

PLAN ON NORTH ARCH GIRDER INNER WIRE (LOOKING DOWN)
 SHOWING WIND SCREEN GUIDE ASSEMBLY POSITION
 FOR MATCH DRILLING & TAPPING TO INNER WIRE & FINISH
 LOCATIONS OF GUIDE WIRES

SHOP NOTE:
 TRACK WIDTH OF 66 TO
 BE MAINTAINED ± 0.5 BY
 USING TRACKS IN AS SPEC

SHOP NOTE:
 GUIDE WIRE COMPONENTS PART TO HAVE
 THIMS INSERTED AT TOP END TO ALLOW FOR
 FIELD REMOVAL OF THESE COMPONENTS. THIM
 THICKNESS TO BE A MAXIMUM OF .0254mm (.001")

SHOP NOTE:
 THESE DIMS MUST BE MAINTAINED
 WITHIN GIVEN TOLERANCES TO ALLOW
 PROPER STACING OF WIND SCREEN

GENERAL NOTES

- 1) FOR DETAILS OF ITEMS ON THIS PAGE SEE PAGES 41, 42, 43, 44, 45
- 2) FOR DETAILS OF SHOP & FIELD BRACES IN GUIDE WIRE SEE PAGE 46
- 3) FOR ASSEMBLY MATCH DRILLING PROCEDURE SEE PAGE 47
- 4) FOR DETAILS OF ARCH GIRDER SEE ARCH SECTIONS #3
- 5) FOR FIELD ERECTION OF THESE ITEMS SEE ARCH

SECTION A-A

SECTION E

3R/3001165



MATERIAL	G40.21 (44W) w/n	No.	BY	DATE	REVISION
SURF. PREP. & PAINT	SEE MEMO	DETAILS NORTH WIND SCREEN GUIDE ASSEMBLY & MOUNTING			
FOR 4.2M TELESCOPE DOME LA HOUA					
DRAWN	DATE	CHECKED	DATE	DRAWING No.	
PK				1420-4a	MVF
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.					

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m-abcdefghijklmnpstvwyz

s-abcdefghijklmnpstvwyz

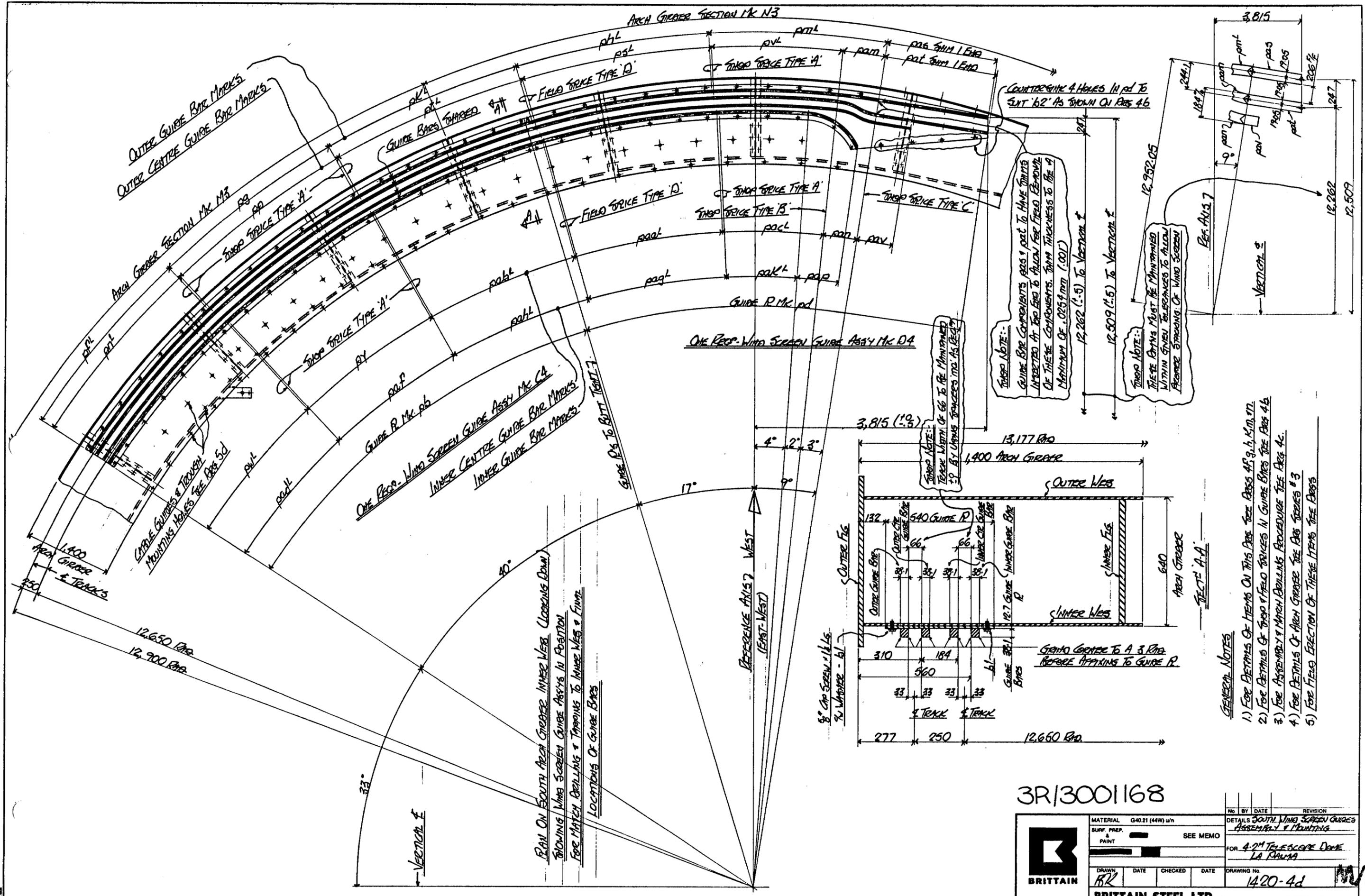
SHOP DEPARTMENT

WIND SCREEN GUIDES ASSEMBLY & MATCH DRILLING PROCEDURE TO ARCH GIRDER INNER WEB

- 1.) FABRICATE ARCH GIRDER SECTIONS A3, B3, C3, D3, & F3 AS PER DRG SERIES #3 & COMPLETELY WELD & BOLT ALL FIG'S, WEBS, & DIAPHRAGMS
- 2.) FABRICATE ALL ITEMS AS SHOWN ON DRGS 4f, 4g, 4h, 4k, 4m, & 4n. (SHIMS C4, D4, & F4 MAY BE FAB'D AT A LATER TIME)
- 3.) CLAMP OR TACK WELD GUIDE R's pa & pc FIRMLY TO INNER WEBS OF ARCH GIRDER AS SHOWN ON DRGS 4a & 4b
- 4.) USING CENTRE PUNCH MARKS IN GUIDE R's - DRILL THRU GUIDE R & INNER WEB WITH TAP DRILL RECD FOR 8-11 UNC THREADS
- 5.) REMOVE GUIDE R's & REAM HOLES TO 18° (16°) & COUNTERSINK THE 8 BOTTOM HOLES AS SHOWN ON DRG 4a
- 6.) TAP HOLES IN ARCH GIRDER FOR 8-11 UNC THREADS
- 7.) REPLACE GUIDE R's & BOLT WITH BOLTS 'b1' & 'b2' IN AT LEAST 50% OF HOLES
- 8.) GRIND 3 RADIUS ON CORNERS OF GUIDE BARS AS SHOWN ON DRG 4a.
- 9.) LOCATE GUIDE BARS ON GUIDE R's AS SHOWN BEING SURE TO USE SHIMS AS NOTED AT TOP END OF BARS pas & pat.
- 10.) TACK WELD ONLY BARS pas & pat & STITCH WELD ALL OTHER BARS AS SHOWN ON DRG 4b EXCEPT AS NOTED (FIELD SPACE 'D')
- 11.) USING HOLES WHERE SUPPLIED IN GUIDE BARS pas & pat & C FIELD SPACE TYPE 'D', MARK GUIDE R 'pc' USING SAME SIZE OF DRILL (TAP DRILL FOR 2-13 UNC THREADS). NOTE: DO NOT DRILL THRU AT THIS TIME.
- 12.) REMOVE GUIDE BARS pas & pat & GRIND SMOOTH ALL TACK WELDS
- 13.) UNBOLT GUIDE R's & REMOVE GUIDE ASS'YS IN TWO PIECES
- 14.) DRILL THRU GUIDE R 'pc' WITH TAP DRILL FOR 2-13 UNC THREADS (LOCATIONS MARKED IN STEP 11.)
- 15.) TAP THESE HOLES IN GUIDE R & REAM & COUNTERSINK GUIDE BARS AS SHOWN ON DRG 4b (BOLTED GUIDE BAR MOUNTING DETL)
- 16.) BOLT GUIDE BARS pas & pat IN POSITION USING BOLTS 'b3'
- 17.) INSERT BOLTS 'b3' C FIELD SPACE THRU GUIDE BARS & SECURE WITH NUT 'n1' TO PREVENT LOSS DURING SHIPMENT.
- 18.) PRIME COAT GUIDE ASS'YS & SET ASIDE FOR SHIPMENT

NOTE:- THIS PROCEDURE WILL BE REPEATED FOR REMAINING ARCH GIRDER SECTIONS G3, H3, K3, M3, & N3 EXCEPT THAT GUIDE R & GUIDE BAR MARKS WILL CHANGE. SEE DRG 4d

No.	DIV.	1	2	3	4	5	6	7	8	9	10	DATE	CH'KD	DATE	MADE BY	BRITAIN STEEL LTD. NEW WESTMINSTER B.C.	3R/3001167	REVISION	DWG. No.	REV.
																		1420	4c	4c



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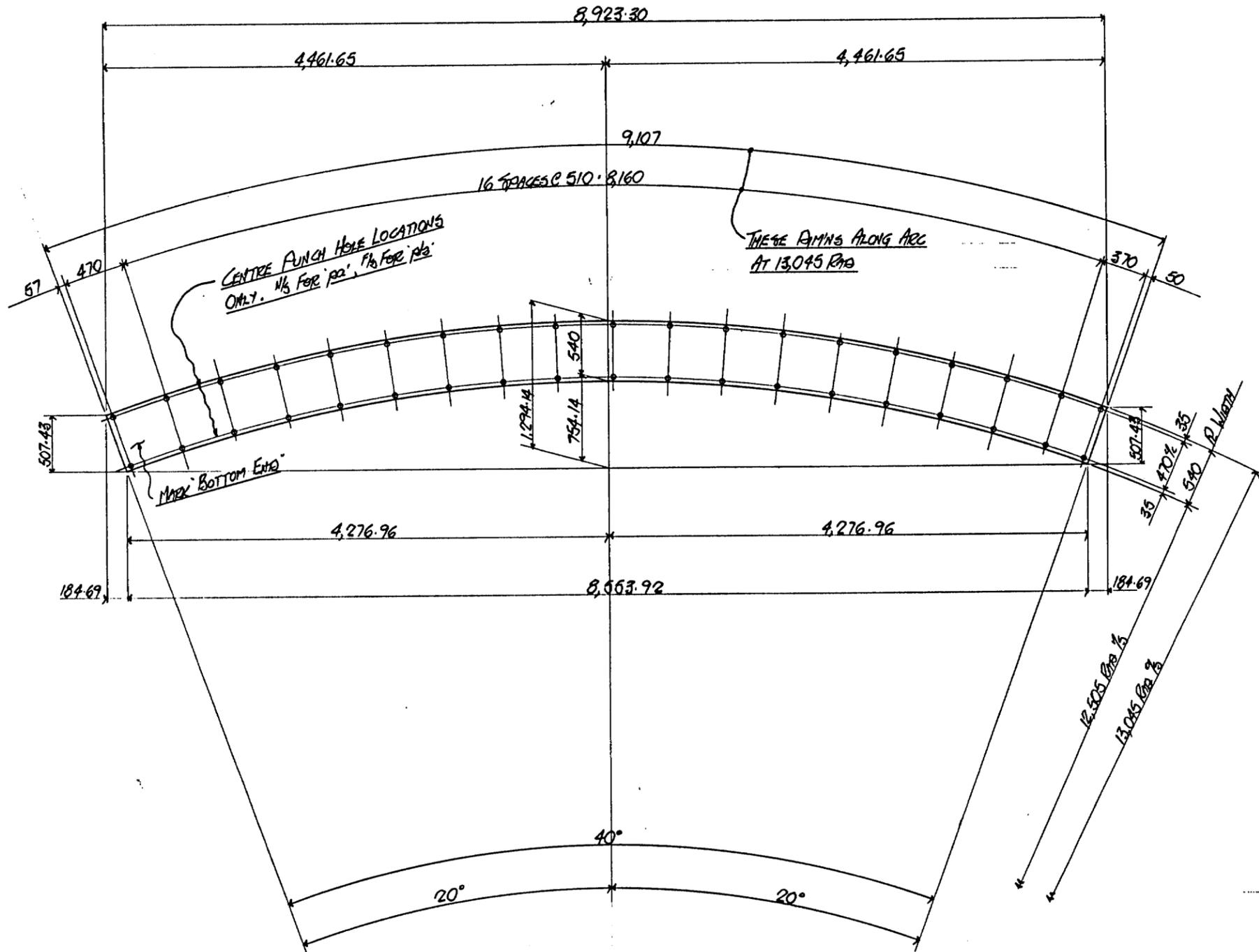
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3R/3001168

	MATERIAL	G40.21 (44W) w/n	NO	BY	DATE	REVISION
	SURF. PREP.	PAINT	DETAILS SOUTH WIND SCREEN GUIDES ASSEMBLY & MOUNTING			
SEE MEMO		FOR 4.2M TELESCOPE DOME LA PALMA				
DRAWN	DATE	CHECKED	DATE	DRAWING NO.		
BR				1420-4d		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, S.C.						
SHOP DEPARTMENT						

- GENERAL NOTES**
- 1) FOR DETAILS OF ITEMS ON THIS DRAWING SEE ASSY 41, 41.1, 41.1.1, 41.1.1.1.
 - 2) FOR DETAILS OF TRAPEZOIDAL TRAPES IN GUIDE BARS SEE ASSY 46.
 - 3) FOR ASSEMBLY & MOUNTING PROCEDURE SEE ASSY 41.
 - 4) FOR DETAILS OF ARCH GREASER SEE ASSY 41.
 - 5) FOR FIELD ERECTION OF THESE ITEMS SEE ASSY 41.

