

80

1750

1050

683 Kg (DOES NOT INCLUDE CA 250, 253 OR 255)

POLE OF MAIN MIRROR

ALTITUDE AXIS

SECTION 'E-E'

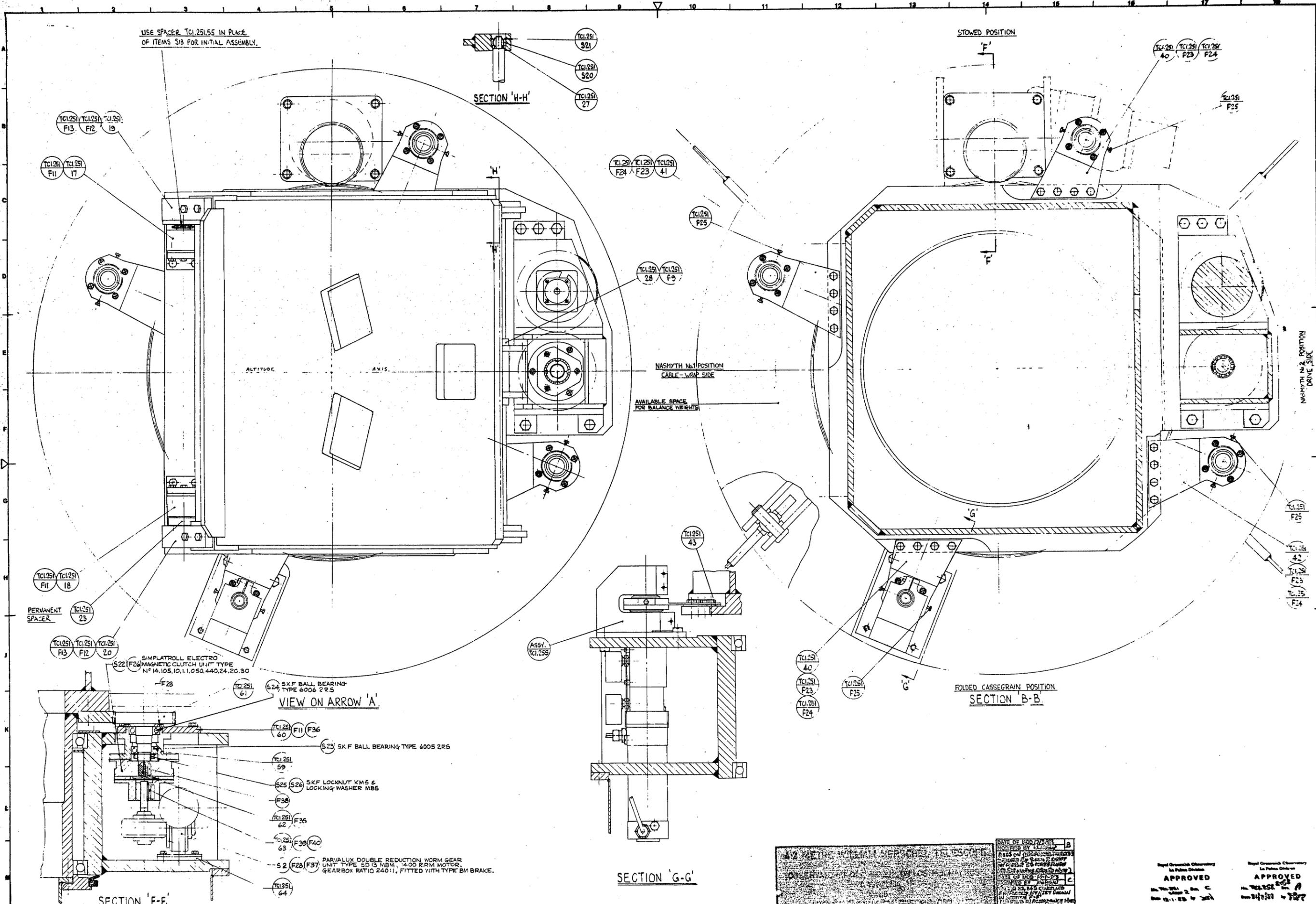
ASSEMBLY PROCEDURE NUMBER:- TC1.251.APL.2 AP2

4.0 METRE WILLIAM HERSCHEL TELESCOPE
 OBSERVATORY OF THE HOUSE OF LAS VICHACHOS
 LA PAZ
 ROYAL GREENWICH OBSERVATORY

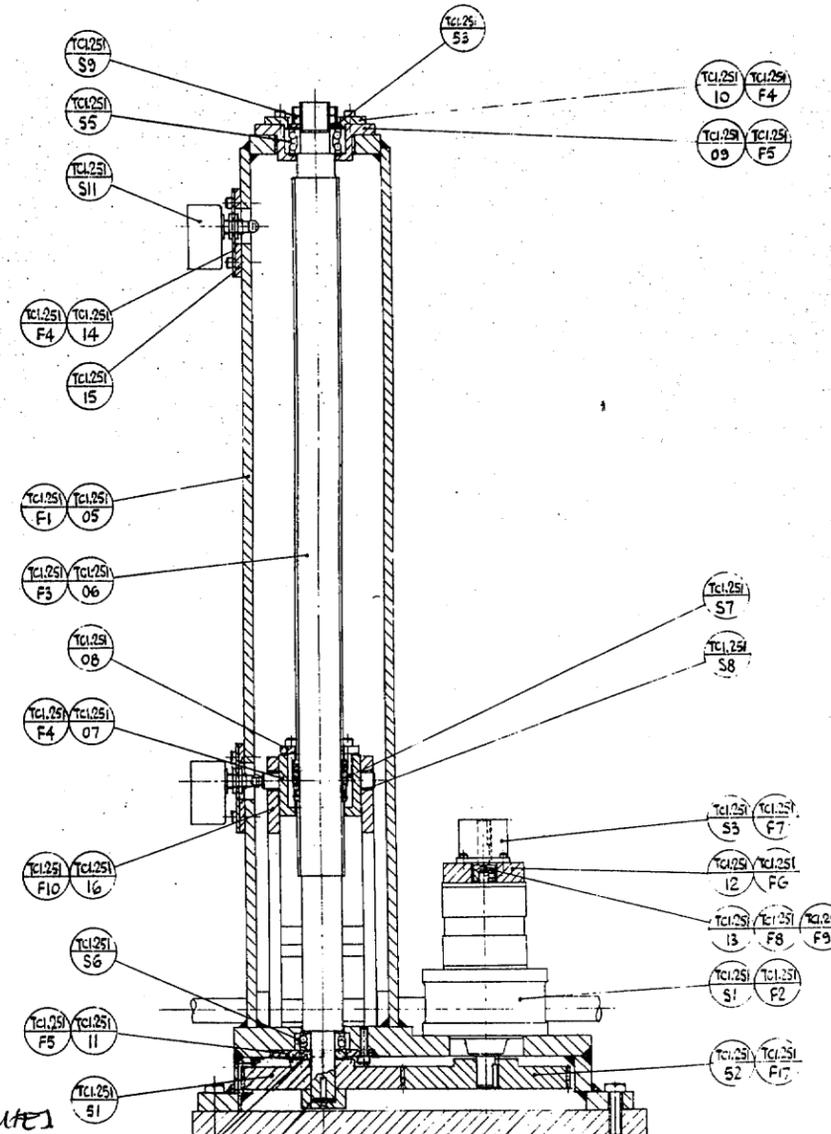
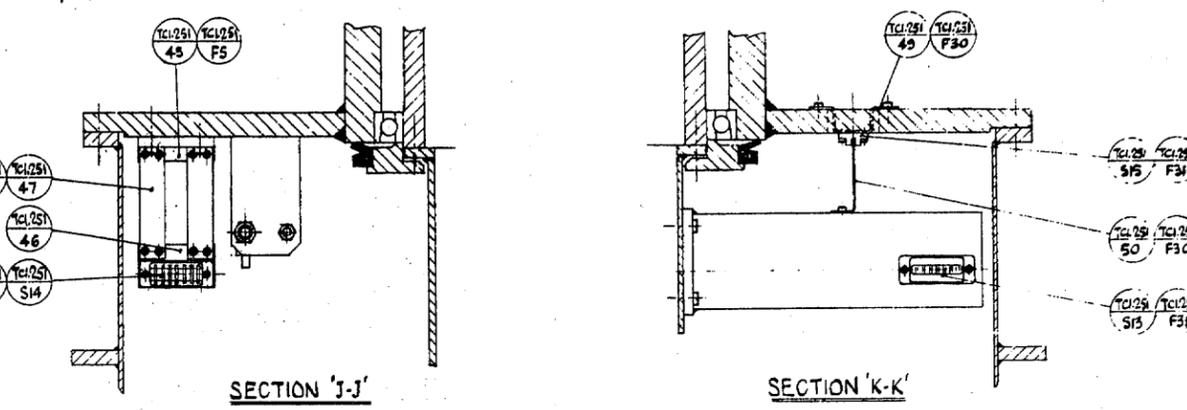
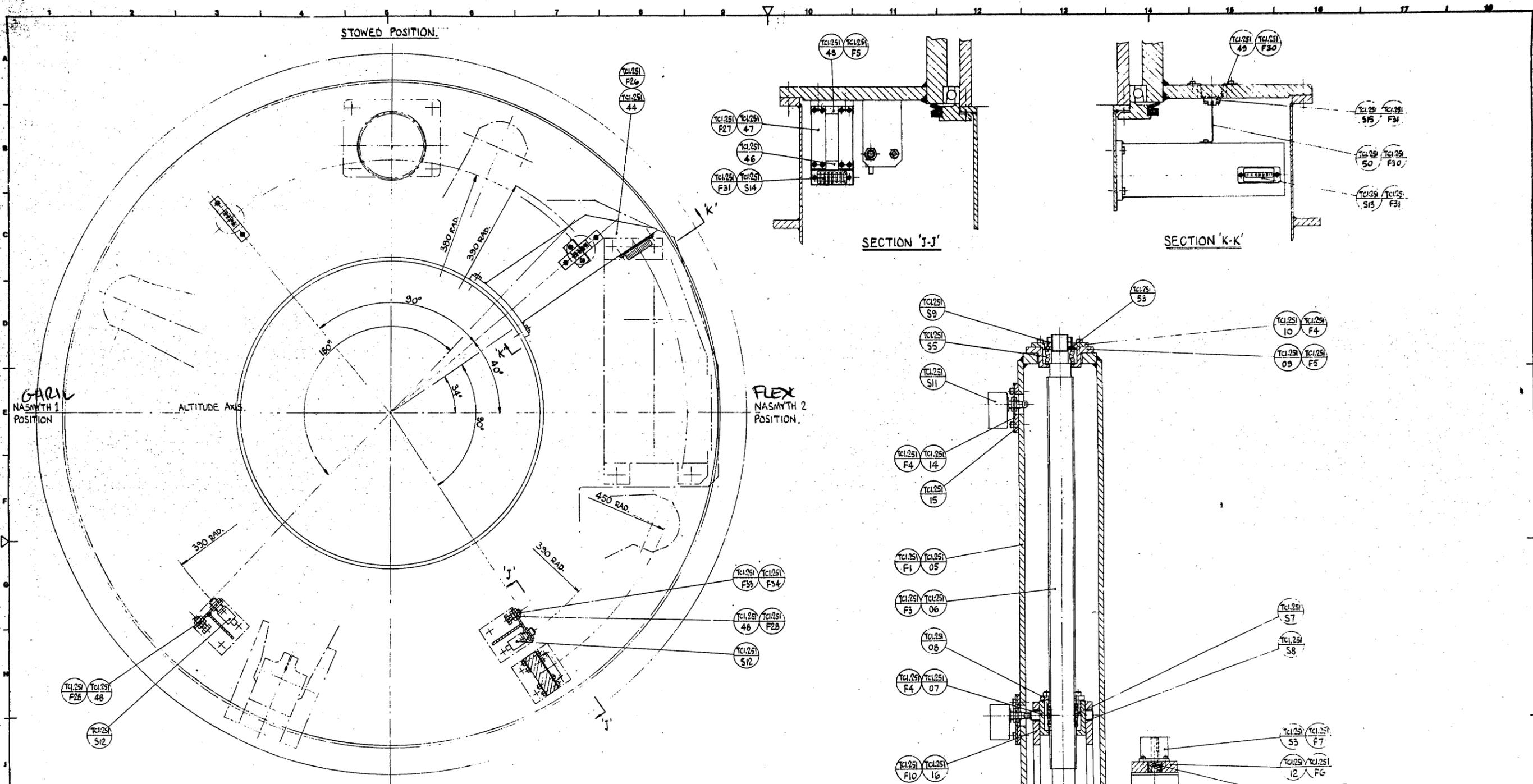
DATE OF MOD. NO. 1-13 MODIFIED BY: A. BROWN	DATE OF MOD. NO. 1-13 MODIFIED BY: A. BROWN
DATE OF MOD. NO. 1-13 MODIFIED BY: A. BROWN	DATE OF MOD. NO. 1-13 MODIFIED BY: A. BROWN

