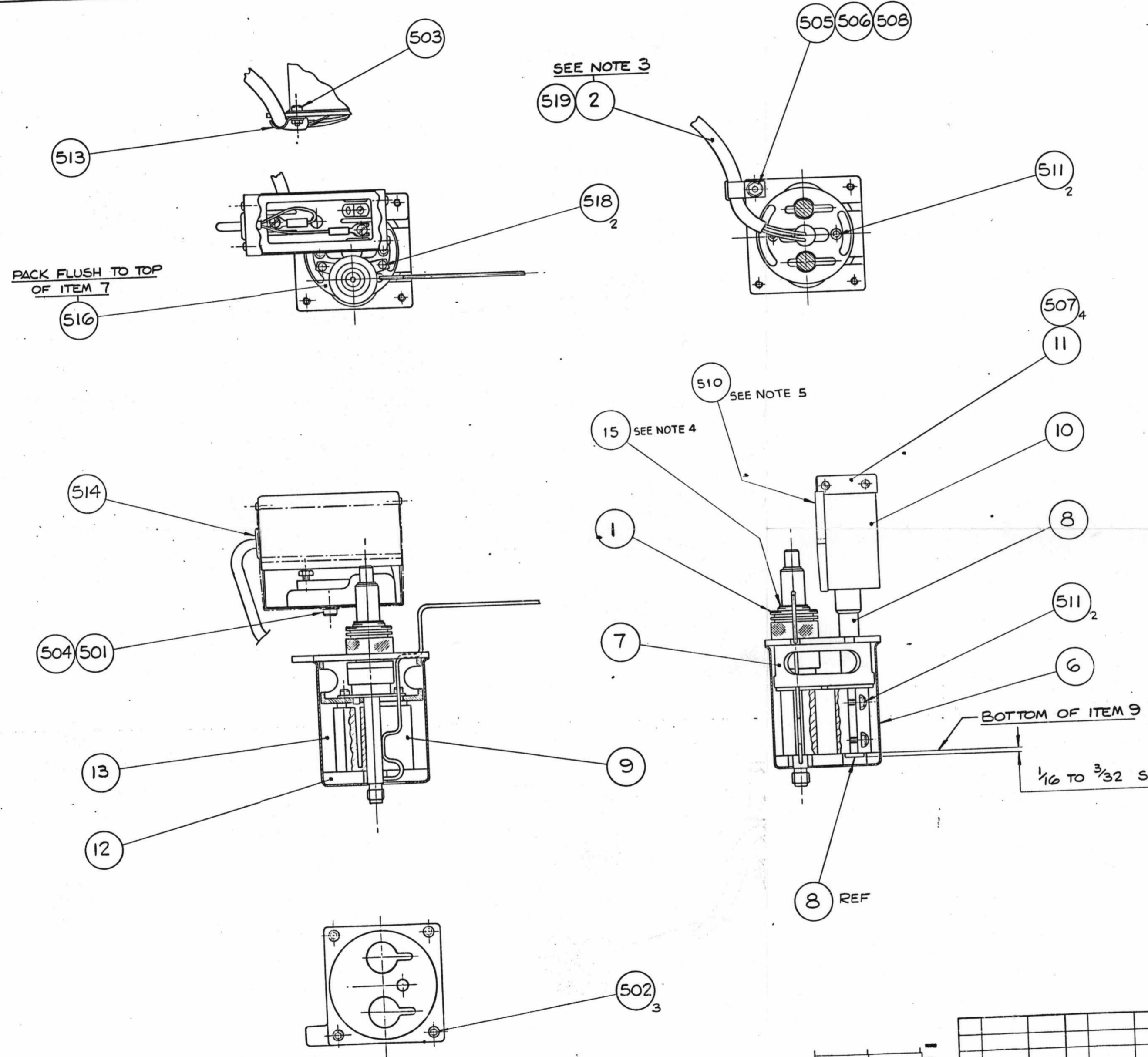


L413 0127 0128

UNLESS OTHERWISE STATED				
METRIC TOLERANCES			INCH TOLERANCES	
DIMENSIONS APPLY TO FINISHED PART. ALLOW FOR PLATING	NO DEC	1 DEC	2 DEC	ANG
REMOVE SHARP EDGES & BURRS	±0.5	±0.2	±0.1	CHAMFER 0.5 × 45°
BS 308 1972 REFERS				INT M/C RAD
DIMENSIONS IN INCHES				CONC. TOL. 0.06 FIM
				CHAMFER 0.2 × 45°
				INT M/C RAD
				CONC. TOL. 0.06 FIM
				SURFACE TEXTURE 63 TO 125 CLA



- NOTES**
1. POSITION SHAFT ON ITEM 8 TO PROTRUDE FROM BOTTOM OF ITEM 9 TO DIMENSION SHOWN, BEFORE CLAMPING SECURELY.
  2. ASSEMBLE WITH KEY SLOTS IN ITEMS 6, 7 & 9 IN LINE.
  3. COAT HEATER & SENSOR BODIES ON ITEM 2 WITH HIGH TEMP. LUB. PASTE (ITEM 519) BEFORE INSERTING IN HEATER BLOCK (ITEM 9).
  4. REMOVE 'O'-RING FROM E.C.D. ASSY, ITEM 1, AND REPLACE WITH P.T.F.E. WASHER, ITEM 15.
  5. CUT TAPE, ITEM 510, INTO TWO 75mm LENGTHS. STICK BOTH LENGTHS OF TAPE TO SIDE OF ITEM 10 AS SHOWN.
  6. COMPLETED UNIT TO BE TESTED TO RE.SPEC. L4839126.

DRG No L413 0127  
L413 0128  
ISS  
SHT 1 OF 1 B

DRAWN Roy Mowatt			DATE 17-5-85			MATERIAL			TITLE E.C.D. MODULE ASSY		
CHECKED C. Elphinstone			DATE 22-5-85			FINISH/TREATMENT			SIZE DRG No L413 0127 (A1)		
PROD ENG			DATE 13-5-85			ISSUE B			PERKIN-ELMER BEACONSFIELD BUCKINGHAMSHIRE		
PROJ ENG Alan			DATE 24-5-85			INST 8500			ISSUE B		
APPROVED JKM			DATE 24-5-85			NEXT L48X 0030 & L41X ASSY 4300/800/800/800/800			ISSUE B		
ISS	C N	DATE	ISS	C N	DATE						

D-01