MVF



— ONE REQ^d - MK 100 } IDENTICAL EXC. FOR CTR PUNCH HOLES FACE
 — ONE REQ^d - MK 105 }
 GUIDE R UPPER PORTION

MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W	L	WEIGHT
100	ONE	R	12.7 THICK	CUT TO	CONTOUR (1/2 R)	44W	6120		
105	ONE	R	12.7 THICK	CUT TO	CONTOUR (1/2 R)	44W	5120		
31	31	Bolt	3/8"	Cap Screw	1 1/2"	A307			
4	4	Bolt	3/8"	Flat Head	1 1/2"	A307			
24	24	Bolt	1/2"	Flat Head	2"	A307			
8	8	Nut	3/8"	Hex	For 2"	A307			

GENERAL NOTES

- 1) FOR ASSEMBLY WITH GUIDE BARS - LOWER PORTION OF GUIDE R SEE DRS 4a, 4c, & 4d
- 2) FOR MATCH-ROLLING TO ARCH GIRDER INNER WEB SEE DRS 4a, 4c, & 4d

3R/3001169



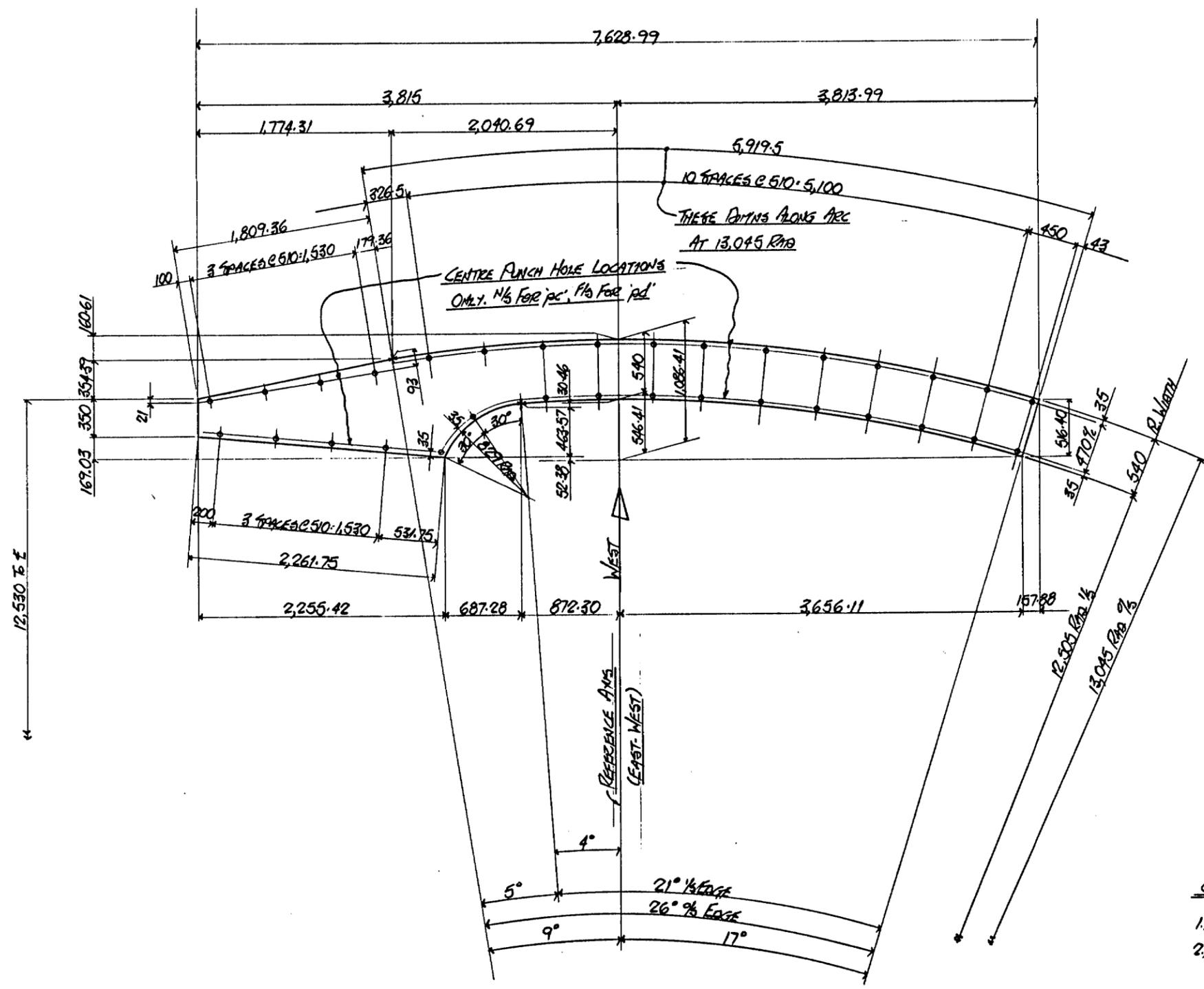
MATERIAL	G40.21 (44W) w/n	DETAILS	SW/SOON GUIDES SUB-ASSEMBLY
SURF. PREP. & PAINT	SEE MEMO	ITEM CUTTING	
OPEN HOLES	NONE	FOR	4.0M TELESCOPE DOCK
PAINT ON FINAL ASSEMBLY		La Pampa	
DRAWN	DATE	CHECKED	DATE
RR			
DRAWING No.		1420-4P	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.			

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SHOP DEPARTMENT / INS / F / S / O / M / T / P / SH / DP / AS / PA / ER / No PRINTS



— ONE REQ^d. MK 'jc' } IDENTICAL EXC. FOR CTR. PUNCHED FACE
 — ONE REQ^d. MK 'pd' }
 GURSE R. LOWER PORTION

MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W	H	WEIGHT
1	pc	ONE	R	R2.7 THICK	CUT TO	CONTOUR (2'R)	44W	5	21	
2	pd	ONE	R	R2.7 THICK	CUT TO	CONTOUR (2'R)	44W	6	21	
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GENERAL NOTES

- 1) FOR ASSEMBLY WITH GURSE RACK & UPPER PORTION OF GURSE R. SEE DRESS Aa & Ad
- 2) FOR MATCH-DRILLING TO ARCH STRONGER HINDER WEBS SEE DRESS Aa & Ac

3R/300/170

	MATERIAL	G40.21 (44W) w/n	No. BY DATE REVISION	
	SURF. PREP. & PAINT	SEE MEMO	DETAILS W/ SCREEN GURSES SUR. 1997 ITEM CUTTING	
	OPEN HOLES	NONE	FOR 4.2M TELESCOPE DOME LA PALMA	
	POINT ON FINAL ASSEMBLY			
DRAWN	DATE	CHECKED	DATE	DRAWING No. 1420-4g
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				
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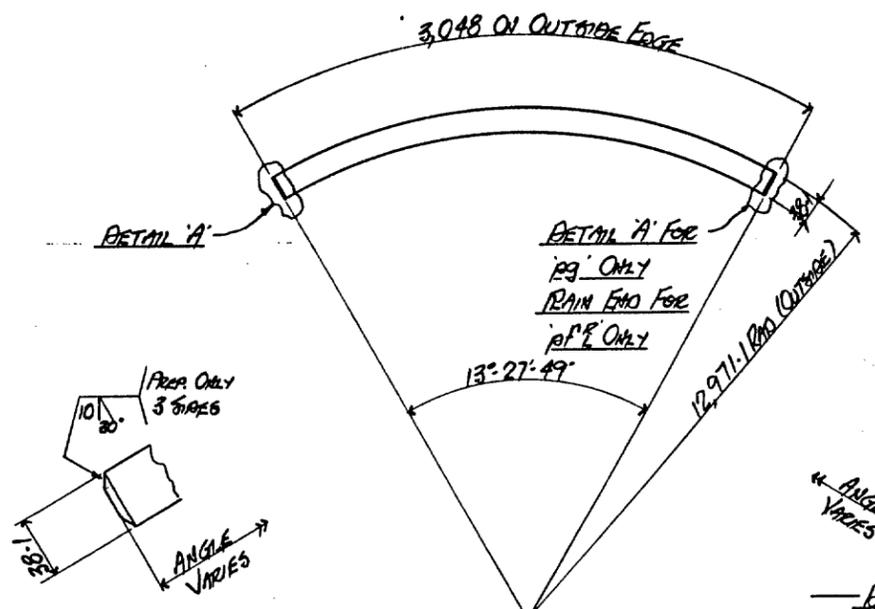
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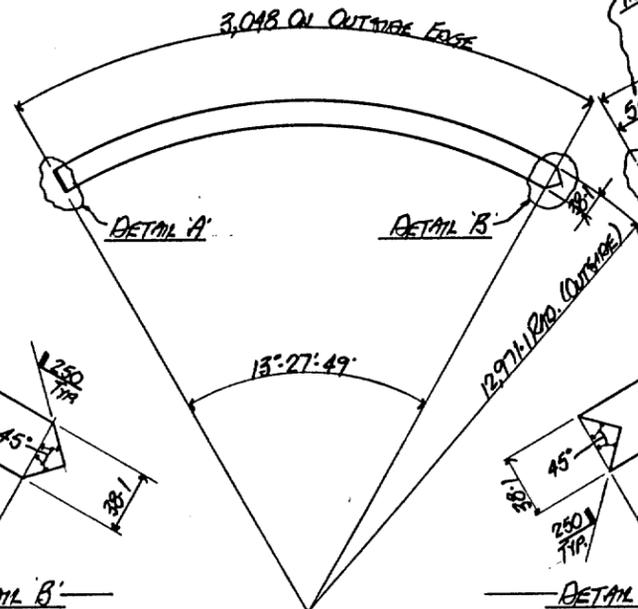
MATERIAL BILL
BRITTAIN STEEL LTD.

CONTRACT 1420

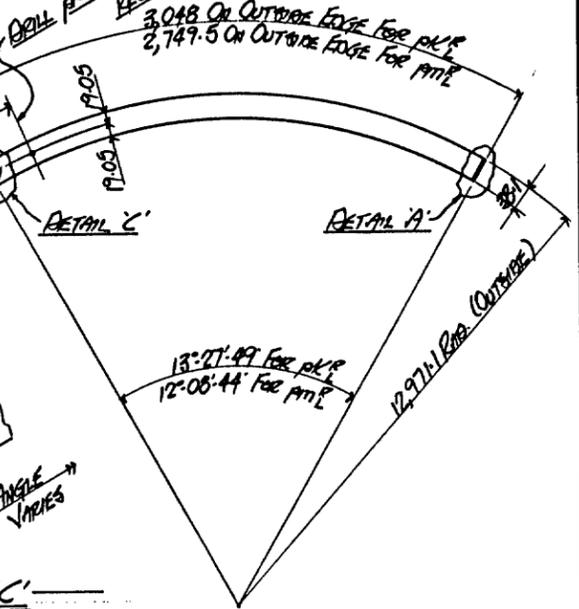
NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W. 1	W. 2	WEIGHT
1	pk ^R	ONE	BAR	38-14	3,048	ROLLED (16")	C08B	6	22	
2	pk ^L	ONE			3,048					
3										
4	pg	2			3,048					
5										
6	pk ^R	ONE			3,067					
7	pk ^L	ONE			3,067					
8										
9	pk ^R	ONE			3,048					
10	pk ^L	ONE			3,048					
11										
12	pm ^R	ONE			2,749.5				5	23
13	pm ^L	ONE			2,749.5				5	23
14										
15	pn ^R	ONE			3,048					5
16	pn ^L	ONE			3,048					5
17										
18	pg	2			3,048					
19										
20	ps ^R	ONE			3,067					
21	ps ^L	ONE			3,067					
22										
23	pk ^R	ONE			3,048					
24	pk ^L	ONE			3,048					
25										
26	pv ^R	ONE			1,956					5
27	pv ^L	ONE			1,956					5
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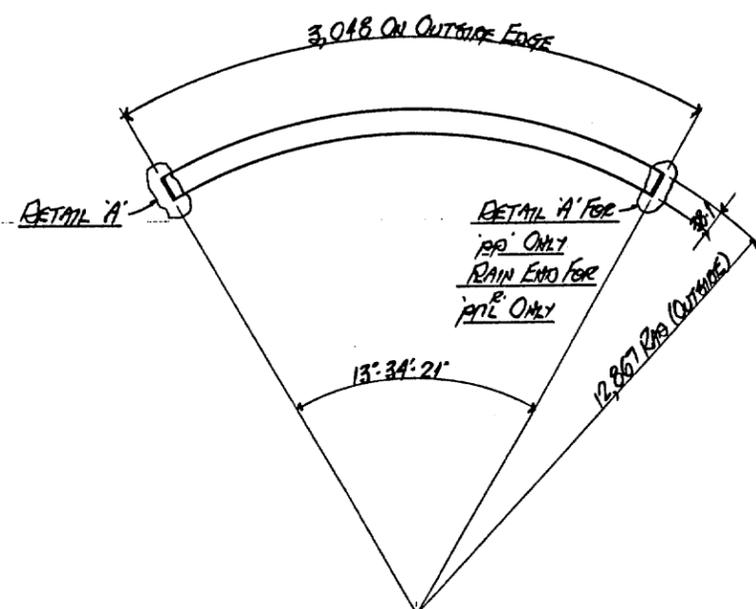
ONE REQ^d - MK pk^R (AS SHOWN)
 ONE REQ^d - MK pk^L (OPP. HAND)
 2 REQ^d - MK pg
 OUTER GUIDE BARS



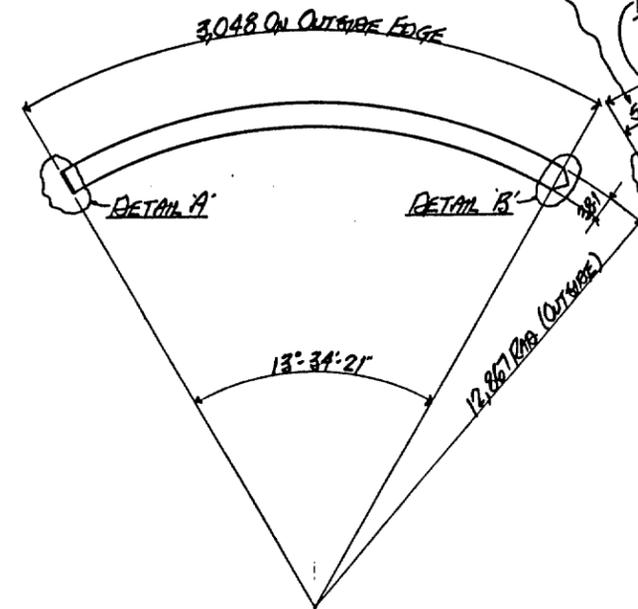
ONE REQ^d - MK pk^R (AS SHOWN)
 ONE REQ^d - MK pk^L (OPP. HAND)
 OUTER GUIDE BARS



