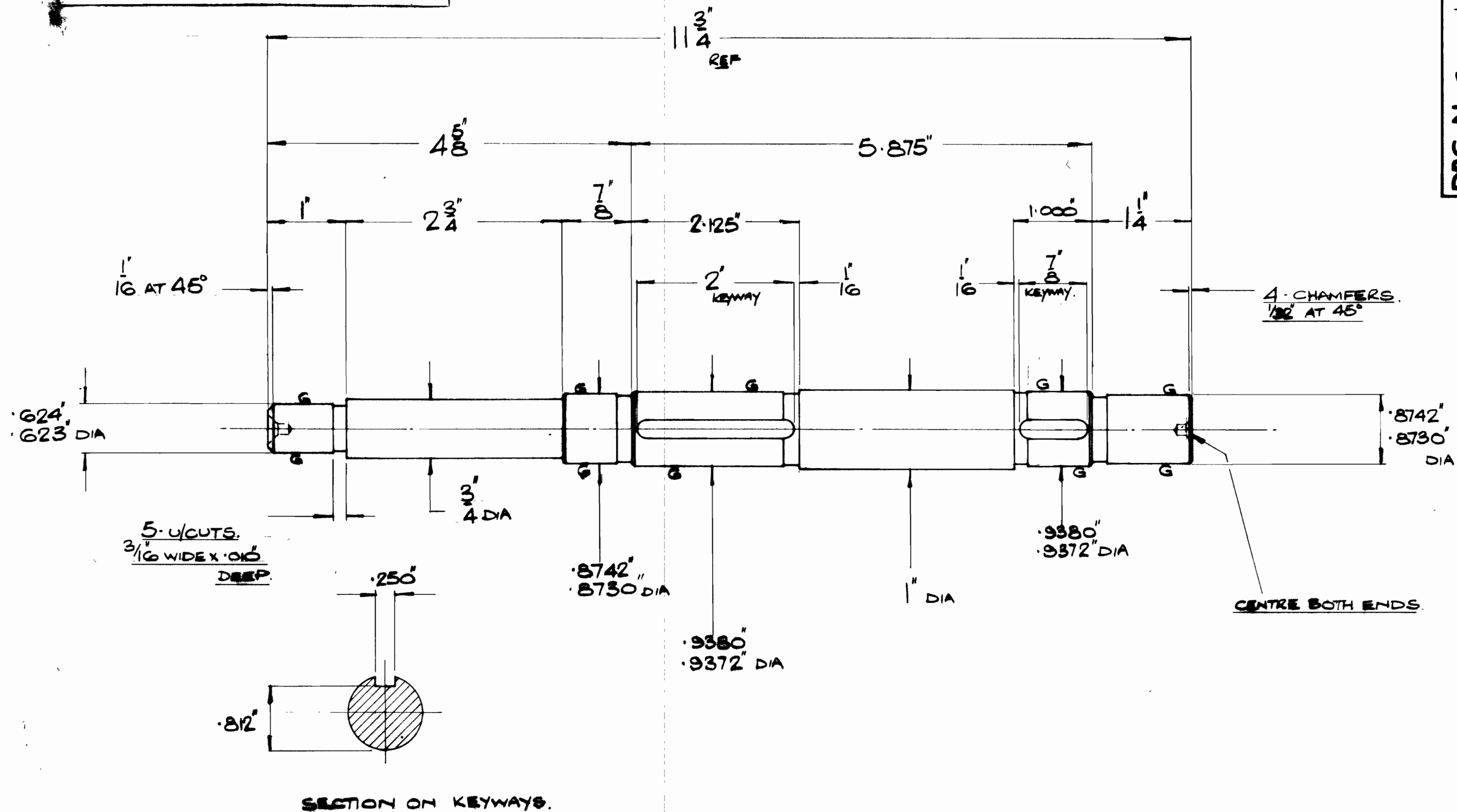


IF IN DOUBT ASK.

DRG. No. RS.100/103



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

'VICEROY' 250 SHAPER

- IDLER STUD

REDRAWN. 16.5.79. V.				
No.	DESCRIPTION	CHKD	APPD	DATE
	ALTERATIONS			

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

RATIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

MATL MILD STEEL

MATL SIZE 1" x 8" LONG.

No REQD. ONE

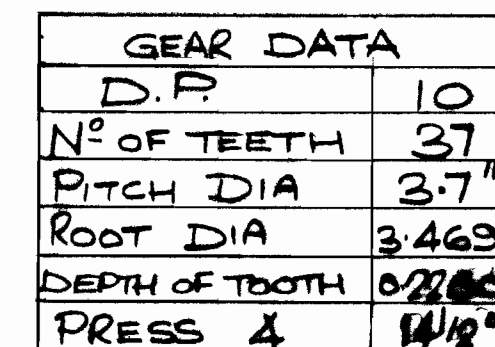
MACHINE AT W

GRIND AT S.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				16.5.79	FULL

DRAWING No. RS.100/103.

