

TC1 281 (F15) 01  
 TC1 281 09  
 TC1 281 10

493 REF

505.8mm TO ESTIMATED COF.G

ALTITUDE AXIS

264.72 kg

600mm TO C.O.F.G. OF INSTRUMENT LOAD  
 200mm TO CORRECTED FOCAL PLANE  
 1570.5mm TO UNCORRECTED FOCAL PLANE

(TC1 281) (F25) (S36)  
 (S25) (S31) (S46) (S49) CONNECTORS 14, 18, 19  
 (S27) (S33) (S44) (S49) CONNECTORS 14, 17, 23, 24  
 (S50) (S51) (S52) (S53) CONNECTORS 28, 29, 30  
 TOP END CENTRE STRUCTURE ASSEMBLY N° TC1 210  
 FACE 'A'  
 (S28) (S34) (S47) (S48) CONNECTORS 25 & 26

NOTES  
 1. ALL CONNECTORS TO BE MOUNTED FROM UNDERSIDE OF PLATE AS SHOWN (WHERE POSSIBLE).  
 2. SELF ADHESIVE LABELS SHOWING CONNECTOR NUMBERS TO BE FIXED TO TOP SURFACE

(TC1 281) (F1) (S19)  
 (TC1 281) (F2) (S20)  
 (TC1 281) (F3) (S21)  
 (TC1 281) (F4) (S22)  
 (TC1 281) (F5) (S23)  
 (TC1 281) (F6) (S24)

ADJUST SHIM THICKNESS (TC1 281 25) ON ASSEMBLY TO SET FACES A & B 493 APART AND PARALLEL WITHIN 0.025

FACE 'B'  
 ASSEMBLE TO PROCEDURE TC1 281 API  
 RANDON TYPE 'A' ANGULAR CONTACT BEARINGS, 1/16" X 1/16" X 1/16" MATED PAIR ASSEMBLED WITH DOTS DIAMETRICALLY OPPOSITE.  
 (S11) (TC1 281) (F4) (S23) (TC1 281) (F6) (S23)