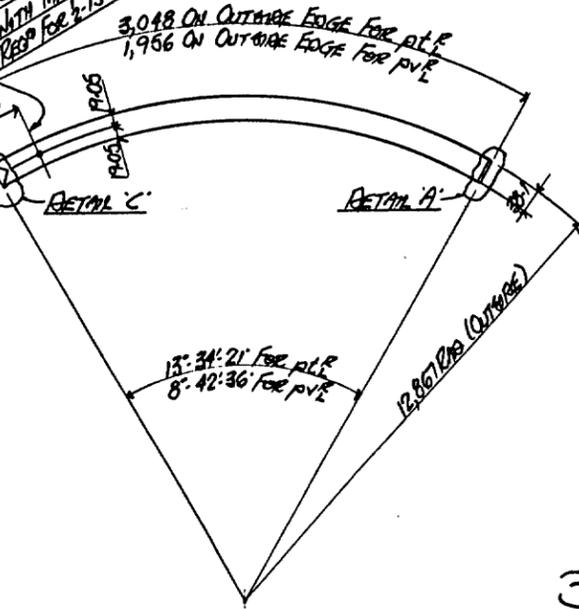
ONE REQ^d - MK pk^R (AS SHOWN)
 ONE REQ^d - MK pk^L (OPP. HAND)
 ONE REQ^d - MK pm^R (AS SHOWN)
 ONE REQ^d - MK pm^L (OPP. HAND)
 OUTER GUIDE BARS



ONE REQ^d - MK pn^R (AS SHOWN)
 ONE REQ^d - MK pn^L (OPP. HAND)
 2 REQ^d - MK pg
 OUTER CENTRE GUIDE BARS



ONE REQ^d - MK ps^R (AS SHOWN)
 ONE REQ^d - MK ps^L (OPP. HAND)
 OUTER CENTRE GUIDE BARS



ONE REQ^d - MK pk^R (AS SHOWN)
 ONE REQ^d - MK pk^L (OPP. HAND)
 ONE REQ^d - MK pv^R (AS SHOWN)
 ONE REQ^d - MK pv^L (OPP. HAND)
 OUTER CENTRE GUIDE BARS

GENERAL NOTES
 1.) FOR FINAL LOCATIONS OF ITEMS ON THIS DRAWING SEE PAGES 4a & 4d

3R/3001171

BRITTAIN logo and project information including 'MATERIAL', 'SURF. PREP & PAINT', 'OPEN HOLES', 'DRAWN', 'DATE', 'CHECKED', 'DATE', 'DRAWING NO. 1420-4h', and 'BRITTAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.'

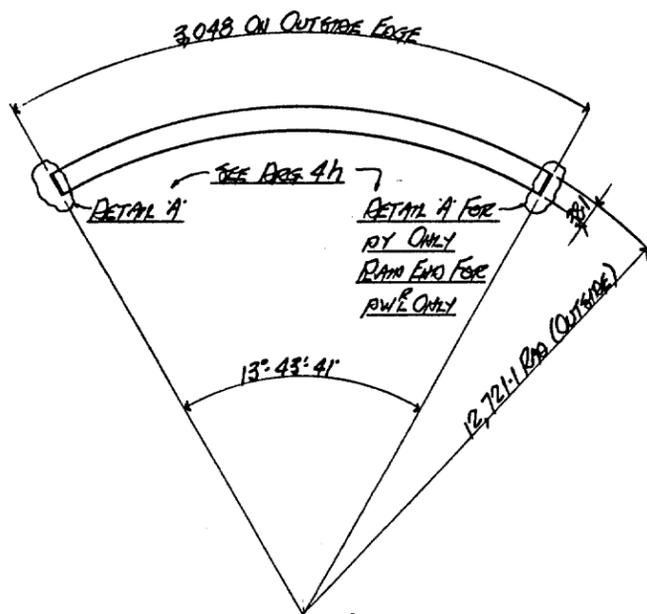
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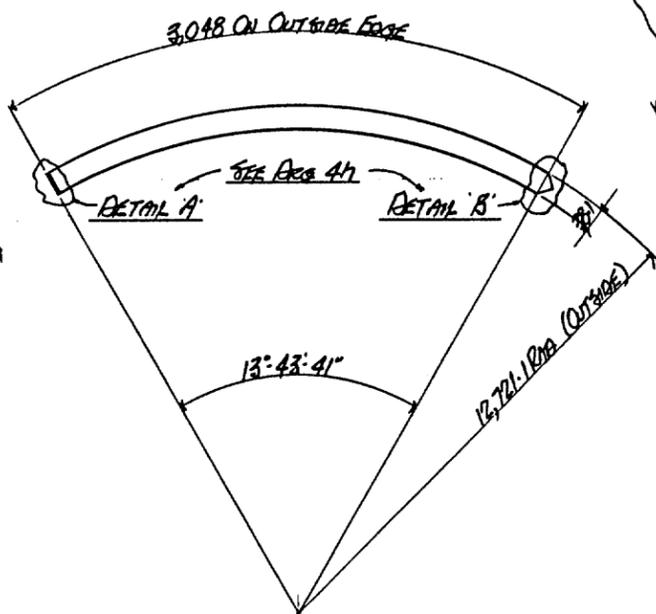
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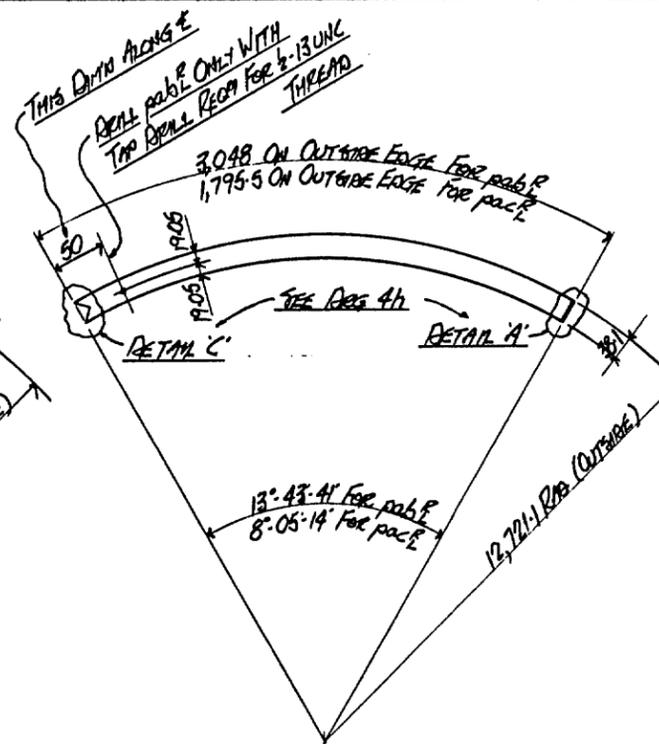
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1	AWP	ONE	BAR	38.14	3.048	ROLLER (1/2")	1018	5.22	
2	AWL	ONE			3.048				
3									
4	RY	2			3.048				
5									
6	pac ^R	ONE			3.067				
7	pac ^L	ONE			3.067				
8									
9	pac ^R	ONE			3.048				
10	pac ^L	ONE			3.048				
11									
12	pac ^R	ONE			1.795.5				
13	pac ^L	ONE			1.795.5				
14									
15	pac ^R	ONE			3.048				
16	pac ^L	ONE			3.048				
17									
18	pac ^R	2			3.048				
19									
20	pac ^R	ONE			3.067				
21	pac ^L	ONE			3.067				
22									
23	pac ^R	ONE			3.048				
24	pac ^L	ONE			3.048				
25									
26	pac ^R	ONE			1.240.5				
27	pac ^L	ONE			1.240.5				
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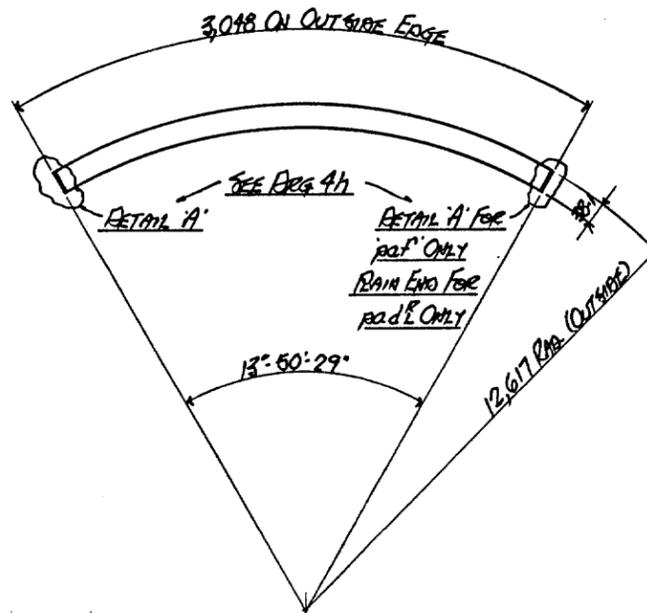
ONE REQ. MC PW^R (AS SHOWN)
ONE REQ. MC PW^L (OPP. HAND)
2 REQ. MC PY
INNER CENTRE GUIDE BARS



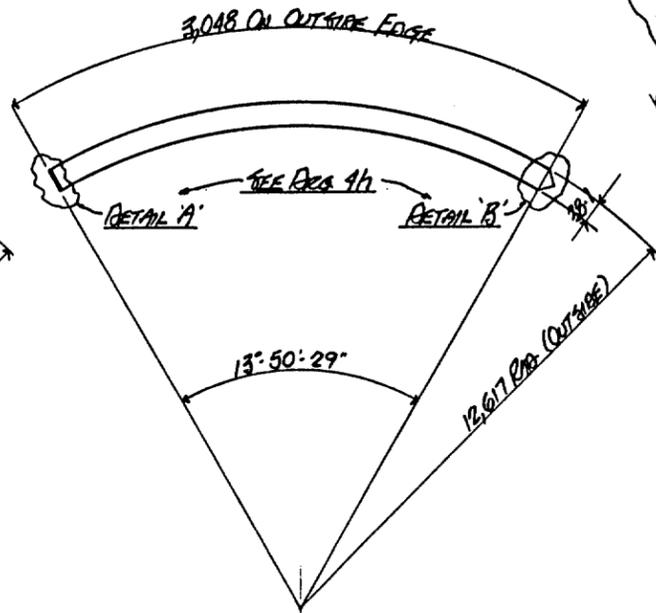
ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
INNER CENTRE GUIDE BARS



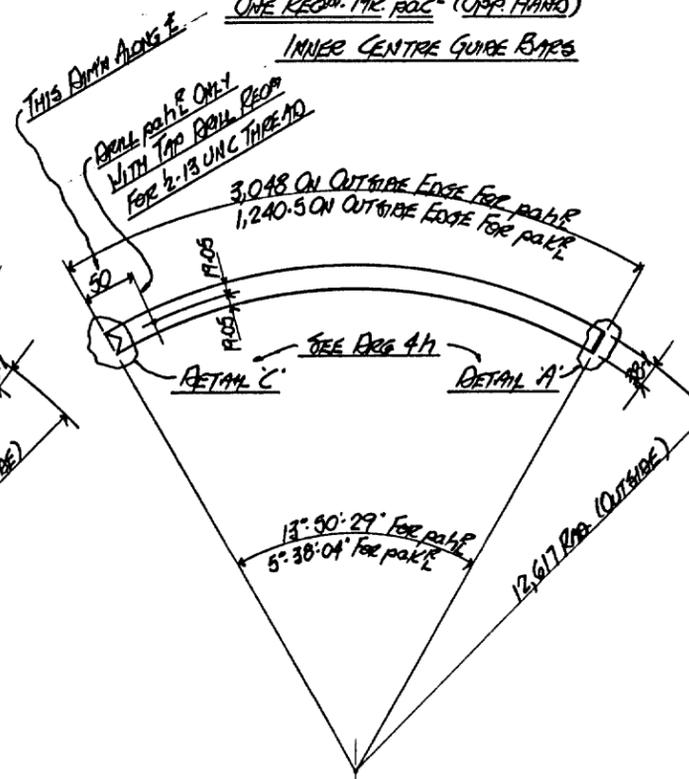
ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
INNER CENTRE GUIDE BARS



ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
2 REQ. MC pac^R
INNER GUIDE BARS



ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
INNER GUIDE BARS



ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
ONE REQ. MC pac^R (AS SHOWN)
ONE REQ. MC pac^L (OPP. HAND)
INNER GUIDE BARS

GENERAL NOTES

1.) FOR FINAL LOCATIONS OF ITEMS ON THIS DRS SEE DRS 1420-41

3R/300172



MATERIAL: Gal Rollon
SURF. PREP. & PAINT: SEE MEMO
OPEN HOLES: AS NOTED
PRINT ON FINAL ASSEMBLY

NO. BY DATE	REVISION
DETAILS BY: [Signature]	1/50000 GUIDES SUB-AS-37
FOR: 4.2M TILES COME DOWN LA PALMA	
DRAWN: BK	DATE: []
CHECKED: []	DATE: []
DRAWING NO. 1420-4K	

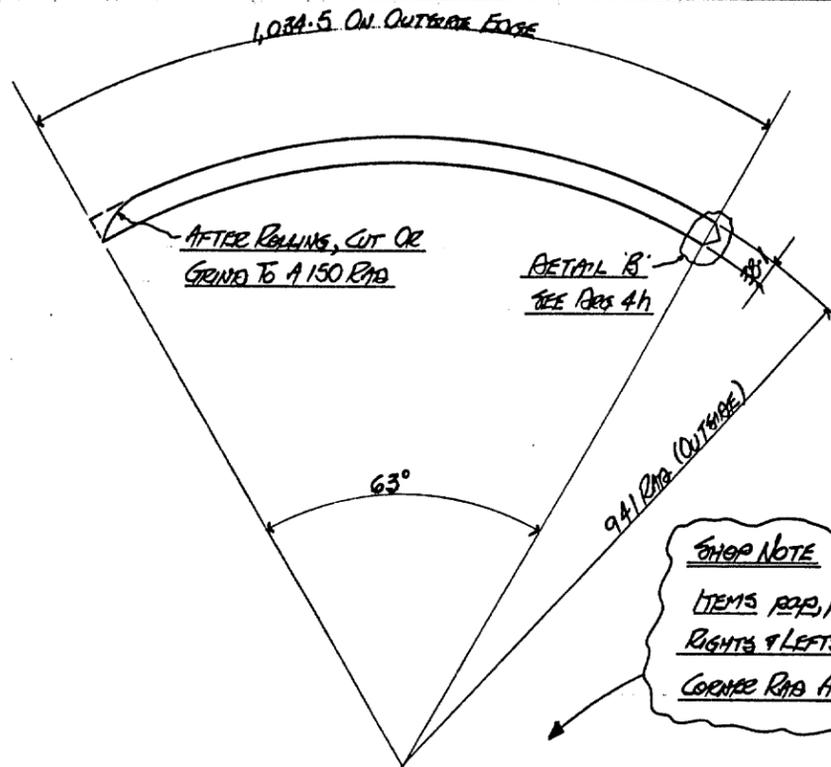
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.