DRG. No.



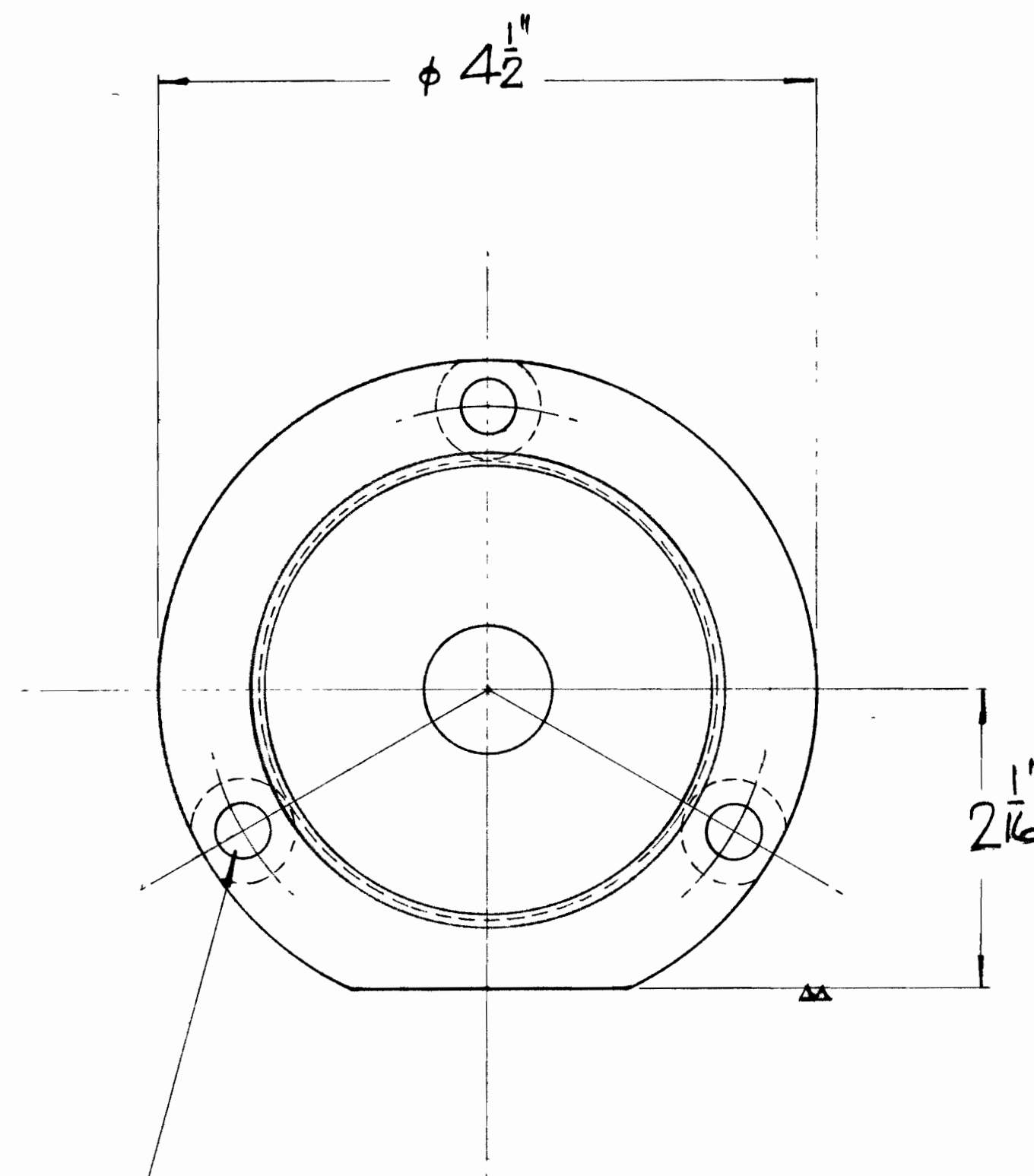
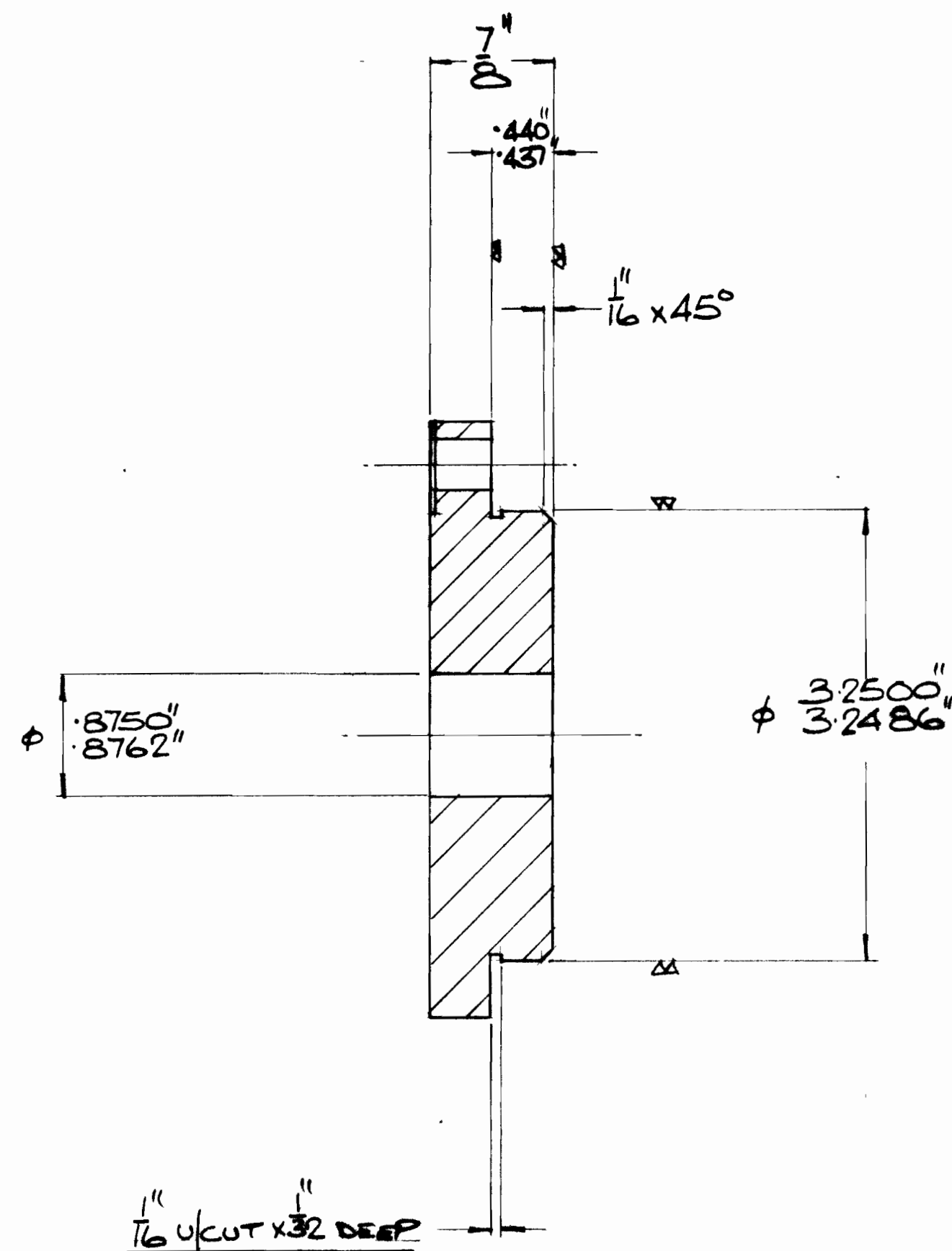
VICEROYAL 10" SHAPER - IDLER GEAR LOW SPEED.

						LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.		MATERIAL CAST IRON / GRADE 17.		DRAWN		TRACED		CHECKED		APPROVED		DATE		SCALE	
								MATERIAL SIZE CASTING		17.								7-3-75		FULL	
No.		DESCRIPTION		DATE		ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$		No. REQD. 1													
		ALTERATIONS				FRACTIONAL $\pm .005^\circ$ 4 PLACE DECIMAL $\pm .0005^\circ$		MACHINE AT W													
								GRIND AT 'G'													

DRAWING No. RS.100/104

IF IN DOUBT ASK.

DRG. No.



3 HOLES, DRILL $\phi 9/16$ & S/FACE
 $\phi 9/16$ EQUALLY SPACED ON A
 3.875" P.C.D.
SPACING RELATIVE TO FLAT IMPORTANT.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 10" SHAPER - IDLER SHAFT END CAP

No.	DESCRIPTION	DATE
	ALTERATIONS	

LIMITS ON DIMENSIONS UNLESS
 OTHERWISE STATED.
 ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$
 FRACTIONAL $\pm .005$ 4 PLACE DECIMAL $\pm .0005$

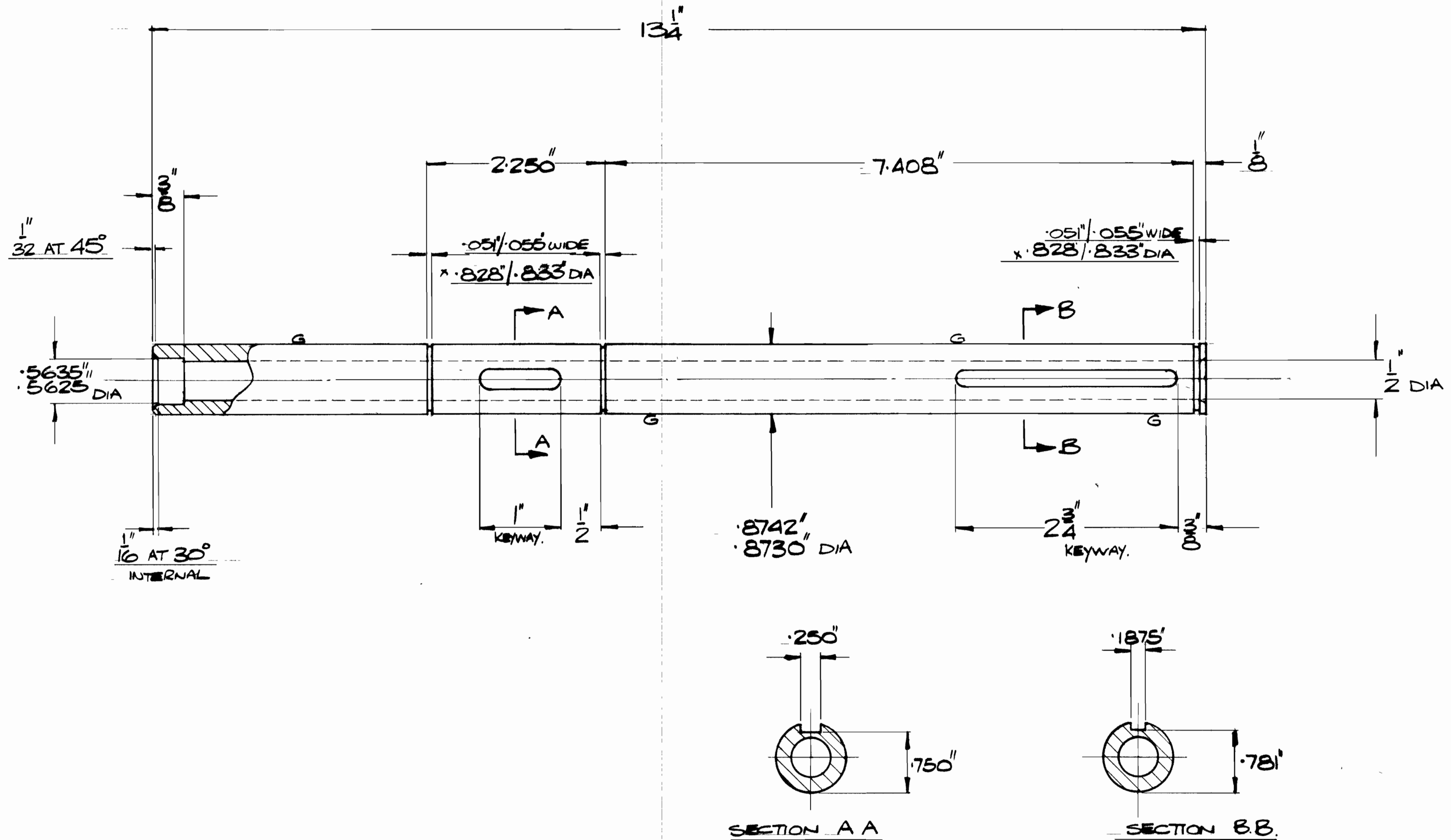
MATERIAL CAST IRON
 MACHINING CASTING
 MACHINE AT W
 GRIND AT 'S.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				25.3.75	FULL

DRAWING No. RS.100/107

IF IN DOUBT ASK.

DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY 250 SHAPER - MAIN DRIVE SHAFT (MATRIX CLUTCH)

No.	DESCRIPTION	CHKD	APPD	DATE
	ALTERATIONS			

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
REGULAR $\pm \frac{1}{32}$ 3 PLACE DECIMAL $\pm .005$ "
FUNCTIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0005$ "

