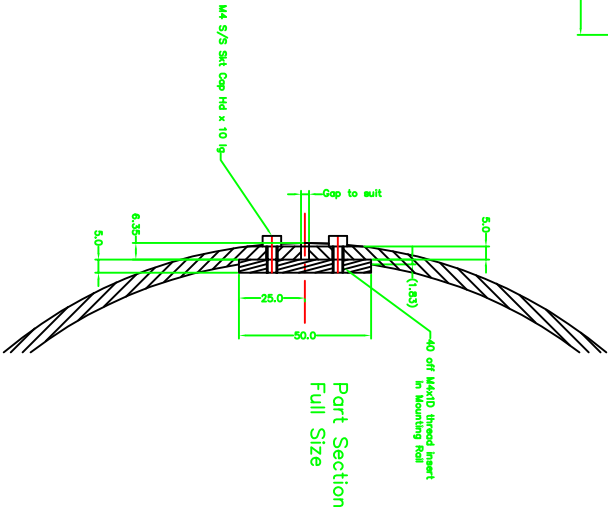


Notes:

Suggested methods of machining: –

1. Face off ends to give required length
2. Machine series of flats down both sides 20 wide and 1.35 deep at 150 pitches
3. Drill M4 clearance holes (ø4.3) in positions shown
4. Slit tube in half lengthwise using suitable cutter
5. Machine internal recesses into inside of tube, one half at a time
6. Internal Mounting Rails may be made up of three lengths each side

IMPORTANT: When slitting tube and also when machining internal recesses it is essential that the tube is correctly supported so as not to introduce distortion of its natural shape



Material & Specification : BS1470 5083-0 (formerly NTR-0)		Tolerances unless stated : 1. Positional from datum 2. Form 3. Feature from datum 4. Feature from datum		University of Cambridge, Department of Physics MR/OI Carriage Tube Assembly	
Treatment/Finish : Clean / Natural	Surface Finish : Ra	Original Scale : 1:5	Original Date : 04/05/06	Rev. No. : MO 2000	Size : A1