AS BUILT DRAWINGS
 This drawing shows all variations to this work
 APPROVED
 23/11/97

SURFACE FINISH EQUIVALENTS MICRONCHES 4 8 16 32 63 125 250 500 MICROINCHES 3 4 8 16 32 63 125 THIS DRAWING CONFORMS TO B.S. 308	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 2500 ± 0.30 ANGLES ± 1: 500 STRAIGHTNESS/FLATNESS 1: 500	THIS DRAWING IS THE PROPERTY OF HEI PARSONS LTD. AND MUST NOT BE COPIED OR DISCLOSED TO A THIRD PARTY WITHOUT GRUBB PARSONS WRITTEN CONSENT.	GENERAL TOLERANCES UNLESS OTHERWISE SPECIFIED DIMENSIONS UP TO 250 ± 0.20 DIMENSIONS FROM 250 TO 2500 ± 0.30 DIMENSIONS OVER 2500 ± 0.50 ANGLES ± 1: 500 STRAIGHTNESS/FLATNESS 1: 500	ALL DIMENSIONS ARE IN MILLIMETRES ANGLE ± 1: 500 SCREW THREADS TO B.S. 3449 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO D1 T.J.R.	PROJECTION FIRST ANGLE DRAWN: A. BROWN DATE: 23/11/97	GRUBB PARSONS NEWCASTLE UPON TYNE NE6 2YB TITLE: 4.0 METRE TELESCOPE ASSEMBLY OF NASHMYTH TURNTABLE. SCALE: 1:2 SHEET: TC1.251
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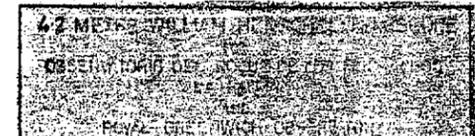


Grubb Parsons A member of Clarke Chapman and Rowlett Parsons	SURFACE FINISH EQUIVALENTS MICROMETRES: 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 MICROINCHES: 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 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	SURFACE FINISH SYMBOLS ✓ DENOTES NOT NECESSARILY MACHINED ✗ DENOTES MACHINED	WELD SYMBOLS TO BS 489 PART 2 1969	FABRICATION TOLERANCES DIMENSIONS UP TO 250 ± 0.20 DIMENSIONS FROM 250 TO 2000 ± 0.30 DIMENSIONS FROM 2000 TO 10000 ± 0.50 DIMENSIONS WITH OVER ± 0.1 STRAIGHTNESS/FLATNESS 1:1000	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 MACHINING TOLERANCES EXCEPT WHERE STATED OTHERWISE UNFINISHED DIMENSIONS ± 0.25 FINISHED DIMENSIONS ± 0.1 DIMENSIONS WITH OVER ± 0.1	ALL DIMENSIONS ARE IN MILLIMETRES ANGLES ± 0.5° SCREW THREADS TO B.S. 3643 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO 0.1 T.K.	GRUBB PARSONS NEWCASTLE UPON TYNE NE5 2YB TITLE: 4.2 METRE TELESCOPE ASSEMBLY OF NASMYTH TURNABLE SCALE: 1:1 TCl.251	SHEET 2 OF 3
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FOLDED CASSEGRAIN POSITION
SECTION 'C-C' (SWITCH ASSEMBLY).
(MIRROR IN NASMYTH 1 POSITION).
GHRIL.

NOTE: BROKEN CASE 2 NAS1 (GHRIL) HAVE OPTICAL SENSORS.
STOWED 2 NAS2 (FLEX) HAVE END STOP LIMIT SWITCHES



SECTION 'D-D'

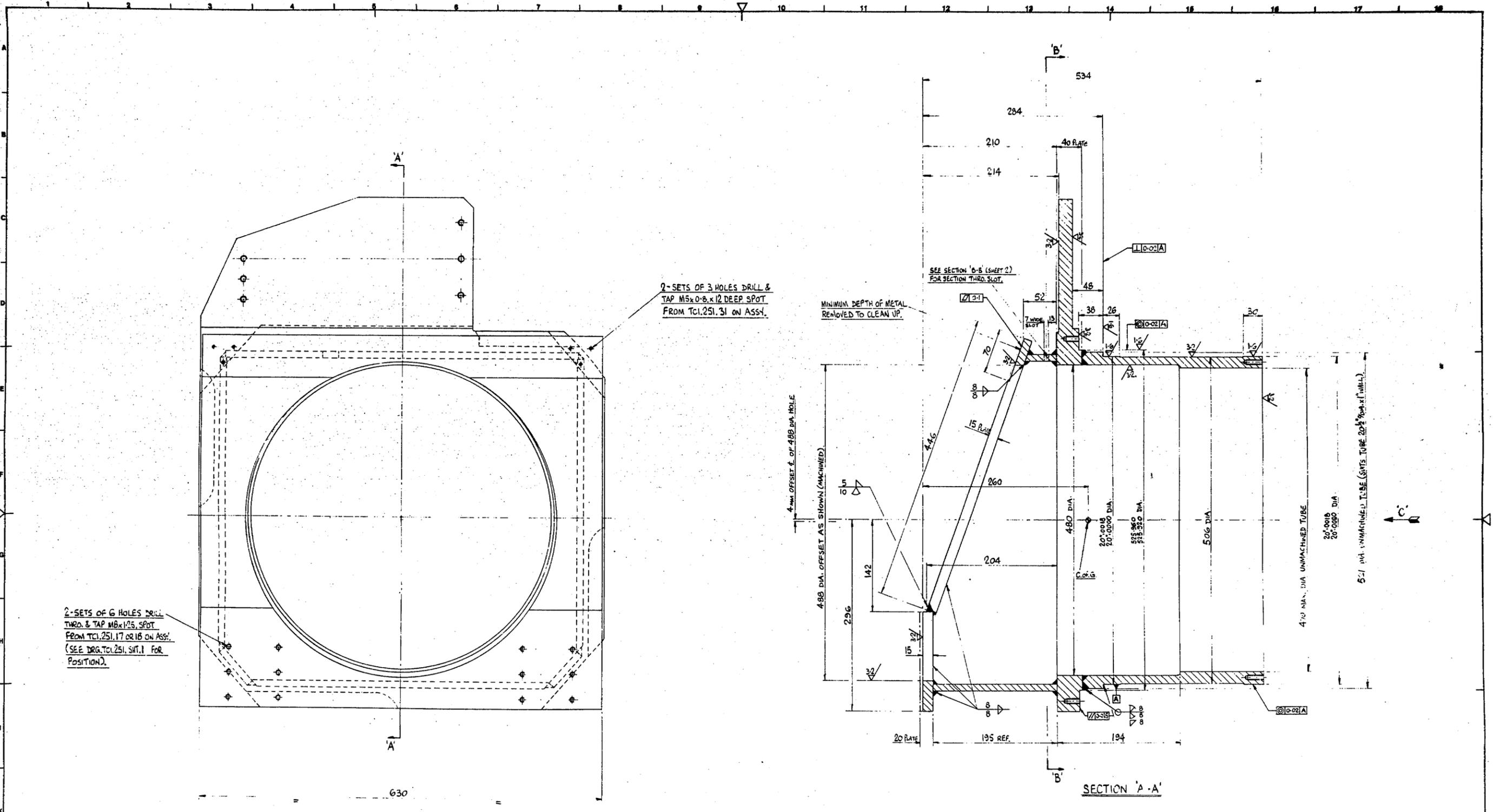
AS BUILT DRAWINGS
This drawing shows all reactions to this work