APPROVED  
 No. TC1 281 002  
 Date 26.1.82

APPROVED  
 No. TC1 281 003  
 Date 6.8.82

APPROVED  
 No. TC1 281 004  
 Date 20.1.82

APPROVED  
 No. TC1 281 001  
 Date 26.1.82

AS BUILT DRAWINGS  
 This drawing shows all variations to this work

SECTION A-A

ASSEMBLY PROCEDURE N° :- TC1 281 API & 492  
 INSPECTION SCHEDULE N° :- TC1 281 TS1  
 TEST SCHEDULE N° :- TC1 281 TS1

ORDER N° 118460

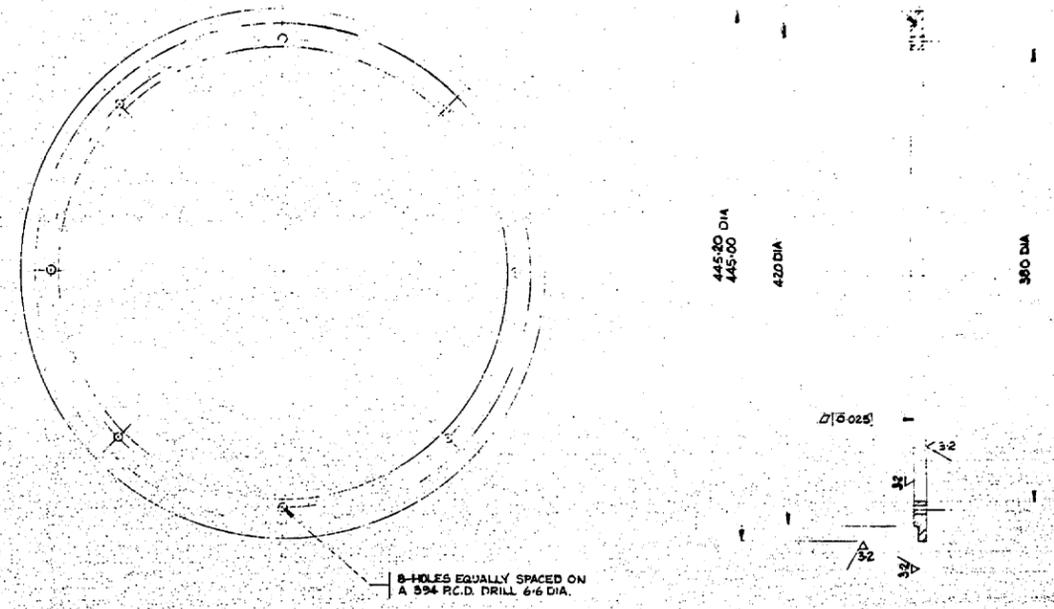
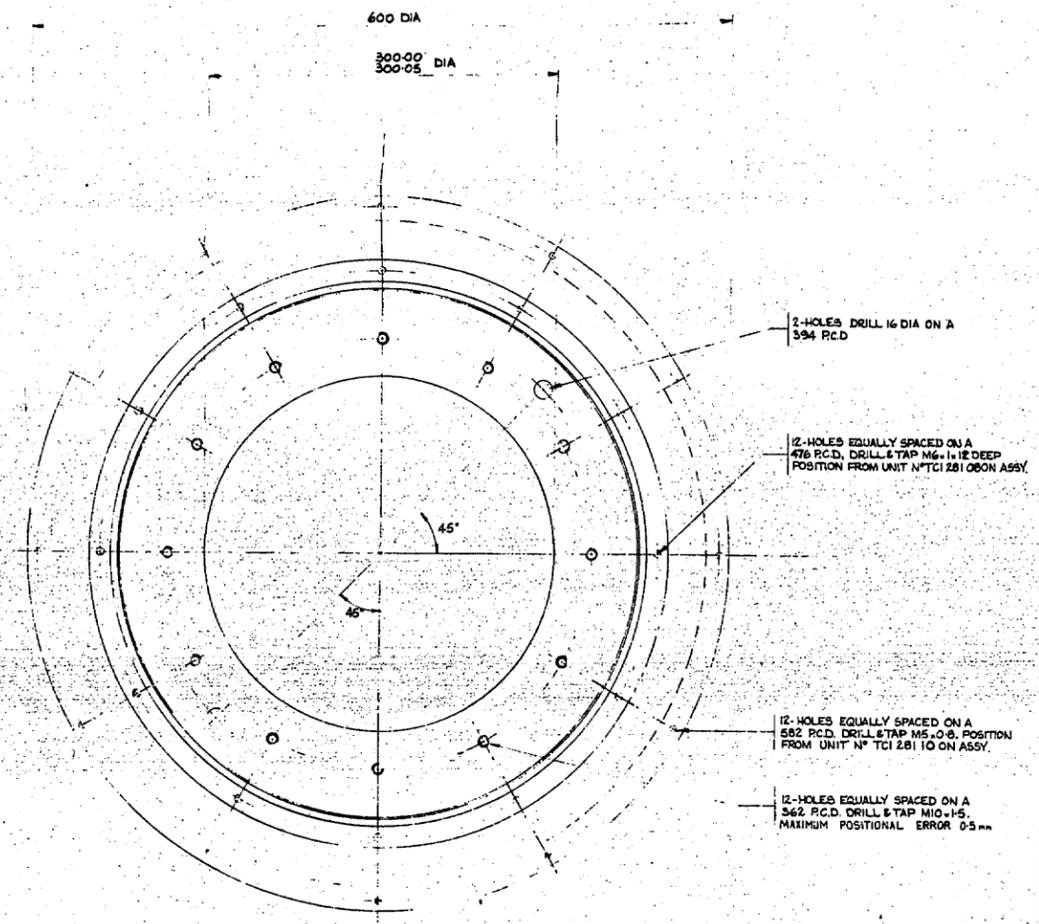
DATE OF MOD 14-1-82 DRAWN BY V. J. P. 14-1-82 TC1 281 010 ADDED	DATE OF MOD 14-1-82 DRAWN BY V. J. P. 14-1-82 TC1 281 010 ADDED	DATE OF MOD 14-1-82 DRAWN BY V. J. P. 14-1-82 TC1 281 010 ADDED
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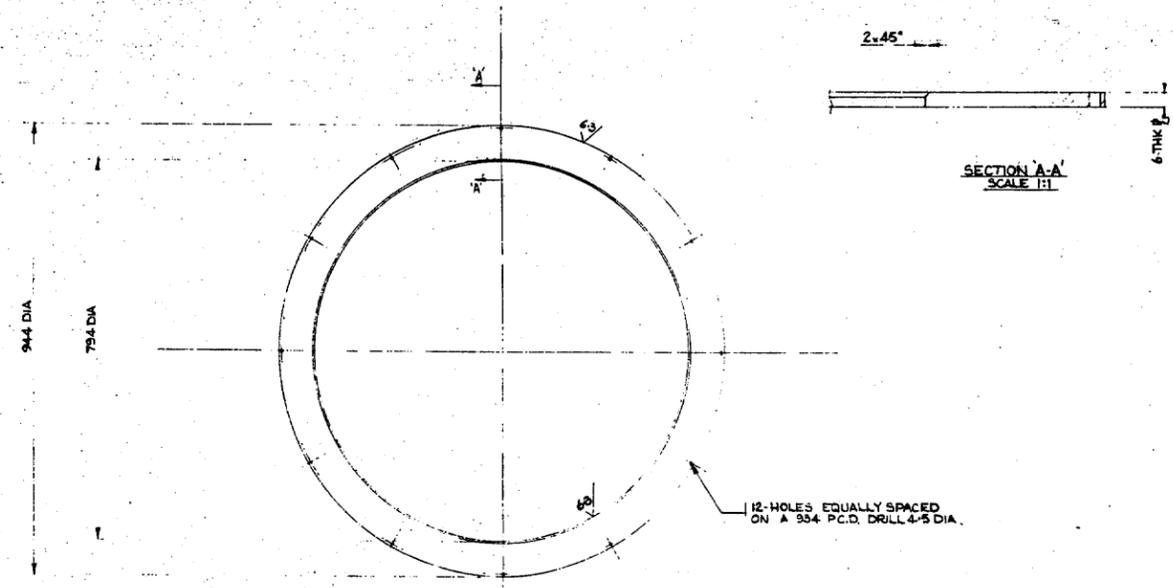
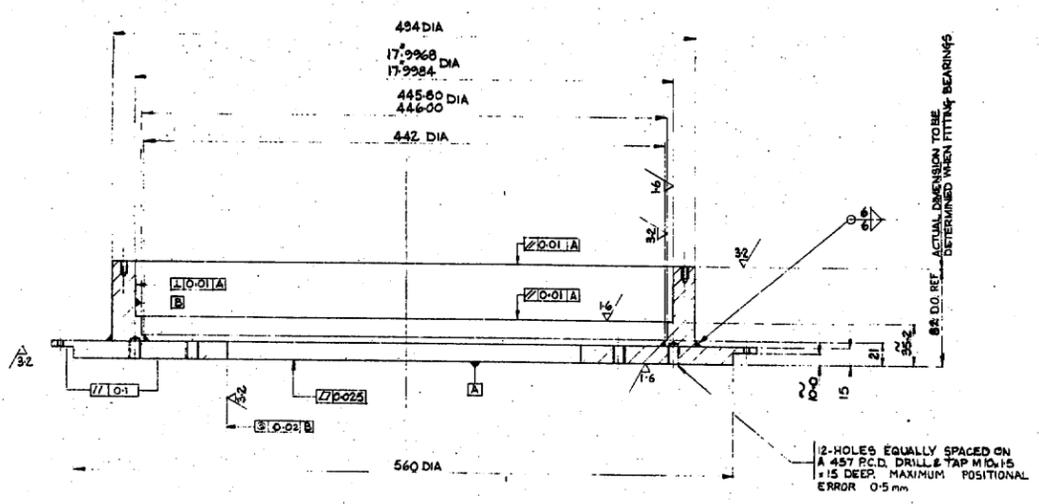






DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL SW 4340
		FIRST ISSUE DATE 24-7-81	FINISH GR 43A
		COST ACCOUNT 281	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE BEARING HOUSING	
		WEIGHT 2.75 kg	SCALE 1:1
		No. OFF PER SET 1	UNIT No. 161 281 06

Royal Greenwich Observatory  
La Palma Division  
**APPROVED**  
No. 761 281 06 Part A  
Date 24.7.81

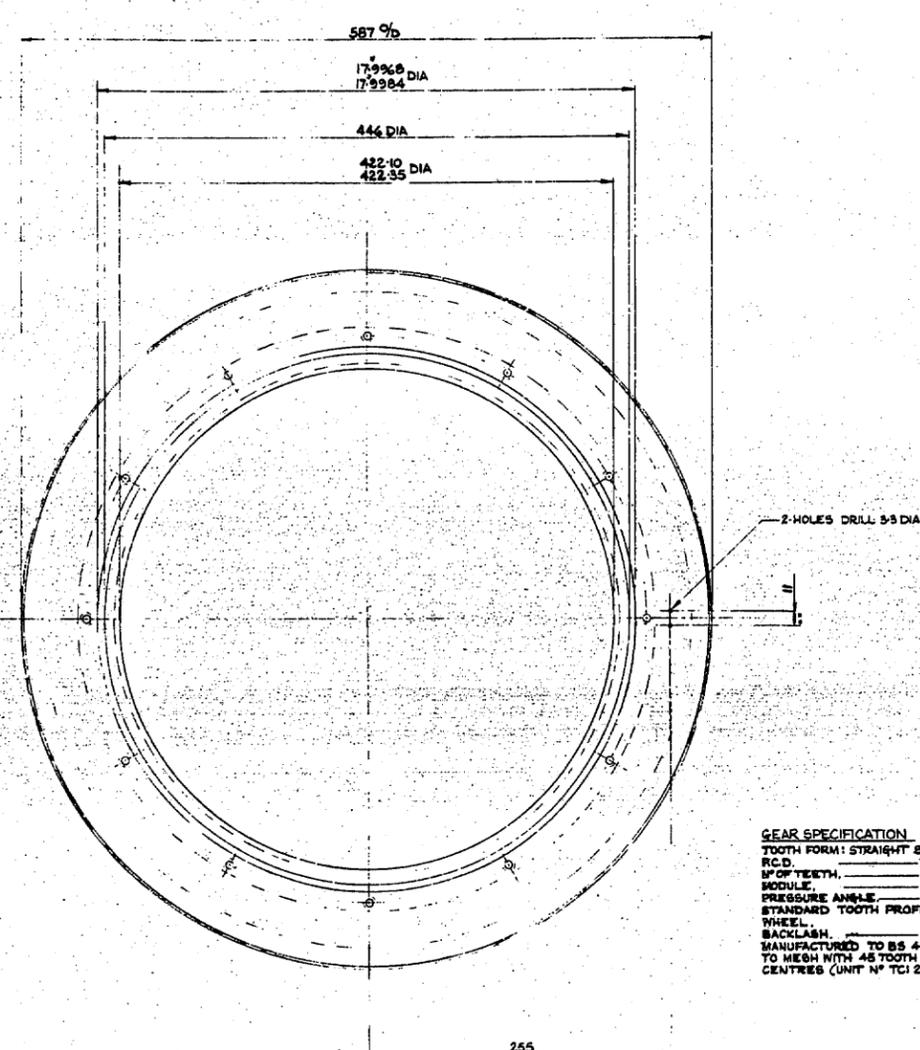


Royal Greenwich Observatory  
La Palma Division  
**AS BUILT DRAWINGS**  
This drawing shows all dimensions in this work.  
**APPROVED**  
No. 761 281 06 Part A  
Date 24.7.81

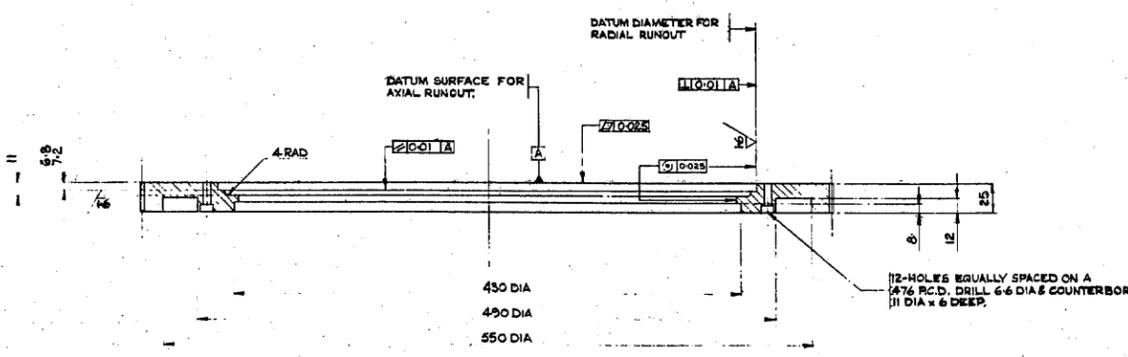
- NOTES**
- 1/ TO BE STRESS RELIEVED TO BS 1500-1958
  - 2/ SECTION AD AND GRIT BLASTED, PAINT WITH PRIMER IMMEDIATELY AFTER GRIT BLASTING.
  - 3/ ALL WELD SURFACES ARE TO BE CLEAN AND FREE FROM SCALE, LAMINATIONS AND INCLUSIONS.
  - 4/ ALL WELDS TO BE CONTINUOUS.
  - 5/ TO PURCHASE SPEC N° 1, ISSUE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