SHOP DEPARTMENT INB / B / O / M / T / P / SH / DP / AS / PA / ER NO. PRINTS

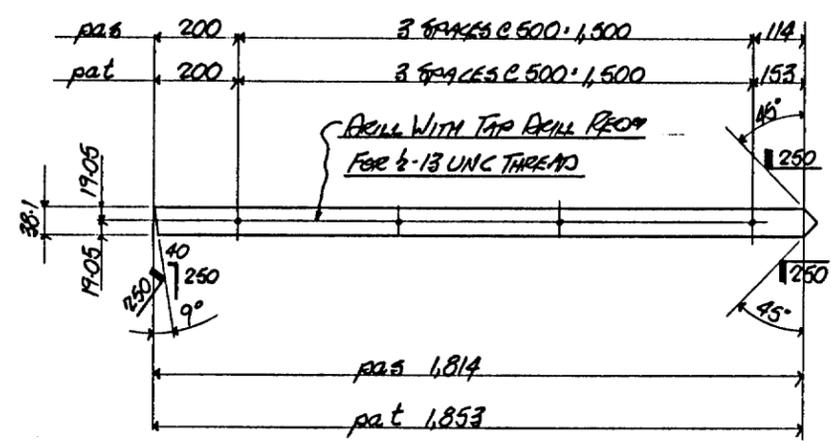
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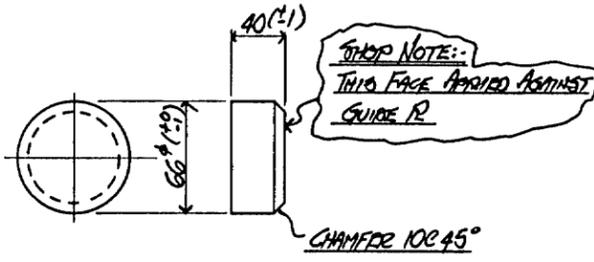
2 REQ^o-MK pap
INNER GUIDE BARS



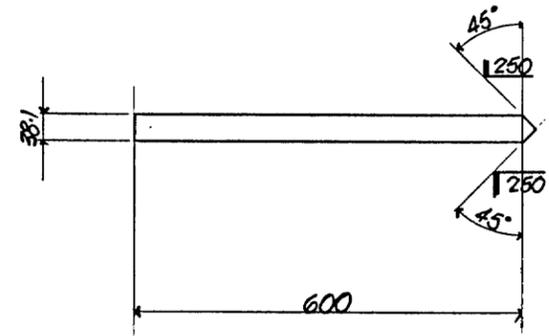
2 REQ^o-MK pas
OUTER GUIDE BARS

2 REQ^o-MK pat
OUTER CENTRE GUIDE BARS

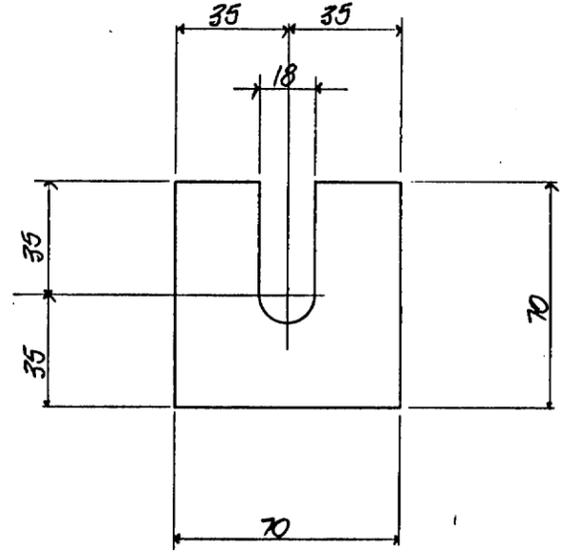
SHOP NOTE
ITEMS pas, pas, & pat WILL BECOME RIGHTS & LEFTS AFTER GRINDING. CORNER R10 AS SHOWN ON DRS 4a & 4d.



6 REQ^o-MK mtr
GUIDE BAR SPACERS



2 REQ^o-MK pav
INNER CENTRE GUIDE BARS



- 150 REQ^o-SHIM MK CA (6.35 THICK)
- 150 REQ^o-SHIM MK DA (3.18 THICK)
- 150 REQ^o-SHIM MK F4 (1.59 THICK)

MATERIAL BILL										CONTRACT 1420	
BRITAIN STEEL LTD.											
W/S	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W	L	WEIGHT	
1	part	2	R	38.1 THICK	CUT TO CONTOUR (1/2" R)		491				
2											
3	part	2	R	38.1 THICK	CUT TO CONTOUR (1/2" R)		491				
4											
5	part	2	BAR	38.1 ^o	1,053.5	ROLLED (1/2" R)		41018	5	22	
6											
7	part	2	BAR	38.1 ^o	1,833	(1/2" R)		41018	5	24	
8											
9	part	2	BAR	38.1 ^o	1,872	(1/2" R)		41018	5	24	
10											
11	part	2	BAR	38.1 ^o	619	(1/2" R)		41018	5	25	
12											
13	CA	150	R	70 x 6.35	70	(1/4" R)		A36			
14											
15	DA	150	R	70 x 3.18	70	(5/8" R)		A36			
16											
17	F4	150	R	70 x 1.59	70	(1/16" R)		A36			
18											
19	mtr	6	BAR	66 ^o	40	(TURN 28 ^o BAR)		A36			
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GENERAL NOTES

- 1.) FOR FINAL LOCATIONS OF ITEMS ON THIS DRAWING SEE DRS 4a & 4d
- 2.) USE 1/8" FOR 18 WIRE SLOTS IF PREFERRED

3R/3001174

	MATERIAL	As Noted	No. BY DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS VISUALLY CHECKED SUR-ASSY ITEM CUTTING	
	OPEN HOLES	As Noted	FOR 4.2" TELESCOPE DOWN LA FALLS	
	DRAWN	DATE	CHECKED	DATE
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.		DRAWING No. 1420-4n		

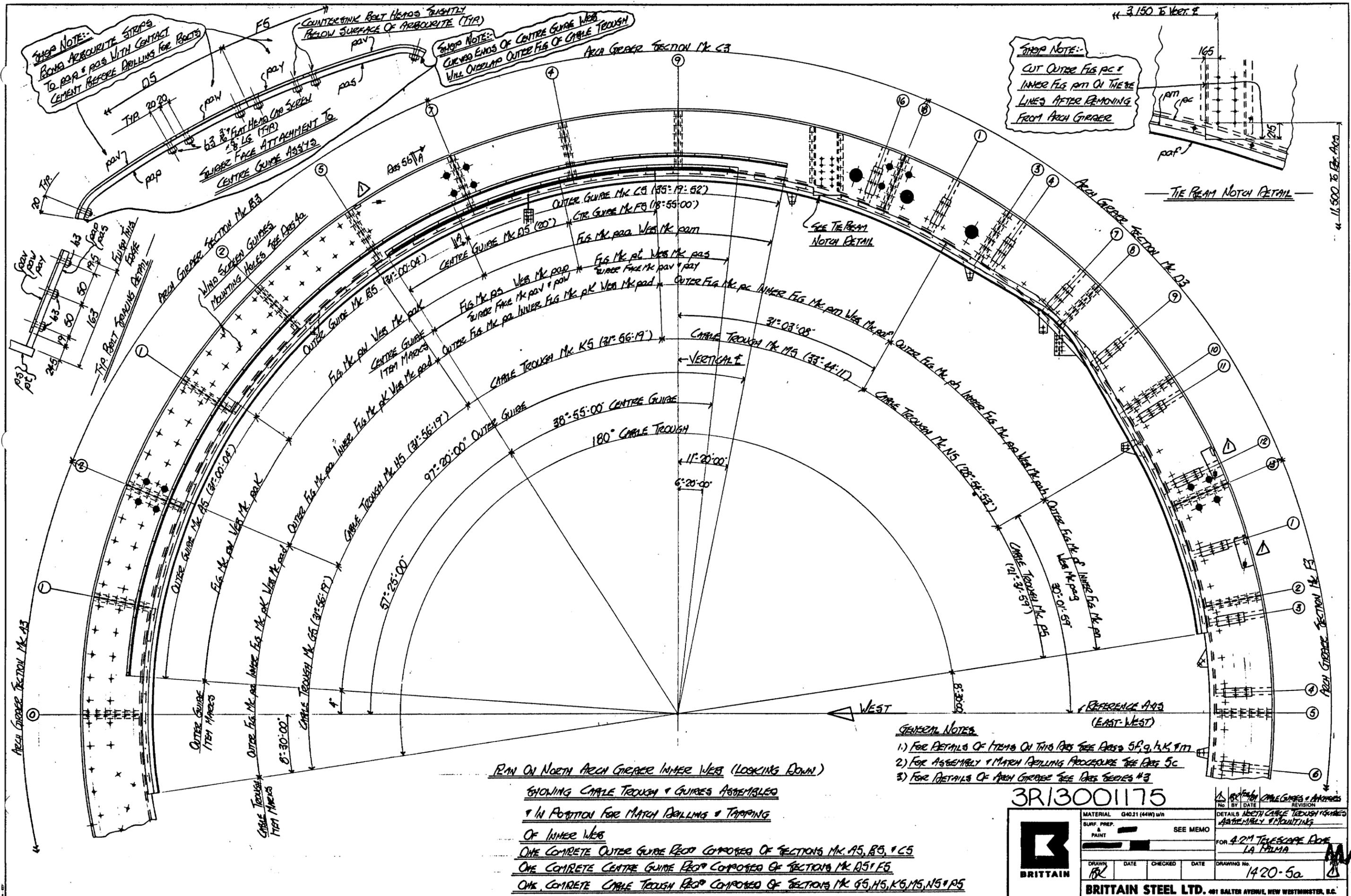
p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

SHOP DEPARTMENT

NO. P/S/O/M/T/P/SH/DP/AS/PA/ER

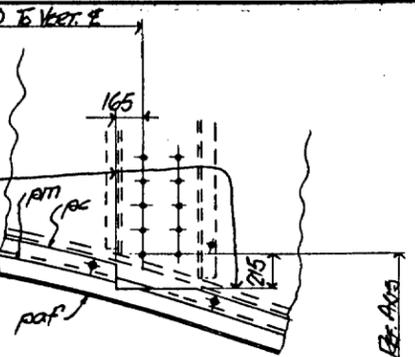


SHOP NOTE:-
 BOND ARBOURITE STRIPS
 TO BAR & PAS WITH CONTACT
 CEMENT BEFORE DRILLING FOR BOLTS

SHOP NOTE:-
 COUNTERSINK BOLT HEADS THIGHTLY
 BELOW SURFACE OF ARBOURITE (TYP)

SHOP NOTE:-
 CHAMFER ENDS OF CENTRE GUIDE WEB
 WILL OVERLAP OUTER FILE OF CABLE TROUGH

SHOP NOTE:-
 CUT OUTER FILE PC &
 INNER FILE PART ON THESE
 LINES AFTER REMOVING
 FROM ARCH GIRDER



- GENERAL NOTES**
- 1) FOR DETAILS OF ITEMS ON THIS DRAWING SEE PAGES 5F, 9, 13, 14, 17
 - 2) FOR ASSEMBLY & MATCH DRILLING PROCEDURE SEE PAGE 5C
 - 3) FOR DETAILS OF ARCH GIRDER SEE DRAWING SERIES #3

RUN ON NORTH ARCH GIRDER INNER WEB (LOOKING DOWN)
 SHOWING CABLE TROUGH & GUIDES ASSEMBLED
 & IN POSITION FOR MATCH DRILLING & TAPPING
 OF INNER WEB
 ONE CONCRETE OUTER GUIDE REGO COMPOSED OF SECTIONS MK. A5, B5, & C5
 ONE CONCRETE CENTRE GUIDE REGO COMPOSED OF SECTIONS MK. D5 & F5
 ONE CONCRETE CABLE TROUGH REGO COMPOSED OF SECTIONS MK. G5, H5, K5, M5, N5 & P5

3R/3001175

MATERIAL G40.21 (44K) W/B		REVISION	
SURF. PREP. & PAINT		SEE MEMO	
DRAWN BY BR		DRAWING NO. 1420-5a	
DATE		DATE	
CHECKED		DATE	
BRITAIN STEEL LTD. 401 BALLET AVENUE, NEW WESTMINSTER, B.C.			

