

2.2.6 Remove the handle B45/7956 on the pivot clamp 36/786 and remove the pivot clamp 36/786 with the four disc spring washers B671/37 and two M5 plain washers D650/125.

2.2.7 Remove the two M3 x 35 hexagon socket cap head screws D650/30335 securing the pick-up end bracket 36/785 to the aluminium datum bar 47/2804 and remove the pick-up end bracket 36/785.

2.2.8 Remove the two of the long clamp bars H45/9010 in the right hand end, as seen from the rear, of the aluminium datum bar, one in the top and one in the bottom. (see Fig 3.14).

2.2.9 Remove the three M3 x 10 socket cap head screws D650/30310 and spring washers B671/203 securing the rack spacing plate 47/2808 to the aluminium datum bar and remove the rack spacing plate.

2.2.10 Slide the datum bar side cover 47/2806 and the rack 47/2807 out of the aluminium datum bar.

2.2.11 Remove the three M3 x 12 slotted countersunk screws D650/11312 securing the rack 47/2807 to the rack spacing 47/2808.

2.3 REMOVAL OF THE C & L TABLE

2.3.1 Referring to Fig 3.1, slacken the two spring adjuster screws H45/9049 (item 1), situated between the two levelling knobs H45/9185, securing the C&L Table to the top thrust plate of the Spindle and back off the centring knobs (item 2).

2.3.2 Taking care not to lose the pins (Part of F520-2) and springs B616/893 held in by the two spring adjuster screws H45/9049, tilt the table top H46/6165 off of the Spindle and place on a clean dry surface.

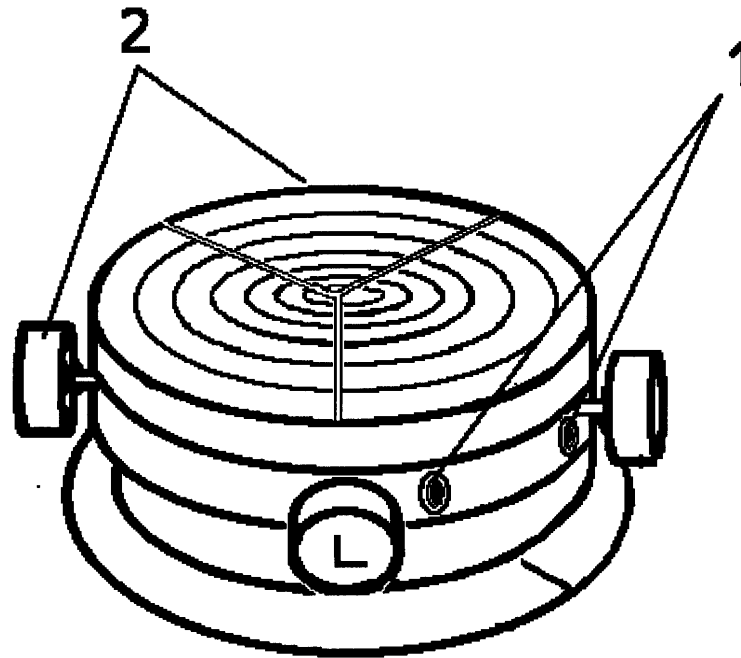


Fig 3.1 Removal of the C & L Table

2.4 DISMANTLING THE C & L TABLE

2.4.1 Turn the C & L Table onto its table top.

2.4.2 Remove the Levelling H45/9185 and Centring H45/9184 Knobs and their pins.

2.4.3 Remove the Spring adjustment screws H45/9049, springs and pins.

2.4.4 Remove the centring ring H46/6275 from the table top.

3.6.26 Rotate the spindle at least one revolution and then line up the engraved line on the top thrust plate with the engraved line on the journal. The reading on the PC must be within $\pm 3^\circ$ of 0° .

3.6.27 Refit the earth tag to the base casting and using the six screws refit the base cover. Place the instrument on its feet.