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL SW 4340
		FIRST ISSUE DATE 24-7-81	FINISH GR 43A
		COST ACCOUNT 281	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE BEARING HOUSING	
		WEIGHT 2.75 kg	SCALE 1:1
		No. OFF PER SET 1	UNIT No. 161 281 05

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 110660	MATERIAL SW 4340
		FIRST ISSUE DATE 24-7-81	FINISH GR 43A
		COST ACCOUNT 281	PATT No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE BEARING HOUSING	
		WEIGHT 2.75 kg	SCALE 1:1
		No. OFF PER SET 1	UNIT No. 161 281 07



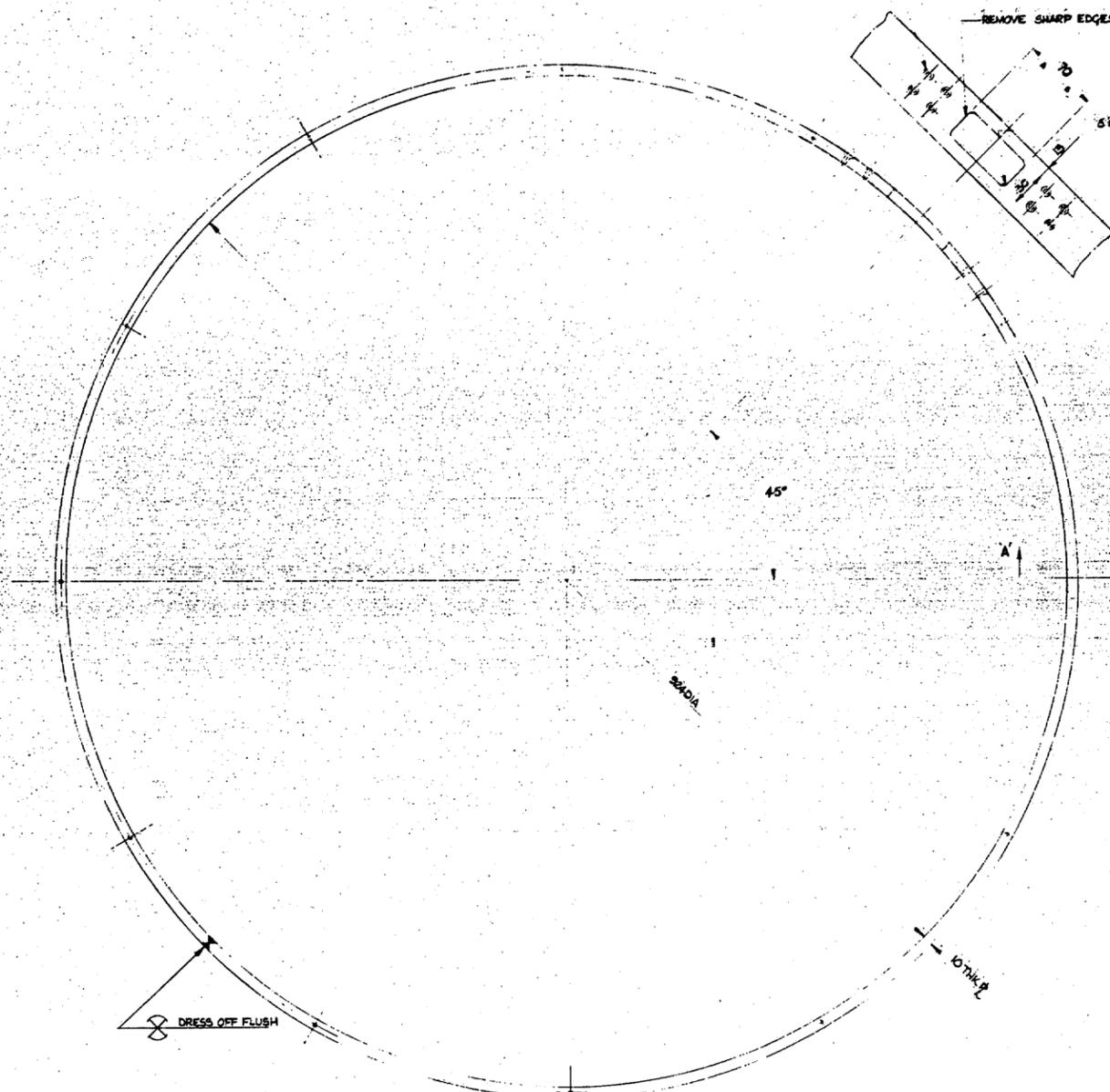
**GEAR SPECIFICATION**  
 TOOTH FORM: STRAIGHT SPUR INVOLUTE.  
 P.C.D. 585  
 N° OF TEETH 55  
 MODULE 1  
 PRESSURE ANGLE 20°  
 STANDARD TOOTH PROFILE UNCORRECTED  
 WHEEL.  
 BACKLASH ZERO  
 MANUFACTURED TO BS 436 PART 2 GRADE 5  
 TO MESH WITH 48 TOOTH PINION AT 518  
 CENTRES (UNIT N° TCI 281 27)



TO BE MANUFACTURED AND INSPECTED TO SPECIFICATION TCI/281/C10

APPROVED  
 No. 1818/281  
 Date 20.7.81

12 SETS OF 4 HOLES (8 HOLES) DRILL 7/8" DIA  
 (C/S TO SUIT 28 A C/S) AND SCREWS POSITION  
 FROM KABELSCHLEPP CONNECTING PIECES  
 (TCI 281 84) ON ASSEMBLY.



