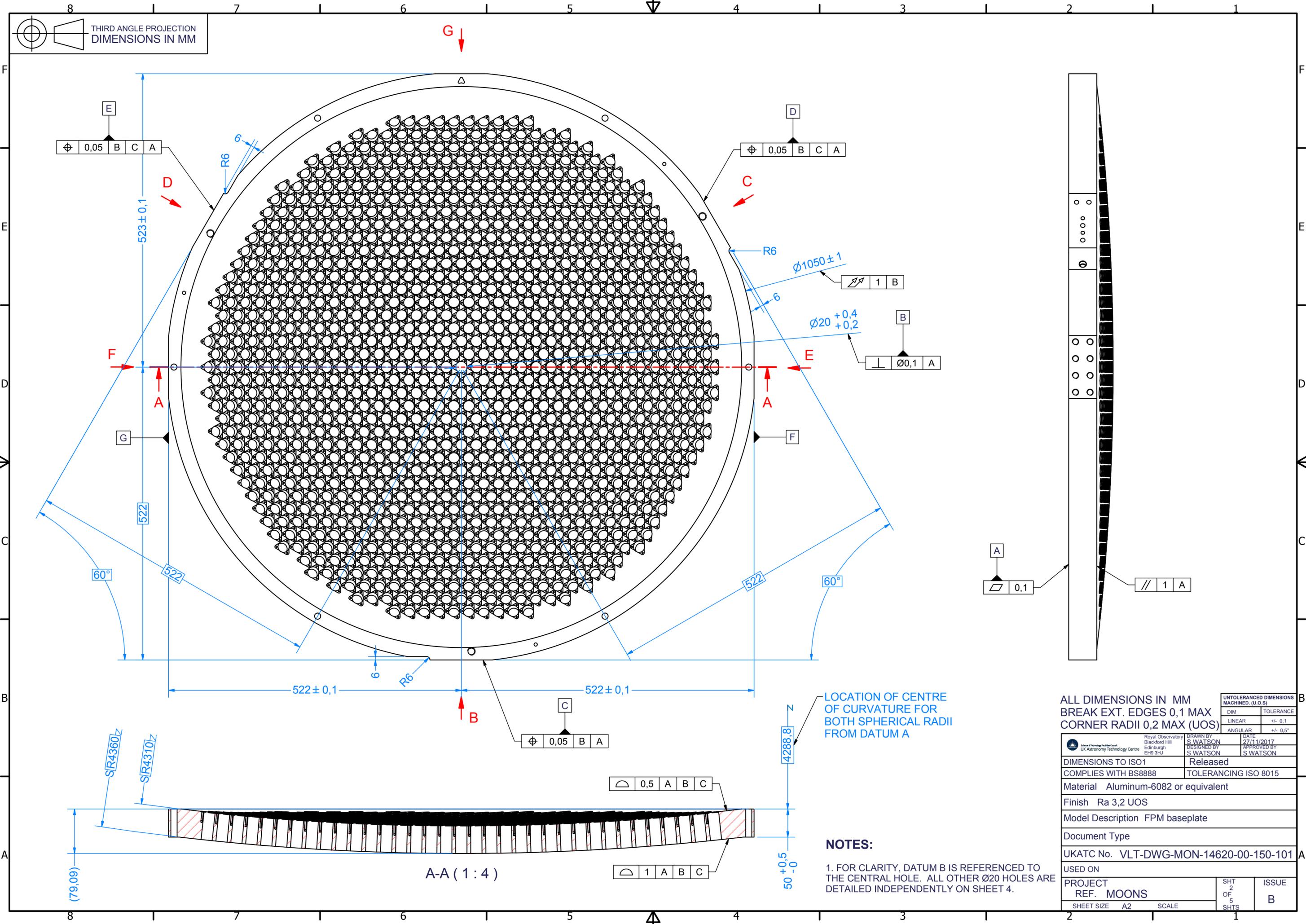


NOTES:

1. DRAWING IS DETAILED ON FIVE SHEETS, AS FOLLOWS:
 - SHEET 1: COVER SHEET
 - SHEET 2: OVERALL DIMENSIONS AND DATUMS
 - SHEET 3: HOLES ON DIAMETER
 - SHEET 4: HOLES ON FACES
 - SHEET 5: FACETS
2. DRAWING REFERS TO A STEP FILE, *VLT-DWG-MON-14620-00-150-101-A.STEP*
3. THE STEP FILE IS MODELLED TO NOMINAL DIMENSIONS. WHERE TOLERANCES ARE ASYMMETRIC, CARE SHOULD BE TAKEN TO DERIVE THE MID SURFACE SPECIFICATION FROM THE DRAWING, NOT THE STEP FILE.
3. INSPECTION IS REQUIRED OF ALL DATUM SURFACES AND ALL 1069 FACETS.
4. THE PART SHALL BE DELIVERED IN A ROBUST, RE-USABLE CRATE WITH PROTECTION AGAINST SHOCK AND IMPACT LOADING.
5. FINISHED PART HAS A MASS OF ~71KG.

	Royal Observatory Blackford Hill Edinburgh EH9 3HJ	DRAWN BY S. WATSON	DATE 27/11/2017
		DESIGNED BY S. WATSON	APPROVED BY S. WATSON
DIMENSIONS TO ISO1		Released	
COMPLIES WITH BS8888		TOLERANCING ISO 8015	
Material Aluminum-6082 or equivalent			
Finish			
Model Description FPM baseplate			
Document Type			
UKATC No. VLT-DWG-MON-14620-00-150-101			
USED ON			
PROJECT REF. MOONS		SHT 1 OF 5 SHTS	ISSUE B
SHEET SIZE A2		SCALE	



ALL DIMENSIONS IN MM
BREAK EXT. EDGES 0,1 MAX
CORNER RADII 0,2 MAX (UOS)

UNTOLERANCED DIMENSIONS MACHINED (U.O.S)	
DIM	TOLERANCE
LINEAR	+/- 0,1
ANGULAR	+/- 0,5°

Royal Observatory Blackford Hill Edinburgh EH9 3HJ	DRAWN BY S. WATSON DESIGNED BY S. WATSON	DATE 27/11/2017 APPROVED BY S. WATSON
DIMENSIONS TO ISO1		Released
COMPLIES WITH BS8888		TOLERANCING ISO 8015
Material Aluminum-6082 or equivalent		
Finish Ra 3,2 UOS		
Model Description FPM baseplate		
Document Type		
UKATC No. VLT-DWG-MON-14620-00-150-101		
USED ON		
PROJECT REF. MOONS	SHT 2 OF 5 SHTS	ISSUE B
SHEET SIZE A2	SCALE	

