2
 - 6 TO QUALITY CONTROL SCHEDULE Q.C.S. 1/4
 - 7 FINISH PAINT EGGSHELL BLACK.
- NOTE 1:- VANES TO BE PREVENTED FROM DEFORMING DURING STRESS RELIEVING

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL SF5AL BS 4860-STA 2-30V R.R. SHRT.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST ISSUE DATE	FINISH PRINTEG EGGSHELL BLACK
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE NASMYTH LOWER VANE	UNIT No. TC1 253 13
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	WEIGHT 10.21 kg	SCALE 1:1
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	No. OFF PER SET 4	ISSUE A

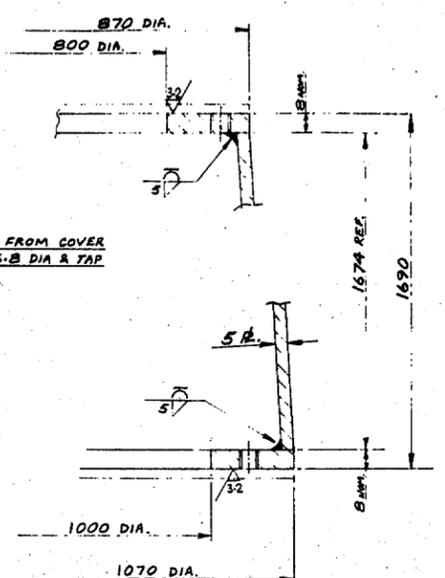


- 1 TO BE STRESS RELIEVED TO BS.1500-1958 SECTION 4 D & GRIT BLASTED
 - 2 PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING
 - 3 ALL WELD SURFACES TO BE CLEAN AND FREE FROM SCALE LAMINATIONS & INCLUSIONS
 - 4 ALL WELDS TO BE CONTINUOUS
 - 5 TO PURCHASE SPEC. N°1 ISSUE 2
 - 6 TO QUALITY CONTROL SCHEDULE Q.C.S. 1/4
 - 7 FINISH PAINT EGGSHELL BLACK.
- NOTE 1:- VANES TO BE PREVENTED FROM DEFORMING DURING STRESS RELIEVING

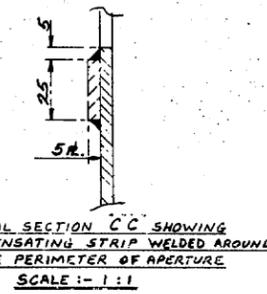
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL SF5AL BS 4860-STA 2-30V R.R. SHRT.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST ISSUE DATE	FINISH PRINTEG EGGSHELL BLACK
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	COST ACCOUNT 253	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE NASMYTH UPPER VANE	UNIT No. TC1 253 14
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	WEIGHT 26.6 kg	SCALE 1:1
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	No. OFF PER SET 2	ISSUE A



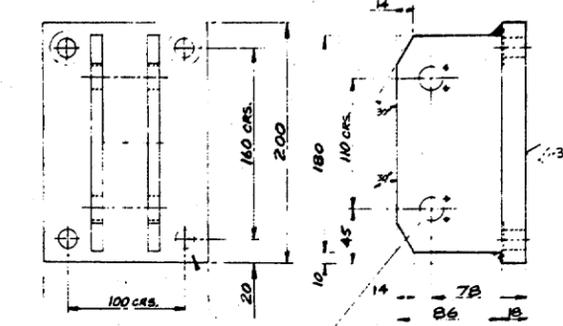
12 HOLES POSITION FROM COVER
TC1 25318 DRILL 6.8 DIA & TAP
M8 x 1.25 THROUGH.