12 HOLES EQUALLY SPACED ON A  
 934 P.C.D. DRILL & TAP #4-07-10 DEEP  
 POSITION FROM UNIT N° TCI 281 07

12 HOLES EQUALLY SPACED ON A  
 934 P.C.D. DRILL & TAP #4-07-10 DEEP  
 POSITION FROM UNIT N° TCI 281 10 ON ASSY

SECTION A-A  
 SCALE 1:1

AS BUILT DRAWINGS  
 This drawing shows all variations to this work

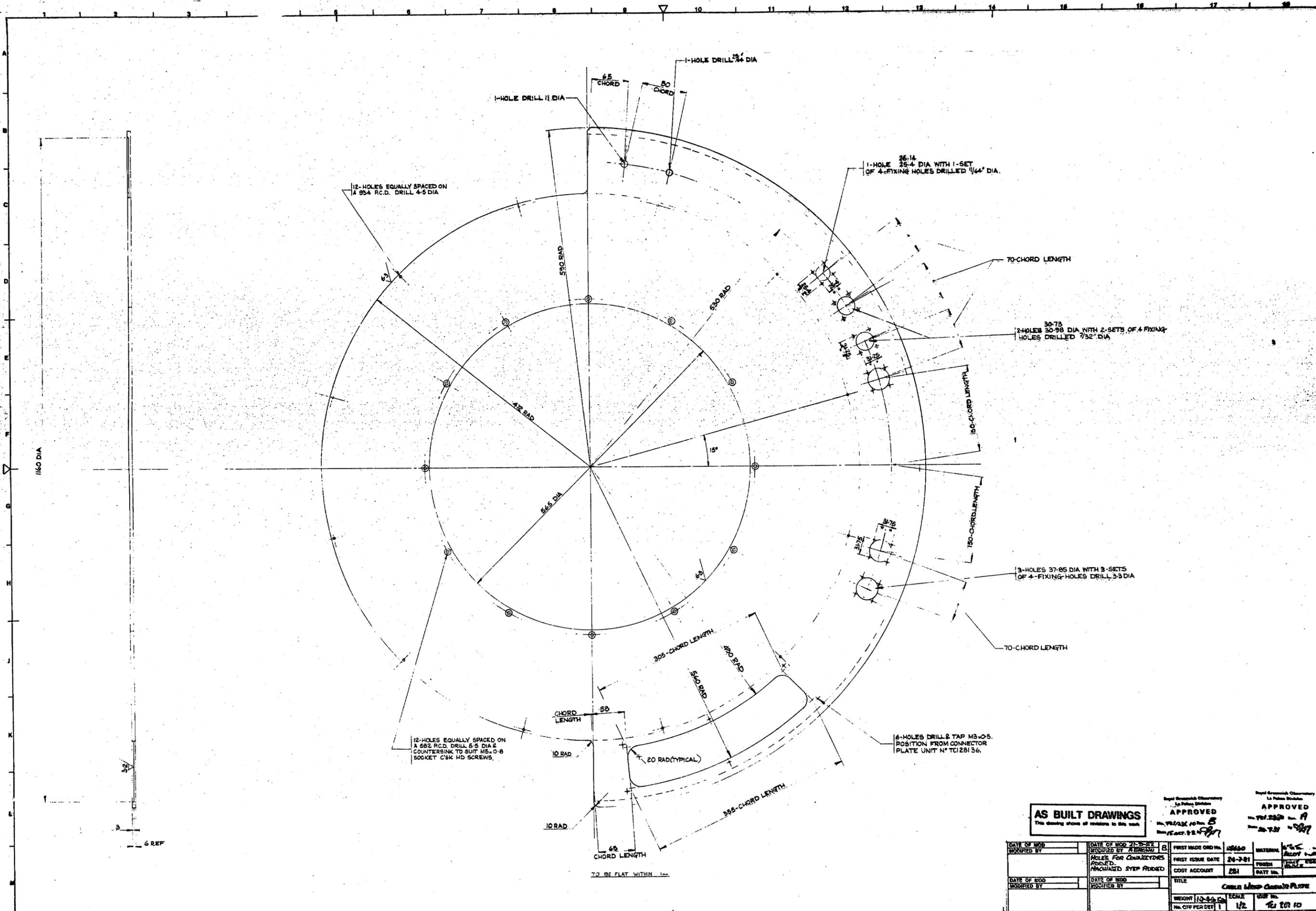
APPROVED  
 No. 1818/281  
 Date 20.7.81

NOTE 3/ ALL OVER EXCEPT  
 MACHINE 2/ WHERE STATED OTHERWISE.

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL S30L EN 8
		FIRST ISSUE DATE 24-7-81	FINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Wheel	
		WEIGHT 18.18 kg	SCALE UNIT No. 1/2 TCI 281 08
		No. OFF PER SET 1	

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 20460	MATERIAL
		FIRST ISSUE DATE 24-3-81	FINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE	
		WEIGHT 14.03 kg	SCALE UNIT No. TCI 281 09
		No. OFF PER SET 1	





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

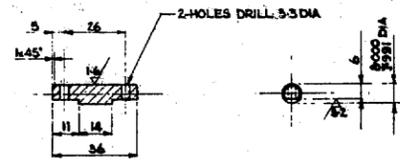
Royal Greenwich Observatory  
La Palma Station  
**APPROVED**  
No. 201208 Rev. A  
Date 20.7.81

