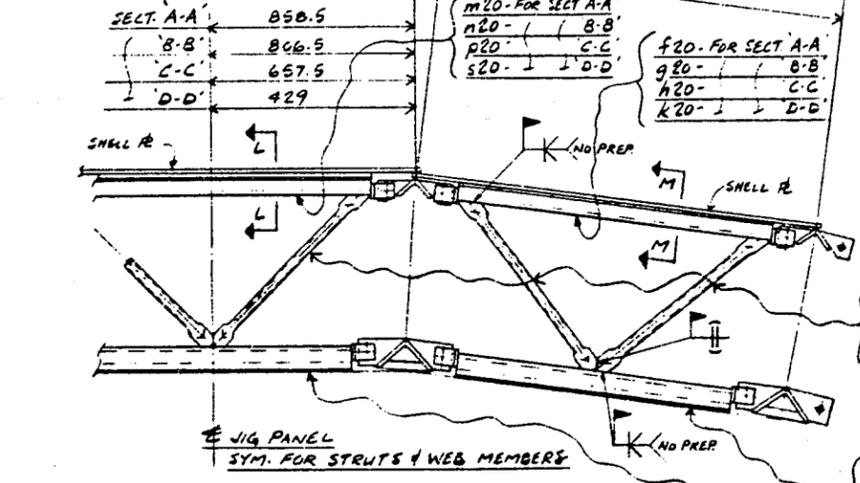


ITEM MARK	QTY	DESCRIPTION	REF DWG
a19	4	LOWER RIB SECTION	19c
b19	1	UPPER RIB SECTION	19d
c19	1		19f
d19	1		19g
f19	1		19h
a17	1	SHELL R	17a
b17	2		17a
d17	3		17b
a20	6	BRACE FRAME WEB MEMBER	20a
b20	6		
c20	6		
d20	6		
f20	2	OUTER CHORD STRUT	20b
g20	2		
h20	2		
k20	2		
m20	1		
n20	1		
p20	1		
s20	1		
aa20	3	INNER CHORD STRUT	20c
ab20	3		
ac20	3		
ad20	3		
af20	6		
ag20	6		
ah20	3		
ak20	3		
am20	3		20d
an20	3		
ap20	3		
as20	3		
f19	4	RIB WEB MEMBER	19b

SCHMATIC PLAN ON JIG PANEL

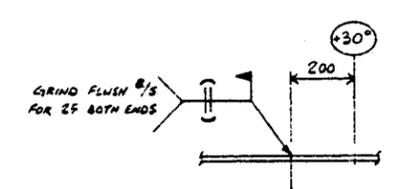
2-REQ'D. ~ MK. A23^R (AS DRAWN)
 2-REQ'D. ~ MK. A23^L (OPP. HAND)

SECT	HEEL/HEEL
SECT A-A	1717
B-B	1613
C-C	1315
D-D	858

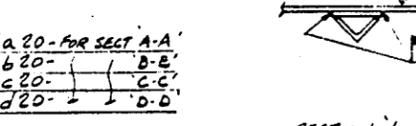


10° SECTION A-A
 20° SECTION B-B
 40° SECTION C-C
 60° SECTION D-D

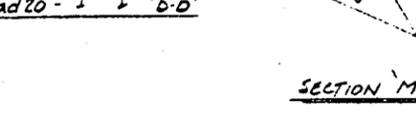
NOTE: HEEL TO HEEL DIMENSIONS ARE AT (±) WORK LINE (W.L.)



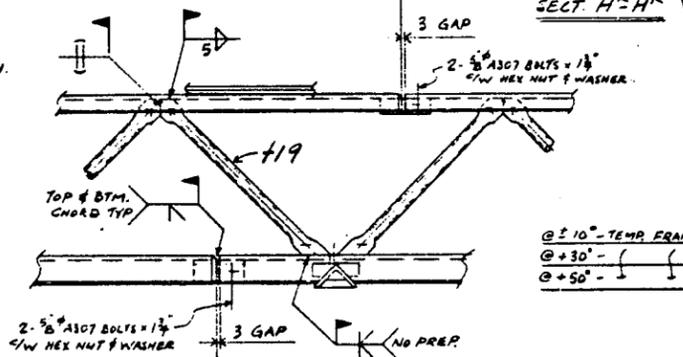
SECTION G-G (TYP SHELL R SPLICE)



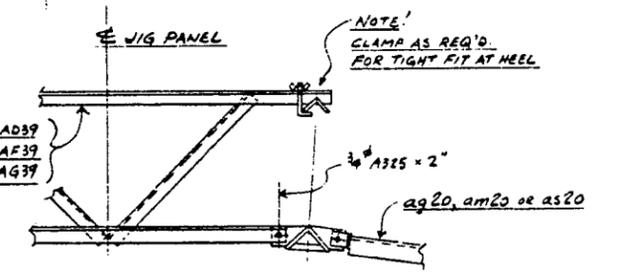
SECTION L-L



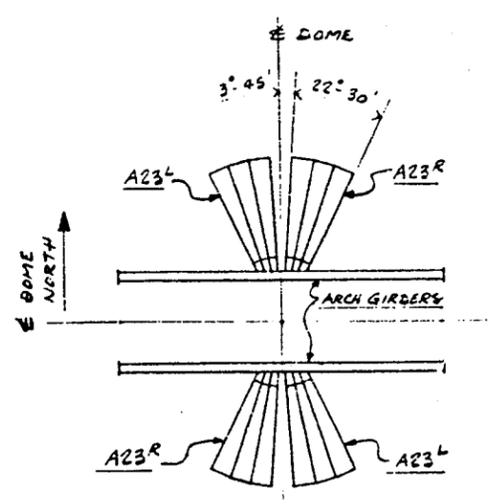
SECTION M-M



SECTION F-F (TYP RIB SPLICE)



DETAIL I - SHOWING TEMP ALIGNMENT FRAMES FOR ALIGNMENT OF RIBS. REMOVE AFTER WELDING OF BRACE FRAMES.



KEY DIAGRAM SHOWING LOCATION OF JIG PANELS

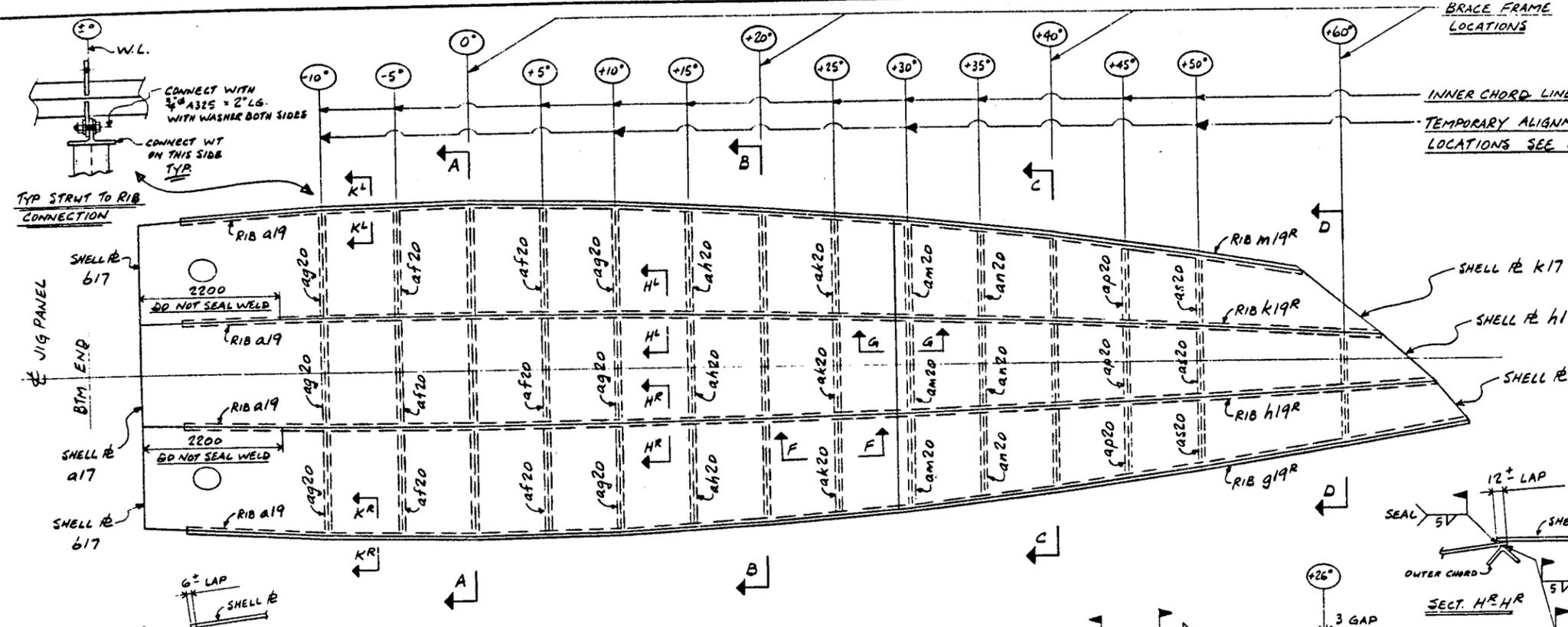
- GENERAL NOTES:
- 1) FOR ASSEMBLY TO RING GIRDER SEE DWG. E1C & E1D
 - 2) FOR ASSEMBLY TO ARCH GIRDER SEE DWG.
 - 3) FOR JIG FRAME DETAILS SEE DWG. SERIES #39

MATERIAL		DETAILS	
SURF PREP & PAINT		SEE MEMO	
OPEN HOLES		FOR 32" TELESCOPE DOME LA PALMA	
DRAWN	DATE	CHECKED	DATE
G.V.A.	SEPT/83		
DRAWING NO. 1420-23a		REV.	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.		NO PRINTS	



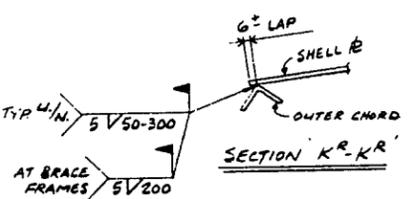
BRACE FRAME LOCATIONS
 INNER CHORD LINER STRUT LOCATIONS
 TEMPORARY ALIGNMENT FRAME LOCATIONS SEE DETAIL 'J' ON DWG. 23a

ITEM LIST FOR ONE B23R			
ITEM MARK	QTY.	DESCRIPTION	REF DWG
a19	4	LOWER RIB SECTION	19c
g19R	1	UPPER RIB SECTION	19k
h19R	1		19m
k19R	1		19n
m19R	1		19p
a17	1	SHELL PL	17a
b17	2		17a
g17	1		17c
h17	1		17c
k17	1		17d
a20	6	BRACE FRAME WEB MEMBER	20a
b20	6		
c20	6		
d20	4		
f20	2	OUTER CHORD STRUT	20b
g20	2		
h20	2		
k20	1		
m20	1		
n20	1		
p20	1		
s20	1		
aa20	3	INNER CHORD STRUT	20c
ab20	3		
ac20	3		
ad20	2		
af20	6		
ag20	6		
ah20	3		
ak20	3		
am20	3		20d
an20	3		
ap20	3		
as20	3		
a19	4	RIB WEB MEMBER	19b

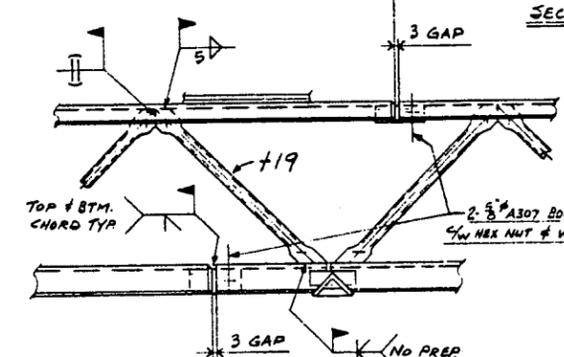


SCHEMATIC PLAN ON JIG PANEL

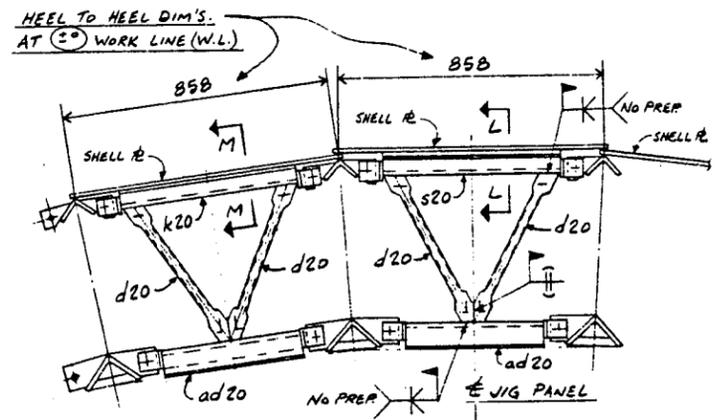
2-REQ'D ~ MK. B23R (AS DRAWN)
 2-REQ'D ~ MK. B23L (OPP. HAND)



SECTION K-K'



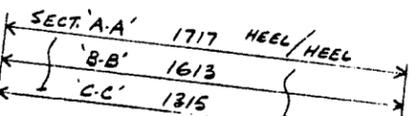
SECTION F-F' (TYP. RIB SPLICE)



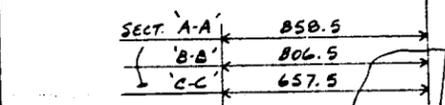
(60°) SECTION D-D'



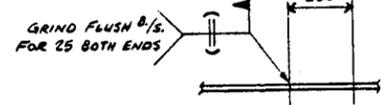
SECTION A-A'



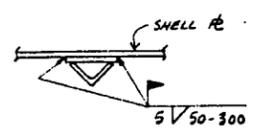
SECTION B-B'



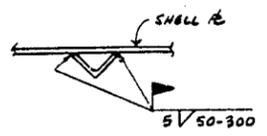
SECTION C-C'



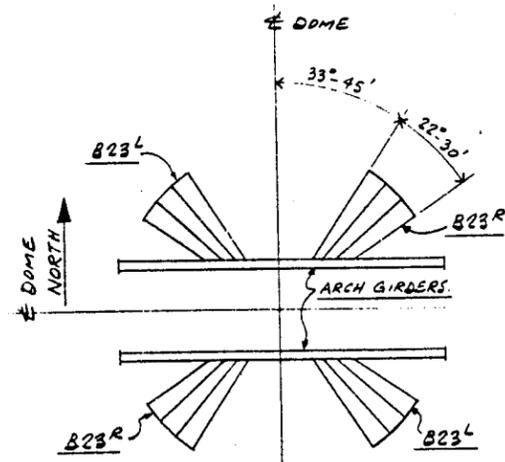
SECTION G-G' (TYP. SHELL PL SPLICE)



SECTION L-L'



SECTION M-M'



KEY DIAGRAM SHOWING LOCATION OF JIG PANELS

GENERAL NOTES:

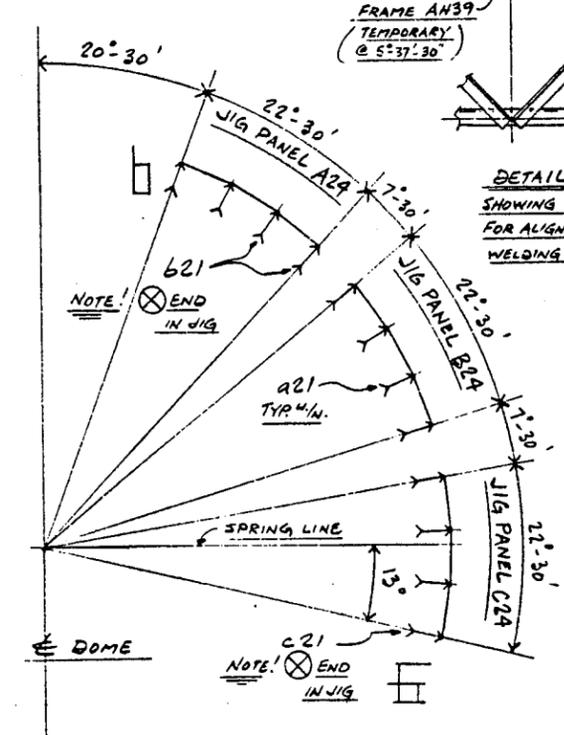
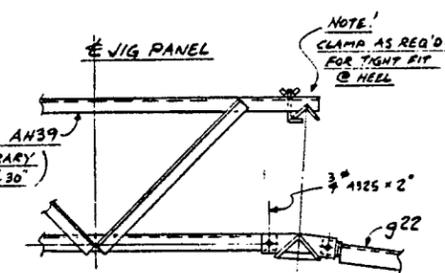
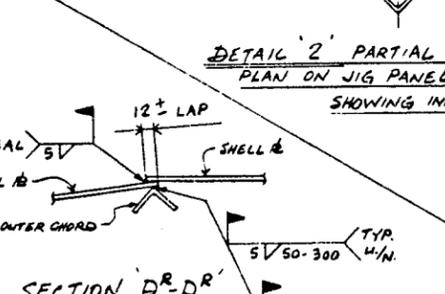
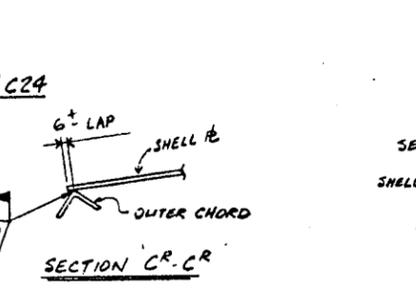
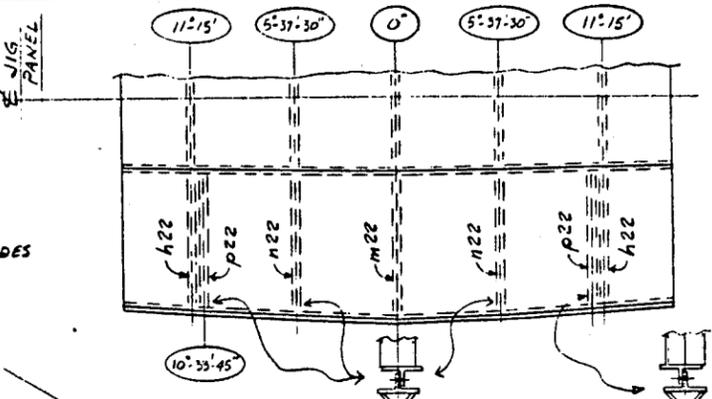
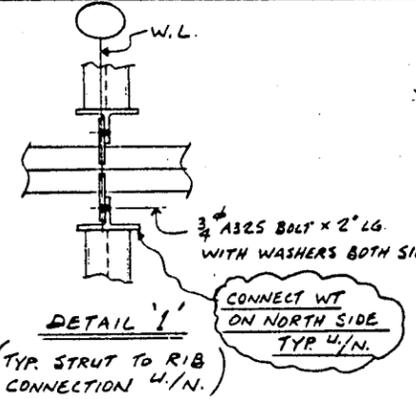
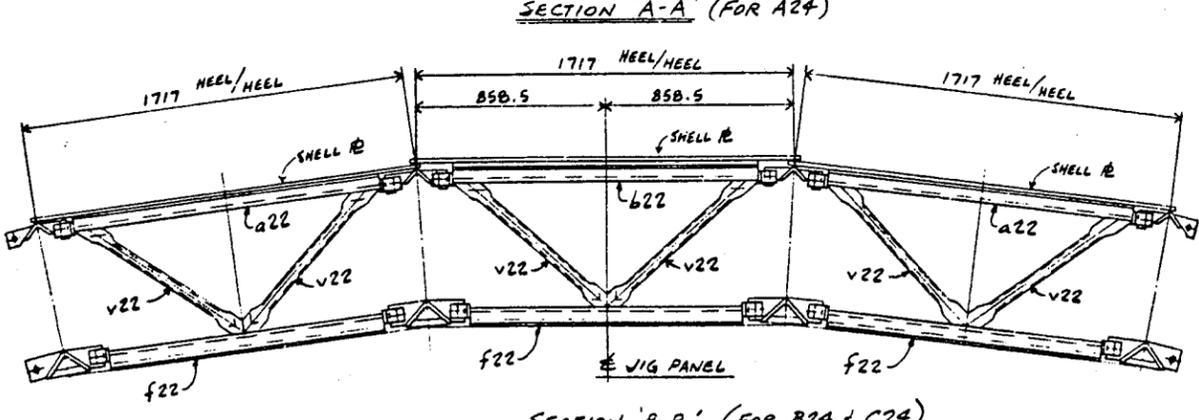
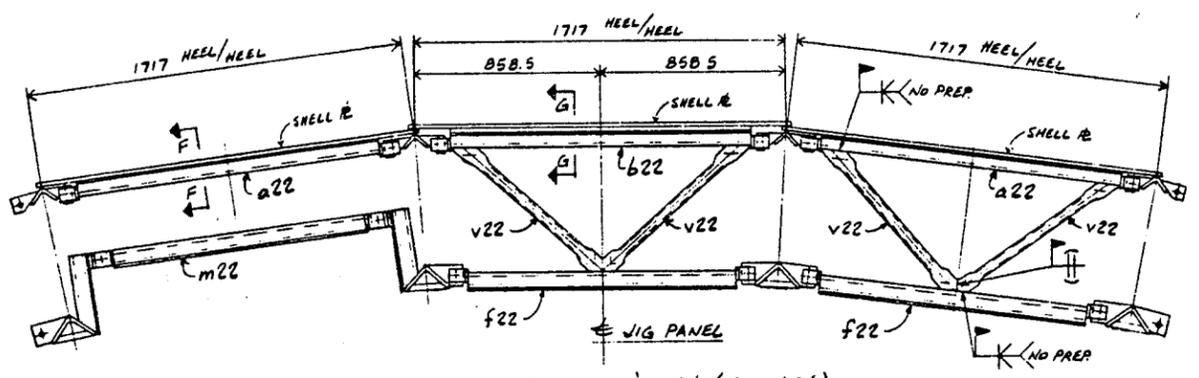
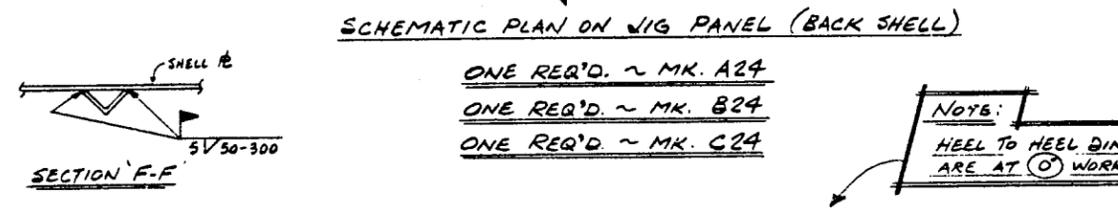
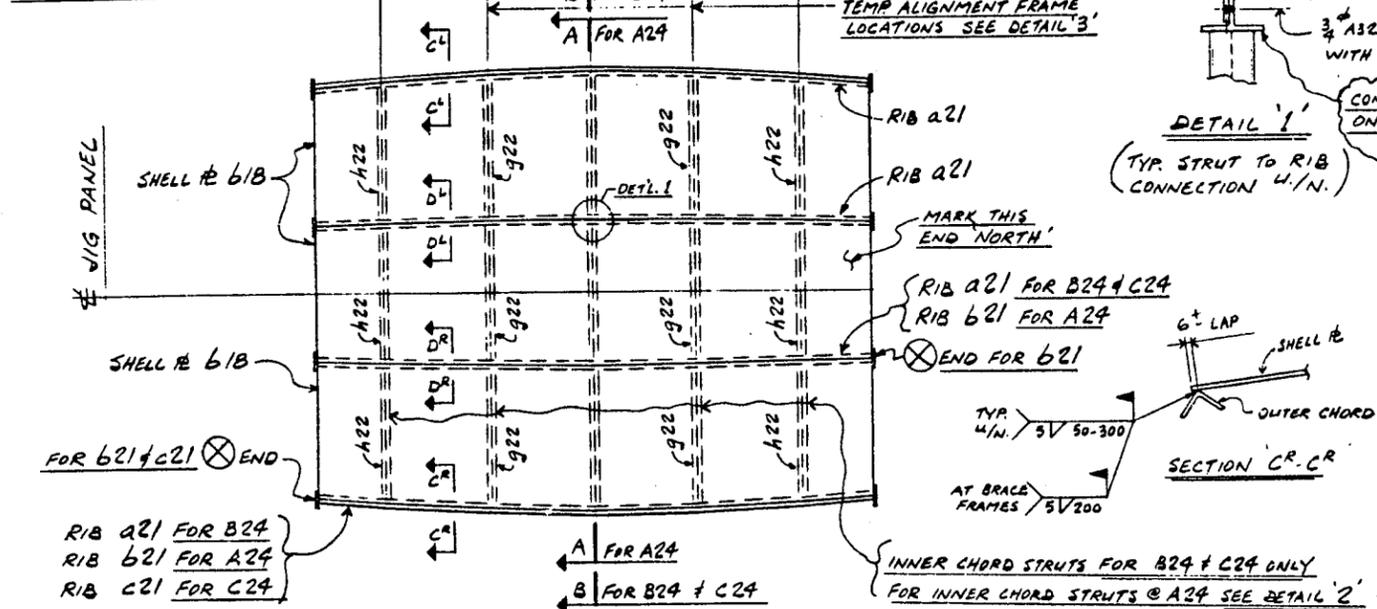
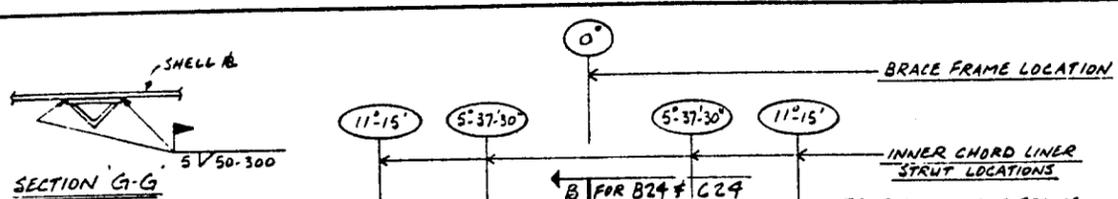
- 1) FOR JIG FRAME DETAILS SEE DWG SERIES 39
- 2) FOR ASSEMBLY TO RING GIRDER SEE DWG EIC & E1d.
- 3) FOR ASSEMBLY TO ARCH GIRDER SEE DWG.

- (0°) SECTION A-A'
- (20°) SECTION B-B'
- (40°) SECTION C-C'

NOTE: HEEL TO HEEL DIMENSIONS ARE AT (0°) WORK LINE (W.L.)

MATERIAL		NO. BY DATE REVISION	
SURF. PREP & PAINT		DETAILS: JIG PANELS B23R & B23L	
OPEN HOLES		FOR 4.2" TELESCOPE DOME LA PALMA	
DRAWN: G.V.A.	DATE: SEPT. 63	CHECKED:	DATE:
BRITAIN STEEL LTD.		DRAWING NO. 1420-236	





ITEM LIST FOR JIG PANEL A24

ITEM MARK	QTY	DESCRIPTION	REF DWG
a21	2	RIB	21a
b21	2	"	21b
6/B	2	SHELL #	18a
v22	4	BRACE FRAME WEB MEMBER	22b
a22	2	OUTER CHORD STRUT	22a
b22	1	"	"
f22	2	INNER CHORD STRUT	"
g22	4	"	"
h22	6	"	"
m22	1	"	22c
n22	2	"	"
p22	2	"	"

ITEM LIST FOR JIG PANEL B24

ITEM MARK	QTY	DESCRIPTION	REF DWG
a21	4	RIB	21a
6/B	3	SHELL #	18a
v22	6	BRACE FRAME WEB MEMBER	22b
a22	2	OUTER CHORD STRUT	22a
b22	1	"	"
f22	3	INNER CHORD STRUT	"
g22	6	"	"
h22	6	"	"

ITEM LIST FOR JIG PANEL C24

ITEM MARK	QTY	DESCRIPTION	REF DWG
a21	3	RIB	21a
c21	1	"	21c
6/B	3	SHELL #	18a
v22	6	BRACE FRAME WEB MEMBER	22b
a22	2	OUTER CHORD STRUT	22a
b22	1	"	"
f22	3	INNER CHORD STRUT	"
g22	6	"	"
h22	6	"	"

NOTE: HEEL TO HEEL DIMENSIONS ARE AT WORKLINE W.L.

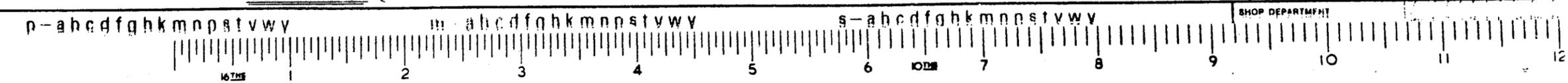
- GENERAL NOTES:
- FOR JIG FRAME DETAILS SEE DWG SERIES 39
 - FOR ASSEMBLY TO ARCH GIRDER SEE DWG. E4

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

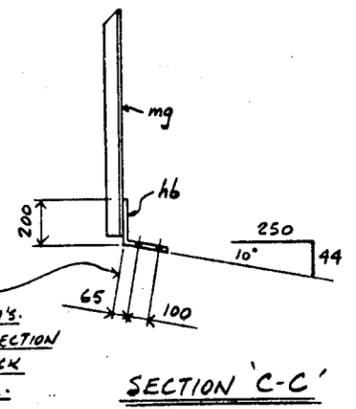
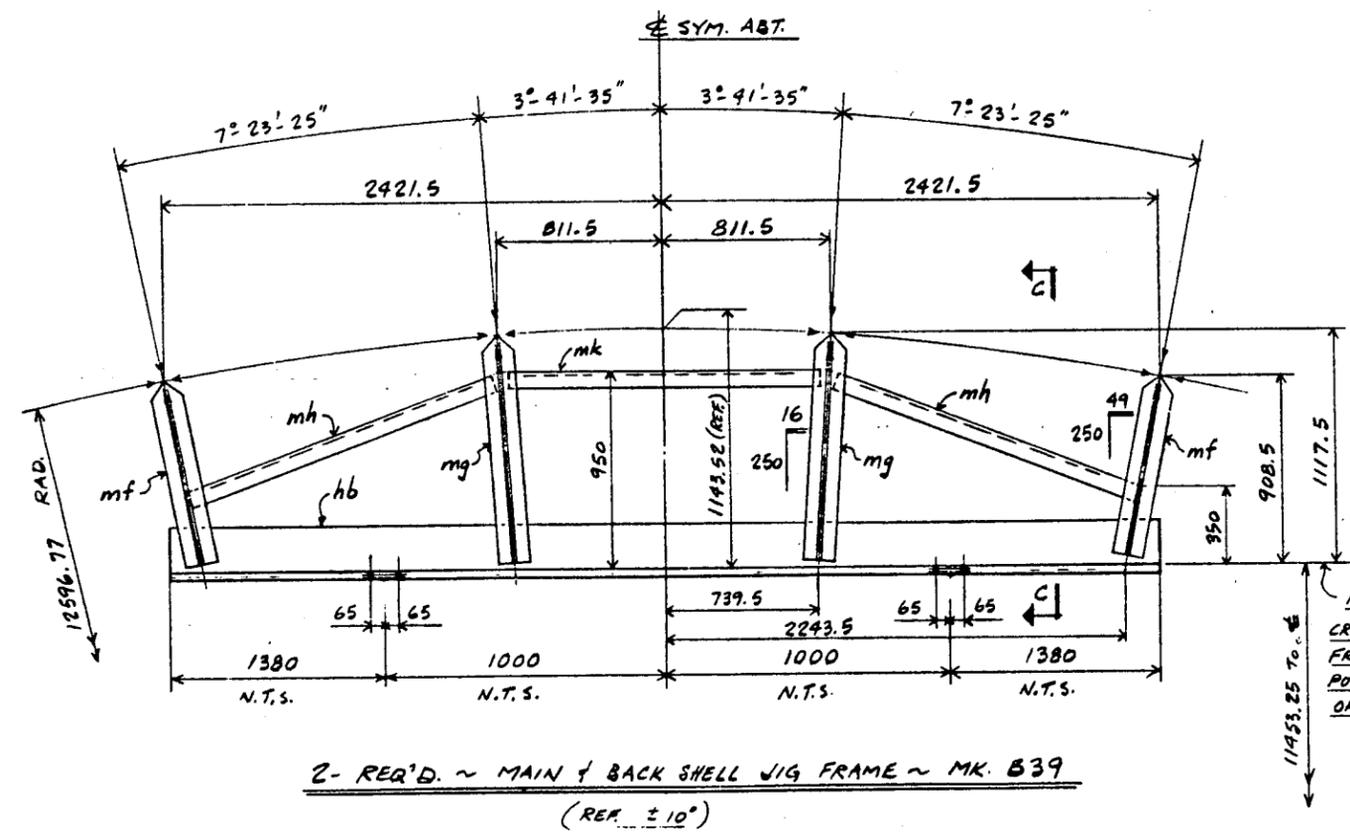
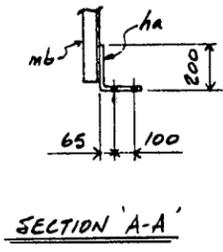
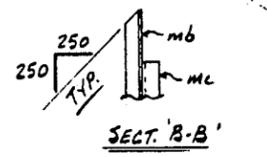
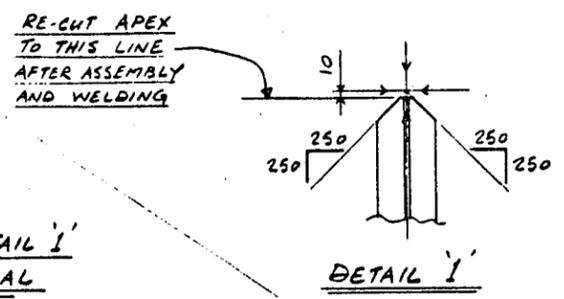
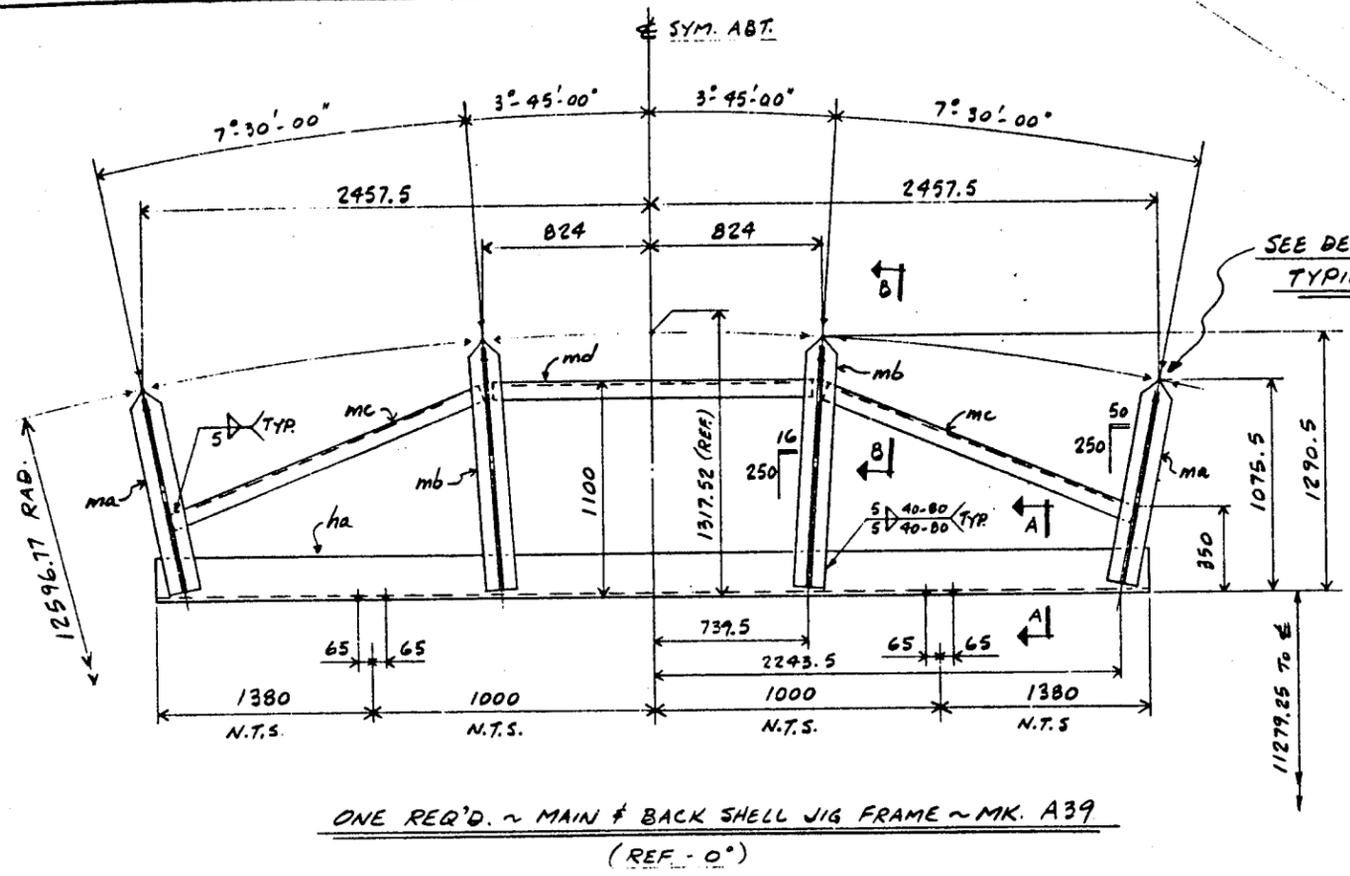
FOR 4.2M TELESCOPE DOME LA PALMA