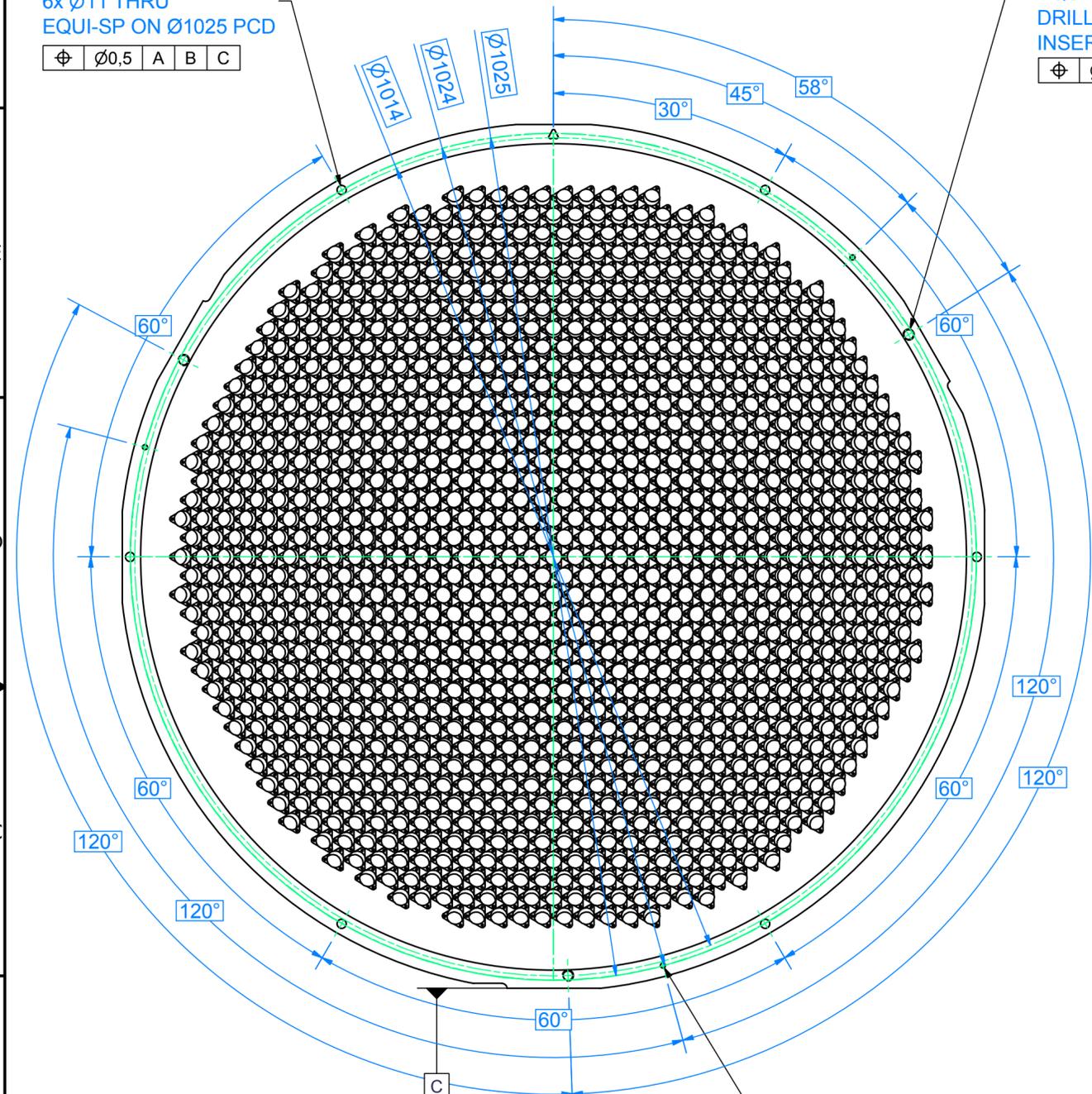
LOCATION OF CENTRE OF CURVATURE FOR BOTH SPHERICAL RADII FROM DATUM A

NOTES:
1. FOR CLARITY, DATUM B IS REFERENCED TO THE CENTRAL HOLE. ALL OTHER Ø20 HOLES ARE DETAILED INDEPENDENTLY ON SHEET 4.

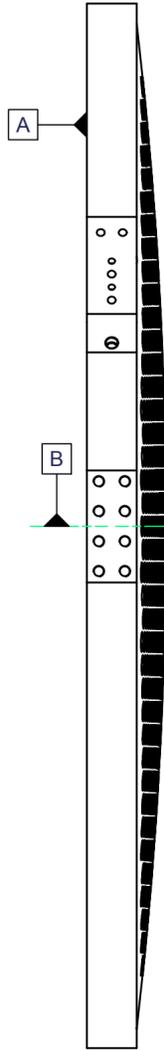
A-A (1 : 4)