DATE OF MOD 13-1-69 DRAWN BY: [Signature] CHECKED BY: [Signature] APPROVED BY: [Signature]	DATE OF MOD 13-1-69 DRAWN BY: [Signature] CHECKED BY: [Signature] APPROVED BY: [Signature]
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Approved
La Palma Station
No. TCI. 251. 1969. C
Date 20.1.69 by [Signature]

Approved
La Palma Station
No. TCI. 251. 1969. B
Date 20.1.69 by [Signature]

Approved
La Palma Station
No. TCI. 251. 1969. A
Date 20.1.69 by [Signature]



2-SETS OF 6 HOLES DRILL THRO. & TAP M8x1.25, SPOT FROM TCI.251.17 OR 18 ON ASSY. (SEE DRG. TCI.251.1 FOR POSITION).

2-SETS OF 3 HOLES DRILL & TAP M5x0.8x12 DEEP SPOT FROM TCI.251.31 ON ASSY.

MINIMUM DEPTH OF METAL REMOVED TO CLEAN UP.

SEE SECTION 'B-B' (SHEET 2) FOR SECTION THRO. SLOT.

4mm OFFSET ± OF 488 DIA HOLE

488 DIA. OFFSET AS SHOWN (MACHINED)

506 DIA. UNMACHINED TUBE (SITS TUBE 204 DIA. UNMACHINED TUBE)

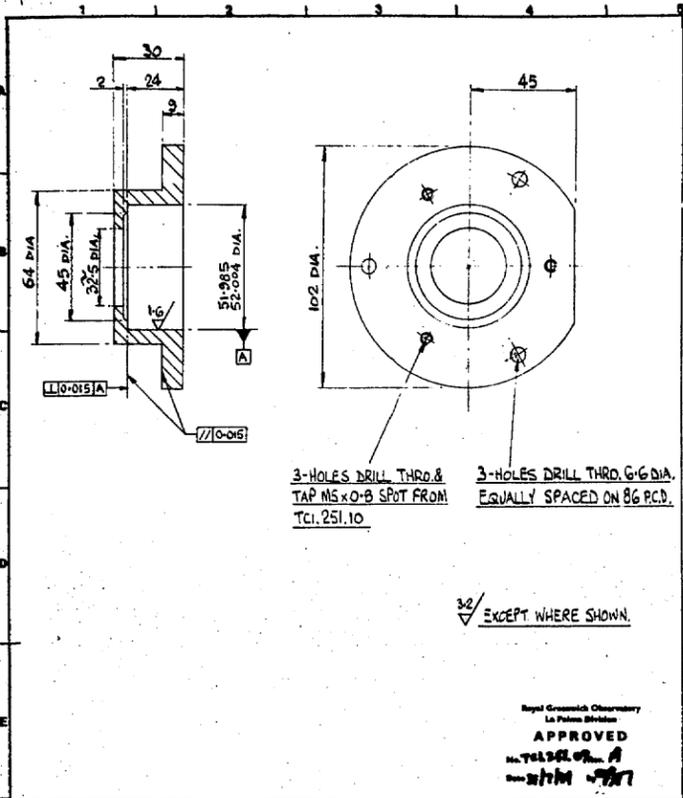
SECTION 'A-A'

- NOTES:-
- 1/ TO BE STRESS RELIEVED TO BS1500-1958 SECTION 4 D & GRIT BLASTED. PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING.
 - 2/ ALL WELD SURFACES ARE TO BE CLEAN & FREE FROM SCALE, LAMINATIONS AND INCLUSIONS.
 - 3/ ALL WELDS TO BE CONTINUOUS.
 - 4/ TO PURCHASE SPEC. No. 1 ISSUE 2
 - 5/ TO QUALITY CONTROL SCHEDULE Q.C.S. 1/4

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

APPROVED
T.C.I. 251.03

SURFACE FINISH EQUIVALENTS MICROMETRES: 4 8 12 20 30 50 100 MICROINCHES: 1 2 4 8 16 32 63 125		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 ± 1:100 STRAIGHTNESS/FLATNESS 1:100		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 MACHINING TOLERANCES (EXCEPT WHERE STATED OTHERWISE) UNFINISHED SURFACES ± 0.15 FINISHED SURFACES ± 0.075 ANGLES ± 0.5 UNMACHINED SURFACES ± 0.1 AND DESIGN SIGN.		ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED ANGLES = SCREEN THREADS TO B.S. 3643 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO 0.1 T.L.L.		DATE OF MOD. APPROVED BY DATE OF MOD. APPROVED BY		DATE OF MOD. APPROVED BY DATE OF MOD. APPROVED BY		FIRST MADE ORD. NO. 11822 FIRST ISSUE DATE COST ACCOUNT 251 PART NO.		MATERIAL BS 4360-43A FORM GRUBB PARSONS		SCALE 1/2 UNIT NO. TCI.251.03 REV. A		GRUBB PARSONS NEWCASTLE UPON TYNE NES 2YB 4.2 METRE TELESCOPE DETAILS OF NASMYTH TURNABLE.		SECTION 1 OF 2 T.C.I.251.03	
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3-HOLES DRILL THRO. & TAP MS X 0.8 SPOT FROM TCI.251.10

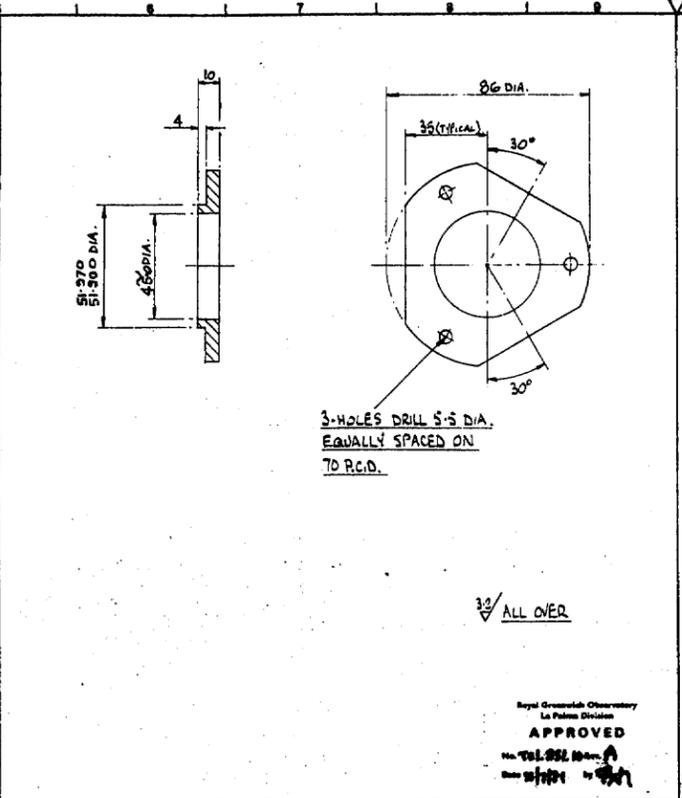
3-HOLES DRILL THRO. 6/6 DIA. EQUALLY SPACED ON 86 R.C.D.

3-HOLES DRILL THRO. 6/6 DIA. EQUALLY SPACED ON 70 R.C.D.

3/2 EXCEPT WHERE SHOWN.