TYPICAL PART SECTION
SCALE: 1:1



TYPICAL SECTION C-C SHOWING
COMPENSATING STRIP WELDED AROUND
INSIDE PERIMETER OF APERTURE
SCALE: 1:1



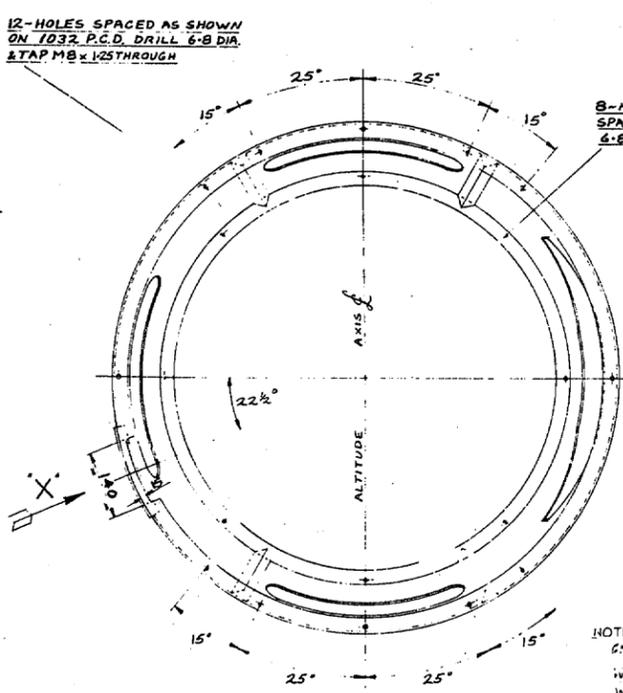
2 HOLES DRILL & REAM THROUGH
20 DIA.
4 HOLES POSITION FROM KEEP PLATE
(TC1 210 08) DRILL 4.2 DIA & TAP
M5 x 0.8

4 HOLES DRILL 18 DIA. THROUGH
SPOTFACE 20 DIA.

TO BE STRESS RELIEVED TO BS 1500-1958
SECTION 4 D & GRIT BLASTED. PAINT WITH PRIMER
IMMEDIATELY AFTER GRIT BLASTING
ALL WELD SURFACES TO BE CLEAN & FREE FROM SCALE,
LAMINATIONS & INCLUSIONS.
ALL WELDS TO BE CONTINUOUS

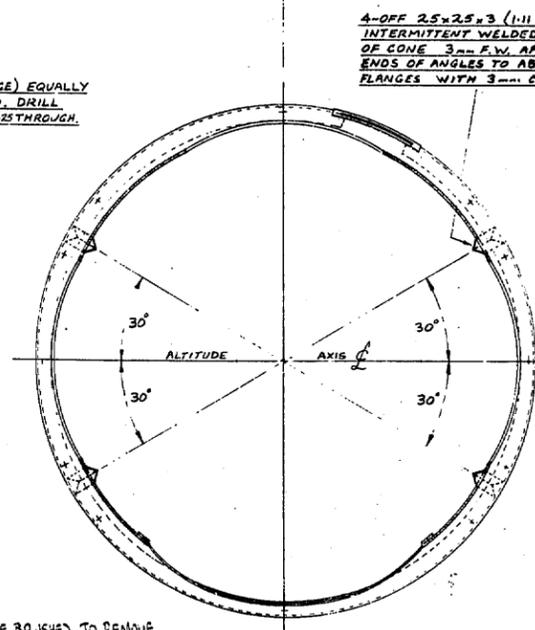
APPROVED
No. 463.05 A
Date 31.7.81

DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST MADE ORD No. 18660	MATERIAL BS 4360-43A
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PART No.
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE VANE BRACKET	
		WEIGHT 4.4 kg	SCALE 1:2
		No. OFF PER SET 4	UNIT No. TC125316