THIRD ANGLE PROJECTION
DIMENSIONS IN MM

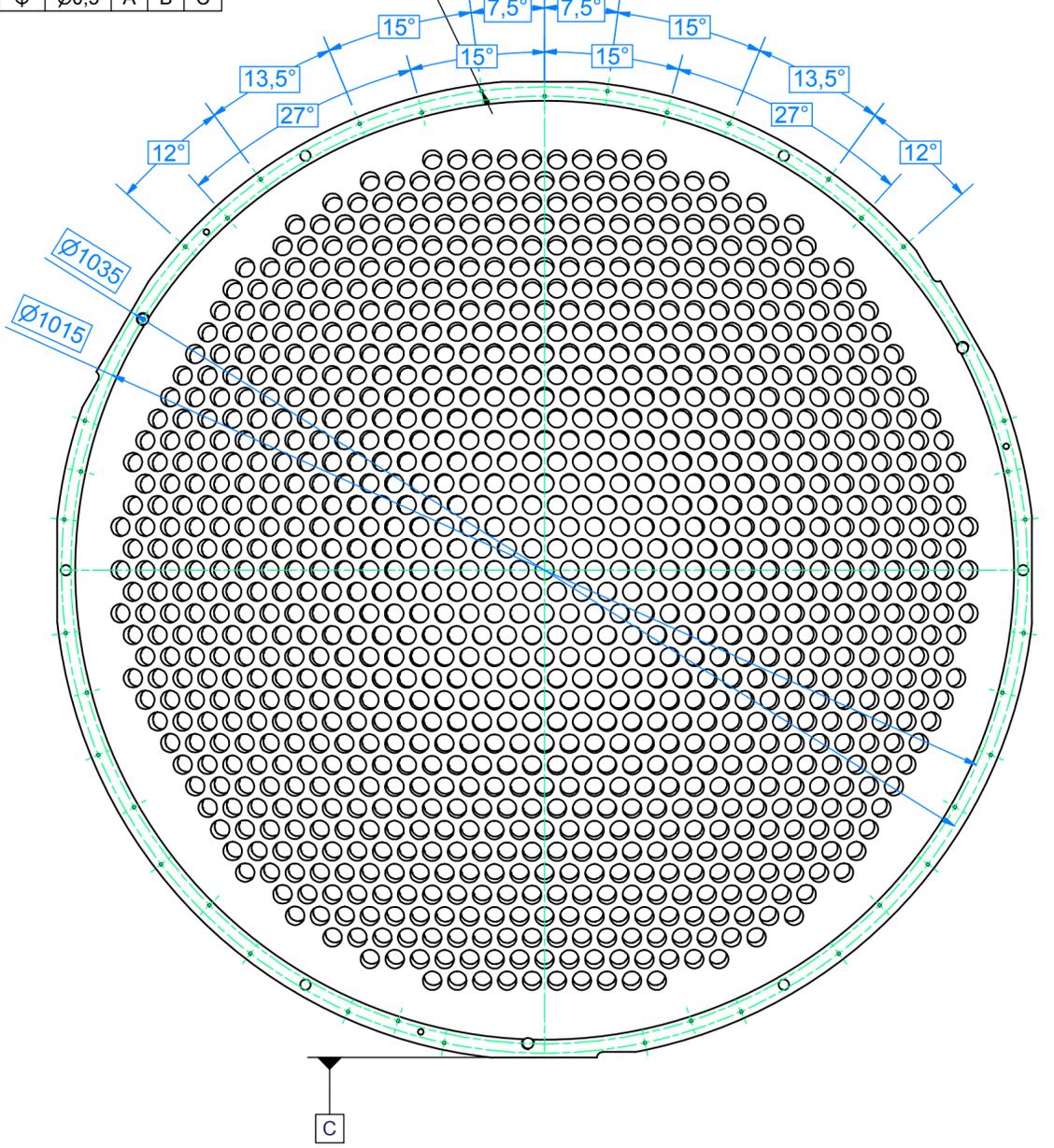
6x Ø11 THRU
EQUI-SP ON Ø1025 PCD
⊕ Ø0,5 A B C