DATE: SEPT/83

DRAWING NO: 1420-24



NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	WGT
1								
2								
3								
4	ha	1	B	380 x 10 (3)	9760	BEND		
5	ma	2	WT	152 x 76 x 6 x 11	1060	SPLIT W/150 x 22 (W6=15)		
6								
7	mb	2	WT	152 x 76 x 6 x 11	1280			
8	mc	2	L	76 x 76 x 8	1640	L3 x 3 x 5/16		
9	md	1	L	L	1570	L		
10								
11								
12								
13	hb	2	B	380 x 10	4760	BEND		
14	mf	4	WT	152 x 76 x 6 x 11	900			
15	mg	4	L	L	1105			
16	mh	4	L	76 x 76 x 8	1590			
17	mk	2	L	L	1550			
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								
51								
52								
53								
54								
55								



- GENERAL NOTES:
- FOR FINAL ASSEMBLY SEE DWG. 39A
 - MAINTAIN CRITICAL LOCATION POINTS MARKED THUS

BRITAIN

MATERIAL Q40 21 (44W) OR A36
SURF PREP & PAINT REMOVE LOOSE SCALE NO PAINT
OPEN HOLES 1/2" MIN 21"

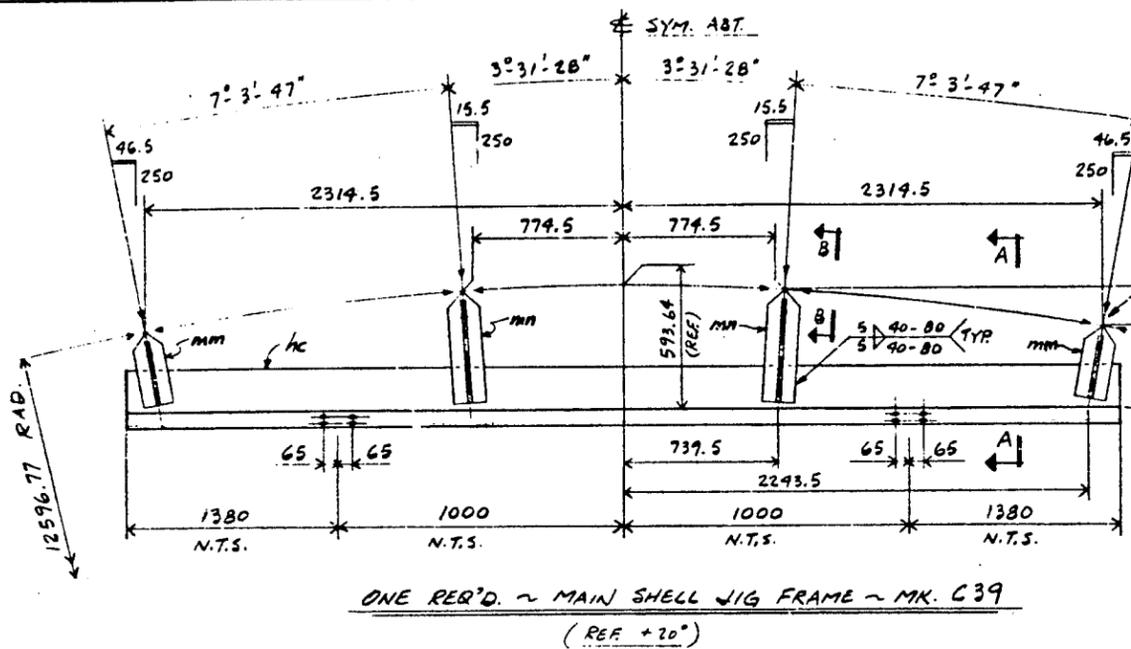
DETAILS MAIN & BACK SHELL JIG GROSS FRAMES
FOR 4.2" TELESCOPE DOME LA PALMA

DRAWN G.V.A. DATE OCT/03 CHECKED DATE DRAWING NO. 1420-396

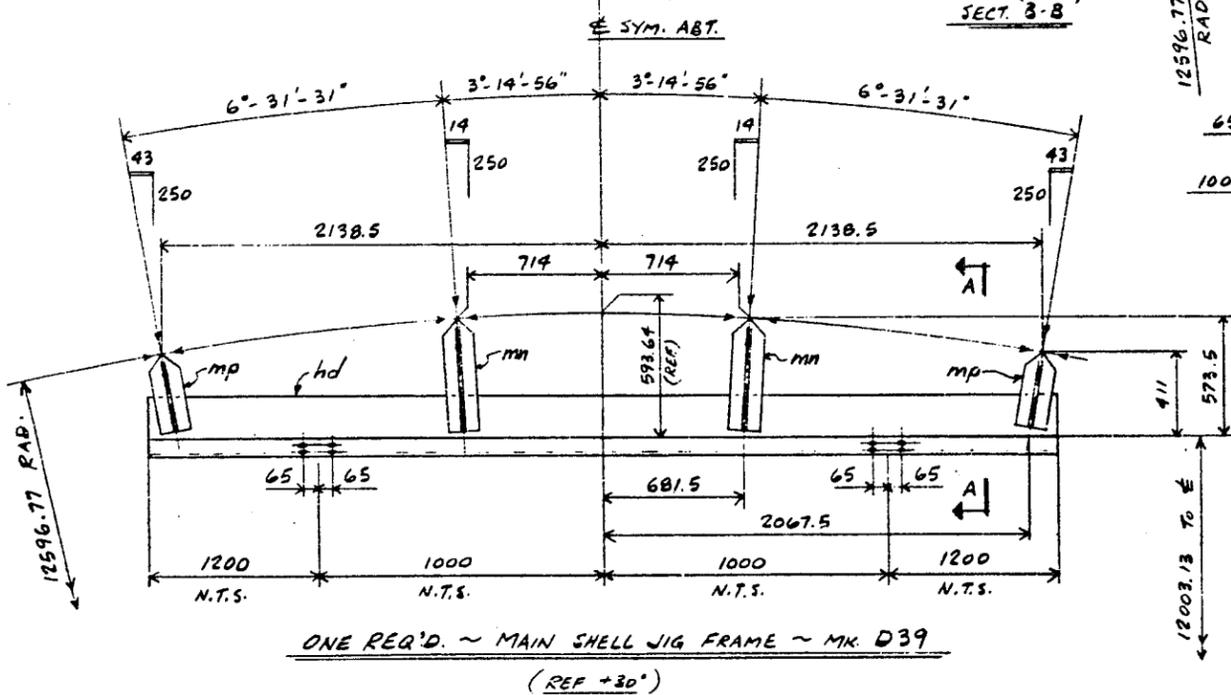
BRITAIN STEEL LTD. 401 SALTERS AVENUE, NEW WESTMINSTER, B.C.

SHOP DEPARTMENT



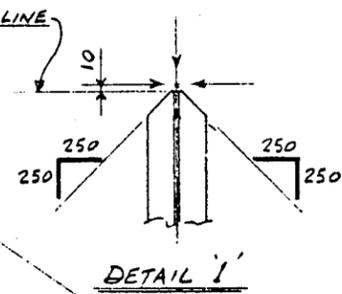


ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. C39
(REF +20°)

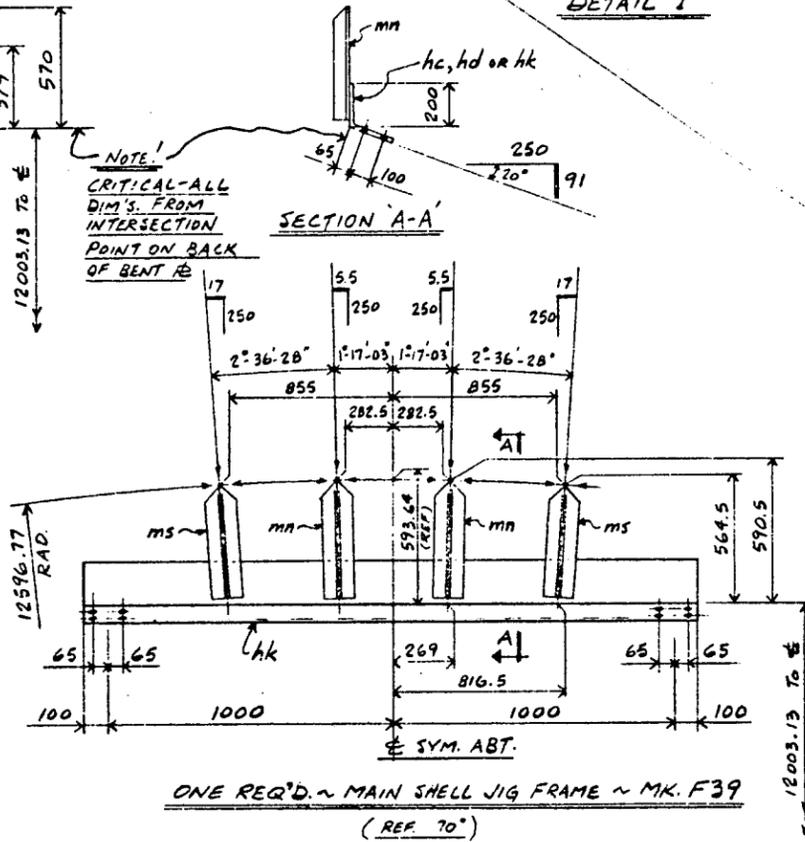


ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. D39
(REF +30°)

RE-CUT APEX TO THIS LINE AFTER ASSEMBLY AND WELDING.



SEE DETAIL 1 TYPICAL



ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. F39
(REF 70°)

MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

LINE NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	WEIGHT
1								
2			ONE REQ'D. ~ MK. C39					
3	hc	1	PL	380x10	4760	BEND	44W	
4	mm	2	WT	152x76x6x11	360	2 BENT W150x22	PR ATL	
5						(G'3' 3' 25)		
6	mm	2	WT	152x76x6x11	560	(WB x 15)		
7								
8								
9								
10			ONE REQ'D. ~ MK. D39					
11								
12	hd	1	PL	380x10	4400	BEND		
13	mm	2						
14	mp	2	WT	152x76x6x11	390			
15								
16								
17								
18			ONE REQ'D. ~ MK. F39					
19								
20	hk	1	PL	380x10	2200	BEND		
21	mm	2						
22	ms	2	WT	152x76x6x11	550			
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								
51								
52								
53								
54								
55								

GENERAL NOTES:

- 1) FOR FINAL ASSEMBLY SEE DWG. 39a
- 2) MAINTAIN CRITICAL LOCATION POINTS MARKED THUS *

p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw



SHOP DEPARTMENT



MATERIAL G40 21 (44W) OR A36
SURF PREP REMOVE
PAINT COARSE SCALE NO PAINT
OPEN HOLES 13 21

DRAWN G.V.A. DATE OCT/83
CHECKED DATE
DRAWING NO 1420-39c

NO. BY DATE REVISION

DETAILS MAIN SHELL JIG CROSS FRAMES

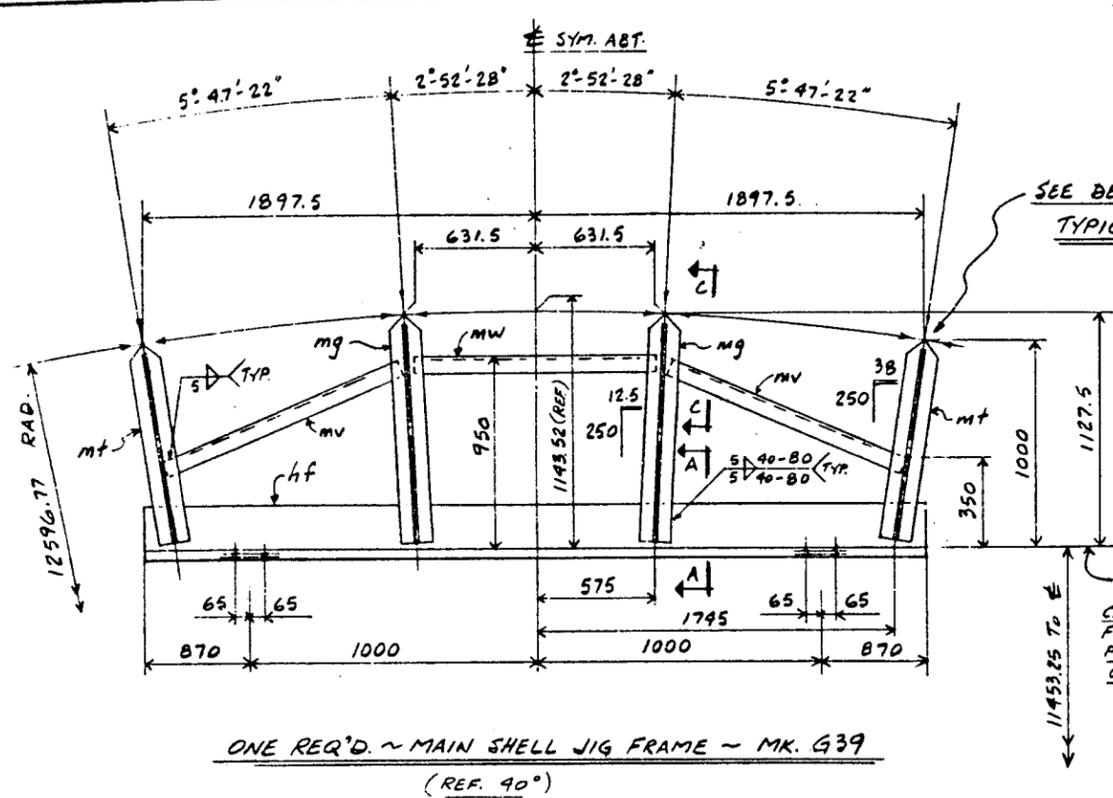
FOR 9.2M TELESCOPE DOME LA PALMA

REV

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

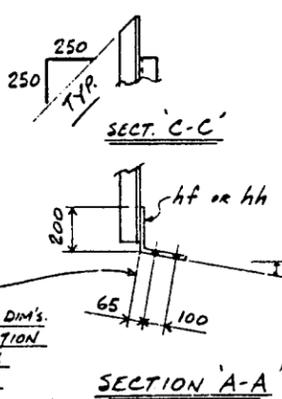
INS. F/S/O/M/T.P. SH. DP. AS. PA. ER

PRINTS

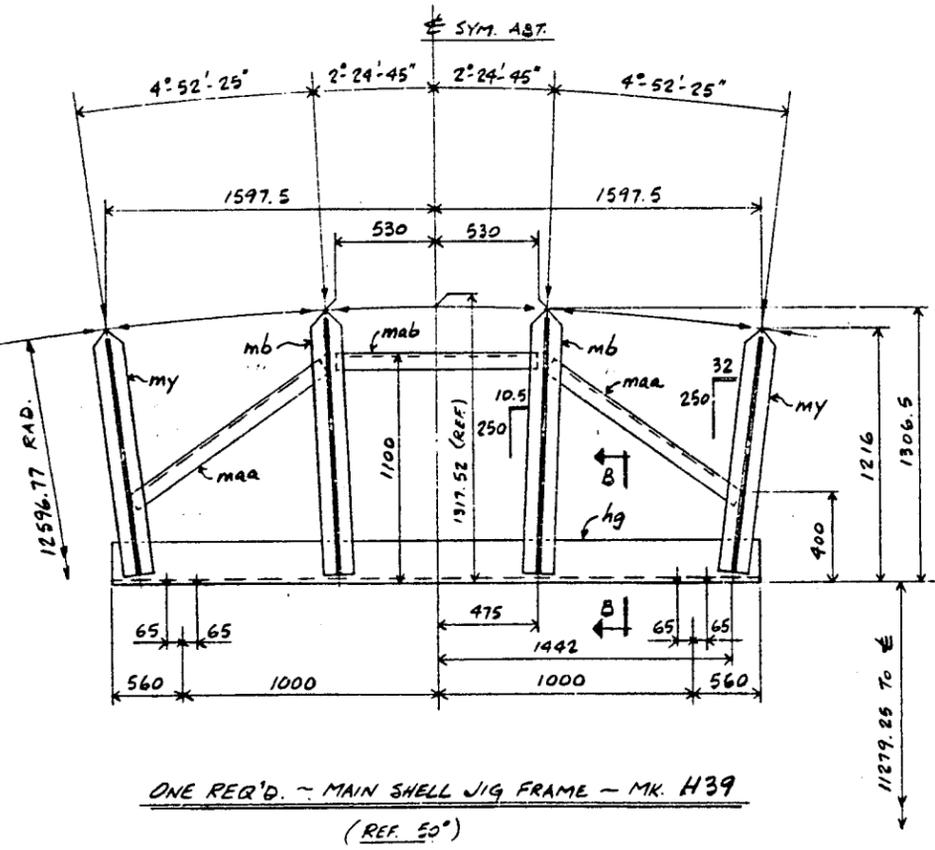
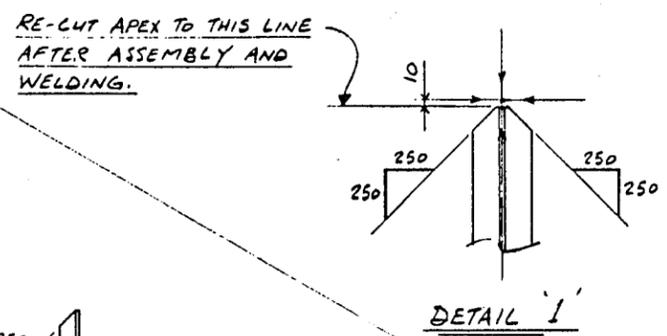


ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. G39
(REF. 40°)

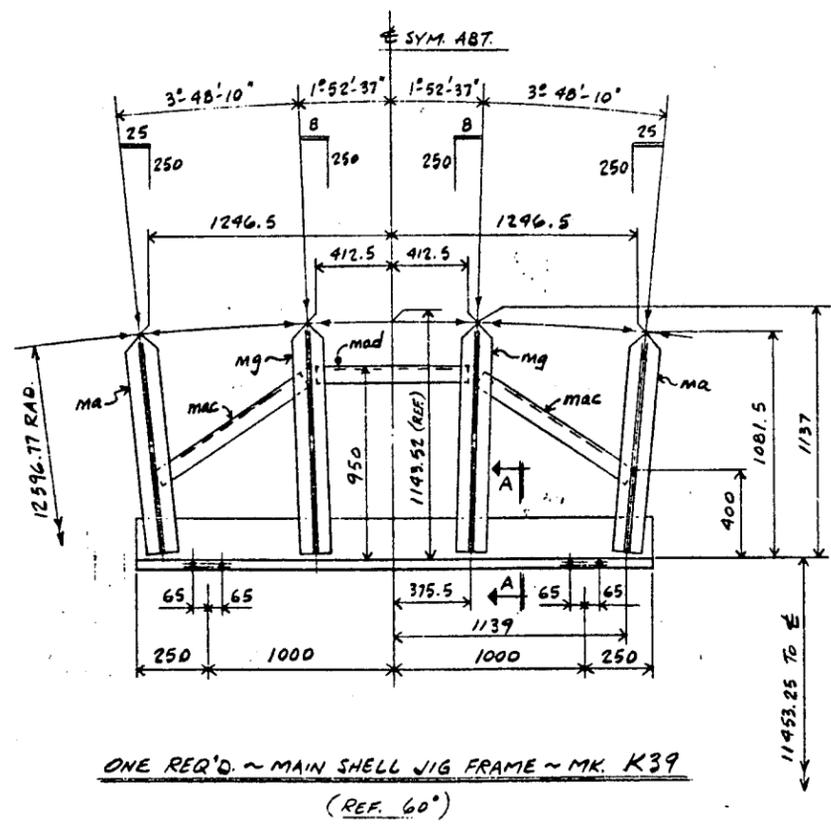
SEE DETAIL 'I'
TYPICAL



NOTE!
CRITICAL - ALL DIM'S.
FROM INTERSECTION
POINT ON BACK
OF BENT PLATE'S.



ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. H39
(REF. 50°)

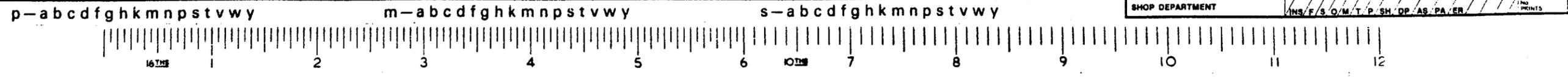


ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. K39
(REF. 60°)

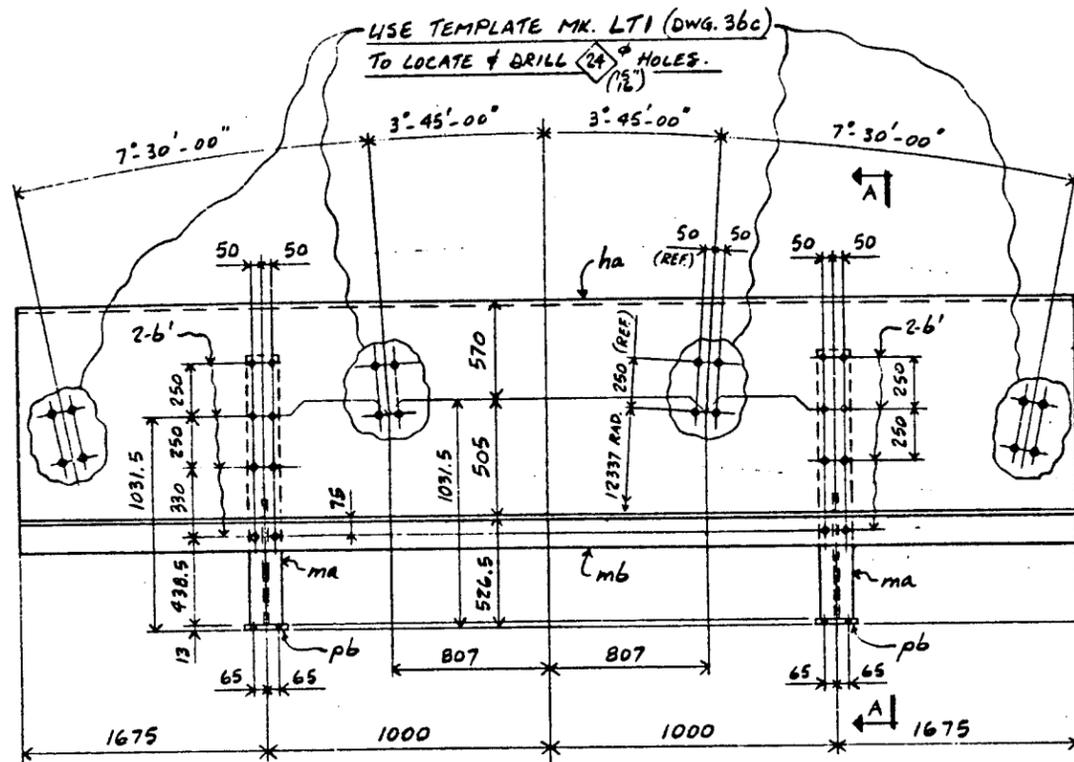
MATERIAL BILL										CONTRACT 1420	
BRITAIN STEEL LTD.											
NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	WGT			
1											
2			ONE REQ'D. ~ MK	G39							
3											
4	hf	1	PL	380 x 10 (B)	3740	BEND					
5	mt	2	WT	152 x 76 x 6 x 11	990	SPLIT W/50 x 22					
6				(6 x 3 x 5 x 7.5)		(W6 = 15)					
7	mg	2	WT	152 x 76 x 6 x 11	1105						
8	mw	2	L	76 x 76 x 8	1200	L3 x 3 x 5"					
9	mw	1	L	L	1200						
10			ONE REQ'D. ~ MK	H39							
11											
12	hg	1	PL	380 x 10	2120	BEND					
13	mlb	2	WT	152 x 76 x 6 x 11	1280						
14	my	2	L	L	1200						
15	maq	2	L	76 x 76 x 8	1160						
16	mab	1	L	L	1000						
17			ONE REQ'D. ~ MK	K39							
18											
19											
20	hh	1	PL	380 x 10	2500	BEND					
21	ma	2	WT	152 x 76 x 6 x 11	1060						
22	mg	2	L	L	1105						
23	mac	2	L	76 x 76 x 8	900						
24	mad	1	L	L	750						
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											
51											
52											
53											
54											
55											

GENERAL NOTES:
1) FOR FINAL ASSEMBLY SEE DWG. 39a
2) MAINTAIN CRITICAL LOCATION POINTS MARKED THUS *

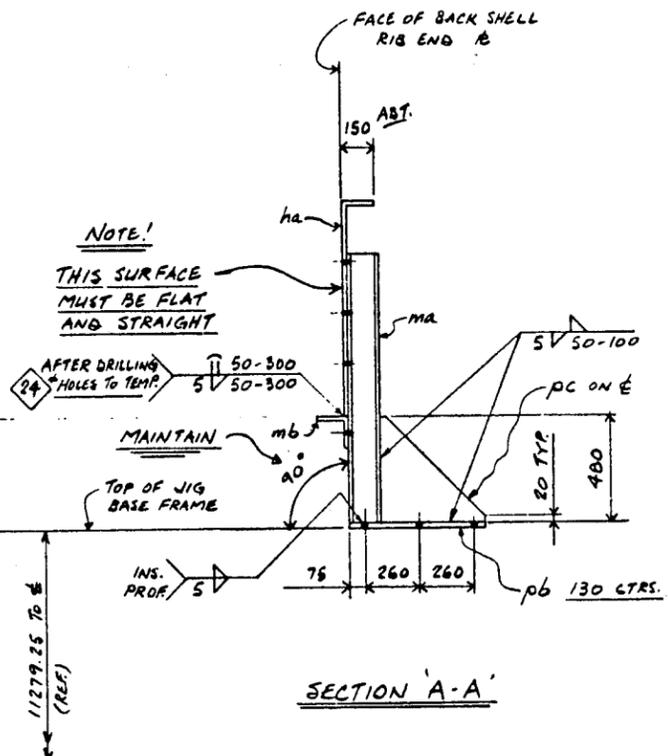
	MATERIAL	G40 21 (4W) OR A36	NO. BY DATE	REVISION
	SURF PREP	REMOVE	DETAILS MAIN SHELL JIG CROSS FRAMES	
	PAINT	LOOSE NO PAINT	FOR 4.2m TELESCOPE DOME LA PALMA	
	OPEN HOLES	13" 21"		
DRAWN	DATE	CHECKED	DATE	DRAWING NO.
G.V.A.	OCT/83			1420-39d
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				



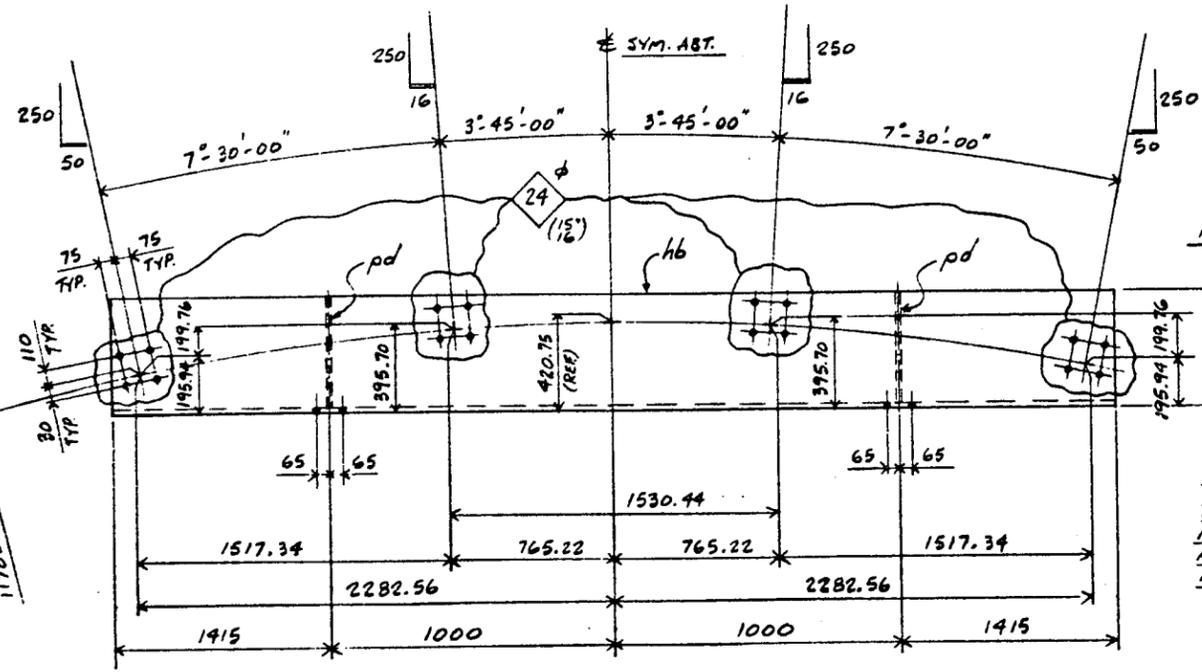
MATERIAL BILL										CONTRACT 1920	
BRITAIN STEEL LTD.											
NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MAT'L TYPE	REV.	WEIGHT		
1											
2		2	REQ'D	~ MK M39							
3											
4	ma	4	W	150 x 22	1305	C.S.I.F. (WG=15)					
5	mb	2	L	150 x 150 x 13	5350	(LG=6" x 1/2")					
6	ha	2	R	1215 x 12(6)	5350	BEND					
7											
8	pb	4	R	200 x 13(1/2)	630						
9	pc	4	R	480 x 10(3/8)	480	TEMP.					
10	b	32	BOLT	3/8" A325	x 2"						
11											
12											
13											
14											
15	hb	1	R	860 x 13(1/2)	4830	BEND					
16	pd	2	R	317 x 10(3/8)	527	TEMP.					
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											
51											
52											
53											
54											
55											



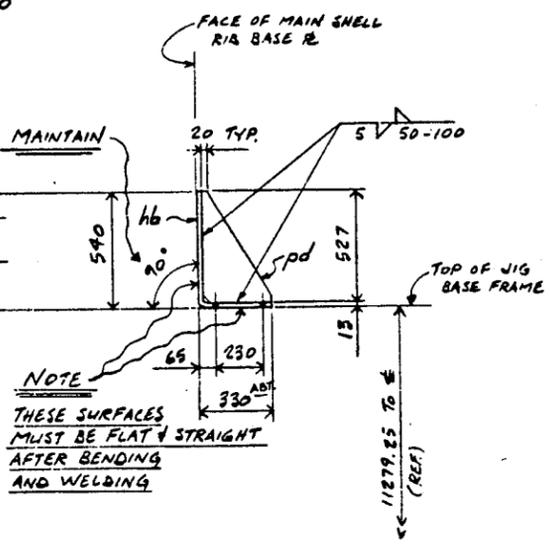
2 REQ'D. ~ BACK SHELL JIG FRAME ~ MK. M39



SECTION 'A-A'