DATE OF MOD. DRAWN BY	DATE OF MOD. CHECKED BY	FIRST MADE ORG. NO.	MATERIAL
		20-7-81	ALUMINUM
DATE OF MOD. MODIFIED BY	DATE OF MOD. MODIFIED BY	FIRST ISSUE DATE	FORN
		20-7-81	ALUMINUM
TITLE		COST ACCOUNT	PART NO.
CABLE MOUNT CONNECTOR PLATE		201	
WEIGHT		SCALE	DRW. NO.
10.45 kg		1/2	201 10
NO. OFF PER SET			
1			

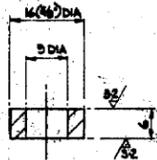
<b>GRUBB PARSONS</b> NEWCASTLE UPON TYNE NES 2YB A member of Clarke Chapman and Rayve's Parsons	SURFACE FINISH EQUIVALENTS MACHINING FINISH: 1-3, 2-4, 3-5, 4-6, 5-7, 6-8, 7-9, 8-10, 9-11, 10-12, 11-13, 12-14, 13-15, 14-16, 15-17, 16-18, 17-19, 18-20, 19-21, 20-22, 21-23, 22-24, 23-25, 24-26, 25-27, 26-28, 27-29, 28-30, 29-31, 30-32, 31-33, 32-34, 33-35, 34-36, 35-37, 36-38, 37-39, 38-40, 39-41, 40-42, 41-43, 42-44, 43-45, 44-46, 45-47, 46-48, 47-49, 48-50, 49-51, 50-52, 51-53, 52-54, 53-55, 54-56, 55-57, 56-58, 57-59, 58-60, 59-61, 60-62, 61-63, 62-64, 63-65, 64-66, 65-67, 66-68, 67-69, 68-70, 69-71, 70-72, 71-73, 72-74, 73-75, 74-76, 75-77, 76-78, 77-79, 78-80, 79-81, 80-82, 81-83, 82-84, 83-85, 84-86, 85-87, 86-88, 87-89, 88-90, 89-91, 90-92, 91-93, 92-94, 93-95, 94-96, 95-97, 96-98, 97-99, 98-100, 99-101, 100-102, 101-103, 102-104, 103-105, 104-106, 105-107, 106-108, 107-109, 108-110, 109-111, 110-112, 111-113, 112-114, 113-115, 114-116, 115-117, 116-118, 117-119, 118-120, 119-121, 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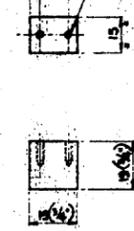


APPROVED  
 24-7-81

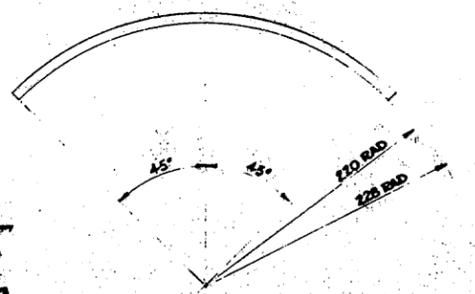


APPROVED  
 24-7-81

2-HOLES DRILL STAR MS-05  
 6 DEEP POSITION FROM  
 UNIT 1/10 DIA ON ASSY



APPROVED  
 24-7-81



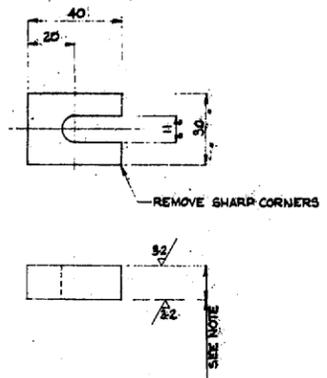
NOTE:  
 TO BE CUT FROM SAME PIECE OF MATERIAL OR FROM PIECES SELECTED FOR CONSISTANT THICKNESS. MAXIMUM ACCEPTABLE THICKNESS VARIATION 0-0.05

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

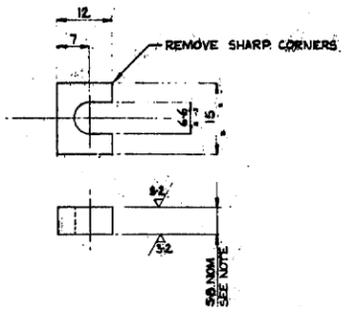
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		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	



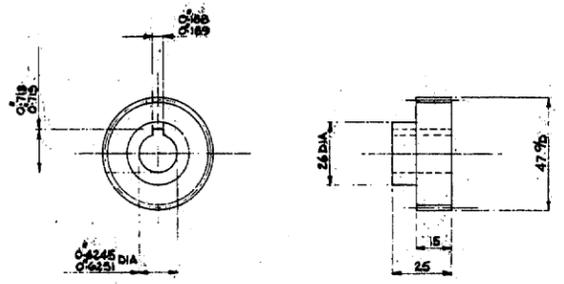
NOTE:  
 THICKNESS & FORM OF SHIM TO BE DETERMINED ON ASSEMBLY

APPROVED  
 24-7-81



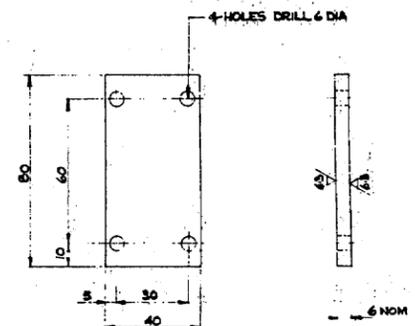
NOTE:  
 THICKNESS & FORM OF SHIM TO BE DETERMINED ON ASSEMBLY

APPROVED  
 24-7-81



GEAR SPECIFICATION  
 PCD 45  
 N° OF TEETH 45  
 MODULE 1  
 PRESSURE ANGLE 20°  
 MANUFACTURED TO BS 456 PART 2, GRADE 6  
 TO MESH WITH PART N° TC128106

APPROVED  
 24-7-81



NOTE:  
 ACTUAL THICKNESS TO BE DETERMINED ON ASSEMBLY

AS BUILT DRAWINGS  
 This drawing shows all features as built.