3x M12 X 1.75 THREAD INSERT
1.5 D
EQUI-SP ON Ø1014 PCD
DRILL AND TAP THRU
INSERTS FROM BOTH SIDES
⊕ Ø1 A B C



3x / 11x M3 X 0.50
DRILL ∇ 10
TAP ∇ 6
POSN AS SHOWN
EQUI-SP 3x PATTERN
⊕ Ø0,5 A B C

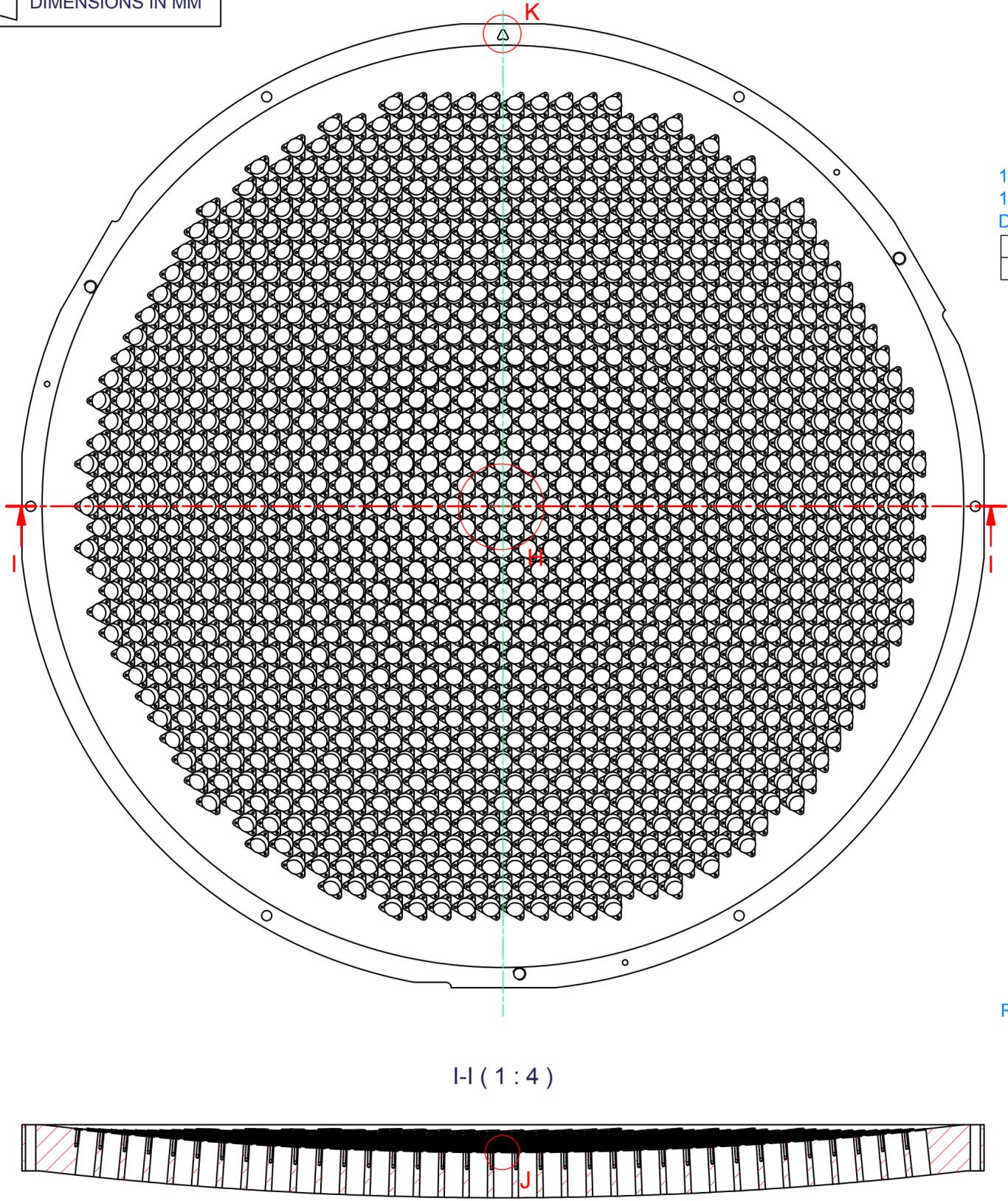


3x Ø6 H7 THRU
EQUI-SP ON Ø1024 PCD
⊕ Ø0,5 A B C

ALL DIMENSIONS IN MM
BREAK EXT. EDGES 0,1 MAX
CORNER RADII 0,2 MAX (UOS)