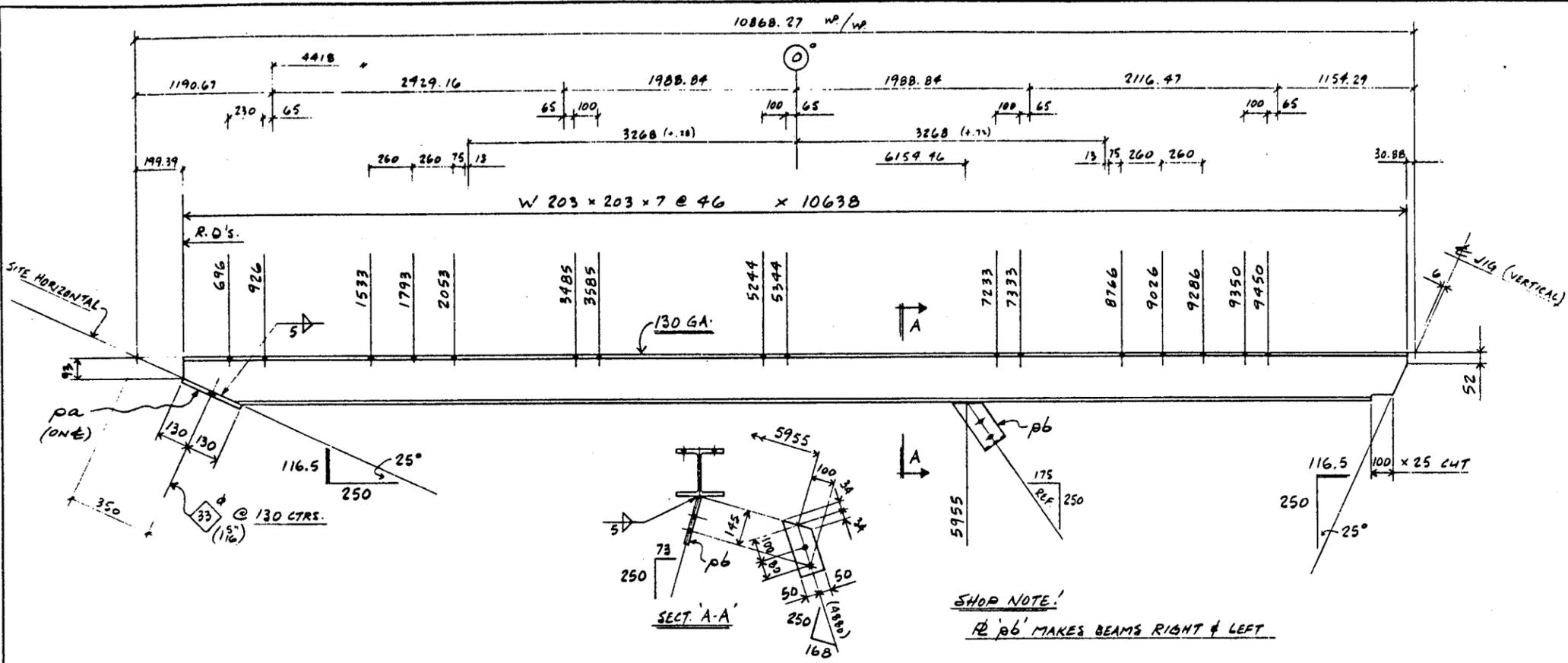
ONE REQ'D. ~ MAIN SHELL JIG FRAME ~ MK. N39



GENERAL NOTES:
1) FOR FINAL ASSEMBLY SEE DWG. 39a

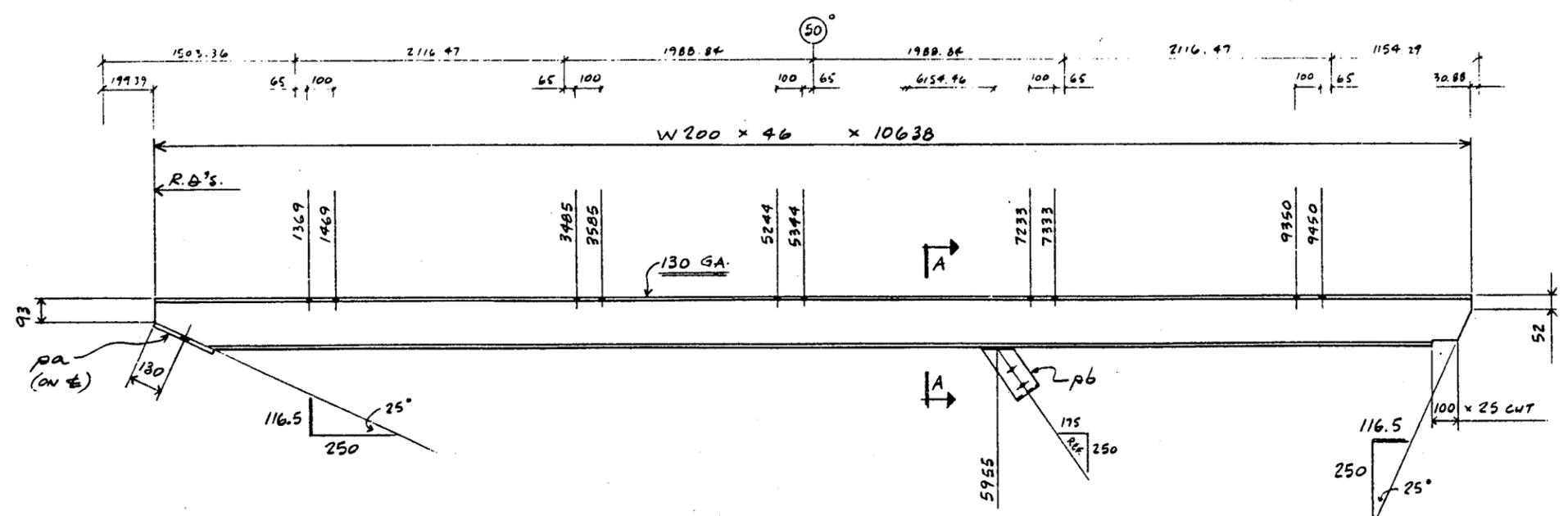
	MATERIAL	G4021 (44W) OR A36	DETAILS	PLAIN AND BACK SHELL JIG CROSS FRAMES
	SURF PREP & PAINT	REMOVE LODES SCALE NO PAINT	FOR	4.2 M TELESCOPE DOME LA PALMA
	OPEN HOLES	13/16" DIA 21"	DRAWING NO	1920-39f
DATE	OCT. 1957	CHECKED	DATE	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				





ONE REQ'D. ~ SUB-ASSEMBLY ~ MK. a39R (AS SHOWN)
 ONE REQ'D. ~ I I ~ MK. a39L (LEFT OF SHOWN)

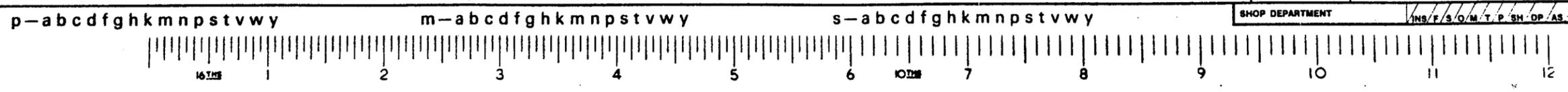
MATERIAL BILL										CONTRACT 1420	
BRITAIN STEEL LTD.											
MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MAT'T	WEIGHT				
1											
2											
3											
4											
5											
6	2	W	200 x 46	10638	WB=21		44W				
7	pa	2	R	200 x 13 (3')	260						
8	pb	2	R	100 x 10 (2')	250						
9											
10											
11											
12											
13											
14											
15	2	W	200 x 46	10638	WB=21		44W				
16	pa	2									
17	pb	2									
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											
51											
52											
53											
54											
55											

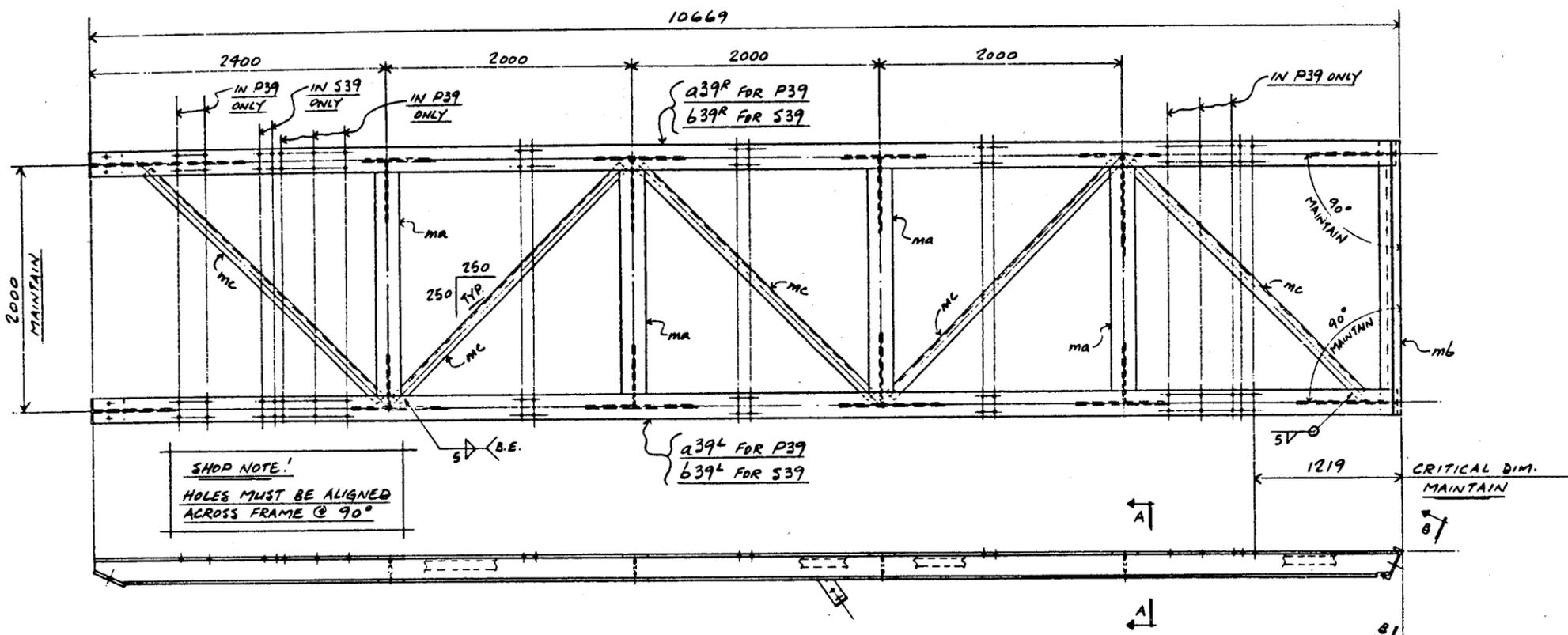


ONE REQ'D. ~ SUB-ASSEMBLY ~ MK. b39R (AS SHOWN)
 ONE REQ'D. ~ I I ~ MK. b39L (LEFT OF SHOWN)

GENERAL NOTES:
 1) FOR FINAL SHOP ASSEMBLY SEE DWG. 39h.

	MATERIAL	G40 21 (44W) w/n	DETAILS	JIG FRAME
	SURF. PREP & PAINT	REMOVE LOOSE SCALE NO PAINT		SUB-ASSEMBLY BEAMS
	OPEN HOLES	1/2" w/n (2/P)	FOR	4.2M TELESCOPE DOME
				LA PALMA
DRAWN		G.V.A. FEB/84	DATE	
CHECKED			DATE	
DRAWING NO		1420-39g		REV
BRITAIN STEEL LTD. 481 SALTER AVENUE, NEW WESTMINSTER, B.C.				
SHOP DEPARTMENT		INS / F / S / O / M / T / P / SH / OP / AS / PA / ER		

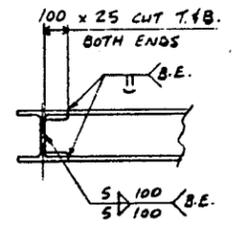




SHOP NOTE!
HOLES MUST BE ALIGNED
ACROSS FRAME @ 90°

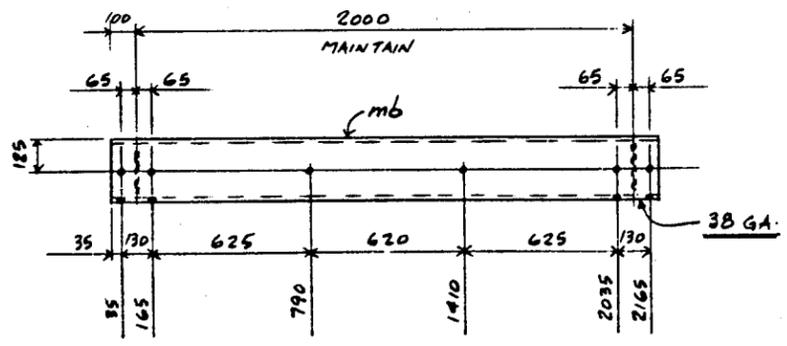
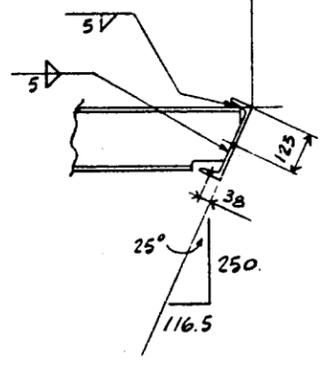
a39 FOR P39
b39 FOR S39

ONE REQ'D. ~ JIG FRAME ~ MK. P39
ONE REQ'D. ~ JIG FRAME ~ MK. S39



SECTION 'A-A'

SHOP NOTE!
FRAMES MUST BE FLAT & TRUE
AFTER WELDING.



VIEW 'B-B'

p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

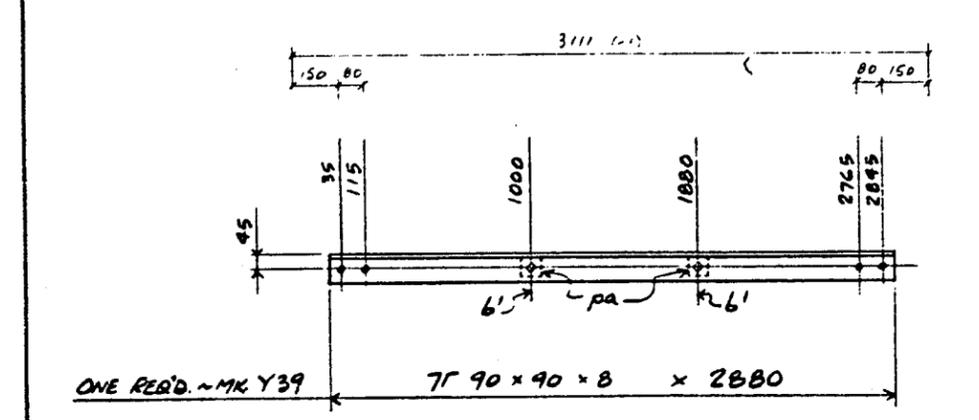
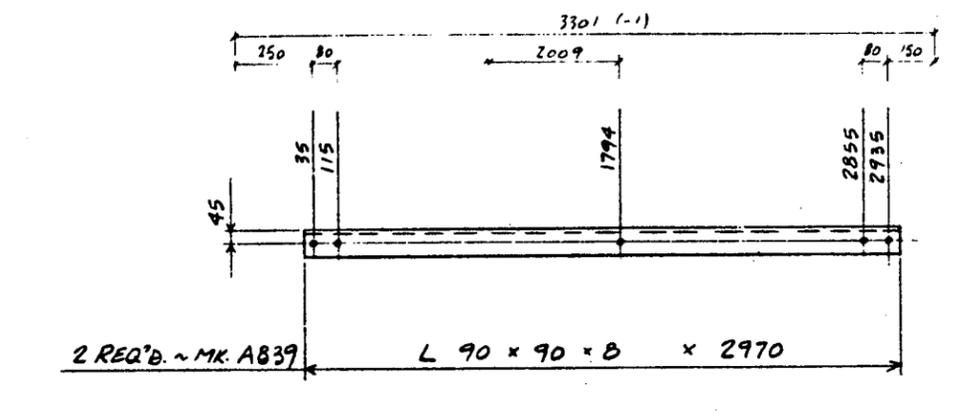
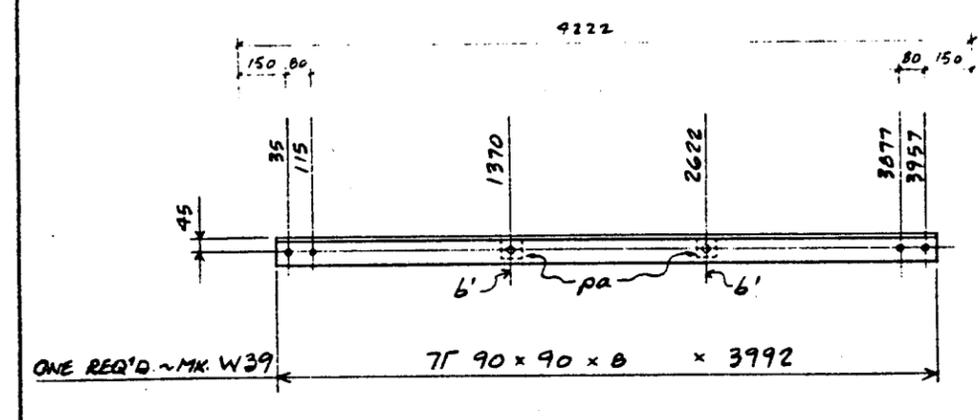
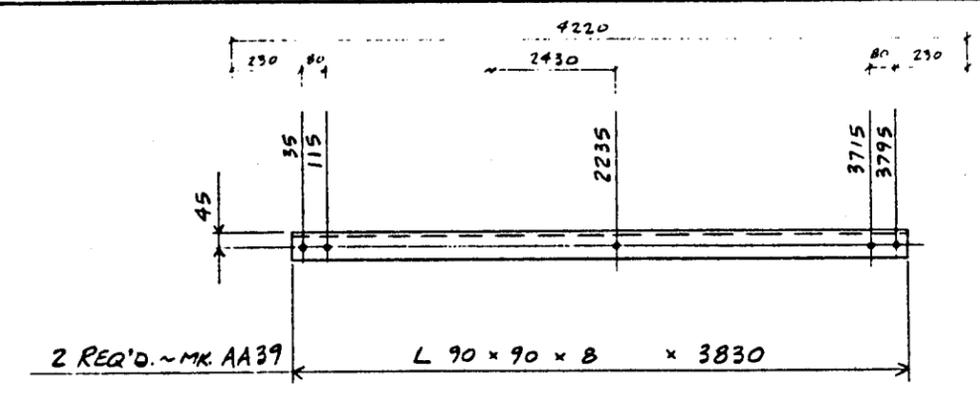
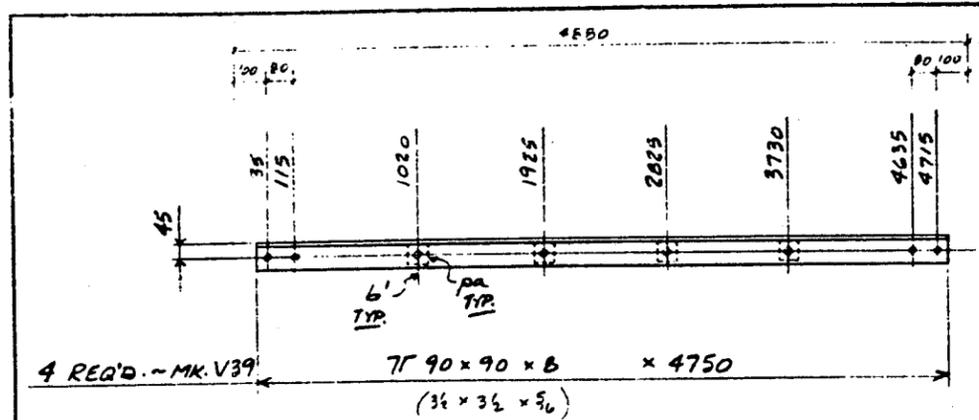
s-abcdefghijklmnpstvw

MATERIAL BILL		BRITAIN STEEL LTD.		CONTRACT 1420				
NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	WEIGHT
1								
2								
3						ONE REQ'D. ~ MK. P39		
4								
5	a39	2	SUB-ASSEMBLY	DETAILED ON DWG. 39g				
6	ma	4	W	202x203x7	1993	C.S. 7E. WB=31 44W		
7	mb	1	C	252x65x6x23	2200	CP=15.3		
8	mc	5	L	90x90x8	2630	L34=34=36		
9								
10								
11								
12						ONE REQ'D. ~ MK. S39		
13								
14	b39	2	SUB-ASSEMBLY	DETAILED ON DWG. 39g				
15	ma	4						
16	mb	1						
17	mc	5						
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								
51								
52								
53								
54								
55								

- GENERAL NOTES:
- 1) FOR SUB-ASSEMBLY BEAMS SEE DWG. 39g.
 - 2) FOR FINAL ASSEMBLY SEE DWG. 39a.