CABLE TROUGH & GUIDES ASSEMBLY & MATCH DRILLING PROCEDURE TO ARCH GIRDER INNER WEB

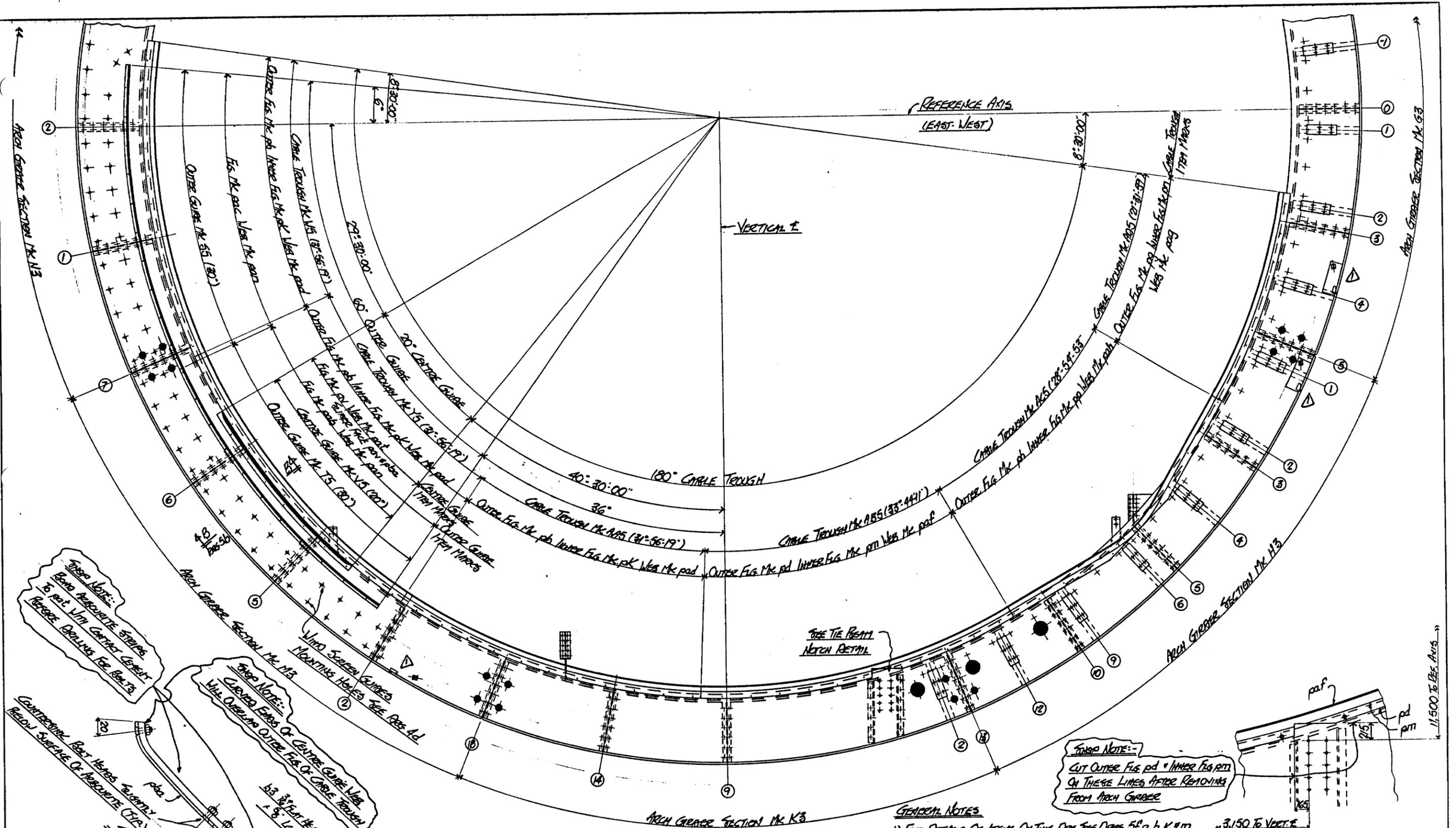
- 1.) FABRICATE ARCH GIRDER SECTIONS A3, B3, C3, D3, & F3 AS PER DRG SERIES #3 & COMPLETELY WELD & BOLT ALL FIG'S, WEBS, & REMAINS
- 2.) FABRICATE ALL ITEMS AS SHOWN ON DRGS 5f, 5g, 5h, 5k, & 5m
- 3.) CLAMP OR TACK WELD ALL FIG. R'S FOR OUTER & CENTRE GUIDES FIRMLY TO INNER WEB OF ARCH GIRDER AS SHOWN ON DRGS 5a & 5b
- 4.) USING CENTRE PUNCH MARKS IN FIG. R'S - DRILL THRU FIG. R'S & INNER WEB WITH TAP DRILL REQD FOR 1/2-13 UNC THREADS
- 5.) REMOVE FIG. R'S & REAM HOLES TO 14° (16°) & COUNTER BORE THE HOLES FOR CENTRE GUIDE FIG. R'S AS SHOWN ON DRG 5b.
- 6.) TAP HOLES IN ARCH GIRDER FOR 1/2-13 UNC THREADS
- 7.) REFACE FIG. R'S & BOLT WITH BOLTS 'b1' & 'b2' IN ALL THE HOLES
- 8.) FIT & STITCH WELD OUTER & CENTRE WEBS TO THEIR RESPECTIVE FIG'S AS SHOWN ON DRG 5b.
- 9.) REMOVE OUTER GUIDE ASSYS A5, B5, & C5, PRIME COAT & SET ASIDE FOR SHIPMENT.
- 10.) ATTACH ARBOURITE SLIPPER STRIPS TO CENTRE GUIDE WEBS AS SHOWN ON DRG 5a.
- 11.) REMOVE CENTRE GUIDE ASSYS D5 & F5, PRIME COAT (DO NOT PAINT ARBOURITE) & SET ASIDE FOR SHIPMENT.
- 12.) CLAMP OR TACK WELD CABLE TROUGH OUTER FIG. R'S TO ARCH GIRDER INNER WEB AS SHOWN ON DRGS 5a & 5b
- 13.) USING CENTRE PUNCH MARKS IN FIG. R'S - DRILL THRU FIG. R'S & INNER WEB WITH TAP DRILL REQD FOR 1/2-13 UNC THREADS
- 14.) REMOVE FIG. R'S & REAM HOLES TO 14° (16°) & COUNTER BORE AS SHOWN ON DRG 5b
- 15.) TAP HOLES IN ARCH GIRDER FOR 1/2-13 UNC THREADS
- 16.) REFACE FIG. R'S & BOLT WITH BOLTS 'b1' IN ALL THE HOLES
- 17.) FIT & TACK WELD CABLE TROUGH WEB R'S TO CABLE TROUGH OUTER FIG. AS SHOWN ON DRGS 5a & 5b
- 18.) FIT & TACK WELD CABLE TROUGH INNER FIG. TO CABLE TROUGH WEB AS SHOWN ON DRGS 5a & 5b.
- 19.) SEAL WELD INNER & OUTER FIGS TO WEB (SIMULTANEOUSLY TO MINIMIZE DISTORTION)
- 20.) REMOVE CABLE TROUGH ASSYS G5, H5, K5, M5, N5, & P5, PRIME COAT & SET ASIDE FOR SHIPMENT.

NOTE:- THIS PROCEDURE WILL BE REPEATED FOR REMAINING ARCH GIRDER SECTIONS G3, H3, K3, M3, & N3 EXCEPT THAT FIG. R. & WEB R. MARKS & ANGULAR LOCATIONS WILL CHANGE. SEE DRG 5d.

3R/3001177

No. DIV.	1	2	3	4	5	6	7	8	9	10
	DATE									
MADE BY										
DATE										
CH'KD										
DATE										
BRITAIN STEEL LTD. B.C.										
NEW WESTMINSTER										
REVISION										
CONTRACT										
DWG. No.										
REV.										
1420										
5c										
MA										

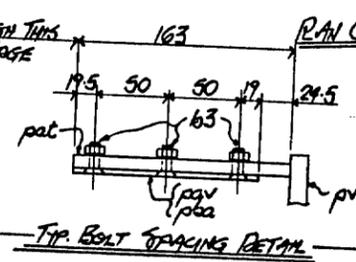




GEN. NOTE:-
 BONA ANCHORAGE STEPS
 TO BE SET WITH CENTRET
 BEFORE BEELLING FOR BOLTS

GEN. NOTE:-
 CURVED ENDS OF CENTRE GUIDE WEBS
 WILL OVERLAP OUTER FIB OF CABLE TROUGH

CONTINUING BOLT HEADS TO BE SET
 REAR SURFACE OF ANCHORAGE (E/F)
 GUARDER FACE ATTACHMENT TO
 CENTRE GUIDE ASSEMBLY



PLAN ON SOUTH ARCH GIRDER INNER WEBS (LOOKING DOWN)
 SHOWING CABLE TROUGH & GUIDES ASSEMBLED
 IN POSITION FOR MATCH BEELLING & TAPPING
 OF INNER WEBS

3R/3001178

ONE COMPLETE OUTER GUIDE REOP COMPOSED OF SECTIONS MK 55 & 75
 ONE COMPLETE CENTRE GUIDE REOP COMPOSED OF SECTION MK V5
 ONE COMPLETE CABLE TROUGH REOP COMPOSED OF SECTIONS MK W5, 75, A45, A55, A65, & A95

GENERAL NOTES

- 1) FOR DETAILS OF ITEMS ON THIS DESS SEE DESS 5P, 9, 11, 15, & 17
- 2) FOR ASSEMBLY & MATCH BEELLING PROCEDURE SEE DESS 5C
- 3) FOR DETAILS OF ARCH GIRDER SEE DESS SERIES #3

GEN. NOTE:-
 CUT OUTER FIB OF INNER FIB WITH
 ON THESE LINES AFTER REMOVING
 FROM ARCH GIRDER

3,150 TO VERT. E
 TIE BEAM NOTCH DETAIL



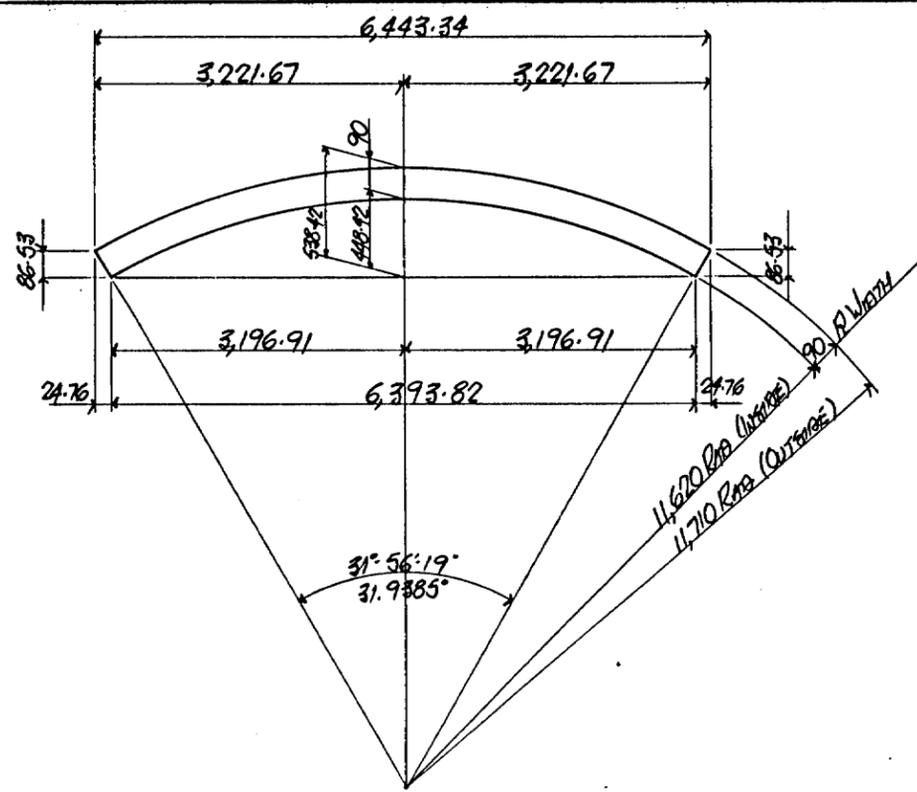
MATERIAL	G40.21 (44W) w/n				
SURF. PREP & PAINT	SEE MEMO				
NO.	BY DATE				
DETAILS SOUTH CABLE TROUGH TROUGH'S ASSEMBLY & MOUNTING					
FOR 4.2M TELESCOPE DOWNS					
L.A. PRIMA					
DRAWN	DATE	CHECKED	DATE	DRAWING NO.	REV
FK				1420-5d	Δ
BRITAIN STEEL LTD. 401 BALTER AVENUE, NEW WESTMINSTER, B.C.					
SHOP DEPARTMENT					
INSTRUMENTS					

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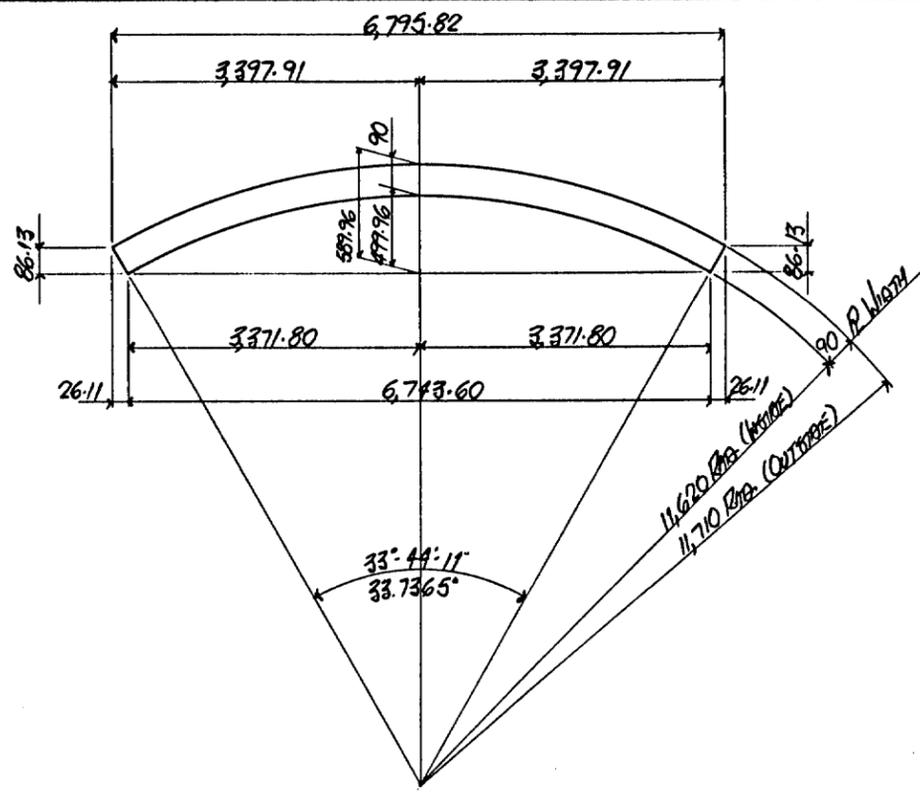
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