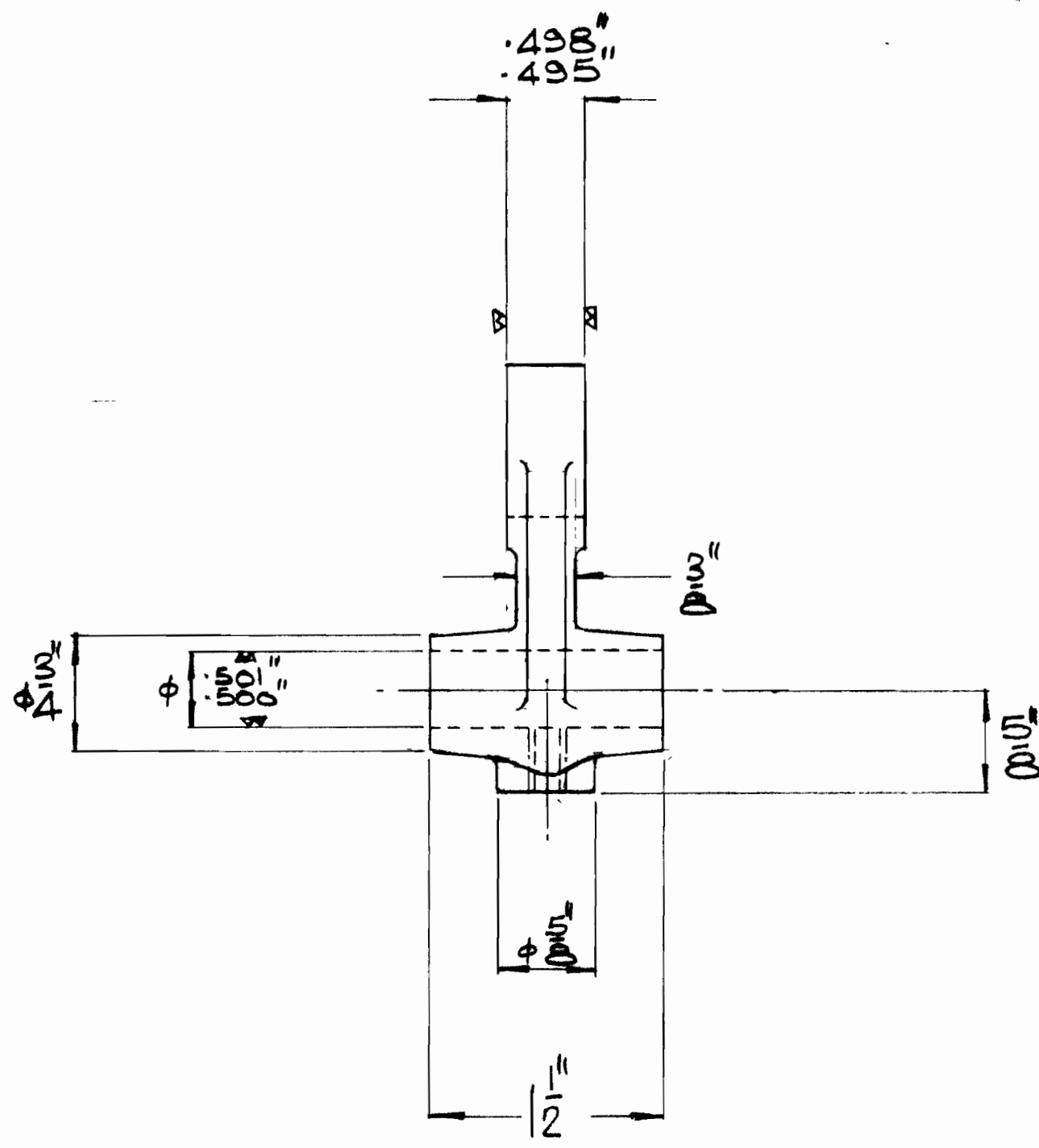
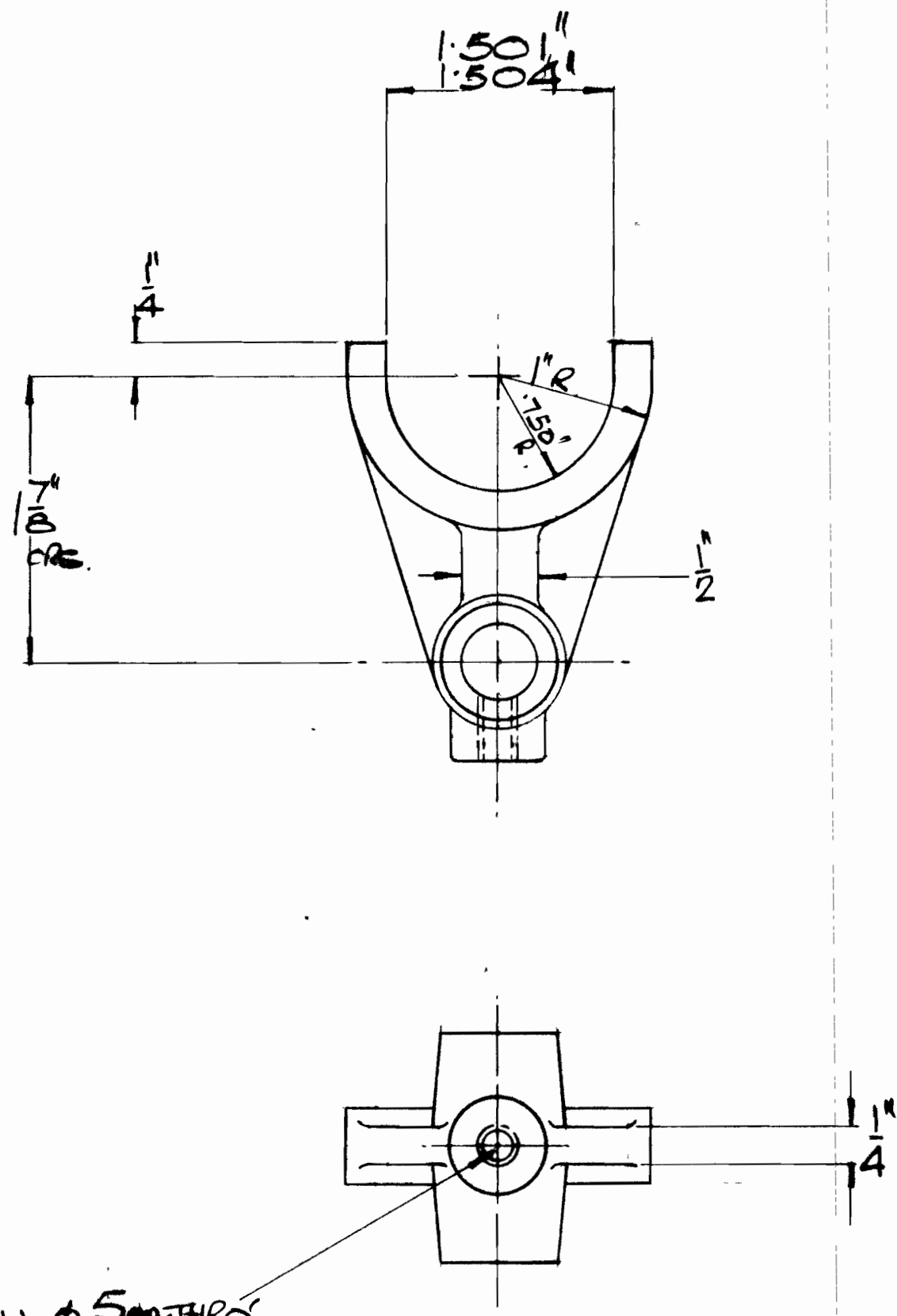
MATL MILD STEEL TUBE
MATL SIZE 1 DIA $\times \frac{1}{2}$ BORE $\times 13 \frac{3}{4}$ "
No. REQD. ONE
MACHINE AT W
GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
W.				6-12-79	FULL
DRAWING No. RS.100/108.A.					