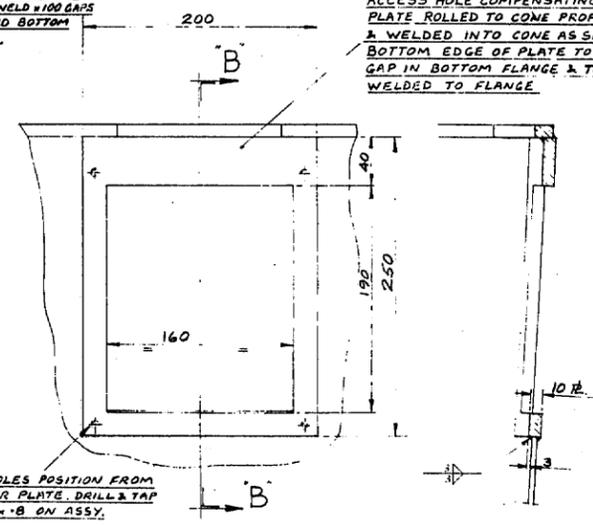
12 HOLES SPACED AS SHOWN
ON 1032 P.C.D. DRILL 6.8 DIA.
& TAP M8 x 1.25 THROUGH

8 HOLES (IN TOP FLANGE) EQUALLY
SPACED ON 846 P.C.D. DRILL
6.8 DIA. & TAP M8 x 1.25 THROUGH.



4 OFF 25x25x3 (1.11 kg/m) ANGLE STIFFENERS
INTERMITTENT WELDED TO INSIDE SURFACE
OF CONE 3mm F.W. APPROX 100 WELD x 100 GAPS
ENDS OF ANGLES TO ABUT TOP AND BOTTOM
FLANGES WITH 3mm CONT. F.W.S.

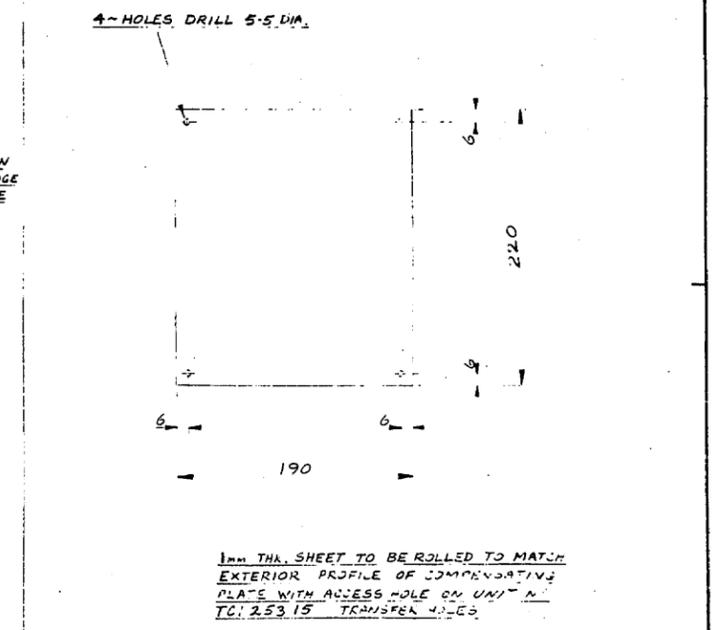
ACCESS HOLE COMPENSATING
PLATE ROLLED TO CONE PROFILE
& WELDED INTO CONE AS SHOWN
BOTTOM EDGE OF PLATE TO BRIDGE
GAP IN BOTTOM FLANGE & TO BE
WELDED TO FLANGE



ENLARGED VIEW ON ARROW X
SCALE: 1:2

SECTION BB

DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST MADE ORD No. 18660	MATERIAL BS 4360-43A
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PART No.
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE NASMYTH ENCLOSURE	
		WEIGHT 198 kg	SCALE 1:1
		No. OFF PER SET 1	UNIT No. TC125315



1mm THK. SHEET TO BE ROLLED TO MATCH
EXTERIOR PROFILE OF COMPENSATING
PLATE WITH ACCESS HOLE ON UNIT No.
TC1 25315 TRANSFER 4 HOLES