	MATERIAL	G4021 (44W) 68	NO. BY DATE	REVISION
	SUPP. PREP & PAINT REMOVE PAINT LOOSE SCALE NO PAINT O.P.N. HOLES 1/2" (2)	DETAILS JIG FRAMES FOR 4.2 M TELESCOPE BOME LA PALMA		
DRAWN G.V.A.	DATE FEB/89	CHECKED	DATE	DRAWING NO. 1420-39h REV.
BRITAIN STEEL LTD. 481 SALTER AVENUE, NEW WESTMINSTER, B.C.				
SHOP DEPARTMENT				



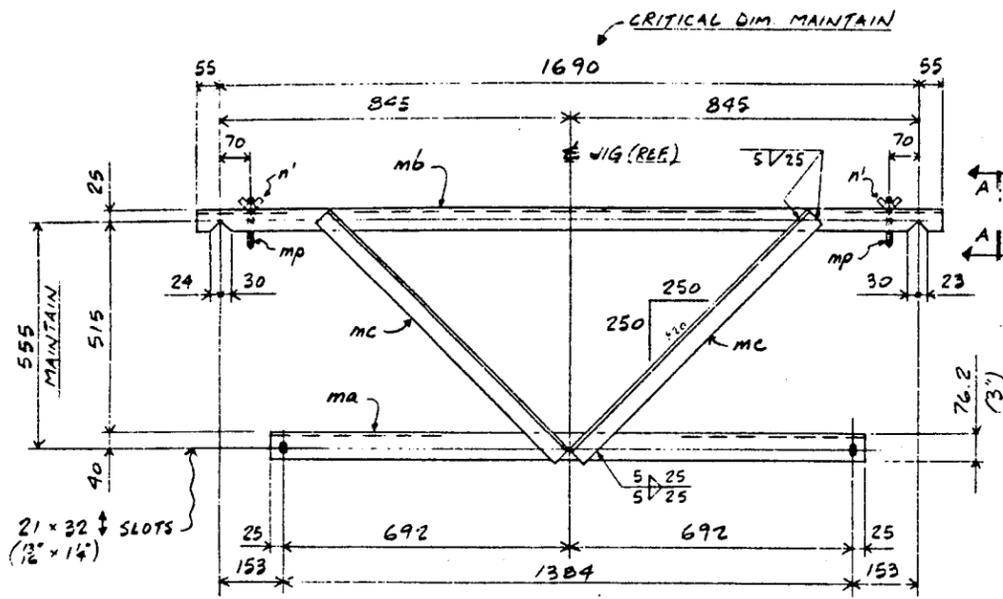


MATERIAL BILL		BRITAIN STEEL LTD.		CONTRACT 1420					
NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MFTL TYPE	W	WEIGHT
1									
2									
3									
4									
5	B	L	90x90x8	4750	L 3/4 x 3/4 x 5/16	44W			
6	pa	16	70x10 1/2	70		126			
7	b'	16	3/4 x 1/2	4307	2 1/2" C/W MAX HWT				
8									
9									
10									
11									
12									
13									
14	pa	2				44W			
15	b'	2							
16									
17									
18									
19									
20									
21	pa	2	L	90x90x8	2880	44W			
22	b'	2							
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									
51									
52									
53									
54									
55									

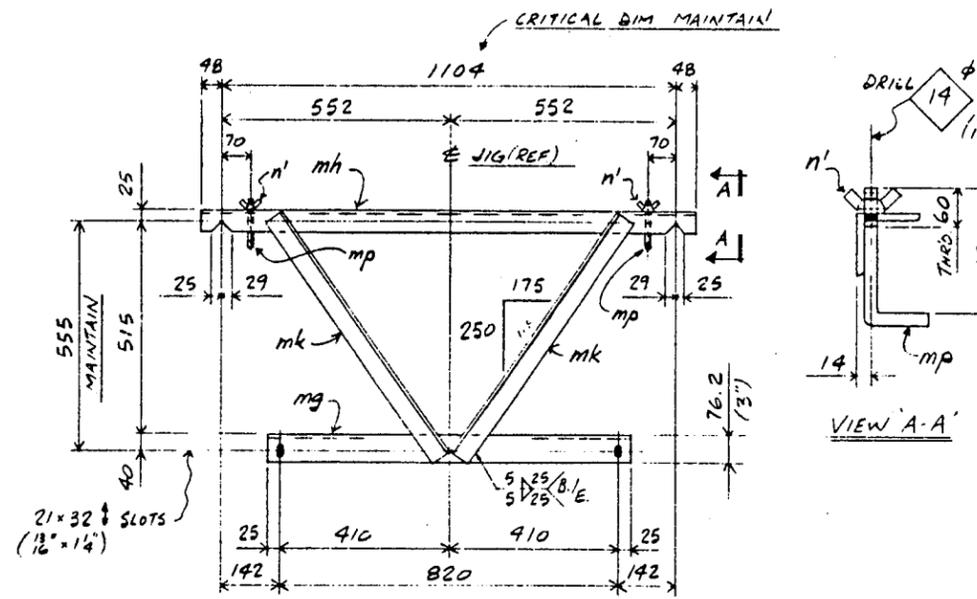
GENERAL NOTES:
1) FOR FINAL ASSEMBLY SEE DWG. 39a

	MATERIAL	G40 21 (44W) W/R	DETAILS	JIG FRAME BRACING					
	SURF PREP	REMOVE PAINT	SCALE	FOR 9.2 M TELESCOPE DOME LA PALMA					
	OPEN HOLES	1 1/2" W/R (21P)	SCALE	NO PAINT					
DRAWN	G.V.A.	DATE	FEB/84	CHECKED	DATE	DRAWING NO.	1420-39m	REV	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.									

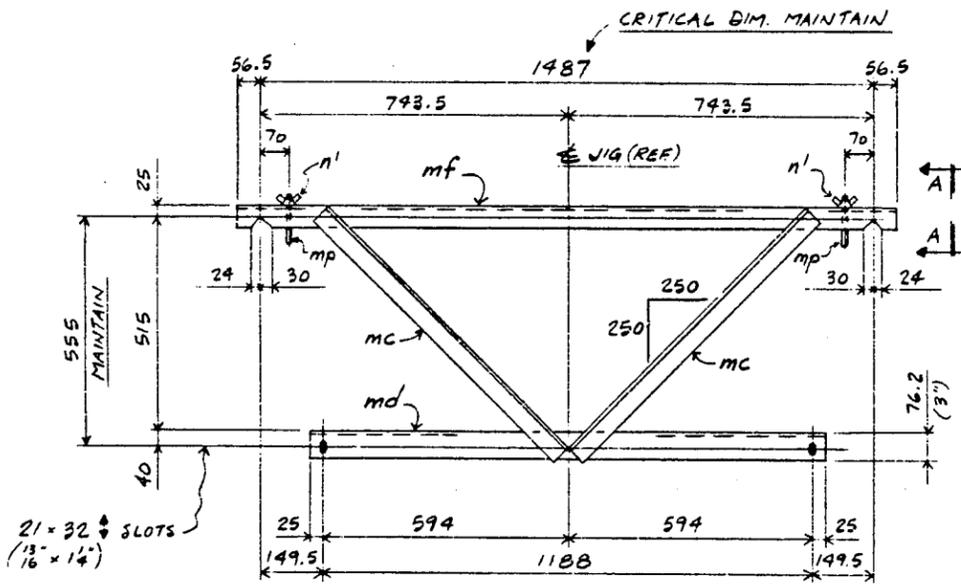
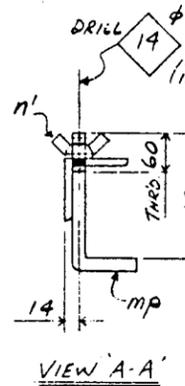




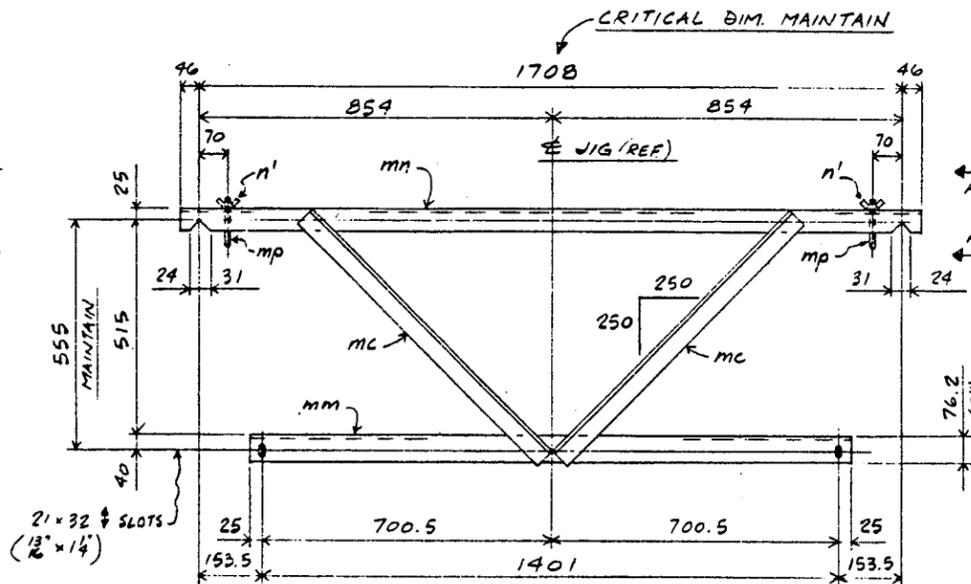
(REF. LOCATION = 10°) 2-REQ'D ~ ALIGNMENT FRAME ~ MK. AD39
(FOR MAIN SHELL JIG PANEL)



(REF. LOCATION +50°) ONE REQ'D ~ ALIGNMENT FRAME ~ MK. AG39
(FOR MAIN SHELL JIG PANEL)



(REF. LOCATION +30°) ONE REQ'D ~ ALIGNMENT FRAME ~ MK. AF39
(FOR MAIN SHELL JIG PANEL)



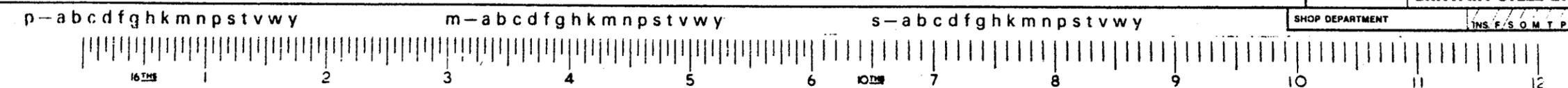
(REF. LOCATION 5:37:30°) 2-REQ'D ~ ALIGNMENT FRAME ~ MK. AH39
(FOR BACK SHELL JIG PANEL)

MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

NO.	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	BLK LINE	WT/GHT
1									
2									
3									
4						2-REQ'D ~ MK. AD39			
5	ma	2	L	76.2*63.5*6.35	1434	(3-2 1/2")	44W		
6	mb	2	L	508*508*4.76	1800	(2-2 1/4")	GA A36		
7	mc	4	L		820				
8	mp	4	BAR	9.53*1/32"	160	SEMI-THRD IE.			
9	n'	4	NUT			WING TYPE			
10						ONE REQ'D ~ MK. AG39			
11	mh	ONE	L	76.2*63.5*6.35	1238				
12	mk	ONE	L	508*508*4.76	1600				
13	mg	2	L						
14	mp	2	L						
15	n'	2	L						
16						ONE REQ'D ~ MK. AF39			
17	mf	ONE	L	76.2*63.5*6.35	870				
18	ma	ONE	L	508*508*4.76	1200				
19	mb	2	L		708				
20	mp	2	L						
21	n'	2	L						
22						2-REQ'D ~ MK. AH39			
23	mn	2	L	76.2*63.5*6.35	1451				
24	mm	2	L	508*508*4.76	1800				
25	mc	4	L						
26	mp	4	L						
27	n'	4	L						
28									
29									
30									
31									
32									
33									
34									
35									
36									
37									
38									
39									
40									
41									
42									
43									
44									
45									
46									
47									
48									
49									
50									
51									
52									
53									
54									
55									

- GENERAL NOTES:**
- FOR FIELD ASSEMBLY @ MAIN SHELL JIG PANEL SEE DWG. 23A & 23B.
 - FOR FIELD ASSEMBLY @ BACK SHELL JIG PANEL SEE DWG. 24.