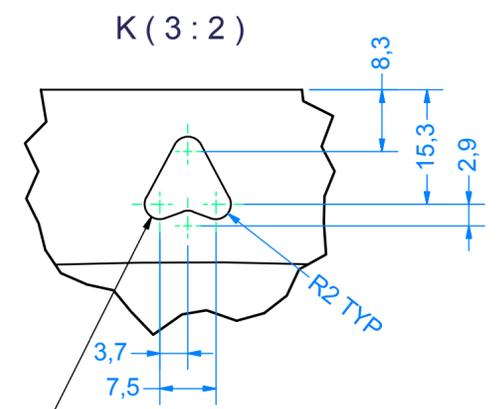
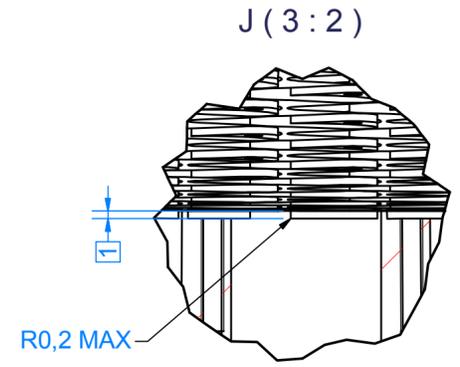
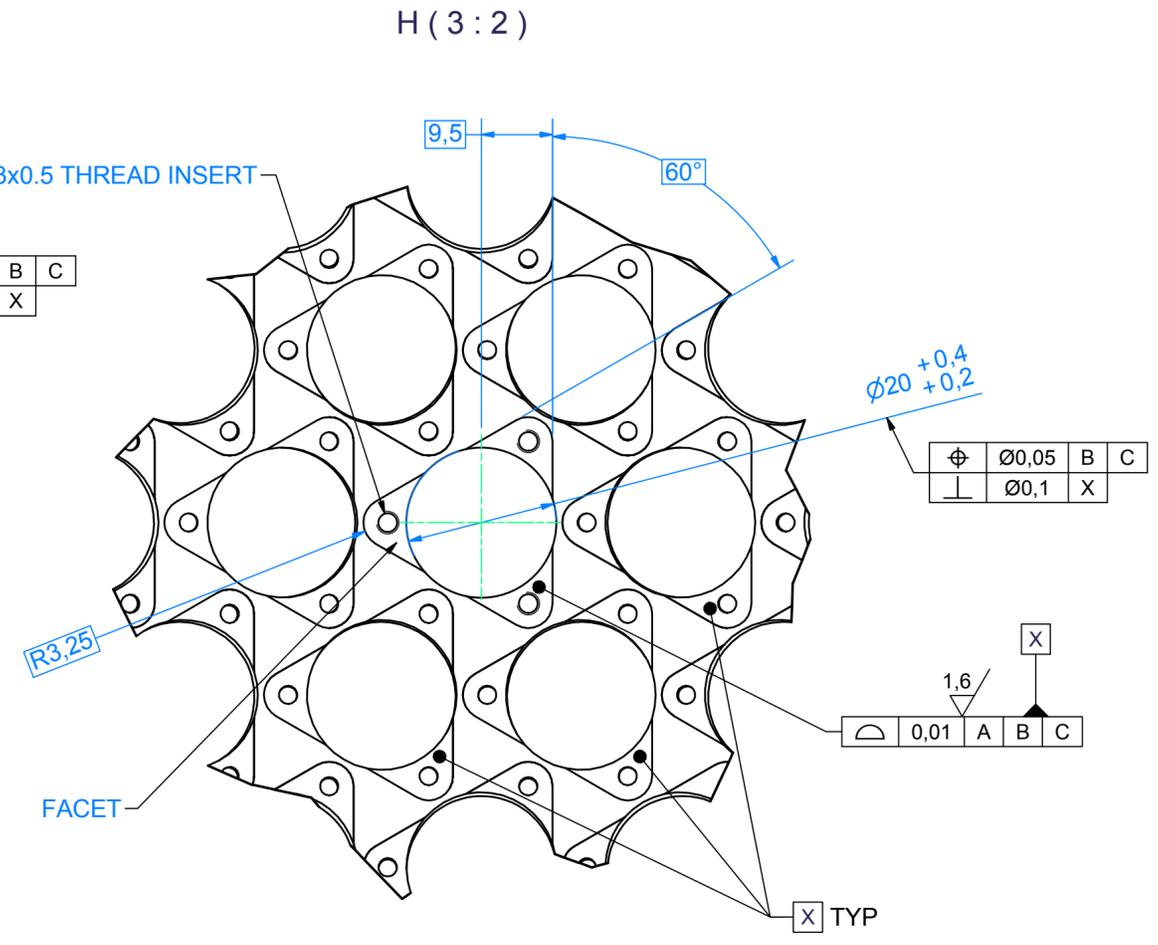
UNTOLERANCED DIMENSIONS MACHINED (U.O.S)	
DIM	TOLERANCE
LINEAR	+/- 0,1
ANGULAR	+/- 0,5°