IF IN DOUBT ASK.

3RD ANGLE PROJECTION

DRG.No.

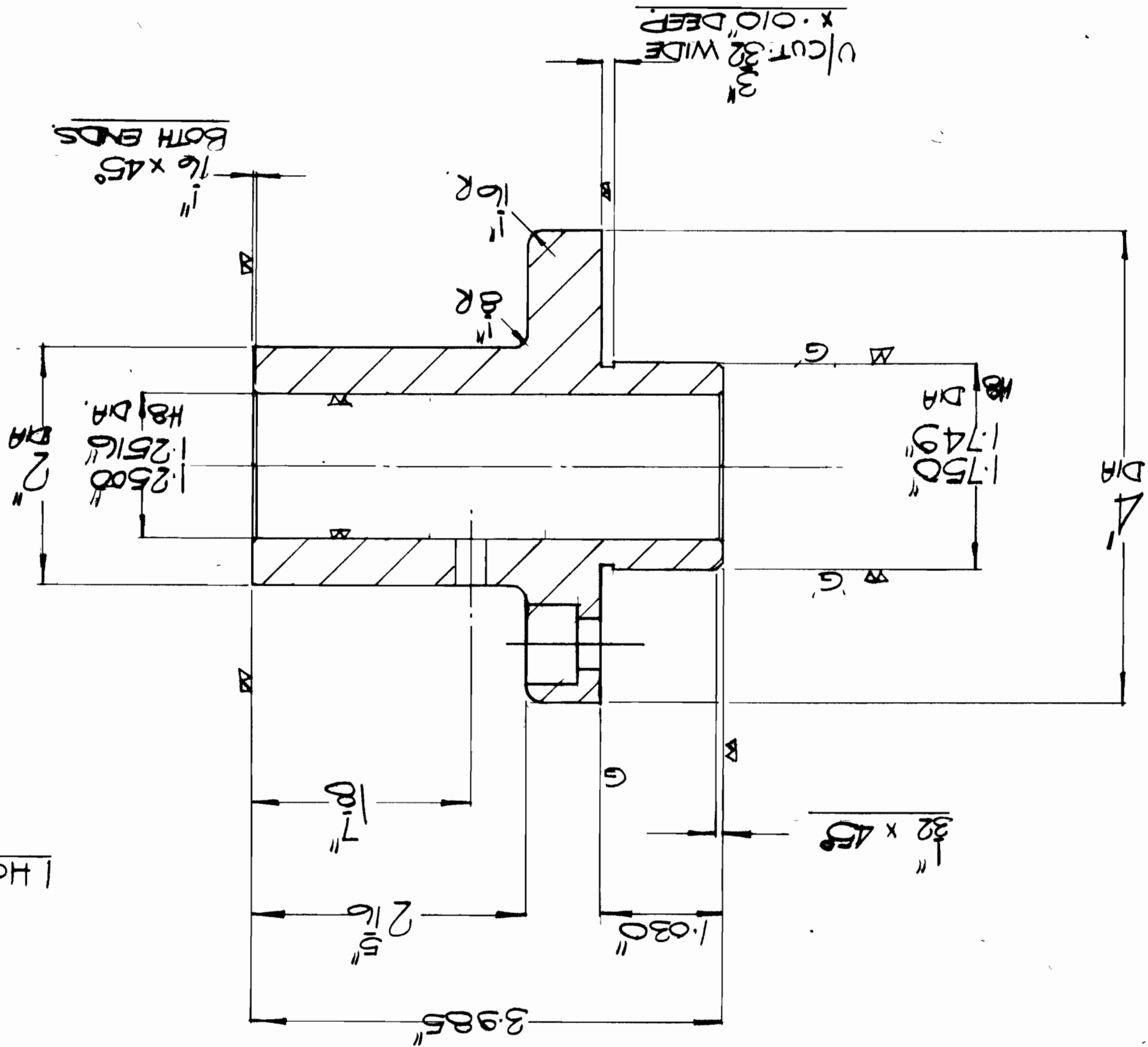


1 HOLE DRILL ϕ 5mm THRO' & TAP M6 x 1.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.				VICEROYAL 10" SHAPER CLUTCH FORK FOR GEAR CHANGE.			
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED				MATERIAL GUN METAL			
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$				CASTING			