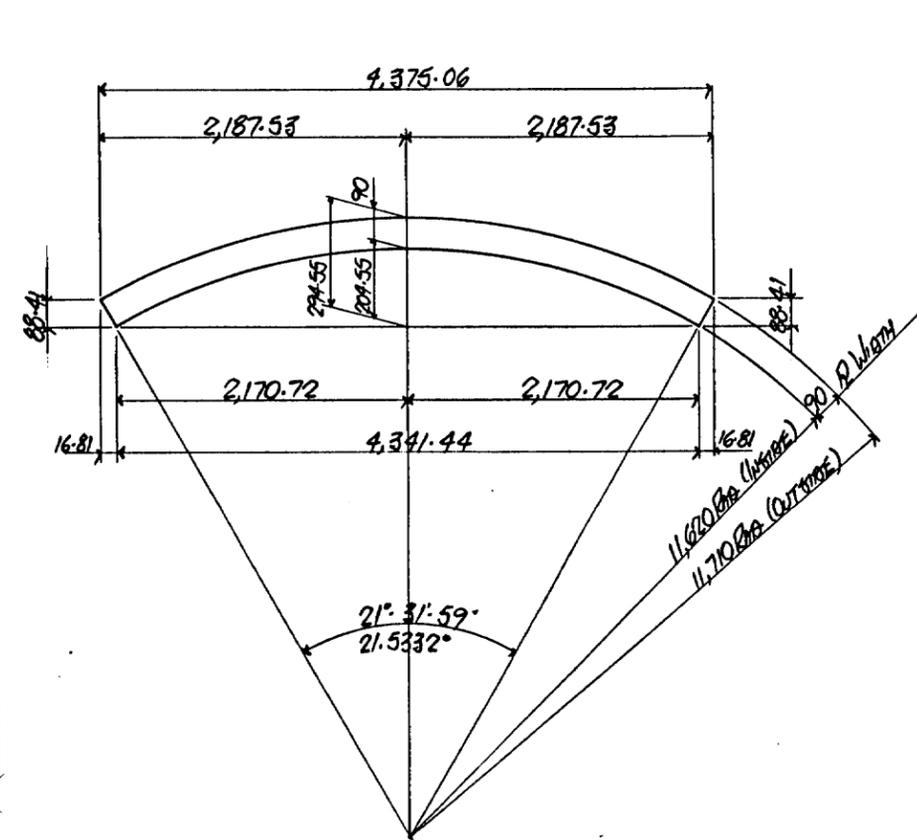
11,500 TO DESS AXIS



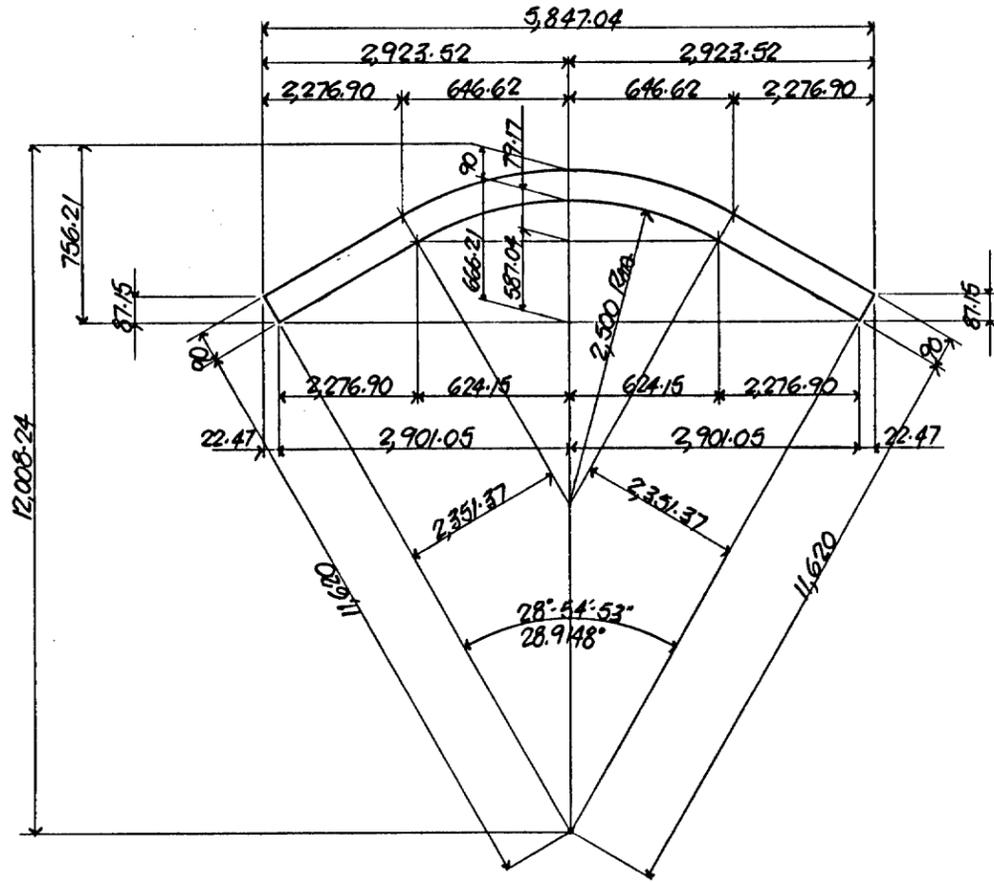
6 REQ^d. MK PK
CABLE TROUGH INNER FLG.



2 REQ^d. MK PM
CABLE TROUGH INNER FLG.



2 REQ^d. MK PN
CABLE TROUGH INNER FLG.



2 REQ^d. MK PP
CABLE TROUGH INNER FLG.

MATERIAL BILL										CONTRACT 1420	
BRITAIN STEEL LTD.											
LINE	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	NO.	LINE	WEIGHT	
1	PK	6	R	9.5 THICK CUT TO CONTOUR (3/8\"/>							

GENERAL NOTES

- 1.) FOR ASSEMBLY WITH WEB & OUTER FLG SEE PAGES 50 & 51
- 2.) FOR NESTING & CUTTING INSTRUCTIONS SEE PAGES 57 & 59.

3R/3001180

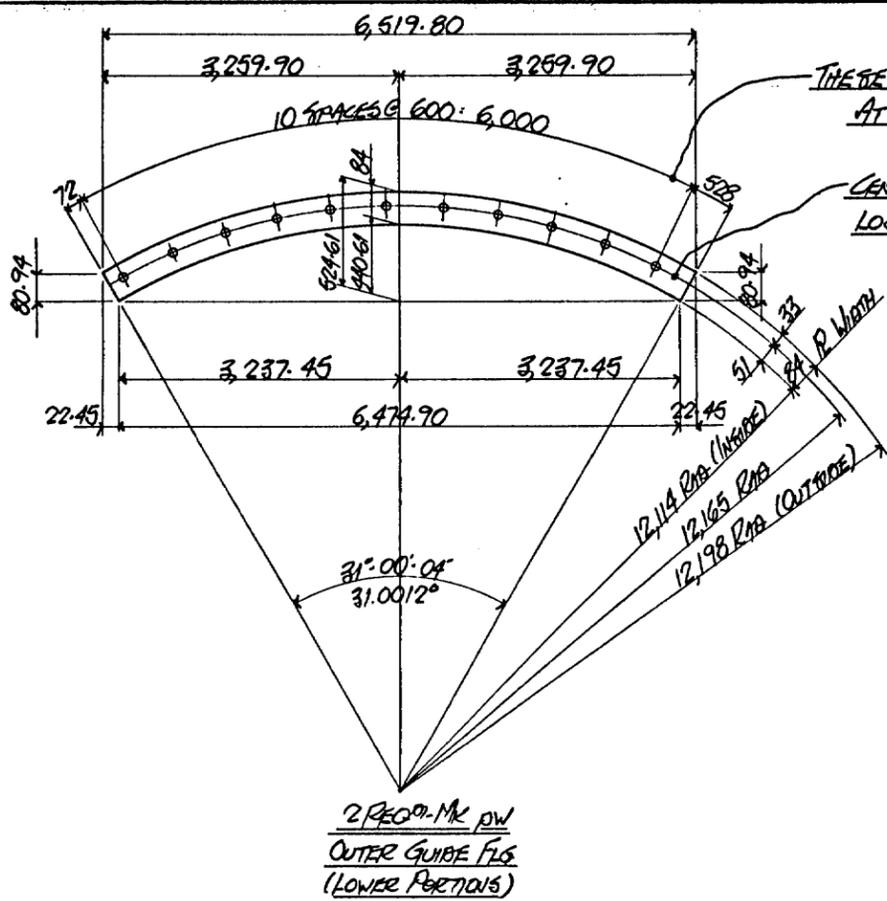
	MATERIAL	G40.21 (44W) W/R	NO.	BY	DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS CABLE TROUGH SUB-ASSEMBLY ITEM CUTTING			
	OPEN HOLES	None	FOR 4-27 TELESCOPE DOCK L4 PARTS			
	PRINT ON FINAL ASSEMBLY		DRAWING NO. 1420-5g			
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.						

p-abcdefghijklmnpstvw

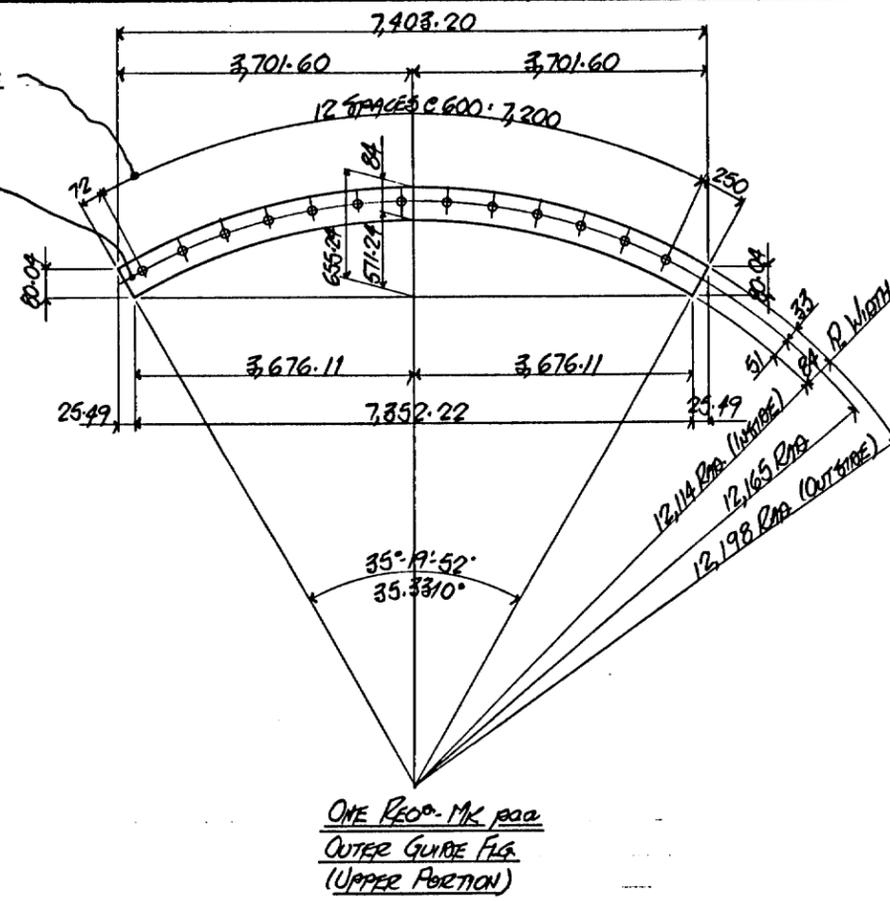
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

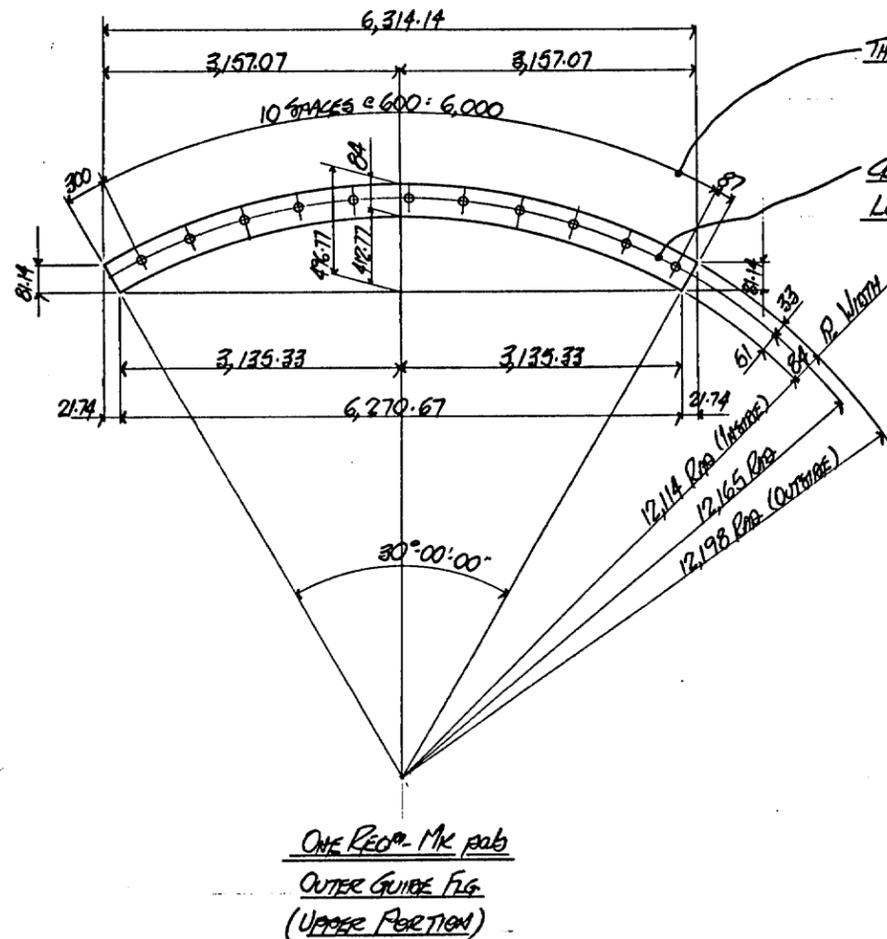
SHOP DEPARTMENT / INS / F / S / O / M / T / P / SH / DP / AS / PA / ER / NO PRINTS