AS BUILT DRAWINGS
This drawing shows all quantities to this work

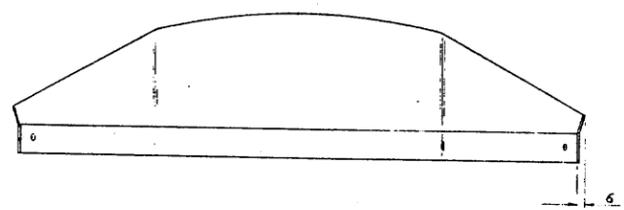
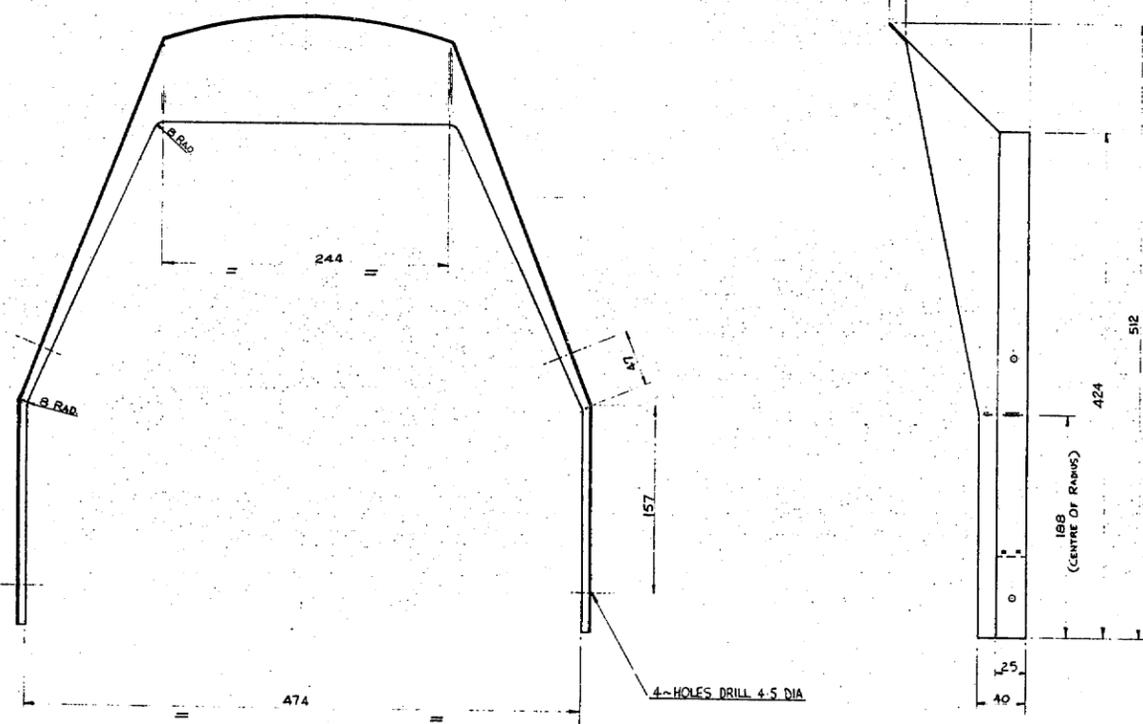
APPROVED
No. 463.05 A
Date 31.7.81

DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST MADE ORD No. 18660	MATERIAL BS 4360-43A
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 253	PART No.
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE COVER PLATE	
		WEIGHT 2.2 kg	SCALE 1:2
		No. OFF PER SET 1	UNIT No. TC125317

NOTE
OPERATION TO BE WIRE BRUSHED TO REMOVE
WELD SPATTER & SURFACE RUST & PRIMED
WITH ANODITE BEFORE MACHINING. ALL WELD
SURFACES TO BE CLEAN & FREE FROM SCALE,
LAMINATIONS AND INCLUSIONS.
ALL WELDS TO BE CONTINUOUS
LONGITUDINAL SEAM TO BE A FULL PENETRATION
BUTT WELD DRESSED OFF ON OUTSIDE.

