

TOP, WHEN TELESCOPE IS IN HORIZONTAL POSITION

SECTOR 1

NOTE: TUBING TO BE POSITIONED ON ASSY, AS SHOWN.

TCI 222 S9 TCI 222 S17

TCI 222 O3

REST PADS

15.088 3.5 DIA. HOLE IN CLIP

RACKING PIECE - TO SUIT CLIPS (BRASS) TCI 222 16

NOTE: 24 HOLES POSITIONED ON ASSY AS SHOWN. DRILL & TAP TO SUIT TUBE CLIP SCREWS TCI 222 F6

DETAIL OF TUBE CLIPS SCALE 2:1

TUBE CLIPS (SEE DETAIL) TCI 222 S16

DRIVE SIDE

COPPER TUBING 1/4" O.D. TCI 222 S18

NYLON TUBING 1/4" O.D. TCI 222 S19

TCI 222 S10 TCI 222 S11 TCI 222 S12

PRIMARY MIRROR LATERAL SUPPORT POSITIONS

SECTOR 3

CABLE WRAP SIDE

T NW PLINIE TCI 222 S13 TCI 222 S14 TCI 222 S15

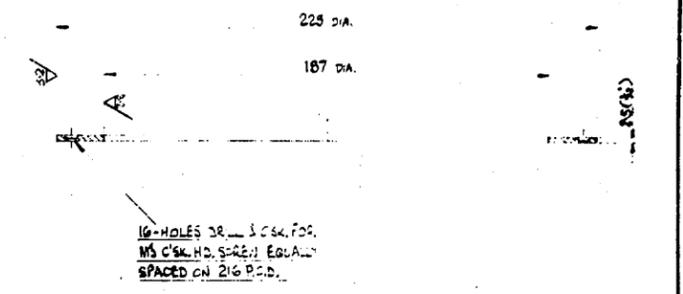
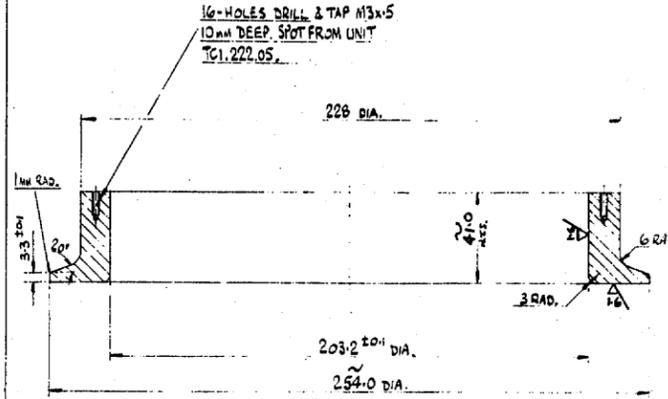
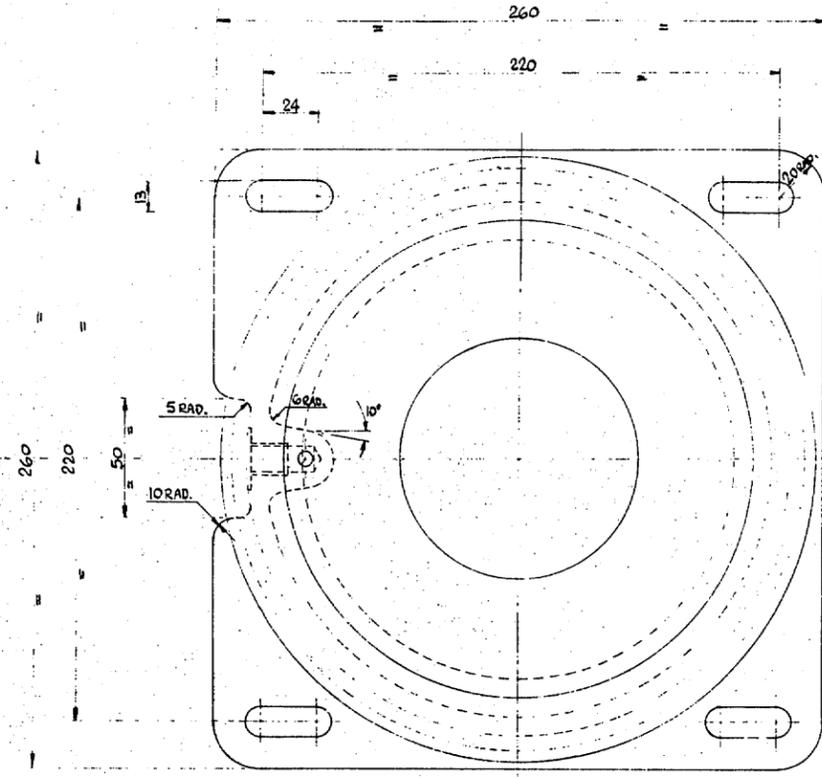
22
22
22
66 Annular RING