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.09
Date 21/11/71

DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE BEARING HOUSING			
		WEIGHT 0.6 Kg	SCALE 1/4	UNIT No. TCI.251.09	ISSUE No. A

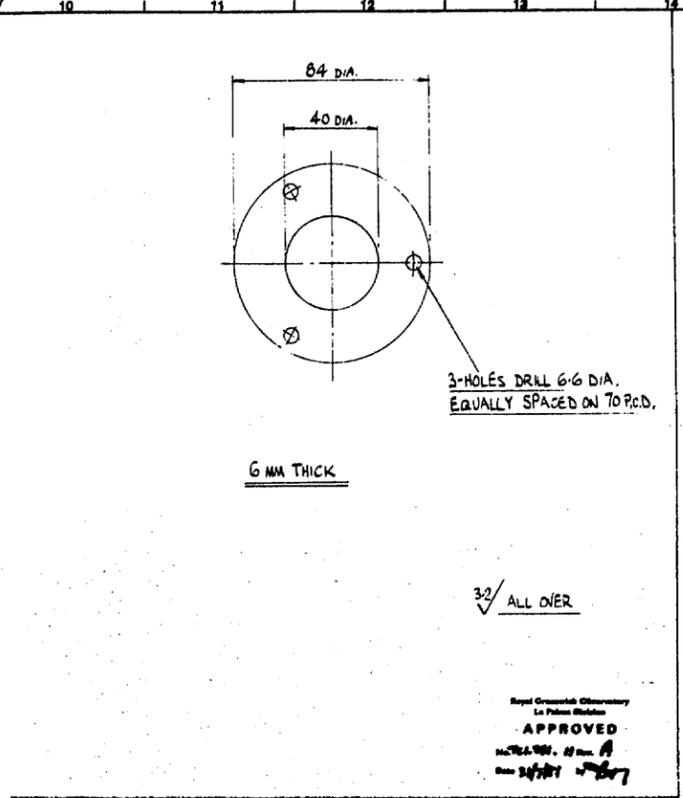


3-HOLES DRILL 5/5 DIA. EQUALLY SPACED ON 70 R.C.D.

3/2 ALL OVER

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.10
Date 21/11/71

DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE BEARING CLAMPING PLATE			
		WEIGHT 0.16 Kg	SCALE 1/4	UNIT No. TCI.251.10	ISSUE No. A

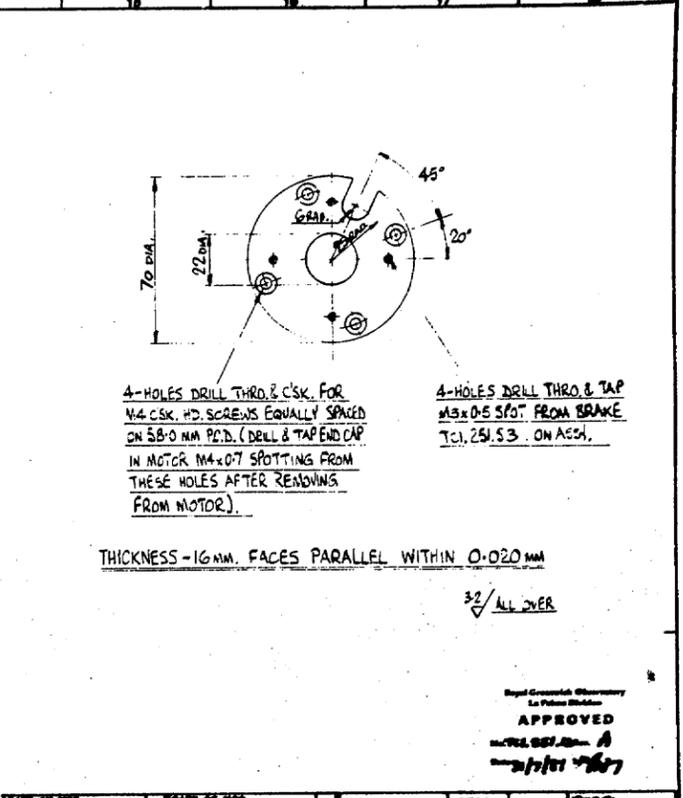


2-HOLES DRILL 6/6 DIA. EQUALLY SPACED ON 70 R.C.D.

3/2 ALL OVER

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.11
Date 21/11/71

DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE BEARING CLAMPING PLATE			
		WEIGHT 0.12 Kg	SCALE 1/4	UNIT No. TCI.251.11	ISSUE No. A



4-HOLES DRILL THRO. & C.S.K. FOR 1/4 C.S.K. HD. SCREWS EQUALLY SPACED ON 58.0 MM P.C.D. (DELL & TAP END CAP IN MOTOR 1M x 0.7 SPOTTING FROM THESE HOLES AFTER REMOVING FROM MOTOR).

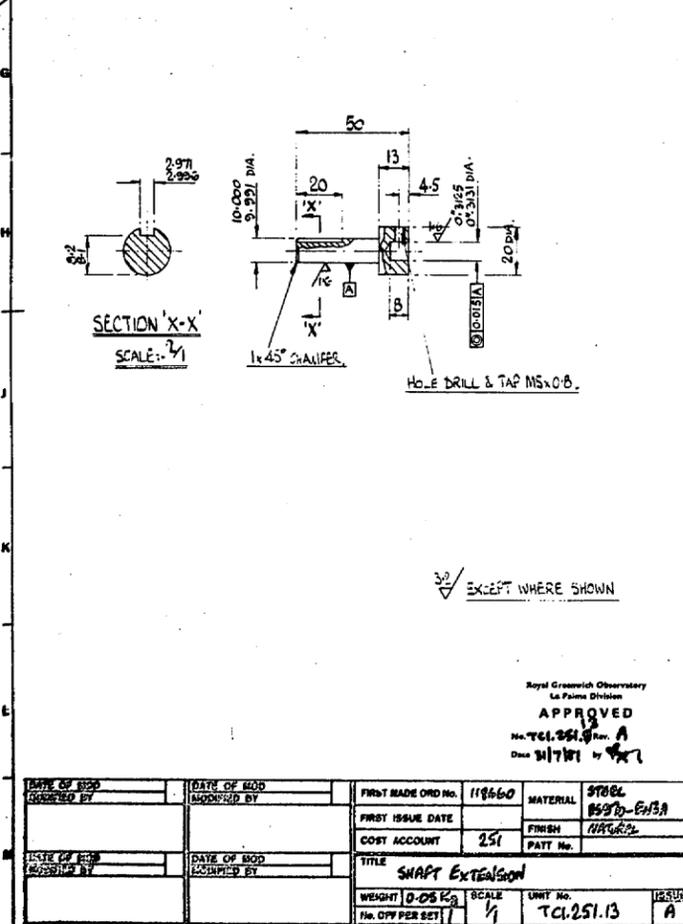
4-HOLES DRILL THRO. & TAP M3 x 0.5 SPOT FROM BRAKE TCI.251.53 ON ACCH.

THICKNESS - 16 MM. FACES PARALLEL WITHIN 0.020 MM

3/2 ALL OVER

Royal Greenwich Observatory
La Palma Division
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No. TCI.251.12
Date 21/11/71

DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE MOTOR/BRAKE ASSEMBLY PLATE			
		WEIGHT 0.47 Kg	SCALE 1/4	UNIT No. TCI.251.12	ISSUE No. A



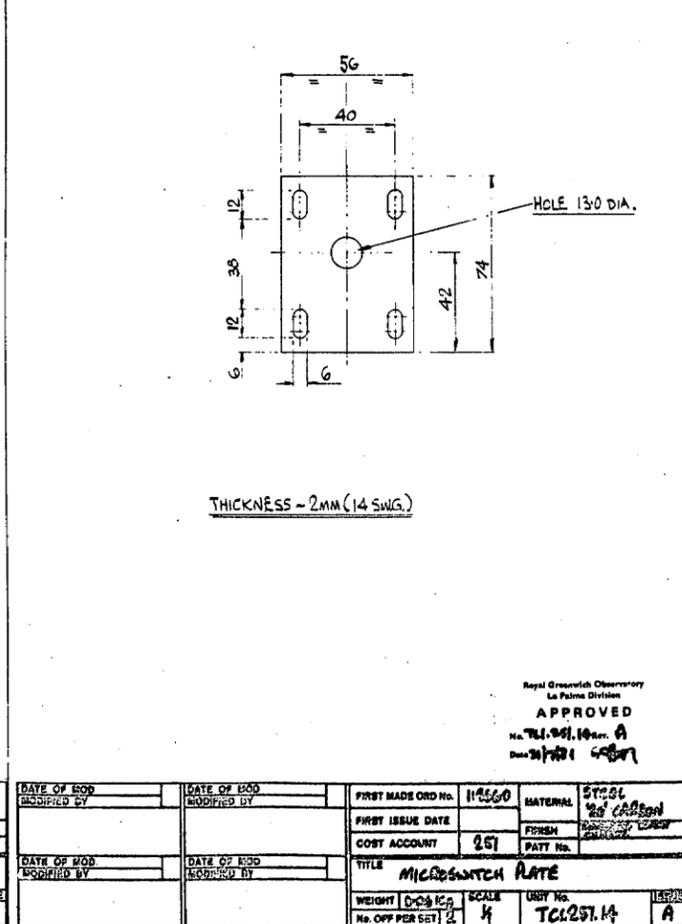
SECTION 'X-X'
SCALE: 1/1

1 HOLE DRILL & TAP MS X 0.8.

3/2 EXCEPT WHERE SHOWN.