3.7 REASSEMBLY OF THE C & L TABLE

3.7.1 Place the centring ring on the table top.

3.7.2 Refit the pins (item 1), springs (item 2) and adjustment screws (item 3).

3.7.3 Refit the pins (item 4), springs (item 5) and adjustment screws (item 6).

3.7.4 Refit the pins (item 7), levelling knobs (item 8), pins (item 9) and centring knobs (item 10).

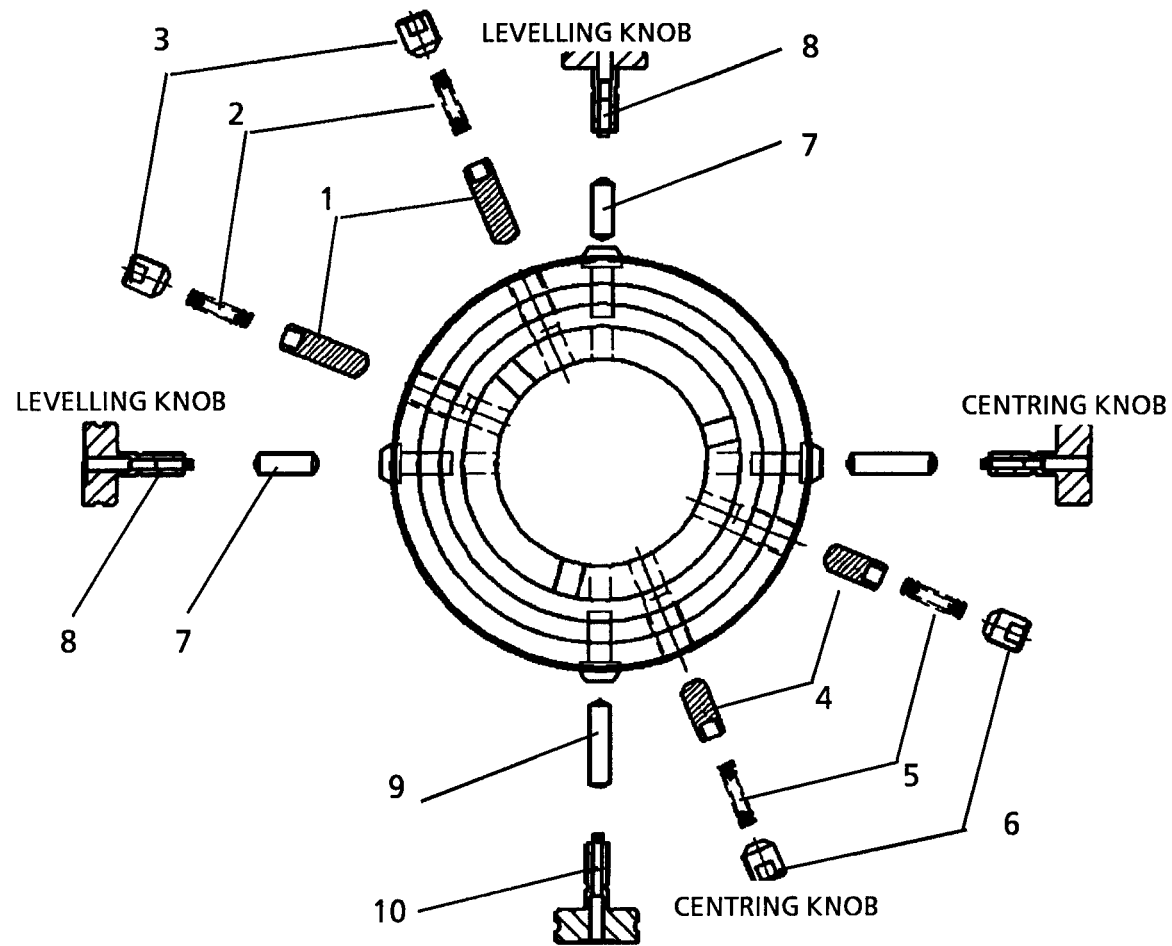


Fig 3.12 Reassembly of the C & L Table

3.8 REFITTING OF THE C & L TABLE

3.8.1 With the spring adjustment screws backed off, place the C & L Table on the spindle.

3.8.2 Tighten the spring adjustment screws and level and centre the table as follows:

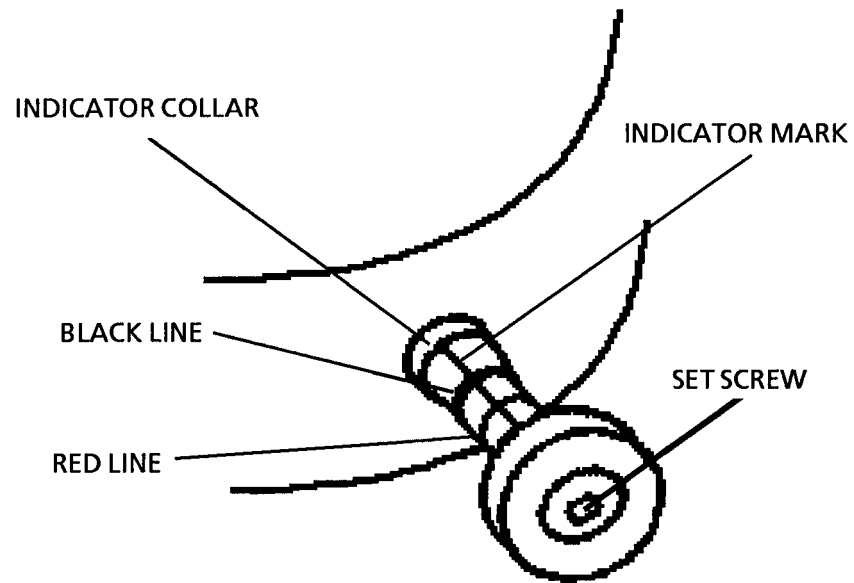


Fig 3.13 Adjustment of the C & L Table

3.8.3 Put the centring and levelling knobs in their mid positions relative to the indicator collar i.e. with the centre red line on the levelling knob in line with the edge of the collar.

3.8.4 Centre and level the table by adjusting the set screws D650/33312, maintaining the relationship to the indicator collar.

3.8.5 Replace the label set B620/2250.

3.9 REASSEMBLY OF RADIAL ARM ASSEMBLY

3.9.1 Ensuring the correct polarity and using Loctite, cement the two magnets B623/100 into the aluminium datum bar 47/2804.

3.9.2 Using the three M3 x 12 slotted countersunk screws D650/11312 refit the rack 47/2807 to the rack spacing plate 47/2808.

3.9.3 Referring to Fig 3.12 place the datum bar side cover 47/2806 over the rack and holding the rack and the datum bar side cover together, slide them both into the recesses in the aluminium datum bar from the right hand end as shown.