AS BUILT DRAWINGS

DATE OF ISSUE: 21.11.67
DRAWN BY: J. GILLON
CHECKED BY: J. GILLON
APPROVED BY: (ASP)
DATE OF END: 22.5.81
DRAWN BY: J. GILLON

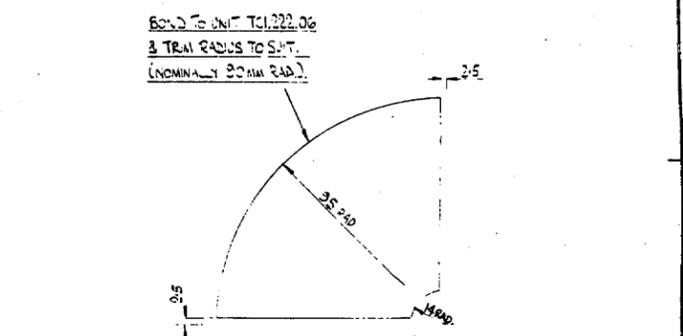
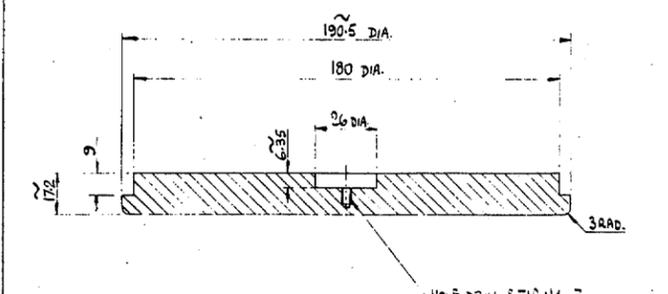
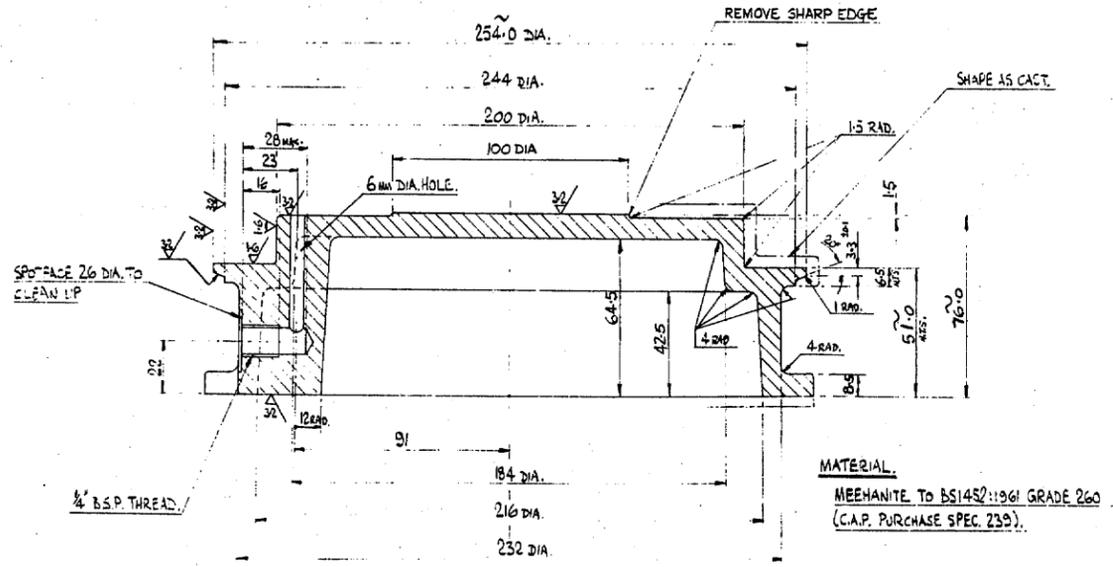
APPROVED
22.5.81
J. GILLON