SECTION AA

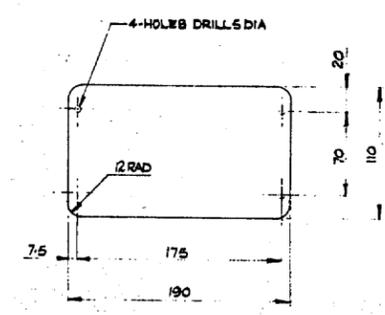
Royal Greenwich Observatory
La Palma Division
APPROVED
No. 463.05 A
Date 31.7.81



NOTE ALL JOINTS TO BE BRAZED

Royal Greenwich Observatory
La Plata Division
APPROVED
No. 701-025-23 Rev. A
Date 26.1.82 by 2557

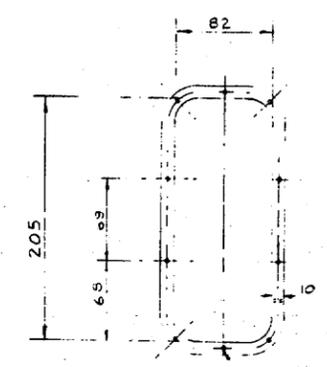
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 18 S.W.G. M/S
		FIRST ISSUE DATE	
		COST ACCOUNT 253	FINISH
			PART No.
		TITLE SEALING GUSSET	
		WEIGHT	SCALE 1:2
		No. OFF PER SET 1	UNIT No. TCI 253 23
			ISSUE A



NOTES:
1. BEND PLATE TO SUIT OUTER DIA OF LIGHT BAFFLE UNIT N° TCI 253 04 ON ASSEMBLY
2. THIS DRAWING IS FOR RECORD PURPOSES ONLY AS UNIT HAS BEEN MANUFACTURED TO SKETCH N° OW 923

Royal Greenwich Observatory
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APPROVED
No. 701-025-26 Rev. A
Date 26.1.82 by 2554

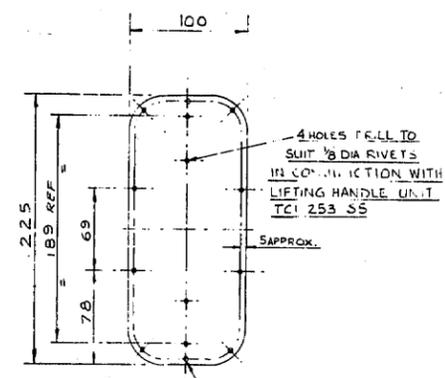
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 S.W.G. MILD STEEL SHEET
		FIRST ISSUE DATE	
		COST ACCOUNT 253	FINISH BRASS
			PART No.
		TITLE COVER PLATE	
		WEIGHT	SCALE 1:2
		No. OFF PER SET 4	UNIT No. TCI 253 24
			ISSUE A



10 HOLES FOR 1/8 DIA RIVETS IN CONNECTION WITH UNITS TCI 253 19 & TCI 253 26

BEND TO SUIT CURVATURE OF ACCESS COVER UNIT TCI 253 19

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118662	MATERIAL 20 S.W.G. MILD STEEL SHEET
		FIRST ISSUE DATE 10-12-82	
		COST ACCOUNT 253	FINISH
			PART No.
		TITLE RECESS GASKET	
		WEIGHT	SCALE 1:2
		No. OFF PER SET 1	UNIT No. TCI 253 25
			ISSUE A



10 HOLES FOR 1/8 RIVETS IN CONNECTION WITH UNITS TCI 253 19 & TCI 253 25

BEND TO SUIT CURVATURE OF RECESS GASKET UNIT TCI 253 25

Royal Greenwich Observatory
La Plata Division
APPROVED
No. 701-025-26 Rev. A
Date 26.1.82 by 2554

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118662	MATERIAL 1/4 S.W.G. STEEL SHEET
		FIRST ISSUE DATE 10-12-82	
		COST ACCOUNT 253	FINISH
			PART No.
		TITLE RECESS PLATE	
		WEIGHT	SCALE 1:2
		No. OFF PER SET 1	UNIT No. TCI 253 26
			ISSUE A