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

DETAILS MAIN & BACK SHELL JIG PANEL ALIGNMENT FRAME: FOR 9.2" TELESCOPE DOME LA PALMA

NO. BY DATE REVISION

MATERIAL G40 21 (A491) OR A36

SURF PREP REMOVE LOOSE SCALE NO PAINT

PAINT AS NOTED

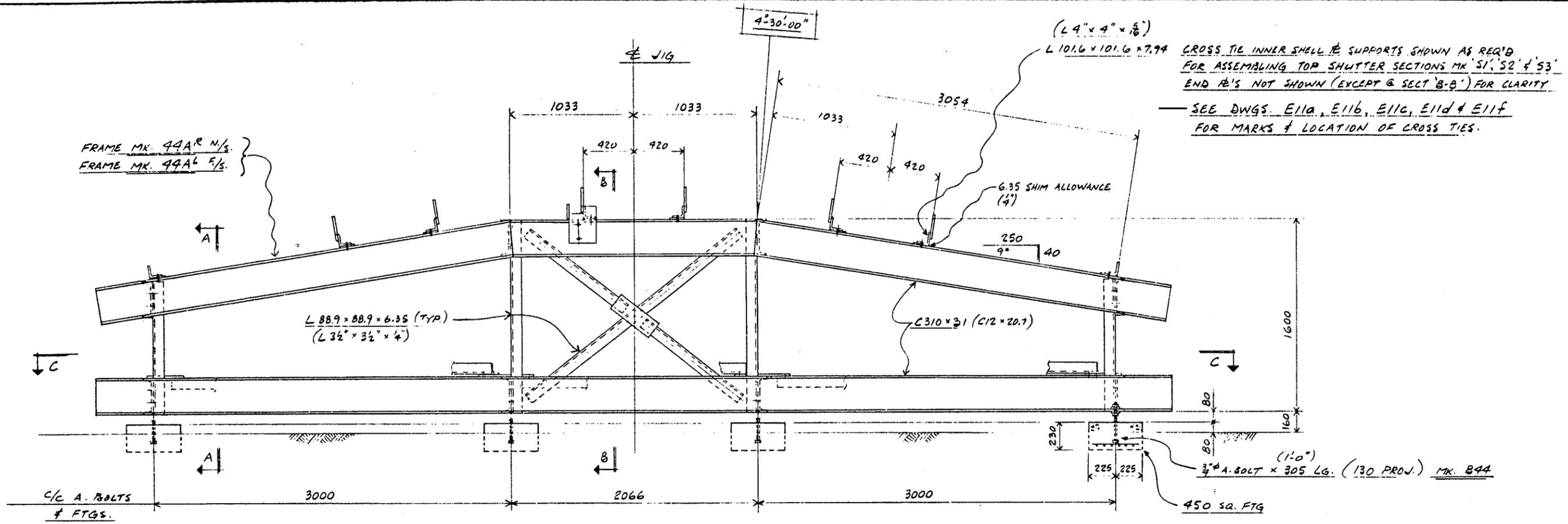
OPEN HOLES AS NOTED

DRAWN G.V.A. DATE FEB 64 CHECKED DATE DRAWING NO 1420-39n REV

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

SHOP DEPARTMENT

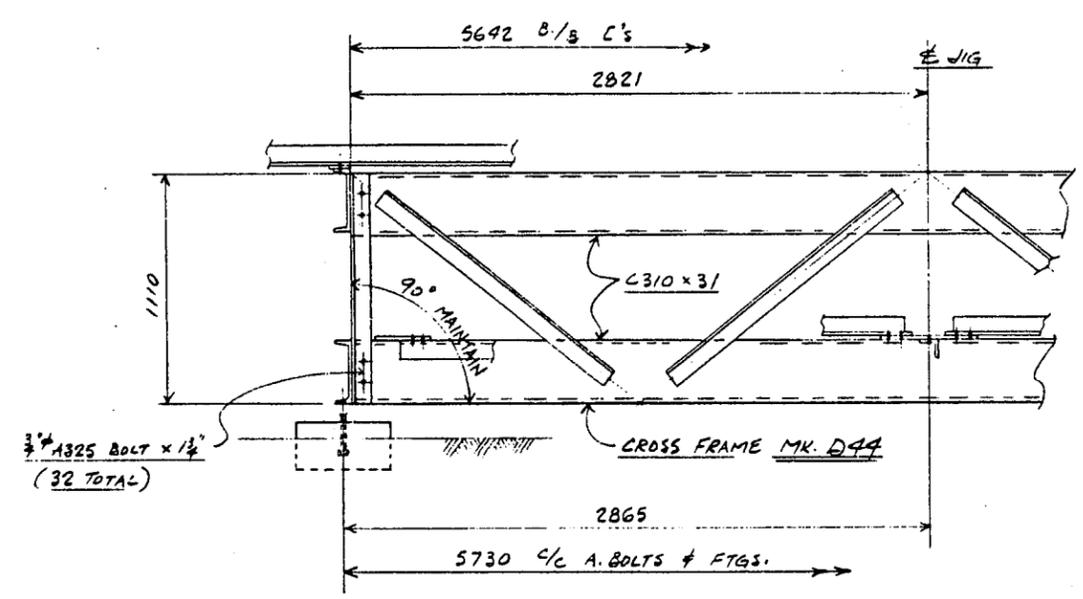
INS F'S O M T P SH OP AS PA ER



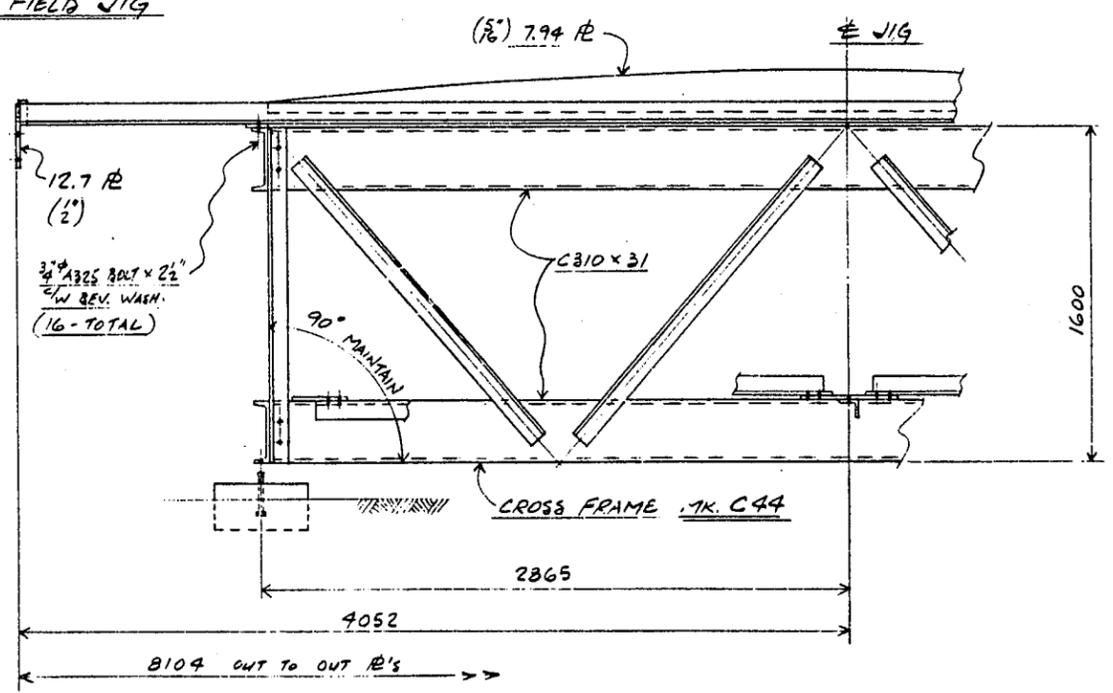
CROSS TIE INNER SHELL RE SUPPORTS SHOWN AS REQ'D FOR ASSEMBLING TOP SHUTTER SECTIONS MK 51, 52 & 53. END RE'S NOT SHOWN (EXCEPT @ SECT B-B) FOR CLARITY.

SEE DWGS. E11a, E11b, E11c, E11d & E11f FOR MARKS & LOCATION OF CROSS TIES.

ELEVATION ON SHUTTER FIELD JIG



SECTION 'A-A'



SECTION 'B-B'

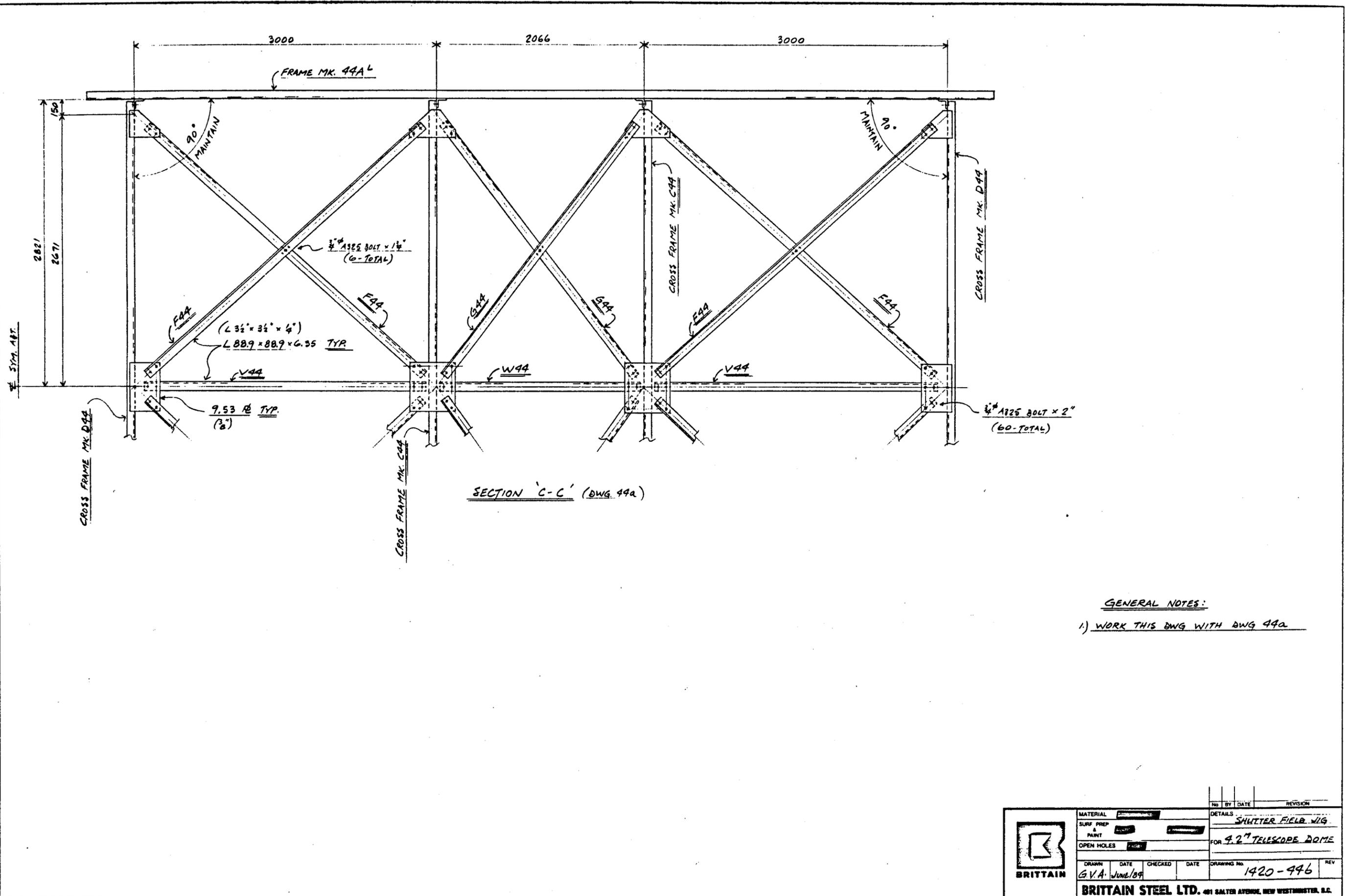
- GENERAL NOTES:
- 1) WORK THIS DWG WITH DWG 44b
 - 2) FOR DETAILS SEE DWGS. 44c, 44d, 44f, 44g & 44h
 - 3) FOR FIELD ASSEMBLY OF SHUTTER SECTIONS SEE DWG. SERIES E11

BRITAIN	MATERIAL	SURF PREP & PAINT		OPEN HOLES		DETAILS		
	SHUTTER FIELD JIG						FOR 4.2" TELESCOPE DOME LA PALMA	
	DRAWN	DATE	CHECKED	DATE	DRAWING NO.	REL.		
G.V.A.		JUNE/84		1420-49a				
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, S.C.								
SHOP DEPARTMENT				INS. F/S Q/M T.P. SH. DP. AS. PA. ER				

p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw



SECTION 'C-C' (DWG. 44a)

GENERAL NOTES:

- 1) WORK THIS DWG WITH DWG 44a

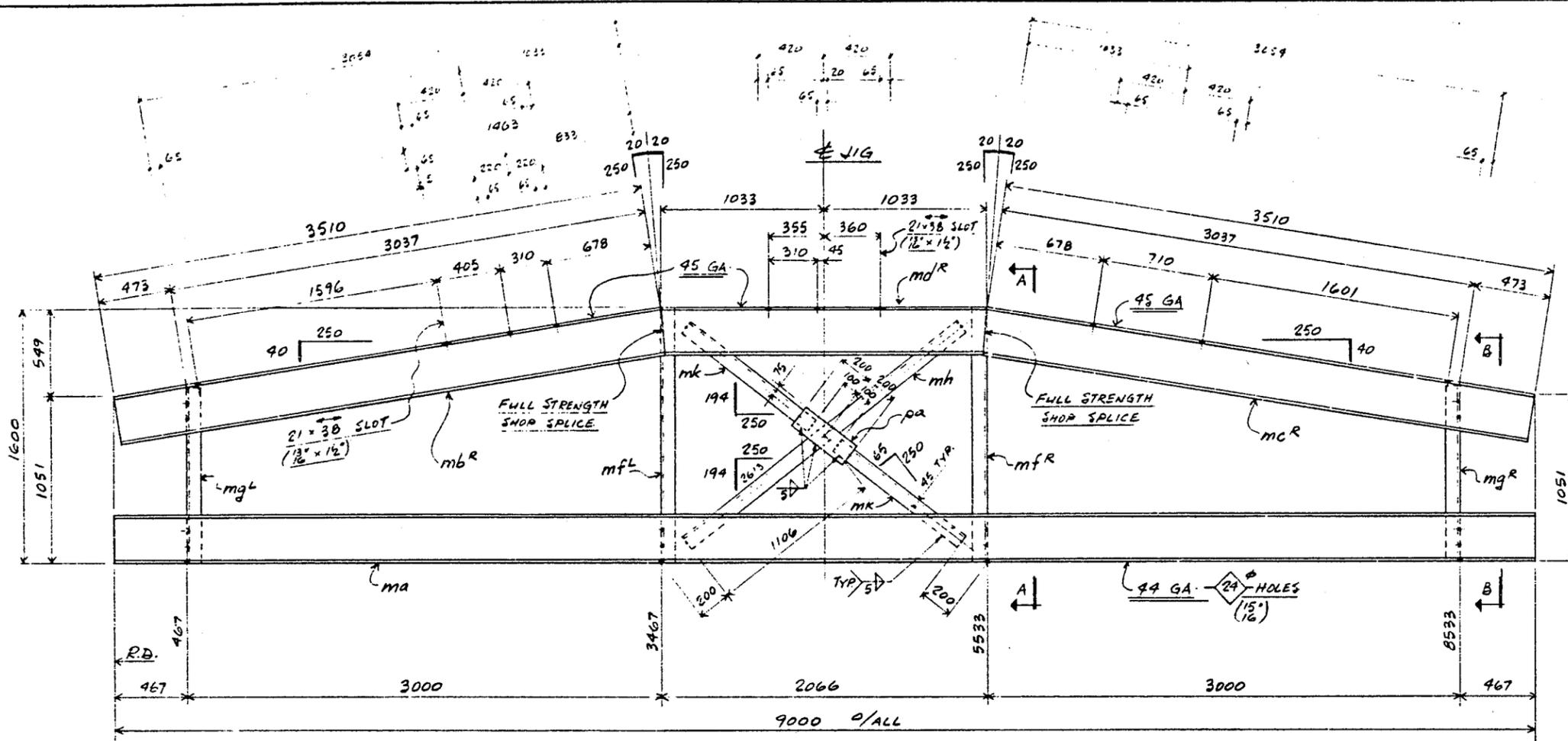
MATERIAL		DETAILS	
SURF PREP & PAINT		SHUTTER FIELD WIG	
OPEN HOLES		FOR 4.2" TELESCOPE DOME	
DRAWN	DATE	CHECKED	DATE
G.V.A.	June/89		
DRAWING NO.		REV	
1420-446			
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.			

p-abcdefghijklmnpstvw

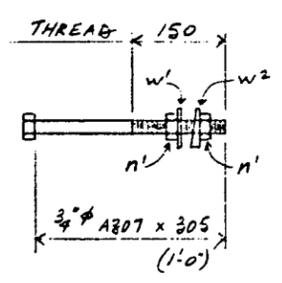
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

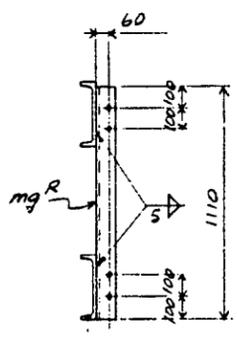
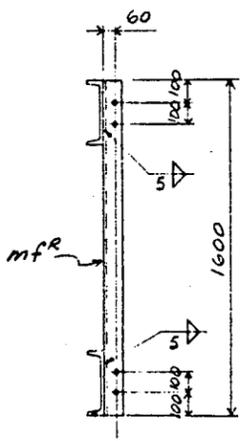




ONE REQ'D. ~ SIDE FRAME ~ MK. A44R (AS SHOWN)
 ONE REQ'D. ~ SIDE FRAME ~ MK. A44L (LEFT OF SHOWN)



8-REQ'D. ~ ANCHOR BOLT ~ MK. B44



MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MAT. TYPE	WEIGHT
1								
2						ONE REQ'D. ~ MK. A44R		
3						ONE REQ'D. ~ MK. A44L		
4								
5	ma	2	C	310 x 31	9000 (C12 x 20.7)	14W 11.1		
6	mbR	2			3510	R.C. 1E. OR A36		2
7	mcL	2			3510			2
8	mdR	2			2066	R.C. 2E.		3
9								
10	mfr	4	L	90 x 90 x 6	1600 (L3 1/2 x 3 1/2 x 4)			6
11	mgR	4			1110			7
12	mh	2			2210			7
13	mk	4			1000			7
14								
15	pa	2	R	10 x 150	900			
16								
17								
18								
19						8-REQ'D. ~ MK. B44		
20								
21	B		BOLT	3/4" A307	305 (1'0") THRD. 1E			
22	N	16	NUT	3/4" H.V.Y. HEX.				
23	W	8	WASHER	3/4" STD. FLAT				
24	W	8	WASHER	3/4" BEV.				
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								
51								
52								
53								
54								
55								

GENERAL NOTES:

- 1) FOR FIELD ASSEMBLY SEE DWG 44A

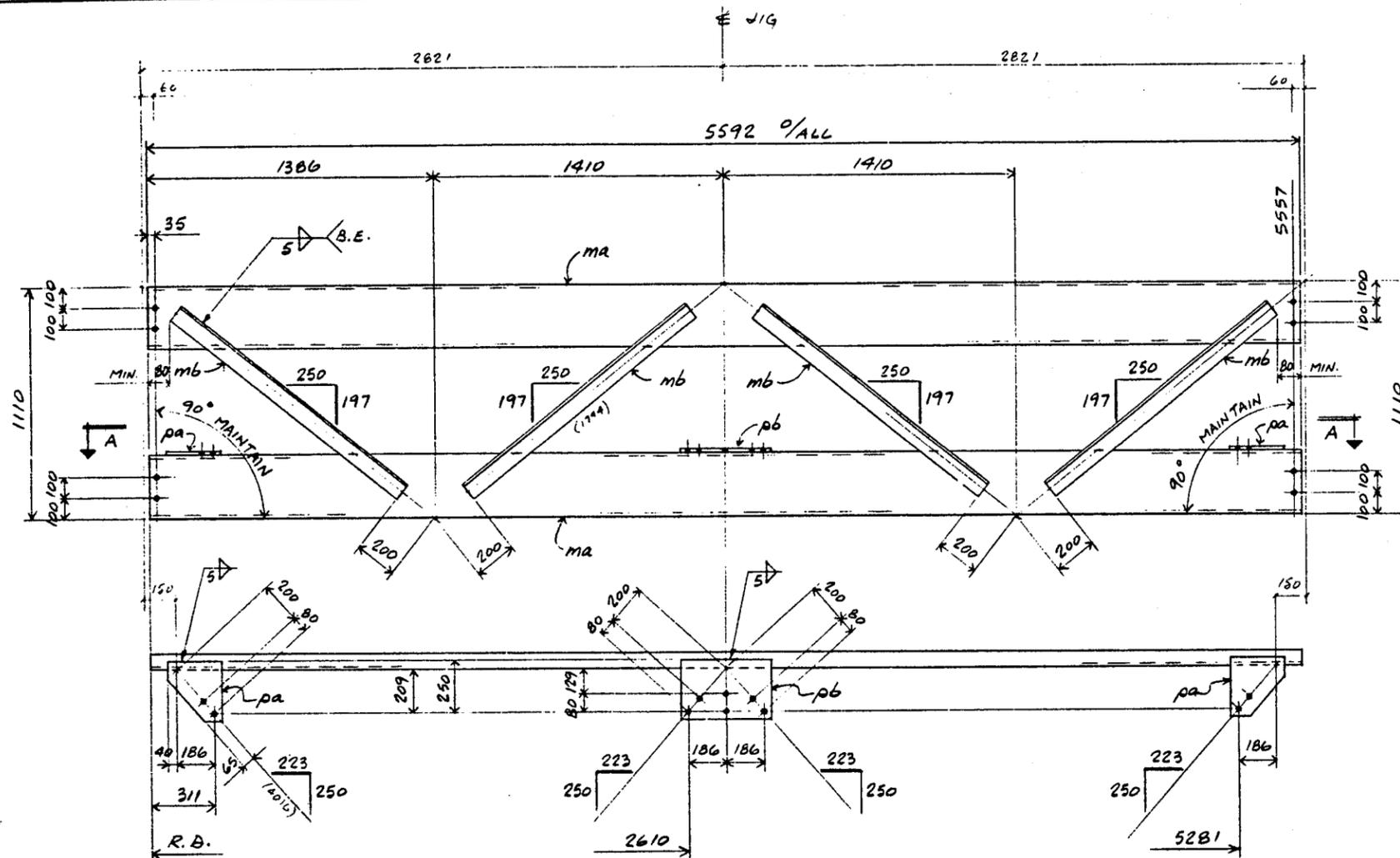
	MATERIAL	G4021 (44W) OR A36	DETAILS	SHUTTER FIELD W/3 SIDE FRAMES
	SURF PREP & PAINT	REMOVE LOOSE SCALE		
	OPEN HOLES	1/2" DIA (21)		FOR 4.2 M TELESCOPE DOME LA PALMA
		NO PAINT		
DRAWN	DATE	CHECKED	DATE	DRAWING NO
GVA	JUNE/68			1420-44c
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				

p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

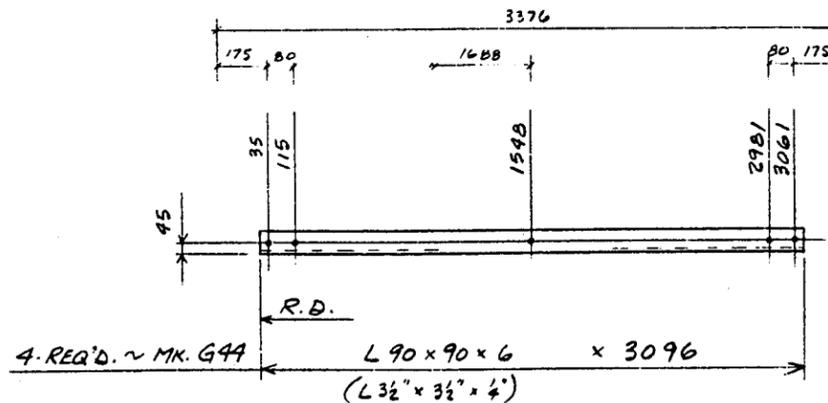
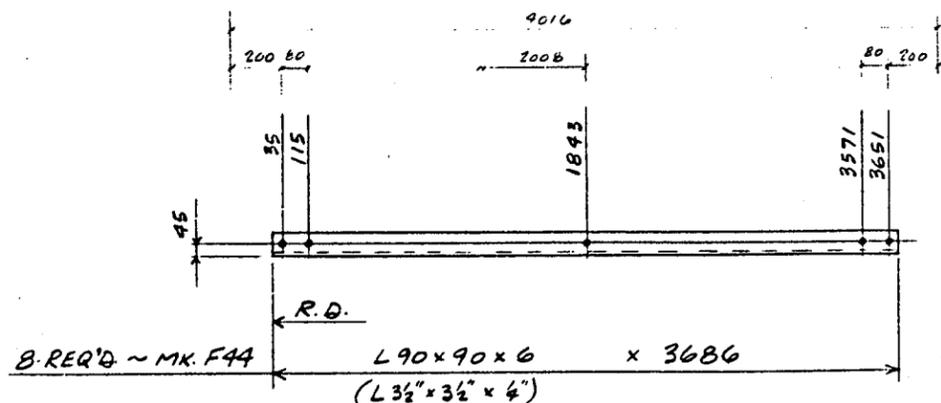
s-abcdefghijklmnpstvw





SECTION 'A-A'

2-REQ'D. ~ CROSS FRAME ~ MK. D44



MATERIAL BILL

BRITAIN STEEL LTD.

CONTRACT 1420

NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MAT'L TYPE	WEIGHT
1								
2						2-REQ'D ~ MK. D44		
3								
4	ma	4	C	310x31	5592	(C12x20.7) C.S. 28. F4W 11.4		
5	mb	8	L	90x90x6	1380	(L3 1/2 x 3 1/2 x 1/4) GR A36 11.6		
6	pa	4	R	10x260	285			
7	pb	2	R	10x285	490			
8								
9								
10								
11						8-REQ'D ~ MK. F44		
12								
13	B	L	90x90x6	3686	(L3 1/2 x 3 1/2 x 1/4)			11.9
14								
15								
16								
17								
18						4-REQ'D ~ MK. G44		
19								
20	F	L	90x90x6	3096	(L3 1/2 x 3 1/2 x 1/4)			11.10
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								
51								
52								
53								
54								
55								

GENERAL NOTES:

1) FOR FIELD ASSEMBLY SEE DWG. 44a & 44b.

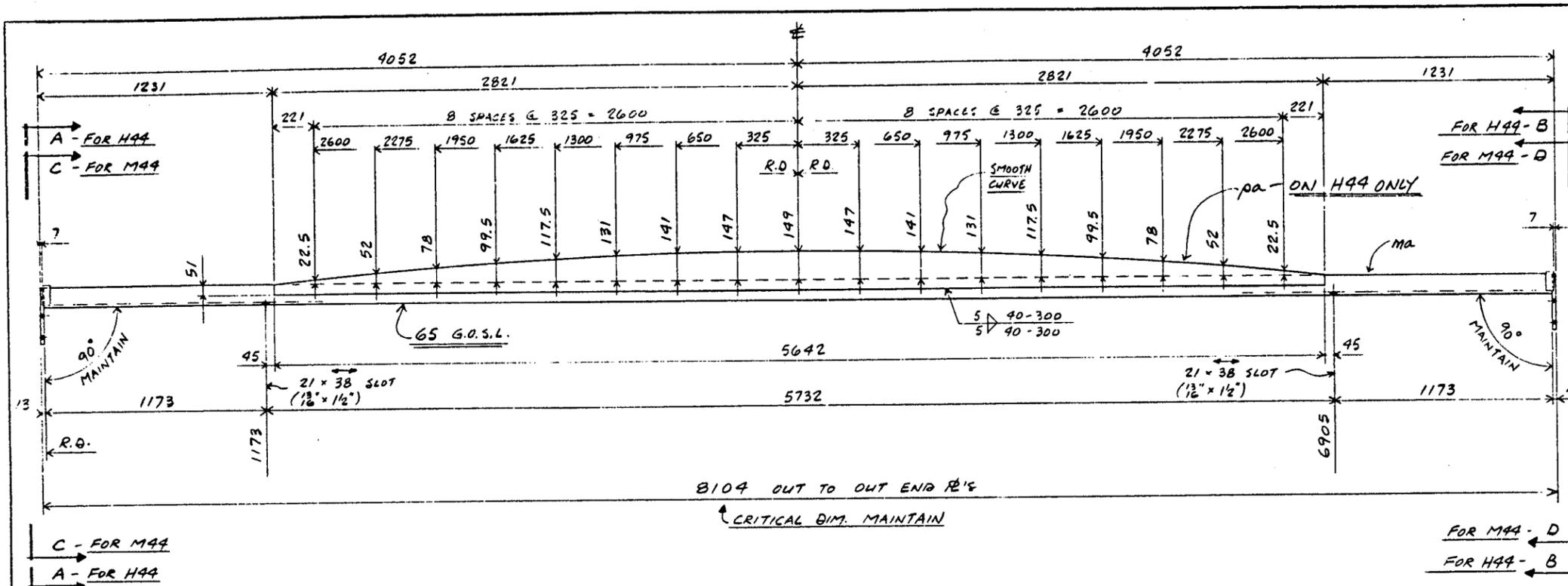
	MATERIAL	G4021 (4W) OR A36	DETAILS	SHUTTER FIELD JIG
	SURF PREP	REMOVE	CROSS FRAMES & BRACING	
	PAINT	LOOSE	FOR 4.2M TELESCOPE DOME	
	OPEN HOLES	1/2" (21)	LA PALMA	
		NO PAINT		
DRAWN	DATE	CHECKED	DATE	DRAWING NO
G.V.A	JUNE/89			1420-44f
BRITAIN STEEL LTD. 461 SALTER AVENUE, NEW WESTMINSTER, B.C.				

p-abcdefghijklmnpstvw

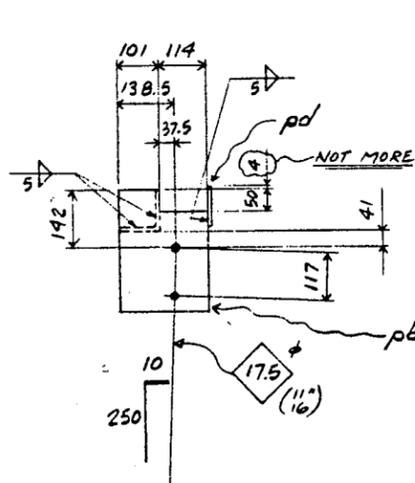
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

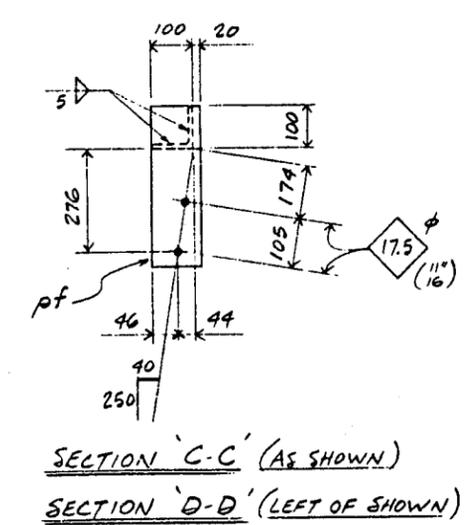




MATERIAL BILL		BRITAIN STEEL LTD.		CONTRACT 1420					
NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	UNIT	WEIGHT
1									
2									
3									
4	ma	6	L	102x102x8	8070	(L4+4+1/2) C.S. 2E	44W	1112	
5	pa	6	R	200x8 (1/2)	5692	CUT TO PROFILE	12 A36		
6	pb	12	R	215x13 (1/2)	295				
7	pd	12	R	40x6 (1/4)	95				
8									
9									
10									
11									
12									
13	ma	2							
14	pf	4	R	120x13 (1/2)	410				
15									
16									
17									
18									
19									
20									
21									
22									
23									
24									
25									
26									
27									
28									
29									
30									
31	N44	20	R	90x6.35 (1/4)	130	SHIMS			
32	P44	16		90x3.18 (1/8)	130				
33	S44	16		90x1.59 (1/16)	130				
34									
35									
36									
37									
38									
39									
40									
41									
42									
43									
44									
45									
46									
47									
48									
49									
50									
51									
52									
53									
54									
55									



SECTION 'A-A' (AS SHOWN)
SECTION 'B-B' (LEFT OF SHOWN)



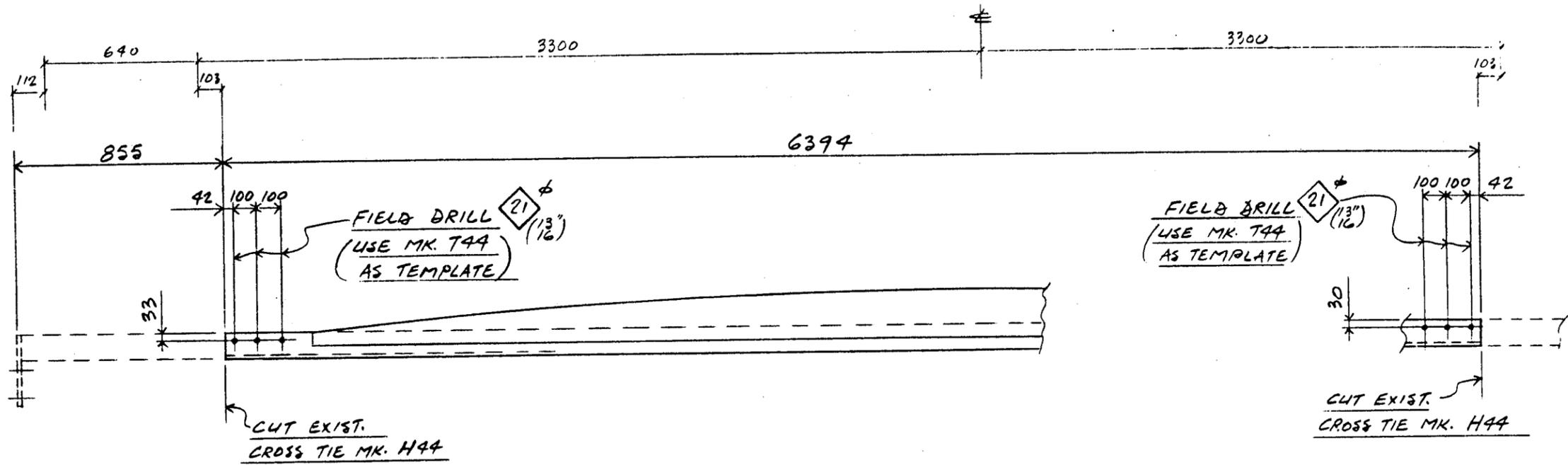
SECTION 'C-C' (AS SHOWN)
SECTION 'D-D' (LEFT OF SHOWN)

6-REQ'D ~ CROSS TIE ~ MK. H44
2-REQ'D ~ CROSS TIE ~ MK. M44

20 REQ'D ~ SHIM ~ MK. N44
16 REQ'D ~ | ~ MK. P44
16 REQ'D ~ | ~ MK. S44

GENERAL NOTES:
1) FOR FIELD ASSEMBLY SEE DWG'S. E11a, E11b, E11c, E11d & E11f.

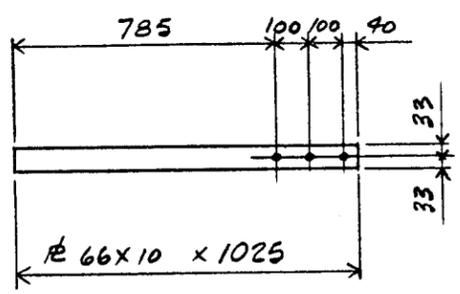
	MATERIAL	G4021 (44W) OR A36	DETAILS	SHUTTER FIELD, VIG. CROSS TIES & SHIMS					
	SURF. PREP & PAINT	REMOVE LOOSE SCALE	FOR 9.2" TELESCOPE DOME LA. PALMA						
	OPEN HOLES	AS NOTED							
		NO PAINT							
DRAWN	G.V.A.	DATE	JUNE/84	CHECKED	DATE	DRAWING NO.	1420-449	REV	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.									



FIELD WORK REQ'D. TO 2 CROSS TIES MK. H44 FOR FIELD SPLICE #1 & #2.

NOTE!

FIELD WORK TO MK. H44 TO BE DONE AFTER SHUTTER SECTIONS HAVE BEEN ASSEMBLED



4 REQ'D. ~ MK. T44

GENERAL NOTES:

1.) FOR FIELD ASSEMBLY SEE DWG. E11f

											No.		BY		DATE		REVISION										
7																											
6																											
5																											
4																											
3																											
2	4	T44	66x10 (3/8")	44W OR A36	1'025																						
1																											
	SHIP No. REQD.	FAB MARK	DESCRIPTION	MAT'L	LENGTH	R.B.	LINE	REMARKS	CUTTING INSTRUCTIONS SPlicing ALLOWED	WEIGHT	DIVISIONS	MATERIAL G40.21 (44W) OR A36		SURF. PREP. & PAINT REMOVE LOOSE SCALE		OPEN HOLES AS NOTED NO PAINT		DRAWN G.V.A. DATE JUNE/04		CHECKED DATE		DATE		DRAWING No. 1420-44h		REV.	
											BRITAIN STEEL LTD.		401 SALTER AVENUE, NEW WESTMINSTER, B.C.														
											SHOP DEPARTMENT		INS / F / S / O / M / T / P / SH / DP / AS / PA / ER						No. PRINTS								

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