<p>SURFACE FINISH EQUIVALENTS</p> <table border="1"> <tr> <td>INCHES</td> <td>4</td> <td>8</td> <td>16</td> <td>32</td> <td>63</td> <td>125</td> <td>250</td> <td>500</td> </tr> <tr> <td>MICROMETRES</td> <td>1</td> <td>2</td> <td>4</td> <td>8</td> <td>16</td> <td>32</td> <td>63</td> <td>125</td> </tr> </table> <p>THIS DRAWING CONFORMS TO B.S. 908</p>	INCHES	4	8	16	32	63	125	250	500	MICROMETRES	1	2	4	8	16	32	63	125	<p>SURFACE FINISH SYMBOLS</p> <p>✓ DENOTES NOT NECESSARILY MACHINED</p> <p>✗ DENOTES MACHINED</p>	<p>WELD SYMBOLS</p> <p>TO BS 499 PART 2 1971</p>	<p>FABRICATION TOLERANCES</p> <p>DIMENSIONS UP TO 250 ± 0.20</p> <p>DIMENSIONS FROM 250 TO 2000 ± 0.30</p> <p>ANGLES ± 1:600</p> <p>STRAIGHTNESS/FLATNESS 1:600</p>	<p>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.</p>	<p>GENERAL MACHINING TOLERANCES</p> <p>REPEAT WHERE STATED ON DRAWING</p> <p>FINISHED DIMENSIONS ± 0.05</p> <p>FINISHED DIMENSIONS WITH OVER ± 0.03</p> <p>FINISHED DIMENSIONS WITH OVER ± 0.01</p> <p>± 0.01</p>	<p>ALL DIMENSIONS ARE IN MILLIMETRES</p> <p>ANGLES & SCREW THREADS 1: J.B. 3643 PART 2 MEDIUM FIT MACHINED DIA CONCENTRIC TO 0.12R.</p>	<p>PROJECTION</p> <p>3rd ANGLE</p>	<p>DRAWN</p> <p>J. Gillon</p>	<p>SCALE</p> <p>1:10</p>	<p>TITLE</p> <p>PRIMARY MIRROR AXIAL SUPPORTS</p>	<p>DATE</p> <p>22.5.81</p>	<p>BY</p> <p>J. Gillon</p>	<p>GRUBB PARSONS NEWCASTLE UPON TYNE NEG 2YS</p>	<p>SHEET</p> <p>2 of 2</p>	<p>TCI 222</p>
INCHES	4	8	16	32	63	125	250	500																									
MICROMETRES	1	2	4	8	16	32	63	125																									



DATE OF MOD. REQUIRED BY	DATE OF MOD. REQUIRED BY	FIRST MADE ORD. NO.	118660	MATERIAL	Aluminium Alloy
		FIRST ISSUE DATE	9-1-57	FINISH	AS SUPPLIED
		COST ACCOUNT	222	PARTY NO.	
		TITLE	DIAPHRAGM SLEEVE		
		WEIGHT	1.1 kg	SCALE	1:1
		NO. OFF PER SET	10	UNIT NO.	TCL 222.04