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No. TCI.251.13
Date 21/11/71

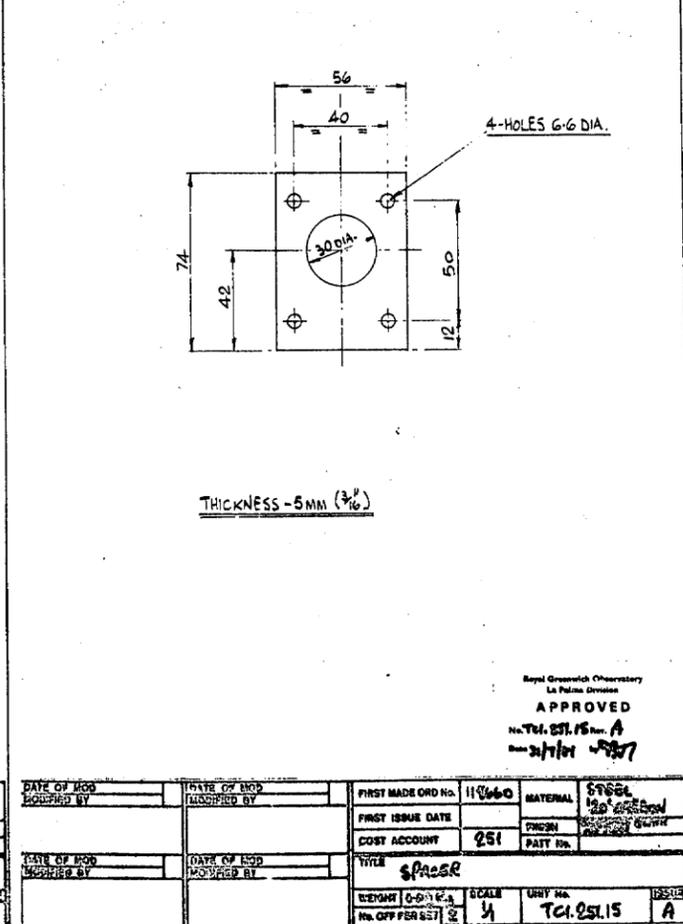
DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE SHAFT EXTENSION			
		WEIGHT 0.05 Kg	SCALE 1/4	UNIT No. TCI.251.13	ISSUE No. A



THICKNESS - 2MM (14 SWG.)

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.14
Date 21/11/71

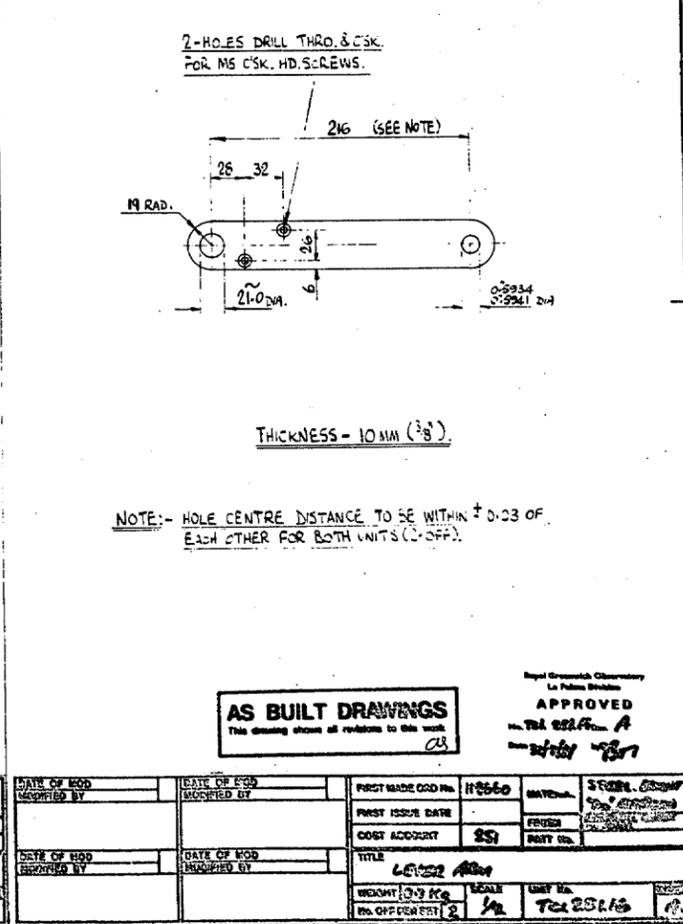
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		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE MICROSWITCH PLATE			
		WEIGHT 0.08 Kg	SCALE 1/4	UNIT No. TCI.251.14	ISSUE No. A



THICKNESS - 5MM (3/16)

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.15
Date 21/11/71

DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE SPACER			
		WEIGHT 0.02 Kg	SCALE 1/4	UNIT No. TCI.251.15	ISSUE No. A



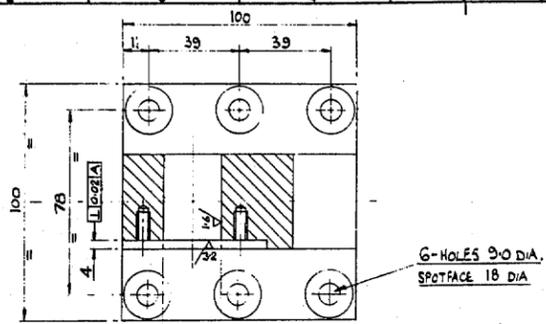
THICKNESS - 10MM (3/8)

NOTE:- HOLE CENTRE DISTANCE TO BE WITHIN ± 0.03 OF EACH OTHER FOR BOTH UNITS (C-3FF).

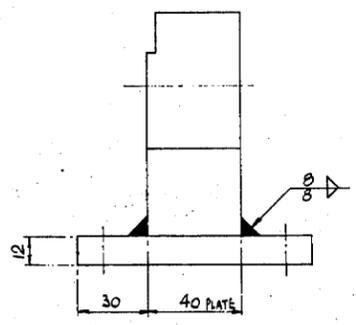
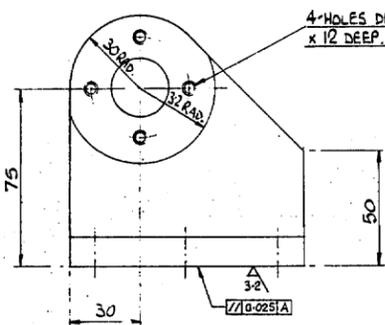
AS BUILT DRAWINGS
This drawing shows all relations to this work

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.16
Date 21/11/71

DATE OF MOD. RECEIVED BY	DATE OF MOD. RECEIVED BY	FIRST MADE ORD. No. 118660	MATERIAL STEEL	FINISH	PART No.
		FIRST ISSUE DATE			
		COST ACCOUNT 251			
		TITLE LENS CELL			
		WEIGHT 0.33 Kg	SCALE 1/4	UNIT No. TCI.251.16	ISSUE No. A

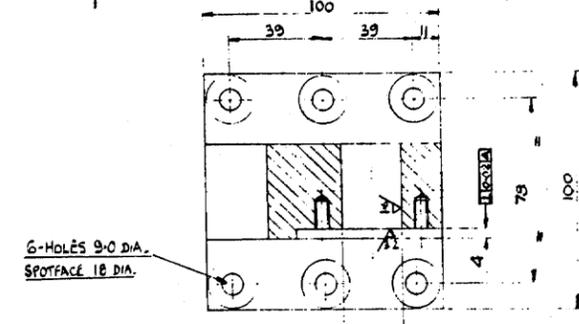


- NOTES:-**
- 1/ TO BE STRESS RELIEVED TO BS1500-1958 SECTION 4D AND GRIT BLASTED. PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING.
 - 2/ ALL WELD SURFACES TO BE CLEAN AND FREE FROM SCALE, LAMINATIONS & INCLUSIONS.
 - 3/ ALL WELDS TO BE CONTINUOUS.
 - 4/ TO PURCHASE SPEC. NO.1 ISSUE 2.
 - 5/ TO QUALITY CONTROL SCHEDULE Q.C.S.1/4.

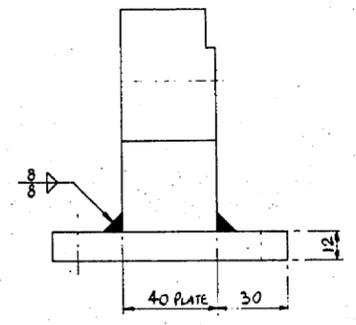


Royal Greenwich Observatory
La Palma Division
APPROVED
No. TOL 251.17
Date 2/1/81 by [Signature]

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL
		FIRST ISSUE DATE	BS4360-43A
		COST ACCOUNT 251	FINISH
			PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Pivot Bracket	
		WEIGHT 31 kg	SCALE 1/4
		UNIT No. TOL 251.17	ISSUE A

