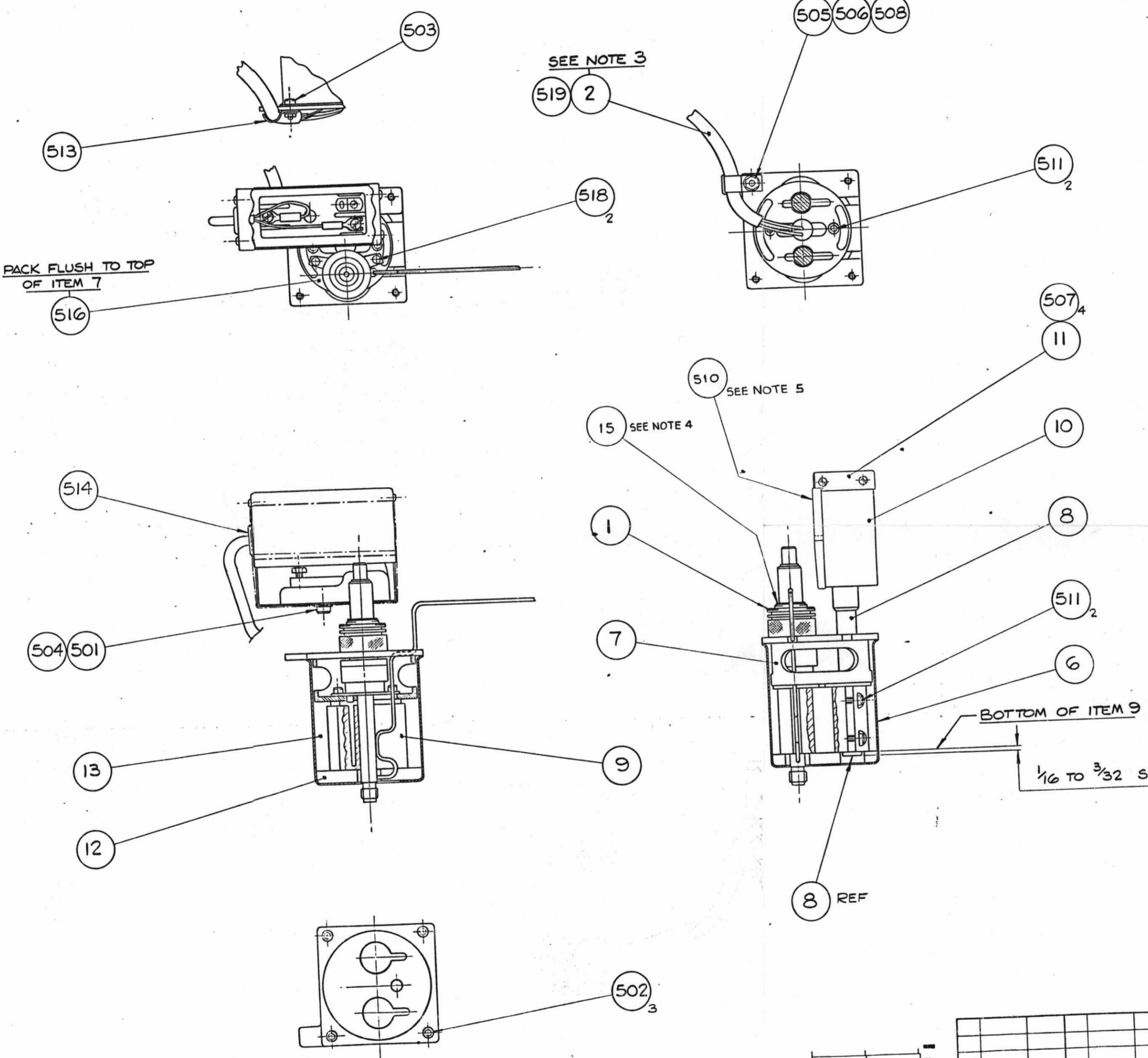


L413 0127 0128

UNLESS OTHERWISE STATED			
METRIC TOLERANCES		INCH TOLERANCES	
DIMENSIONS APPLY TO FINISHED PART. ALLOW FOR PLATING	NO DEC	1 DEC	2 DEC
REMOVE SHARP EDGES & BURRS	±0.5	±0.2	±0.1
SS 308 1912 REFERS	±0.5	±0.2	±0.1
DIMENSIONS IN INCHES	SURFACE TEXTURE N7 TO N8		SURFACE TEXTURE 63 TO 125 CLA
CHAMFER 0.5 x 45°	DEC	FRAC	ANG
INCL/M/C RAD	±.005	±1/64	°
CONC. TOL. 0.15 FIM	CHAMFER 0.2 x 45°		INCL/M/C RAD
CONC. TOL. 0.06 FIM		CONC. TOL. 0.06 FIM	CONC. TOL. 0.06 FIM



- 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 P.E.SPEC. L4839126.

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

DRAWN <b>Roy Mowatt</b>		DATE 17-5-85	MATERIAL	TITLE <b>E.C.D. MODULE ASSY</b>	
CHECKED <i>C. E. Mott</i>		22-5-85	FINISH/TREATMENT	SIZE D L413 0127 (A1) L413 0128	
PROD ENG <i>[Signature]</i>		24-5-85		ISSUE B	
PROJ ENG <i>[Signature]</i>				PERKIN-ELMER BEACONSFIELD BUCKINGHAMSHIRE	
APPROVED <b>JRM</b>		24-5-85	NEXT L48X 0030 & L41X ASSY 4300/1000/1000/1000/1000	INST 8500	
ISS	C N	DATE	ISS	C N	DATE

D-01