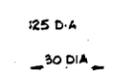
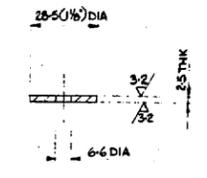
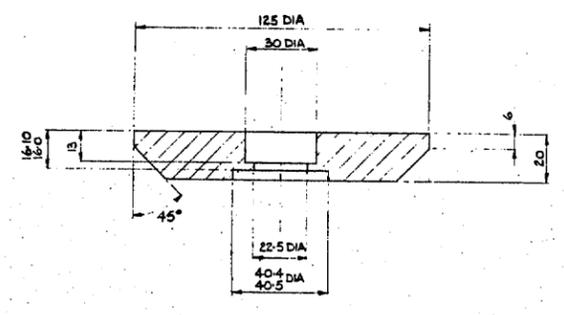
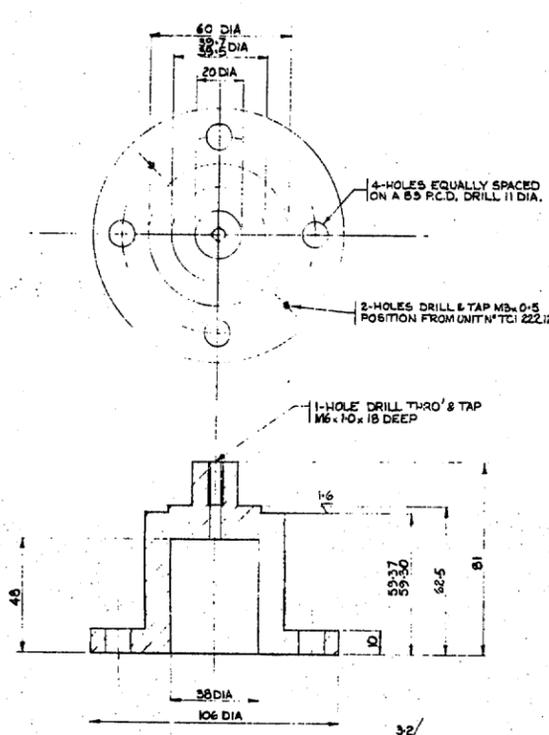
DATE OF MOD. REQUIRED BY	DATE OF MOD. REQUIRED BY	FIRST MADE ORD. NO.	118660	MATERIAL	Aluminium Alloy
		FIRST ISSUE DATE	9-1-57	FINISH	AS SUPPLIED
		COST ACCOUNT	222	PARTY NO.	
		TITLE	PISTON RETAINER RING		
		WEIGHT	0.24 kg	SCALE	1:1
		NO. OFF PER SET	60	UNIT NO.	TCL 222.05



DATE OF MOD. REQUIRED BY	DATE OF MOD. REQUIRED BY	FIRST MADE ORD. NO.	118660	MATERIAL	SEE ABOVE
		FIRST ISSUE DATE	9-1-57	FINISH	AS SUPPLIED
		COST ACCOUNT	222	PARTY NO.	
		TITLE	SUPPORT PAD CASTING		
		WEIGHT	0.3 kg	SCALE	1:1
		NO. OFF PER SET	60	UNIT NO.	TCL 222.03

DATE OF MOD. REQUIRED BY	DATE OF MOD. REQUIRED BY	FIRST MADE ORD. NO.	118660	MATERIAL	Aluminium Alloy
		FIRST ISSUE DATE	9-1-57	FINISH	AS SUPPLIED
		COST ACCOUNT	222	PARTY NO.	
		TITLE	SUPPORT PAD PISTON		
		WEIGHT	1.2 kg	SCALE	1:1
		NO. OFF PER SET	10	UNIT NO.	TCL 222.06

DATE OF MOD. REQUIRED BY	DATE OF MOD. REQUIRED BY	FIRST MADE ORD. NO.	118660	MATERIAL	Aluminium Alloy
		FIRST ISSUE DATE	9-1-57	FINISH	AS SUPPLIED
		COST ACCOUNT	222	PARTY NO.	
		TITLE	SUPPORT PAD PISTON		
		WEIGHT	1.2 kg	SCALE	1:1
		NO. OFF PER SET	10	UNIT NO.	TCL 222.07