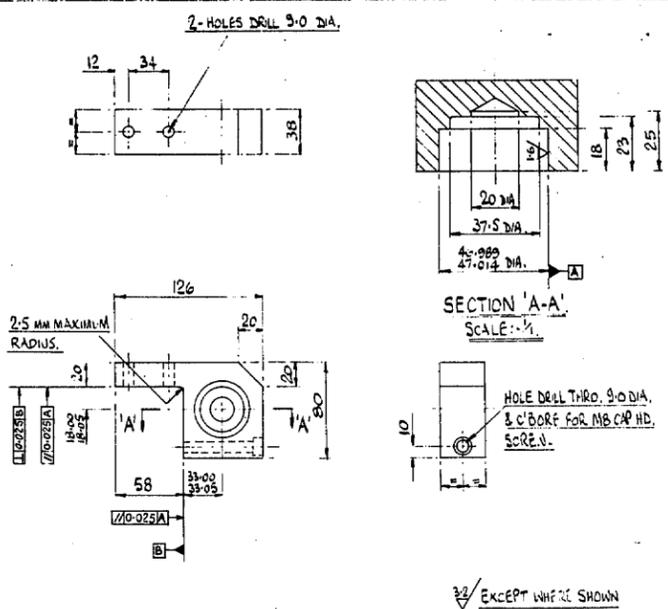
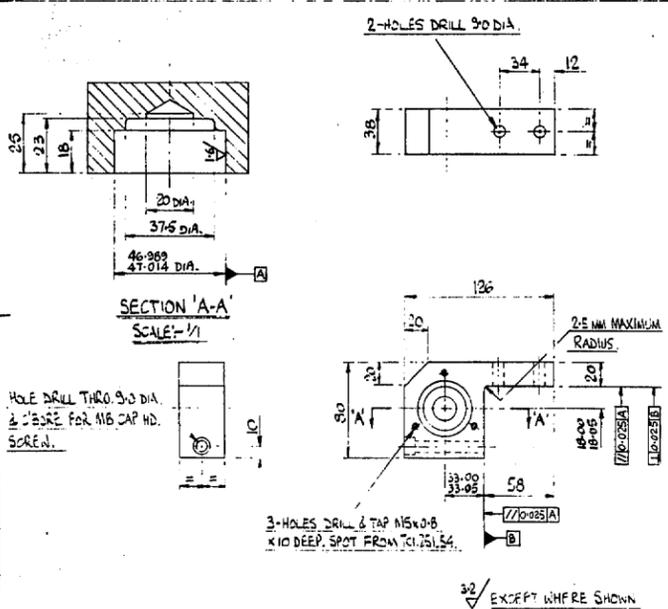


- NOTES:-**
- 1/ TO BE STRESS RELIEVED TO BS1500-1958 SECTION 4D AND GRIT BLASTED. PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING.
 - 2/ ALL WELD SURFACES TO BE CLEAN AND FREE FROM SCALE, LAMINATIONS & INCLUSIONS.
 - 3/ ALL WELDS TO BE CONTINUOUS.
 - 4/ TO PURCHASE SPEC. NO.1 ISSUE 2.
 - 5/ TO QUALITY CONTROL SCHEDULE Q.C.S.1/4.



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La Palma Division
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No. TOL 251.18
Date 2/1/81 by [Signature]

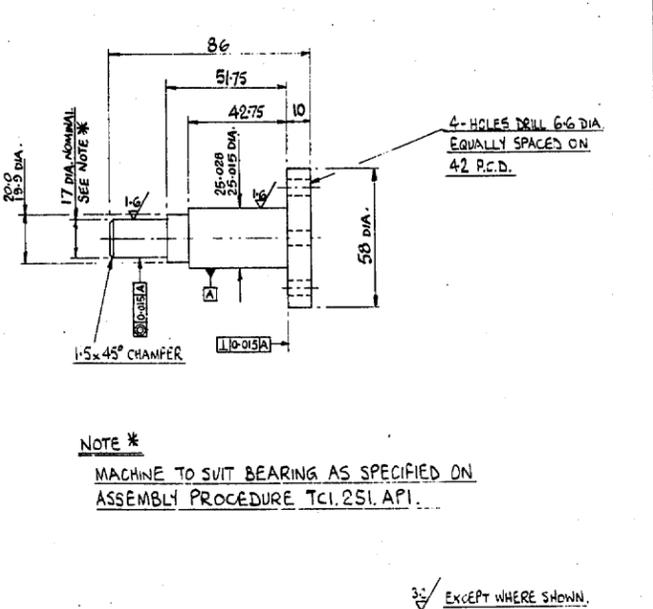
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		FIRST ISSUE DATE	BS4360-43A
		COST ACCOUNT 251	FINISH
			PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Pivot Bracket	
		WEIGHT 31 kg	SCALE 1/4
		UNIT No. TOL 251.18	ISSUE A



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APPROVED
No. TOL 251.19
Date 2/1/81 by [Signature]

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TOL 251.20
Date 2/1/81 by [Signature]

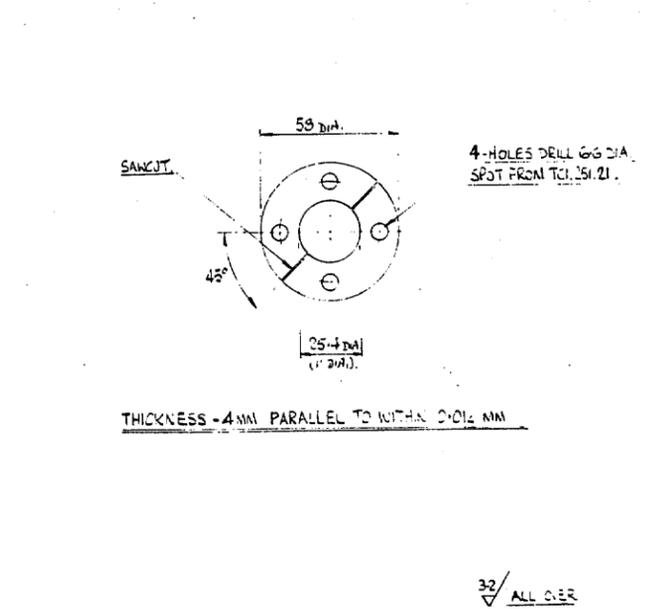
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		FIRST ISSUE DATE	BS4360-43A
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			PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Pivot Block	
		WEIGHT 1.6 kg	SCALE 1/4
		UNIT No. TOL 251.19	ISSUE A



NOTE *
MACHINE TO SUIT BEARING AS SPECIFIED ON ASSEMBLY PROCEDURE TOL 251.17.

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La Palma Division
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No. TOL 251.21
Date 2/1/81 by [Signature]

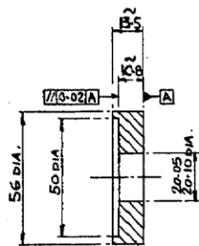
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		FIRST ISSUE DATE	BS4360-43A
		COST ACCOUNT 251	FINISH
			PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Pivot Pin	
		WEIGHT 1.4 kg	SCALE 1/4
		UNIT No. TOL 251.21	ISSUE B



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

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La Palma Division
APPROVED
No. TOL 251.22
Date 2/1/81 by [Signature]

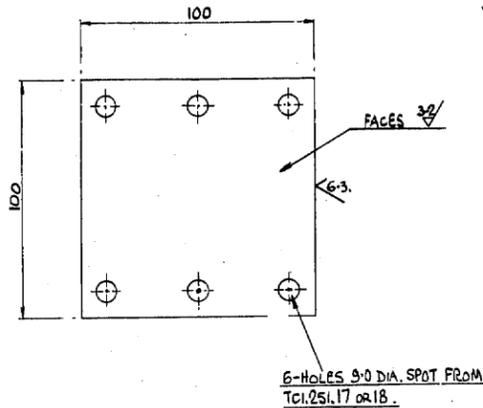
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		FIRST ISSUE DATE	BS4360-43A
		COST ACCOUNT 251	FINISH
			PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE SHW	
		WEIGHT 0.5 kg	SCALE 1/4
		UNIT No. TOL 251.22	ISSUE A



32/ ALL OVER

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.23 Rev. A
Date 31.7.81

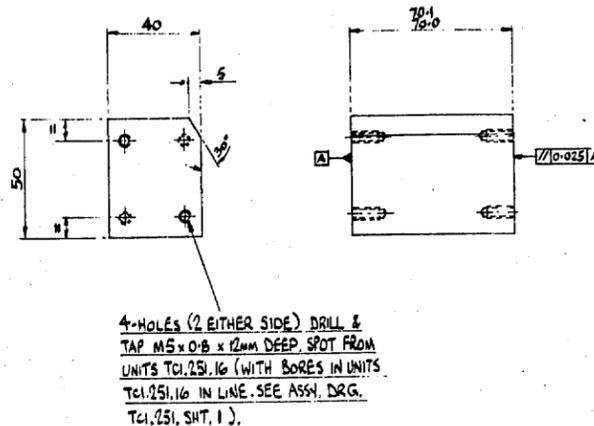
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE SPACER		
		WEIGHT 0.03 Kg	SCALE 1/4	UNIT No. TCI.251.23
		No. OFF PER SET 1		REVISION A



THICKNESS FIXED ON ASSEMBLY

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.24 Rev. A
Date 31.7.81

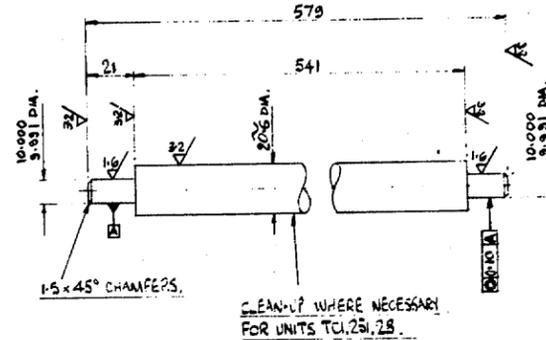
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE SHIM		
		WEIGHT 0.39 Kg	SCALE 1/4	UNIT No. TCI.251.24
		No. OFF PER SET 2		REVISION A



32/ ALL OVER

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.25 Rev. A
Date 31.7.81

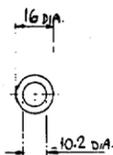
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE LEVER ARM BLOCK		
		WEIGHT 1.1 Kg	SCALE 1/4	UNIT No. TCI.251.25
		No. OFF PER SET 1		REVISION A



MAKE FROM 5/8" DIA. BAR

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.26 Rev. A
Date 31.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE ASSEMBLY ROD		
		WEIGHT 1.41 Kg	SCALE 1/4	UNIT No. TCI.251.26
		No. OFF PER SET 1		REVISION A

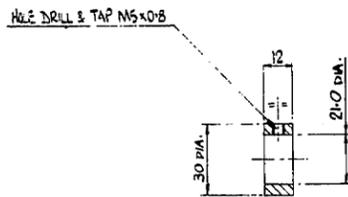


THICKNESS FIXED ON ASSEMBLY - NOMINALLY 4 MM.