FRACTIONAL $\pm .005$ 3 PLACE DECIMAL $\pm .005$				MACHINE AT W			
GRIND AT 'S'.				DRAWN IV.			
TRACED				CHECKED			
APPROVED				DATE 6.3.75			
SCALE FULL				DRAWING No. RS.100/113			
ALTERATIONS							

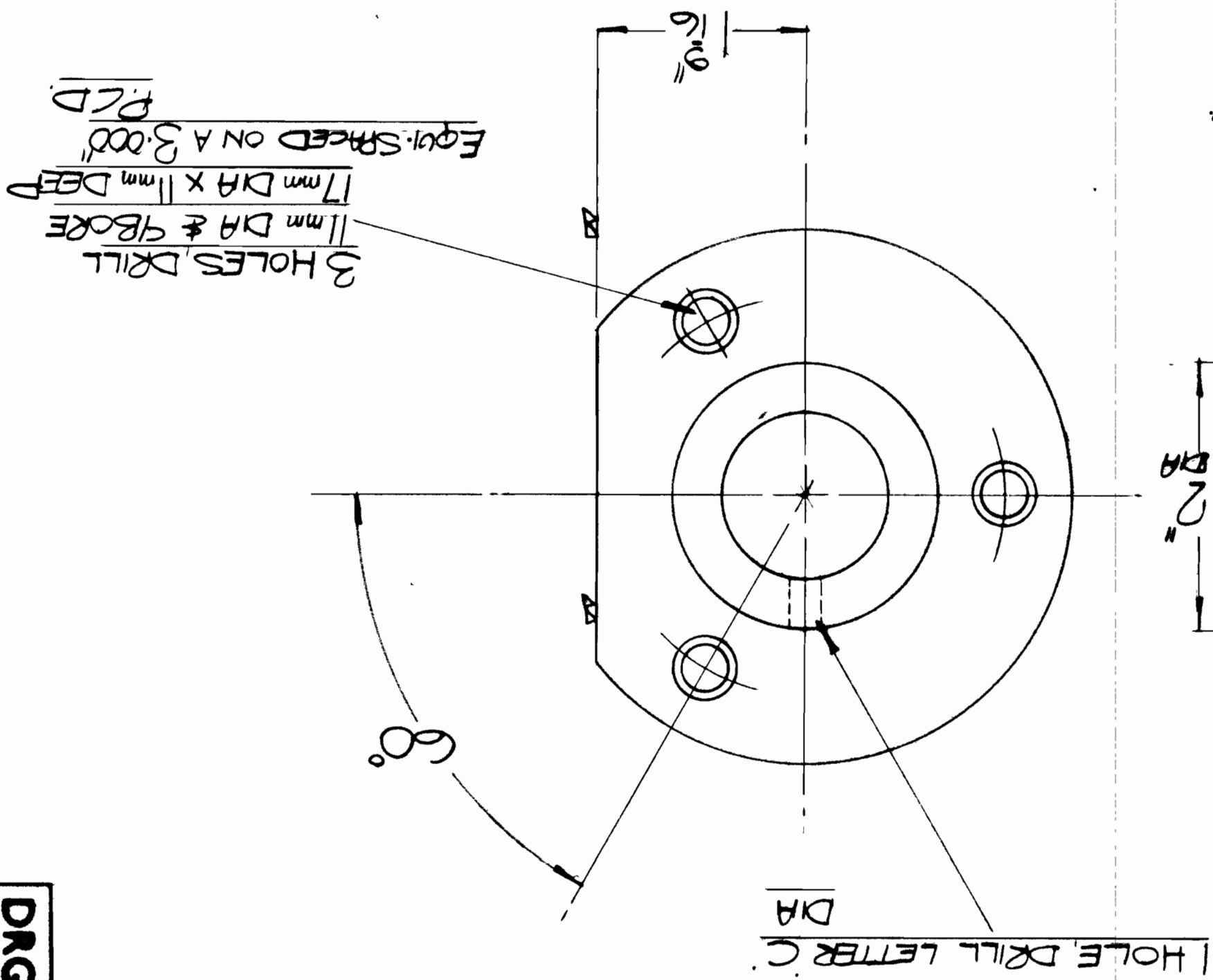
IF IN DOUBT ASK

3rd ANGLE PROJECTION



DRIFT ON N.C. MACHINE

NB. ANGULAR RELATION OF
3 HOLES, OIL HOLE & FLAT
ON FLANGE ARE IMPORTANT



DENFORD MACHINE TOOLS LTD. LINCOLN, YORKSHIRE.