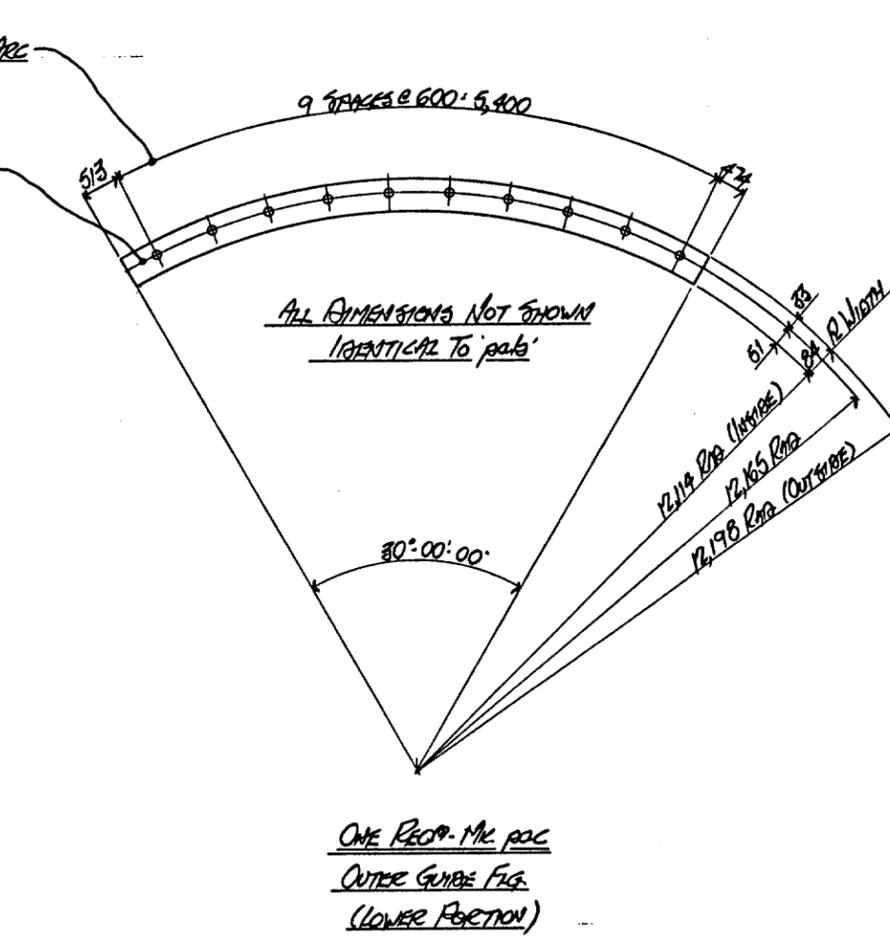
2 REQ^d. MK pw
OUTER GUIDE FLG
(LOWER PORTION)



ONE REQ^d. MK paa
OUTER GUIDE FLG
(UPPER PORTION)



ONE REQ^d. MK pab
OUTER GUIDE FLG
(UPPER PORTION)



ONE REQ^d. MK pac
OUTER GUIDE FLG
(LOWER PORTION)

MATERIAL BILL										CONTRACT 1420	
BRITAIN STEEL LTD.											
NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W	S	WEIGHT	
1	pw	2	R	9.5 THICK CUT TO CONTOUR (38" R)			44W	519			
2											
3	paa	ONE	R	9.5 THICK CUT TO CONTOUR (38" R)			44W	519			
4											
5	pab	ONE	R	9.5 THICK CUT TO CONTOUR (38" R)			44W	519			
6											
7	pac	ONE	R	9.5 THICK CUT TO CONTOUR (38" R)			44W	519			
8											
9											
10											
11											
12											
13											
14											
15											
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55											

- GENERAL NOTES**
- 1) FOR ASSEMBLY WITH WEB SEE DRESS 5a & 5d
 - 2) FOR MATCH DRILLING TO ARCH GROOVER INNER WEB SEE DRESS 5a, 5c & 5d
 - 3) FOR NESTING & CUTTING INSTRUCTIONS SEE DRESS 5c.

3R/3001182

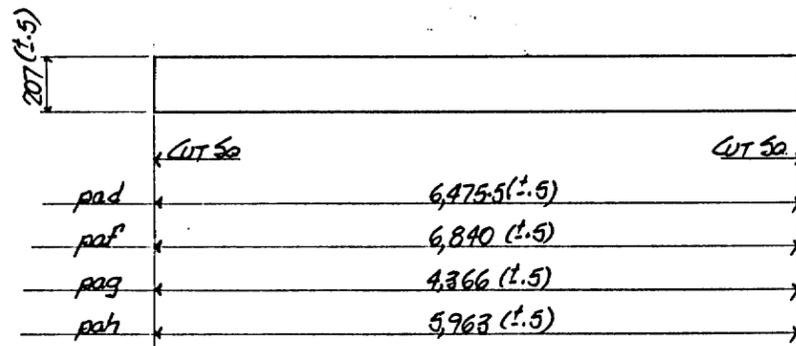
	MATERIAL	G4021 (44W) w/n	NO	BY	DATE	REVISION
	SURF. PREP.	PAINT	SEE MEMO			
	OPEN HOLES	None	FOR 4.2" TELESCOPE DOME			
	PRINT ON FINAL ASSEMBLY					
DRAWN	DATE	CHECKED	DATE	DRAWING NO.	REV	
BK				1420-5K		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, S.C.						
SHOP DEPARTMENT						

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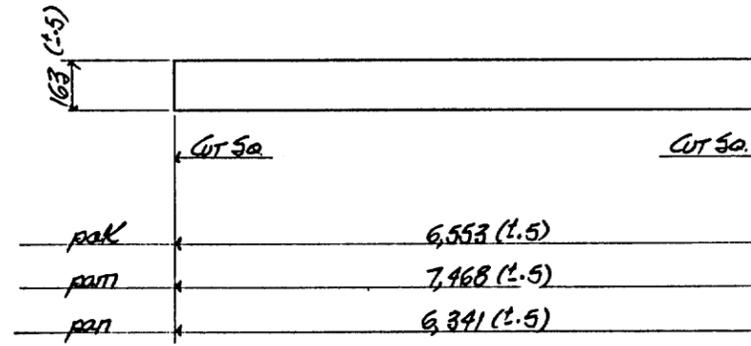
MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

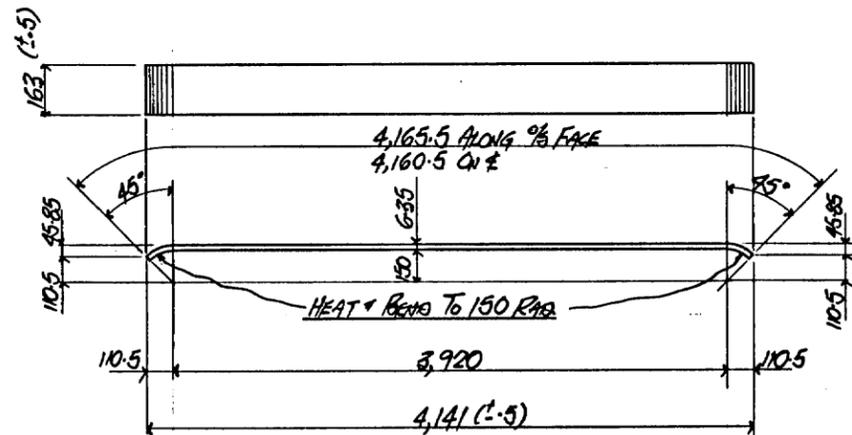
LINE NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W. DIM.	WEIGHT
1	pad	6	R	207-6-35	6,475.5	(4'R)	44W	5.1	
2	pad	2	R	207-6-35	6,840	(4'R)	44W	5.2	
3	pad	2	R	207-6-35	4,366	(4'R)	44W	5.3	
4									
5	pad	2	R	207-6-35	5,963	(4'R)	44W	5.4	
6									
7	pad	2	R	207-6-35	5,963	(4'R)	44W	5.4	
8									
9	pad	2	R	163-6-35	6,553	(4'R)	44W	6.5	
10									
11	pad	ONE	R	163-6-35	7,468	(4'R)	44W	6.6	
12									
13	pad	2	R	163-6-35	6,341	(4'R)	44W	6.7	
14									
15	pad	ONE	R	163-6-35	4,153.5	(4'R)	44W	5.8	
16									
17	pad	ONE	R	163-6-35	3,927.5	(4'R)	44W	6.9	
18									
19	pad	ONE	R	163-6-35	4,165.5	(4'R)	44W	5.0	
20									
21	pad	3		138-5 Wire	2,438.4				PA*
22									
23	pad	ONE		138-5 Wire	1,716				PA*
24									
25	pad	ONE		138-5 Wire	1,492	SMOOTH WHITE ANNEALING			PA*
26									
27	pad	ONE		138-5 Wire	1,729.5	3-18 (18) THICK			PA*
28									
29									
30									
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32									
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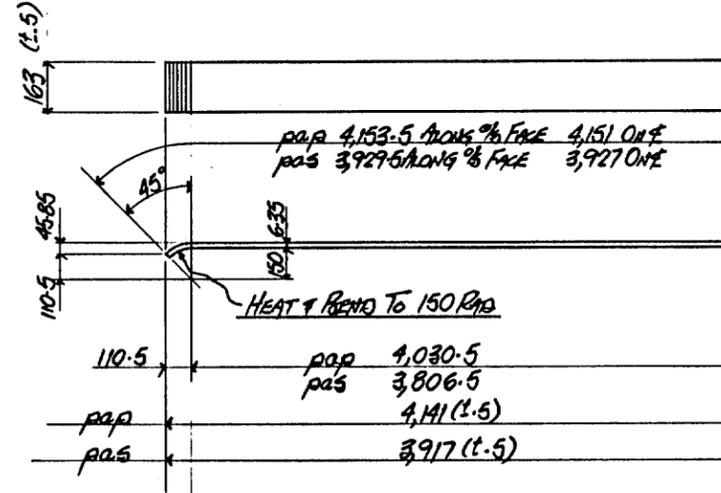
6 REQ^d - MK pad
2 REQ^d - MK pad
2 REQ^d - MK pad
2 REQ^d - MK pad
CABLE TROUGH WEB



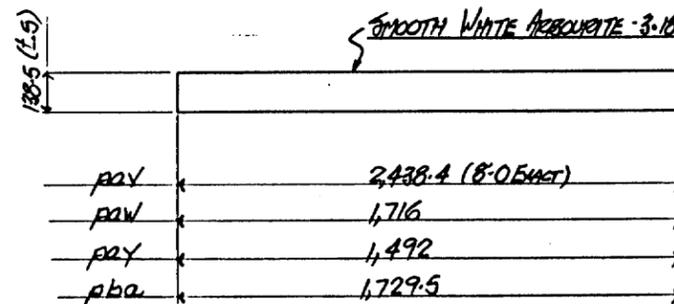
2 REQ^d - MK pad
ONE REQ^d - MK pad
2 REQ^d - MK pad
OUTER GUIDE WEB



ONE REQ^d - MK pad
CENTRE GUIDE WEB



ONE REQ^d - MK pad (LOWER PORTION)
ONE REQ^d - MK pad (UPPER PORTION)
CENTRE GUIDE WEB



3 REQ^d - MK pad
ONE REQ^d - MK pad
ONE REQ^d - MK pad
ONE REQ^d - MK pad
CENTRE GUIDE GUIDE FACE

GENERAL NOTES
1) FOR ASSEMBLY WITH FIG'S SEE PAGES 50-51

3R/3001183



MATERIAL	G40 21 (44W) w/n	NO.	BY	DATE	REVISION
BURF PREP & PAINT		DETAILS CABLE TROUGH, CENTRE & OUTER GUIDE SURF. ASSY. DETA. CUTTINGS			
OPEN HOLES	NONE	FOR 4.2M TELESCOPE ROPE LA FORM			
PRINT ON FINISH ASSEMBLY		REV			
DRAWN	DATE	CHECKED	DATE	DRAWING NO. 1420-5m	
BRITAIN	BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				

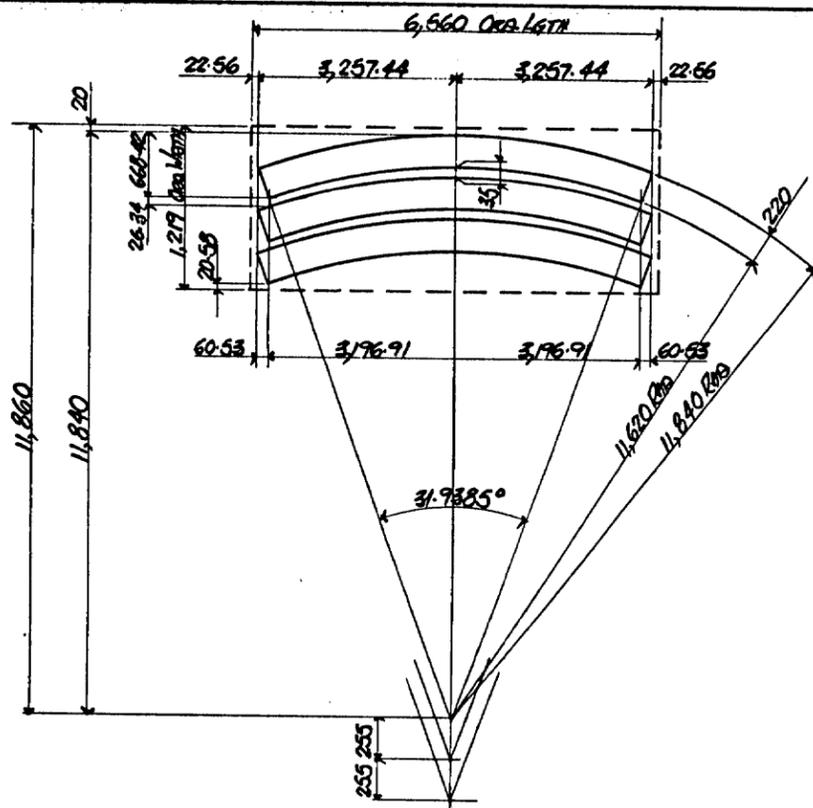
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m-abcdefghijklmnpstvw