32/ ALL OVER

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.27 Rev. A
Date 31.7.81

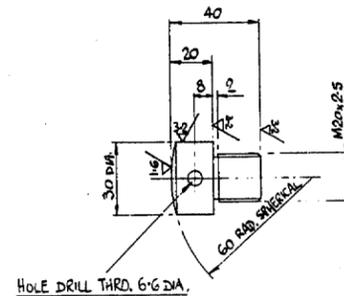
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE SPACER		
		WEIGHT -	SCALE 1/4	UNIT No. TCI.251.27
		No. OFF PER SET 1		REVISION A



32/ ALL OVER

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.28 Rev. A
Date 31.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE COLLAR		
		WEIGHT 0.55 Kg	SCALE 1/4	UNIT No. TCI.251.28
		No. OFF PER SET 2		REVISION A



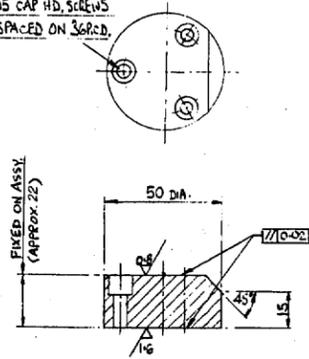
NOTE:-
HARDEN TO 50/55 ROCKWELL 'C'
AFTER MACHINING & DRILLING.

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.29 Rev. A
Date 31.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL STEEL	SYMBOL
		FIRST ISSUE DATE	FINISH	251
		COST ACCOUNT	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE LOCATING PAD		
		WEIGHT 0.15 Kg	SCALE 1/4	UNIT No. TCI.251.29
		No. OFF PER SET 2		REVISION A

AS BUILT DRAWINGS
This drawing shows of revisions to the work.

3-HOLES DRILL 8 C/BORE x 8 DEEP.
TO SUIT M5 CAP HD. SCREWS
EQUALLY SPACED ON 36R.D.



NOTE:-
HARDEN TO 50/55 ROCKWELL 'C'
AFTER MACHINING & DRILLING.

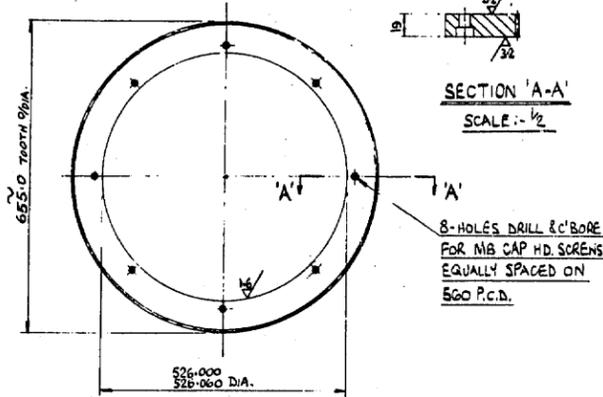
3/2 EXCEPT WHERE SHOWN.

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.31
Date 17/5/82

GEAR SPECIFICATION:-

P.C.D. 650 MM
No. OF TEETH 260
MODULE 2.5
PRESSURE ANGLE 20°
MANUFACTURE TO BS436 GRADE 12
TO MESH WITH UNIT TCI.251.33.

SECTION 'A-A'
SCALE: 1/2



8-HOLES DRILL 8 C/BORE
FOR M16 CAP HD. SCREWS
EQUALLY SPACED ON
560 P.C.D.

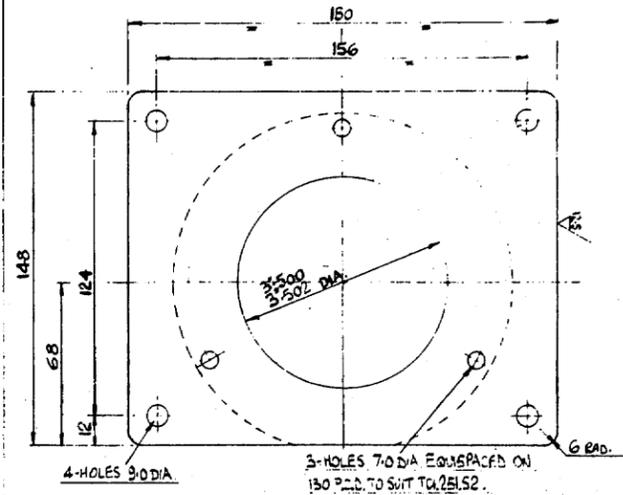
Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.32
Date 17/5/82

GEAR SPECIFICATION

P.C.D. 150 MM
No. OF TEETH 60
MODULE 2.5
PRESSURE ANGLE 20°
MANUFACTURE TO BS436 GRADE B
TO MESH WITH UNIT TCI.251.32.

CANCELLED. A BROWN
10-1-83

Royal Greenwich Observatory
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APPROVED
No. TCI.251.33
Date 17/5/82



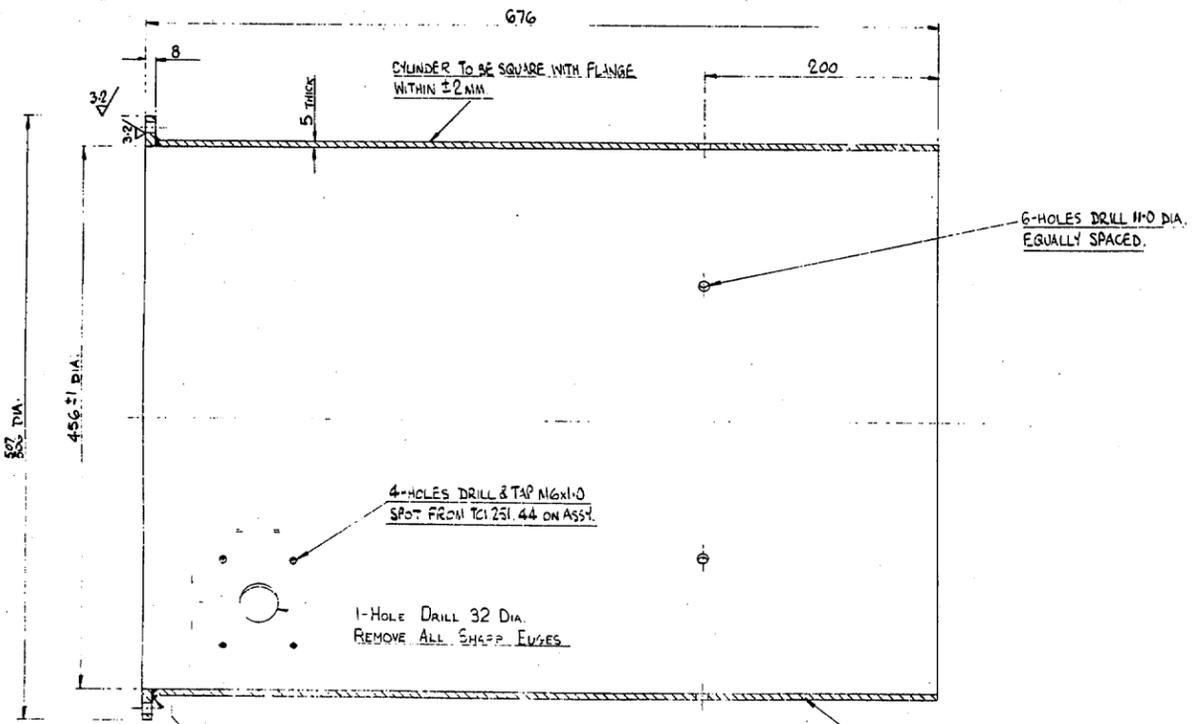
CANCELLED A BROWN
10-1-83

Royal Greenwich Observatory
La Palma Division
APPROVED
No. TCI.251.34
Date 17/5/82

DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST MADE ORD. No. 110660	MATERIAL STEEL
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 251	PATT. No.
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE LOCATION PLATE	
		WEIGHT 0.34 Kg	SCALE 1/4
		No. OFF PER SET 2	UNIT No. TCI.251.31
			ISSUE A

DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST MADE ORD. No. 110660	MATERIAL STEEL
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 251	PATT. No.
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE GEAR	
		WEIGHT 25.8 Kg	SCALE 1/8
		No. OFF PER SET 1	UNIT No. TCI.251.32
			ISSUE A