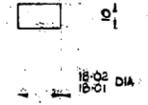
APPROVED  
 24-7-81

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

DATE OF JOB	DATE OF JOB	FIRST MADE ORD NO.	MATERIAL
		18660	20 Carbon Steel
		FIRST ISSUE DATE	FRESH
		24-7-81	
		COST ACCOUNT	PART NO.
		281	
		TITLE	
		SHIM	
		WEIGHT	SCALE
		0.11g	1/1
		UNIT NO.	
		74 281 25	

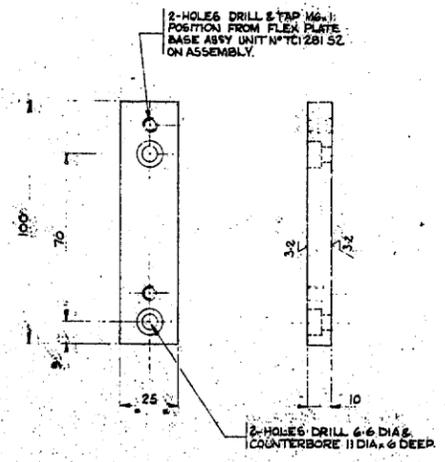


MACHINE ALL OVER

NOTE TO BE MACHINED AND THEN HARDENED TO ROCKWELL N°60 PROCESS SPEC H7/01 ISSUE 15 TEMP 300°C

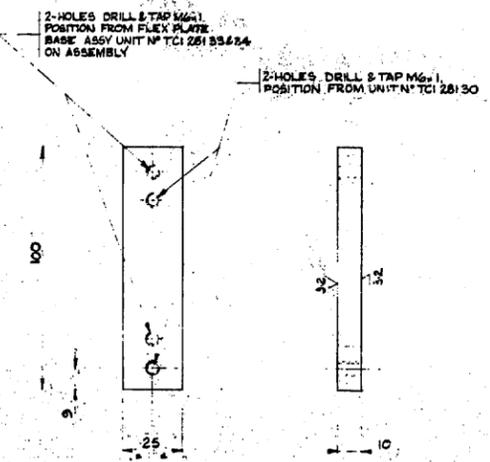
APPROVED  
No. TCI.281.513  
Date 23.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE HARDENED PAD	
		WEIGHT 0.02 kg	SCALE 1/1
		No. OFF PER SET 1	UNIT No. TCI 281 29



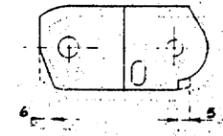
APPROVED  
No. TCI.281.300  
Date 23.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE PACKER	
		WEIGHT 0.2 kg	SCALE 1/1
		No. OFF PER SET 2	UNIT No. TCI 281 30



APPROVED  
No. TCI.281.301  
Date 23.7.81

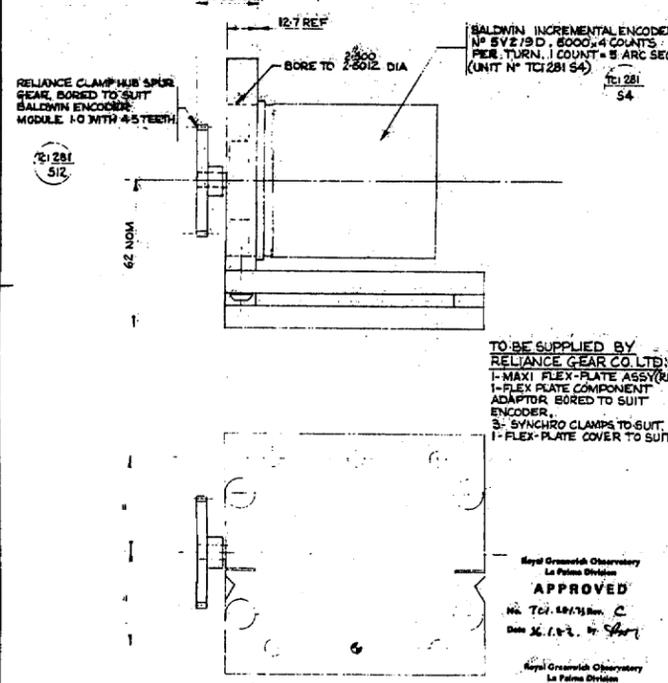
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		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE PACKER	
		WEIGHT 0.2 kg	SCALE 1/1
		No. OFF PER SET 2	UNIT No. TCI 281 31



MODIFICATIONS REQUIRED ON ALL CABLE CHAIN LINKS (98 LINKS) TEMPLATE TO BE MADE.