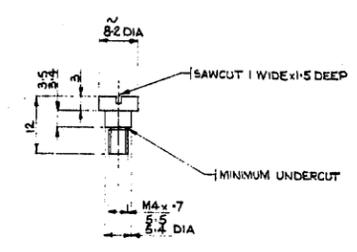
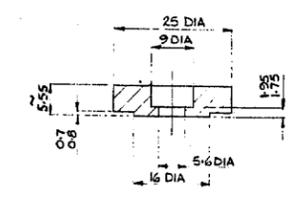
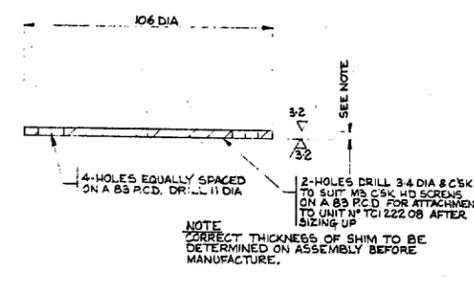


DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	20' Carbon Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Part No. 222
		COST ACCOUNT	222	PART No.	
		TITLE	Base		
		WEIGHT	1.44 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.08
					A

DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	20' Carbon Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Part No. 222
		COST ACCOUNT	222	PART No.	
		TITLE	Star Pro		
		WEIGHT	1.63 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.09
					A

DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	20' Carbon Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Part No. 222
		COST ACCOUNT	222	PART No.	
		TITLE	Star Pro		
		WEIGHT	1.63 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.10
					A

DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	20' Carbon Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Part No. 222
		COST ACCOUNT	222	PART No.	
		TITLE	Star Pro		
		WEIGHT	1.63 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.11
					A



DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	20' Carbon Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Part No. 222
		COST ACCOUNT	222	PART No.	
		TITLE	SHIM		
		WEIGHT	0.185 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.12
					A

DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	Structural Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Normal
		COST ACCOUNT	222	PART No.	
		TITLE	Machine Release Pro		
		WEIGHT	1.63 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.13
					A

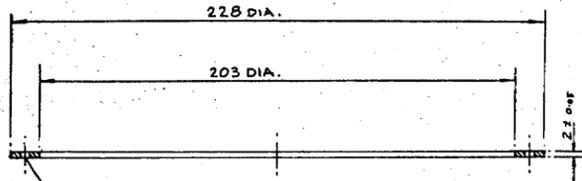
DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	Structural Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Normal
		COST ACCOUNT	222	PART No.	
		TITLE	Release Pro Shim		
		WEIGHT	1.63 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.14
					A

DATE OF MOD RECEIVED BY	DATE OF MOD RECEIVED BY	FIRST MADE ORD No.	118660	MATERIAL	20' Carbon Steel
		FIRST ISSUE DATE	9-1-81	FRESH	Part No. 222
		COST ACCOUNT	222	PART No.	
		TITLE	Star Pro		
		WEIGHT	1.63 Kg	SCALE	1/1
		No. OFF PER SET	50	UNIT No.	TC1 222.15
					A

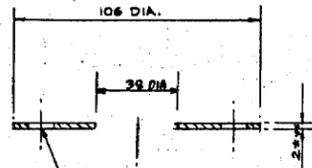
AS BUILT DRAWINGS
This drawing shows all variations to the work.