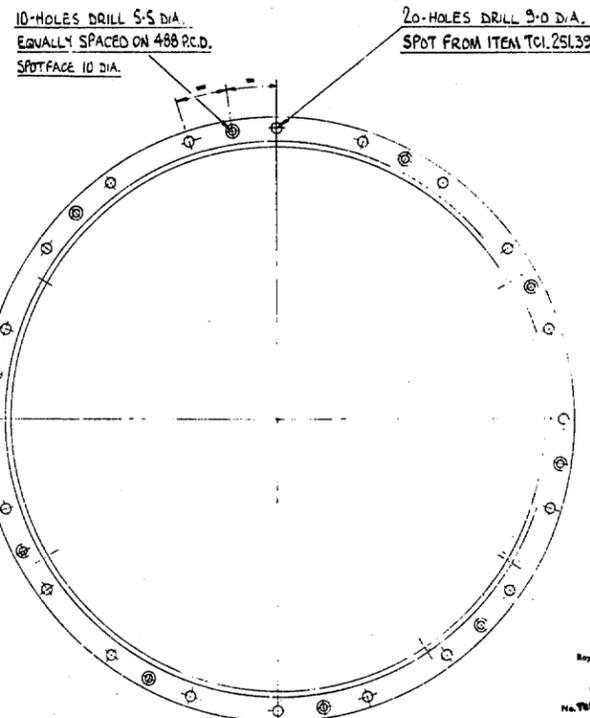
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST MADE ORD. No. 110660	MATERIAL STEEL
		FIRST ISSUE DATE	FINISH
		COST ACCOUNT 251	PATT. No.
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	TITLE BALANCE WEIGHT SUPPORT	
		WEIGHT 10.4 Kg	SCALE 1/8
		No. OFF PER SET 1	UNIT No. TCI.251.35
			ISSUE B



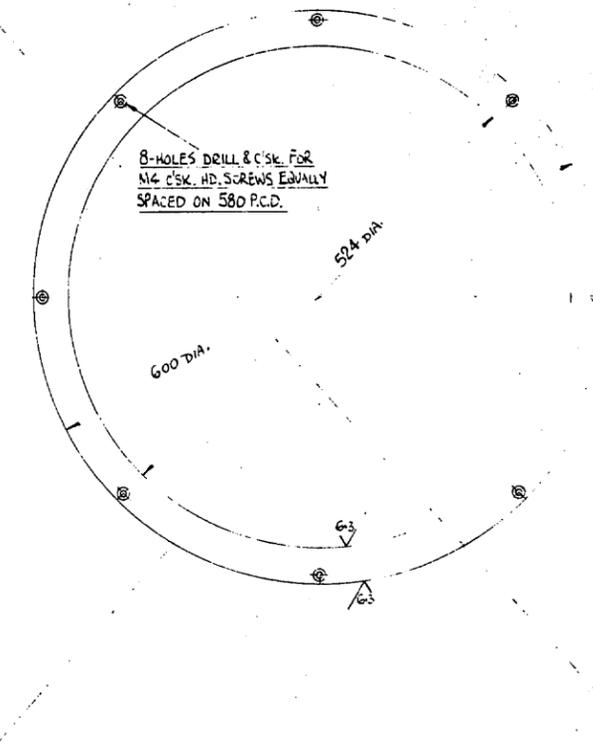
NOTE:- STRESS RELIEVE GAIT BLAST & PAINT
WITH PRIMER BEFORE MACHINING.

TUBE JOINT TO BE FULL PENETRATION WELD
DRESSED OFF ON OUTSIDE SURFACE.

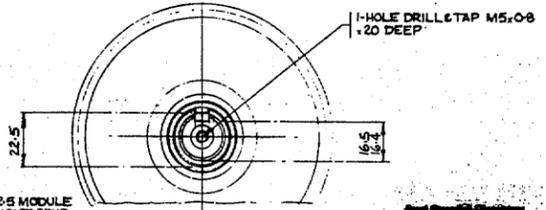
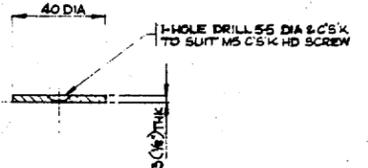
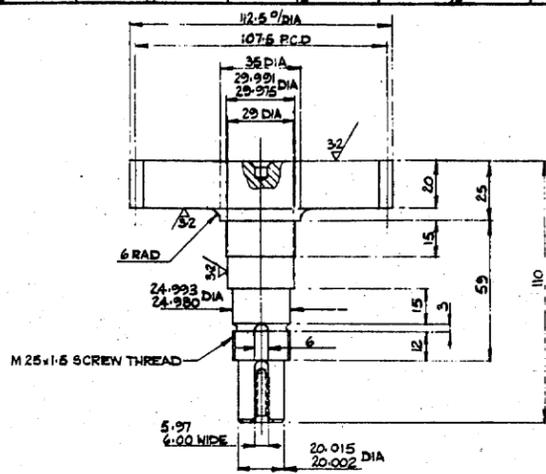
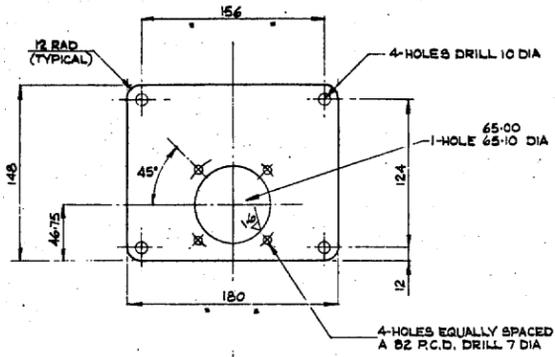
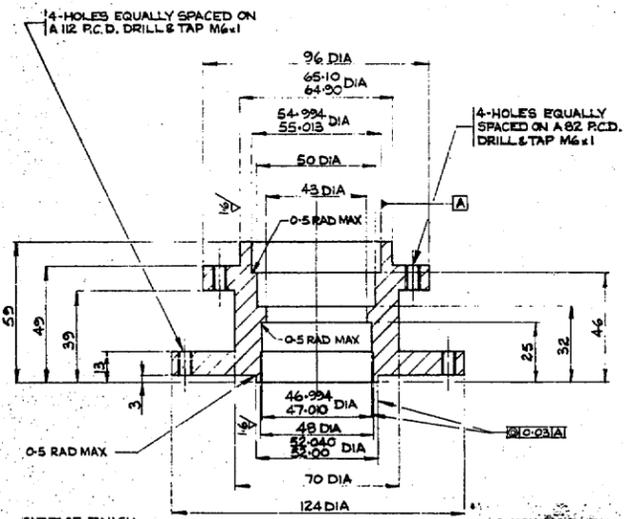
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APPROVED
No. TCI.251.35
Date 17/5/82



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APPROVED
No. TCI.251.35
Date 17/5/82



AS BUILT DRAWINGS
The quantity shown of holes is to suit work



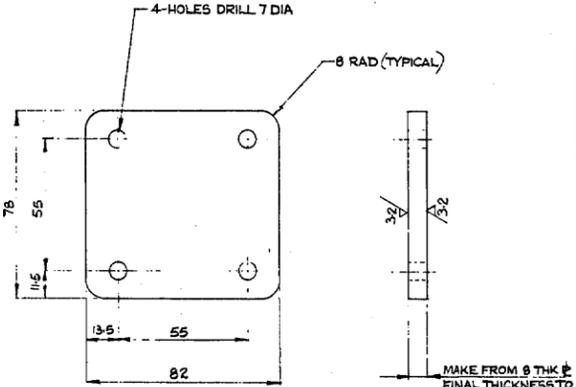
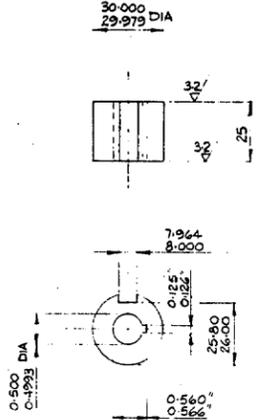
NOTE
 GEAR: 43 TEETH, 2.5 MODULE
 20° ANGLE, STRAIGHT SPUR
 TO BS 436 Pt 2:1970 GRADE 9.
 TEETH CORRECTED TO MESH
 WITH 260 TOOTH WHEEL AT
 378.75mm CENTRES, BACKLASH 0.05

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 5160	SYMBOL 203
		FIRST ISSUE DATE	FINISH	DOUBLE FLAT
		COST ACCOUNT 251	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Housing		
		WEIGHT 1.73 Kg	SCALE 1/1	UNIT No. Tc 251 59
		No. OFF PER SET 1		ISSUE A

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CRONIN STEEL	
		FIRST ISSUE DATE	FINISH	DOUBLE FLAT
		COST ACCOUNT 251	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Mounting Plate		
		WEIGHT 4.83 Kg	SCALE 1/1	UNIT No. Tc 251 60
		No. OFF PER SET 1		ISSUE A

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 5160	
		FIRST ISSUE DATE	FINISH	DOUBLE FLAT
		COST ACCOUNT 251	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Gear		
		WEIGHT 2.11 Kg	SCALE 1/1	UNIT No. Tc 251 61
		No. OFF PER SET 1		ISSUE A

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CRONIN STEEL	
		FIRST ISSUE DATE	FINISH	DOUBLE FLAT
		COST ACCOUNT 251	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Keyway Plate		
		WEIGHT 0.03 Kg	SCALE 1/1	UNIT No. Tc 251 62
		No. OFF PER SET 1		ISSUE A



DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CRONIN STEEL	
		FIRST ISSUE DATE	FINISH	NATURAL
		COST ACCOUNT 251	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Sleeve		
		WEIGHT 0.113 Kg	SCALE 1/1	UNIT No. Tc 251 63
		No. OFF PER SET 1		ISSUE A

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CRONIN STEEL	
		FIRST ISSUE DATE	FINISH	DOUBLE FLAT
		COST ACCOUNT 251	PART No.	
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE SHM		
		WEIGHT 0.42 Kg	SCALE 1/1	UNIT No. Tc 251 64
		No. OFF PER SET 1		ISSUE A

AS BUILT DRAWING
 This drawing shows all modifications to the original.