	Royal Observatory Blackford Hill Edinburgh EH9 3HJ	DRAWN BY S. WATSON DESIGNED BY S. WATSON	DATE 27/11/2017 APPROVED BY S. WATSON
	DIMENSIONS TO ISO1 Complies with BS8888		Released TOLERANCING ISO 8015
Material Aluminum-6082 or equivalent			
Finish Ra 3,2 UOS			
Model Description FPM baseplate			
Document Type			
UKATC No. VLT-DWG-MON-14620-00-150-101			
USED ON			
PROJECT REF. MOONS	SHT 4 OF 5 SHTS	ISSUE B	
SHEET SIZE A2	SCALE		



1069x / 3x M3x0.5 THREAD INSERT
1,5 D
DRILL 12 ∇

Φ	$\Phi 0,15$	B	C
\perp	$\Phi 0,2$	X	



INDICATES ORIENTATION OF PLATE
SHAPE NOT CRITICAL
MAX 1 DEEP

NOTES:

1. EACH FACET HAS A UNIQUE POSITION AND ORIENTATION WITH RESPECT TO DATUMS A, B AND C WHICH IS INCONSISTENT WITH THE GENERAL SPHERICAL PROFILE OF THE PLATE. REFER TO STEP FILE VLT-SWG-MON-14620-00-150-101 FOR NOMINAL POSITIONS AND ORIENTATIONS. THE PROFILE TOLERANCE INDICATED APPLIES TO ALL FACETS.
2. WITH THE EXCEPTION OF DATUM B (SEE SHEET 1), ALL $\Phi 20$ AND M3 HOLES ARE PERPENDICULAR TO THEIR RESPECTIVE FACET, DESIGNATED DATUM X.

ALL DIMENSIONS IN MM BREAK EXT. EDGES 0,1 MAX CORNER RADII 0,2 MAX (UOS)		UNTOLERANCED DIMENSIONS MACHINED. (U.O.S)	
DIM	TOLERANCE	LINEAR	$\pm 0,1$
ANGULAR	$\pm 0,5^\circ$		
		DRAWN BY S. WATSON DESIGNED BY S. WATSON APPROVED BY S. WATSON	DATE 27/11/2017
DIMENSIONS TO ISO1		Released	
COMPLIES WITH BS8888		TOLERANCING ISO 8015	
Material Aluminum-6082 or equivalent			
Finish Ra 3,2 UOS			
Model Description FPM baseplate			
Document Type			
UKATC No. VLT-DWG-MON-14620-00-150-101			
USED ON			
PROJECT	REF. MOONS	SHT 5 OF 5 SHTS	ISSUE B
SHEET SIZE A2	SCALE		