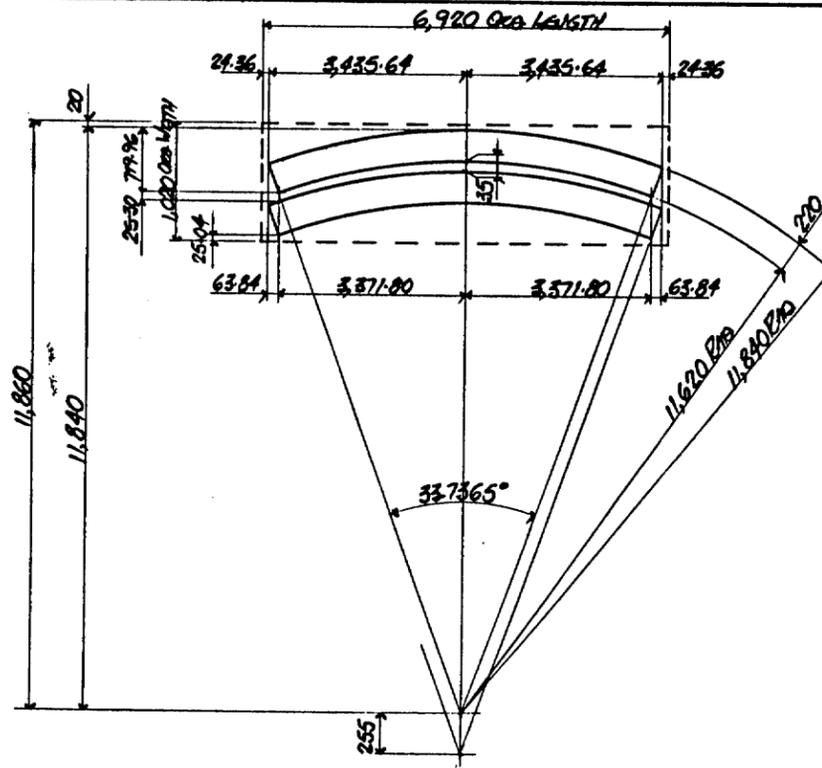
s-abcdefghijklmnpstvw

SHOP DEPARTMENT

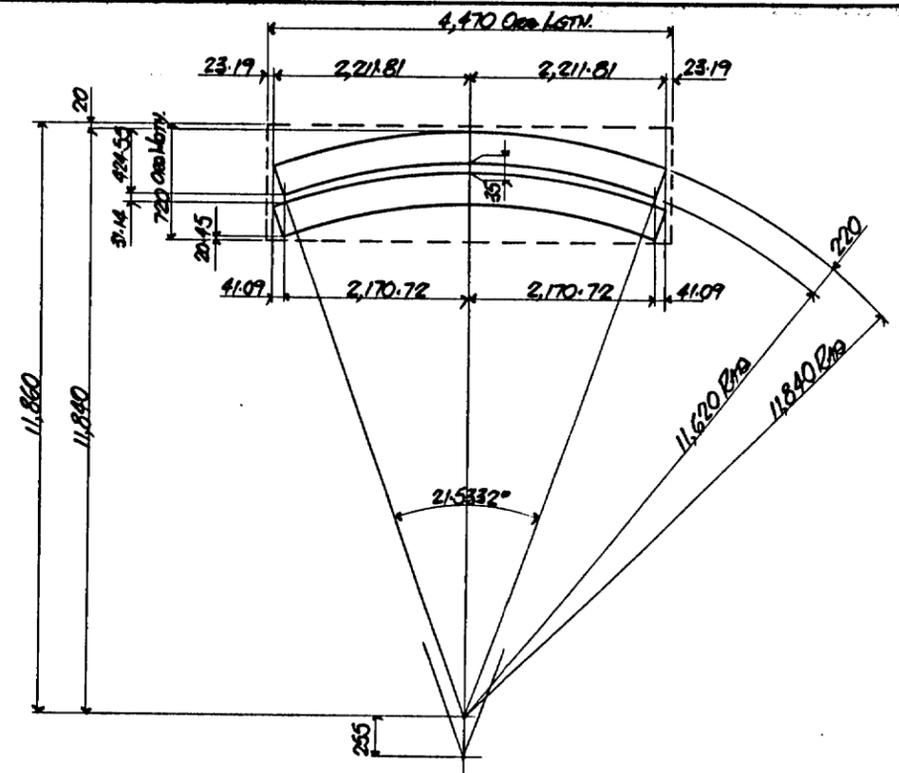
INS / S / O / M / T / P / SH / DP / AS / PA / ER / NO. PRINTS



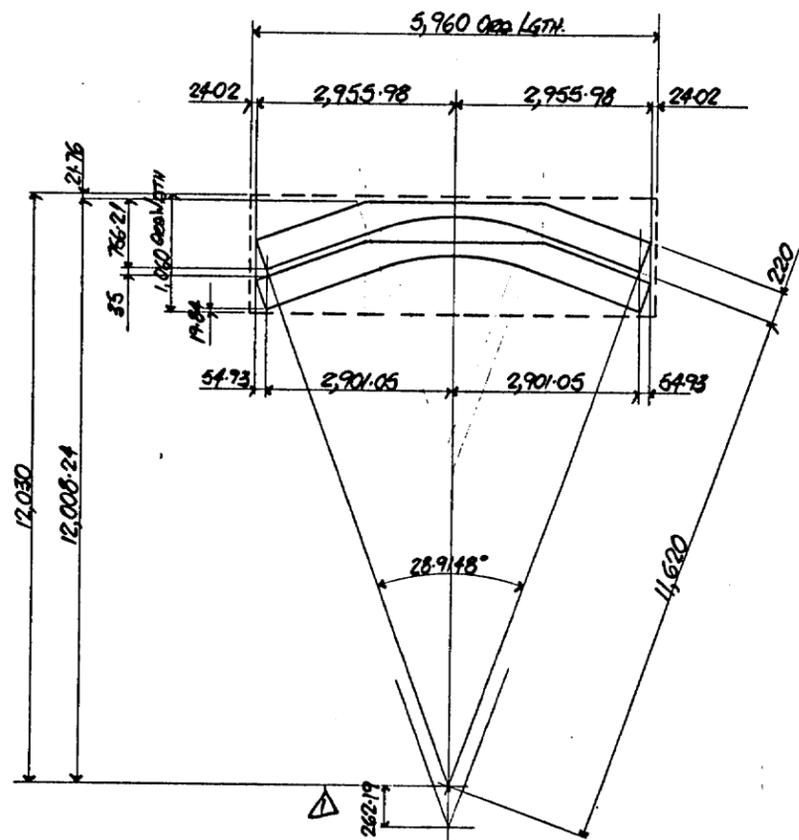
CABLE TROUGH OUTER FLG'S part 11
 RESERVE BILL 5 LINE 11
 ONE R 1,219 * 9.5 * 6,560



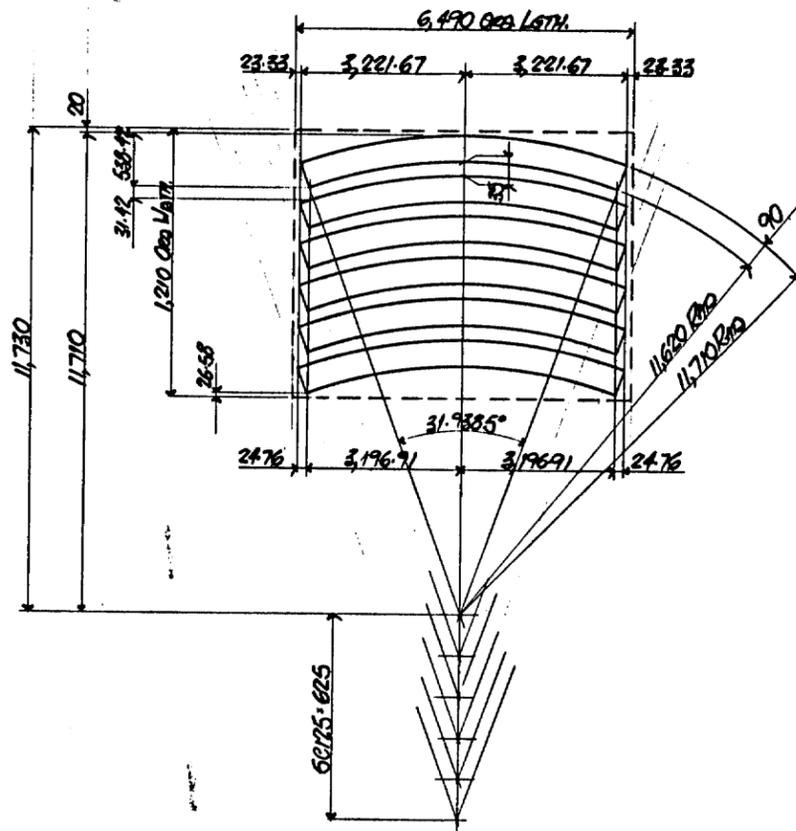
CABLE TROUGH OUTER FLG'S part 12
 RESERVE BILL 5 LINE 12
 ONE R 1,020 * 9.5 * 6,920



CABLE TROUGH OUTER FLG'S part 13
 RESERVE BILL 5 LINE 13
 ONE R 720 * 9.5 * 4,470



CABLE TROUGH OUTER FLG'S part 14
 RESERVE BILL 5 LINE 14
 ONE R 1,060 * 9.5 * 5,960



CABLE TROUGH INNER FLG'S part 15
 RESERVE BILL 5 LINE 15
 ONE R 1,210 * 9.5 * 6,490

GENERAL NOTES

1.) FOR DETAILS & QUANTITIES OF ITEMS CUT ON THIS DRAW SEE DRESS 54 & 59

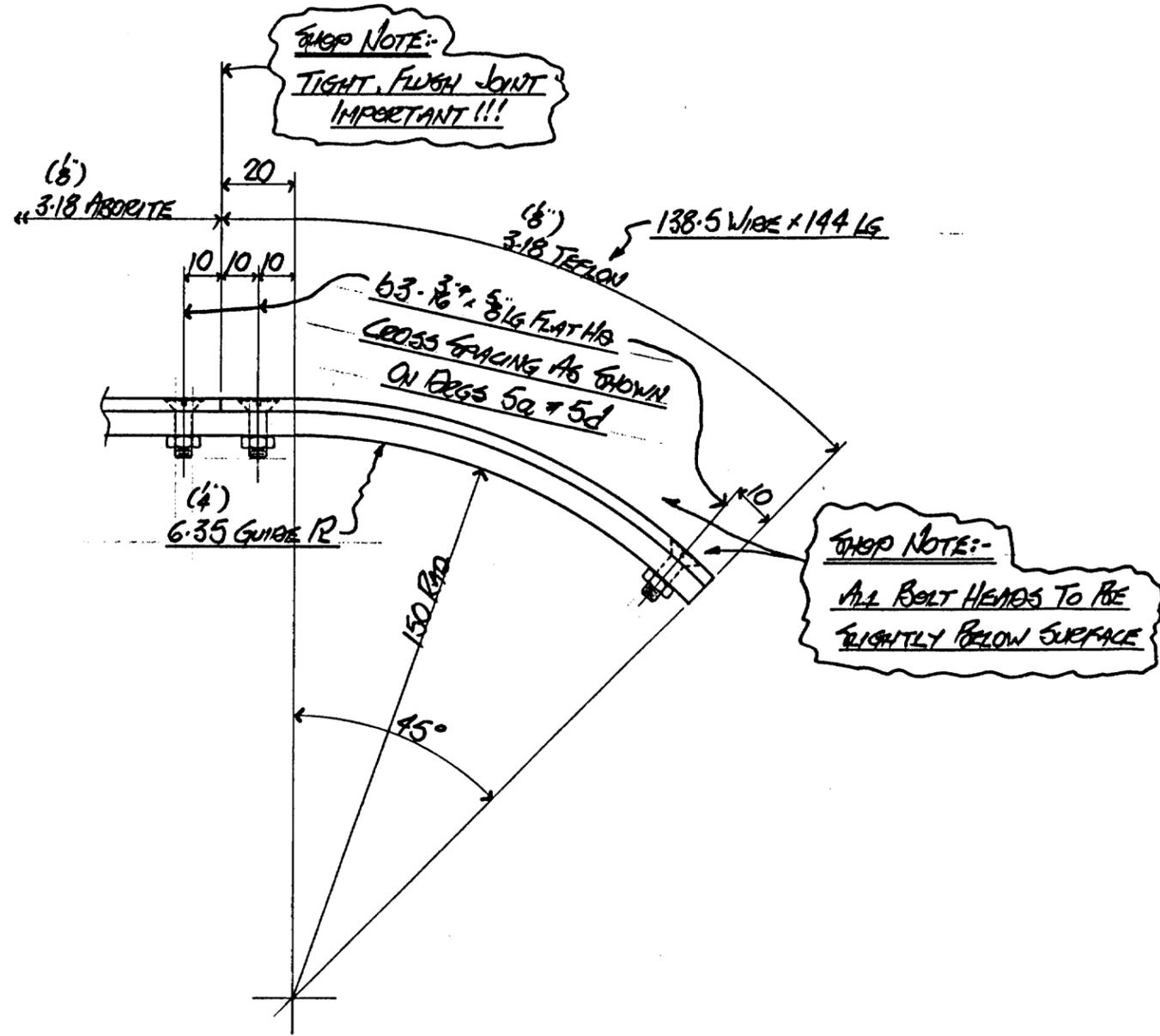
3R/3001184

BRITAIN	MATERIAL	G40.21 (44W) w/n	DETAILS	CABLE TROUGH SUB-ASSEMBLY ITEM CUTTING & NESTING
	SURF. PREP. & PAINT	SEE MEMO	FOR	4.2M TELESCOPE DRIVE LA FERRA
	OPEN HOLES	NONE	DRAWING NO.	1420-51
	PRINT ON FINAL ASSEMBLY			
DRAWN		DATE	CHECKED	DATE
BY		DATE	CHECKED	DATE
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				
SHOP DEPARTMENT		INS / E / S / O / M / T / P / SH / DP / AS / PA / ER		NO. PRINTS

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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw



CENTRE GUIDES END CURVE DETAILS

APPLIES TO ONE END OF CENTRE GUIDE MK D5	
	MK F5
BOTH ENDS	
	MK V5

3R/3001186



MATERIAL	As Noted	
SURF. PREP. & PAINT	SEE MEMO	
OPEN HOLES	6.35 (1/4")	
DRAWN	DATE	CHECKED
BR	12/84	

No.	BY	DATE	REVISION
			DETAILS OF CENTRE GUIDES END CURVE DETAILS
			FOR 4.2M TELESCOPE DOME LA PALMA
DRAWING No.			REV.
1420-55			M/F

BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.

p - a b c d f g h k m n p s t v w y

m - a b c d f g h k m n p s t v w y

SHOP DEPARTMENT

INS / F / S / O / M / T / P / SH / DP / AS / PA / ER

No. PRINTS