APPROVED  
No. TCI.281.302  
Date 23.7.81

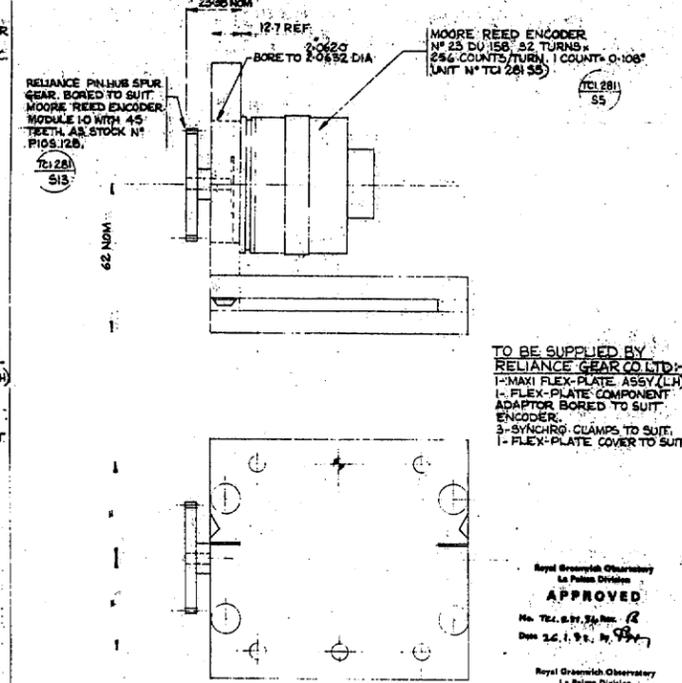
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		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE Macrometric Cable Chain Links	
		WEIGHT 0.2 kg	SCALE 1/1
		No. OFF PER SET 1	UNIT No. TCI 281 32



TO BE SUPPLIED BY RELIANCE GEAR CO. LTD:  
1- MAXI FLEX-PLATE ASSY (LH)  
1- FLEX-PLATE COMPONENT ADAPTOR, BORED TO SUIT ENCODER.  
3- SYNCHRO CLAMPS TO SUIT  
1- FLEX-PLATE COVER TO SUIT.

APPROVED  
No. TCI.281.513  
Date 23.7.81

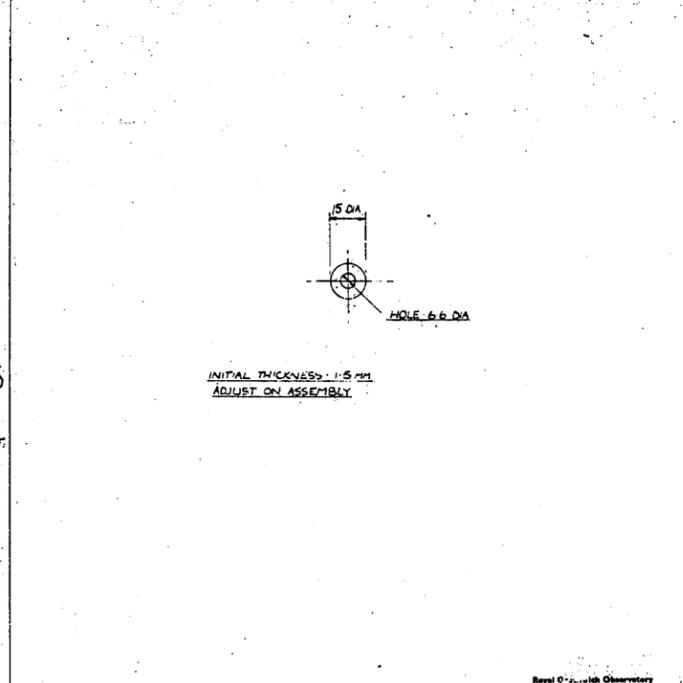
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL AS SUPPLIED
		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE BALDWIN ENCODER & MOUNTING ASSY	
		WEIGHT 0.02 kg	SCALE 1/1
		No. OFF PER SET 1	UNIT No. TCI 281 53



TO BE SUPPLIED BY RELIANCE GEAR CO. LTD:  
1- MAXI FLEX-PLATE ASSY (LH)  
1- FLEX-PLATE COMPONENT ADAPTOR, BORED TO SUIT ENCODER.  
3- SYNCHRO CLAMPS TO SUIT  
1- FLEX-PLATE COVER TO SUIT.

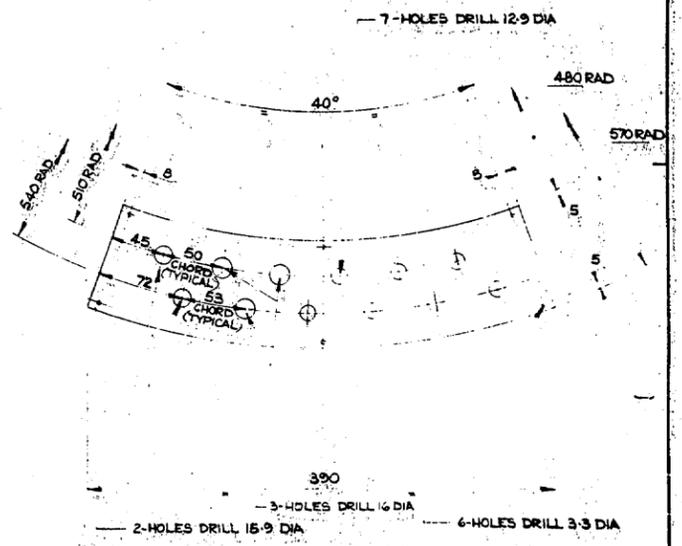
APPROVED  
No. TCI.281.515  
Date 23.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL AS SUPPLIED
		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE MOORE REED ENCODER & MOUNTING ASSY	
		WEIGHT 0.2 kg	SCALE 1/1
		No. OFF PER SET 1	UNIT No. TCI 281 54



APPROVED  
No. TCI.281.514  
Date 23.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE SHIM	
		WEIGHT 0.02 kg	SCALE 1/1
		No. OFF PER SET 1	UNIT No. TCI 281 55



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

APPROVED  
No. TCI.281.516  
Date 23.7.81

DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	FIRST MADE ORD No. 118660	MATERIAL 20 CARBON STEEL
		FIRST ISSUE DATE 24-7-81	FINISH SUPERFINISH
		COST ACCOUNT 281	PART No.
DATE OF MOD MODIFIED BY	DATE OF MOD MODIFIED BY	TITLE CORRECTIVE RATE	
		WEIGHT 0.15 kg	SCALE 1/1
		No. OFF PER SET 1	UNIT No. TCI 281 56