APPROVED
11.11.81
11.11.81



16 HOLES - DRILL 4 DIA. EQUI-SPACED
ON 216 P.C. DIA.



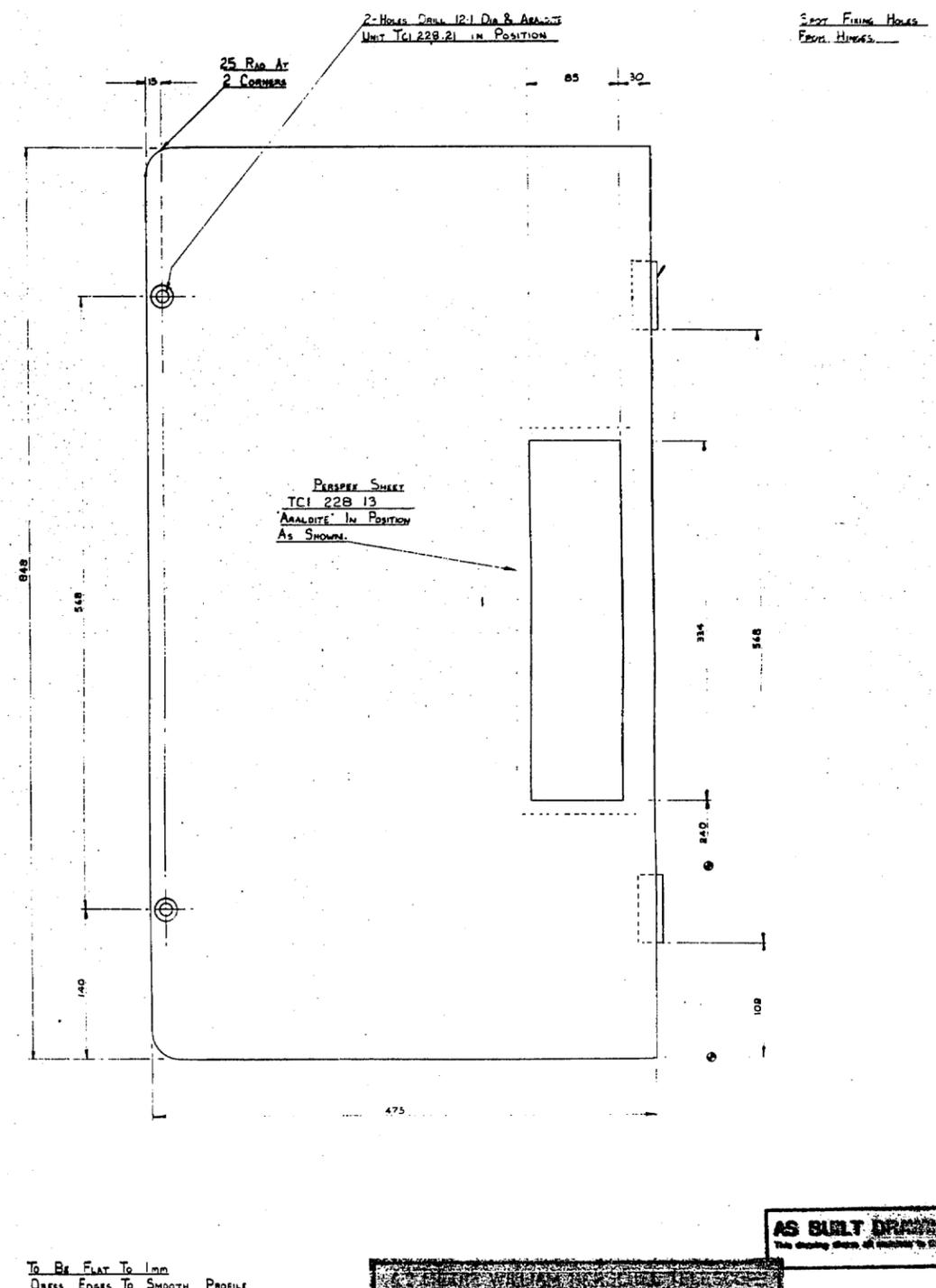
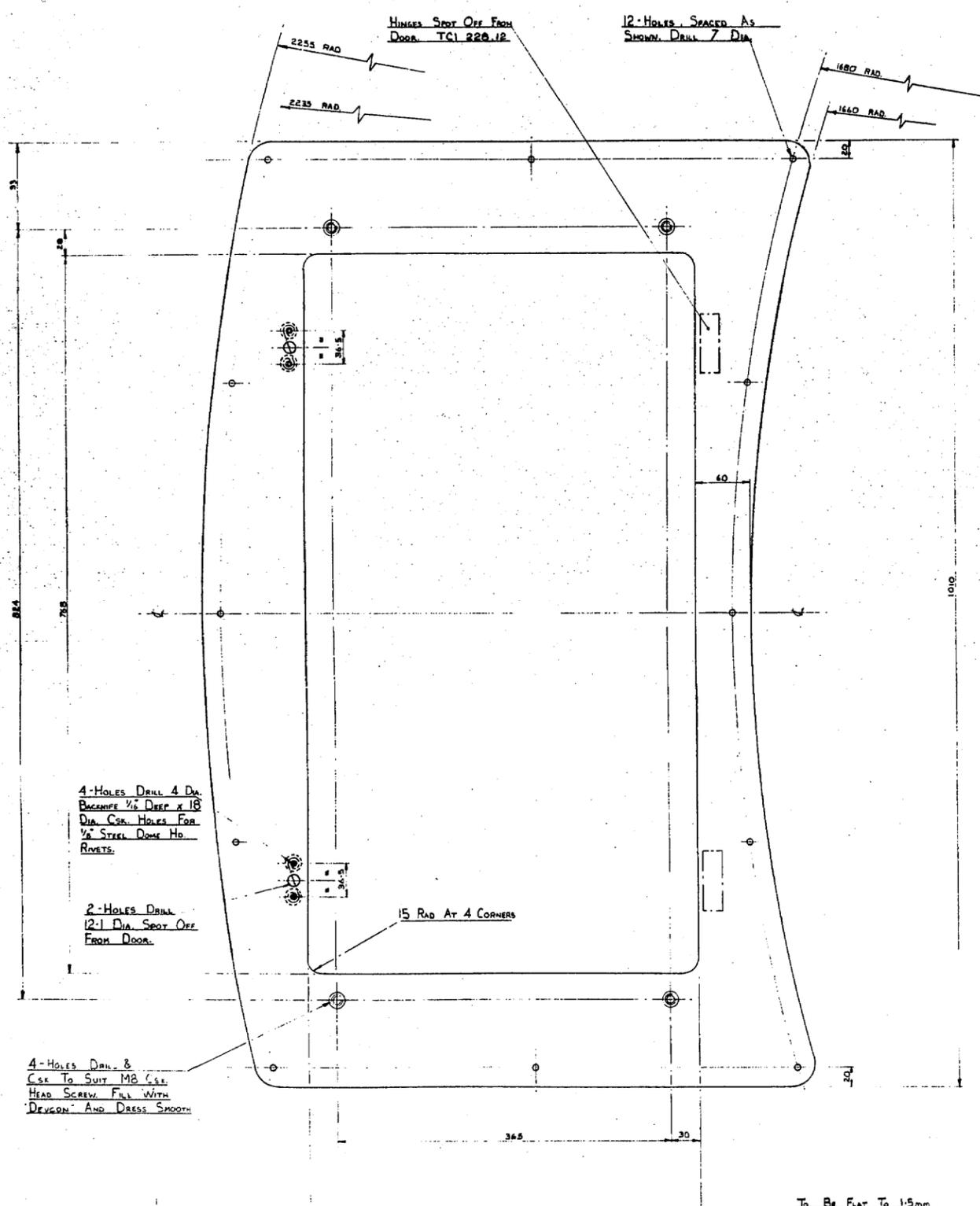
4 HOLES - DRILL 11 DIA.
EQUI-SPACED ON 83 P.C. DIA.

ITEM NO.	1	QTY	1	UNIT	EA
DESCRIPTION	SHIM				
MATERIAL	STAINLESS STEEL				
FINISH	222				
SCALE	FULL				
DATE	TCI-222-17				
DRW. NO.	A				

ITEM NO.	1	QTY	1	UNIT	EA
DESCRIPTION	SHIM				
MATERIAL	2% CARBON STEEL				
FINISH	222				
SCALE	FULL				
DATE	TCI-222-18				
DRW. NO.	B				

AS BUILT DRAWINGS
The existing items of equipment in the work.





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

Approved
T.C.I. 228.12

APPROVED
T.C.I. 228.12

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 1/8 THK SHEET STEEL
		FIRST ISSUE DATE 22-7-81	FINISH PAINT GRASS WHITE
		COST ACCOUNT 228	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE COVER PLATE	
		WEIGHT 1.0 KG	SCALE 1:2
		UNIT No. TCI 228.11	ISSUE A

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 1/8 THK SHEET STEEL
		FIRST ISSUE DATE 22-7-81	FINISH PAINT GRASS WHITE
		COST ACCOUNT 228	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE COVER PLATE	
		WEIGHT 1.0 KG	SCALE 1:2
		UNIT No. TCI 228.12	ISSUE B