VICE ROY ROYAL 250 SHAPER - BEARING

No.	DESCRIPTION	CHECK NO.	DATE
	- 082076 - 4-19-76		
	2239/76 KODAK 2-17-76		

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

1. CASTING
 2. C.I. GRADE 14
 3. DATE 12/1/78
 4. BY 1000
 5. MACHINING AT 10
 6. DATE 12/1/78
 7. BY 1000

DRAWING NO. RS 100/114

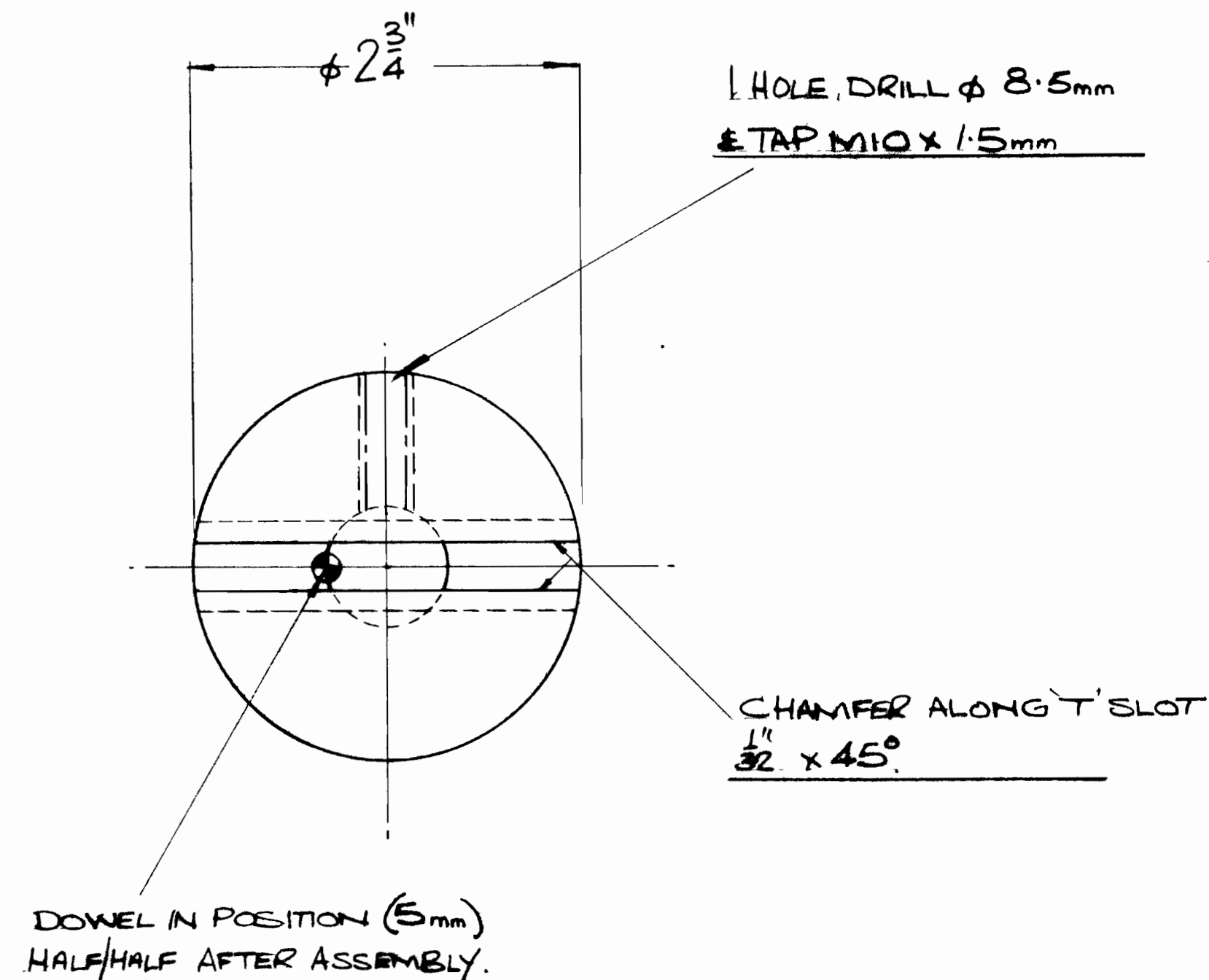
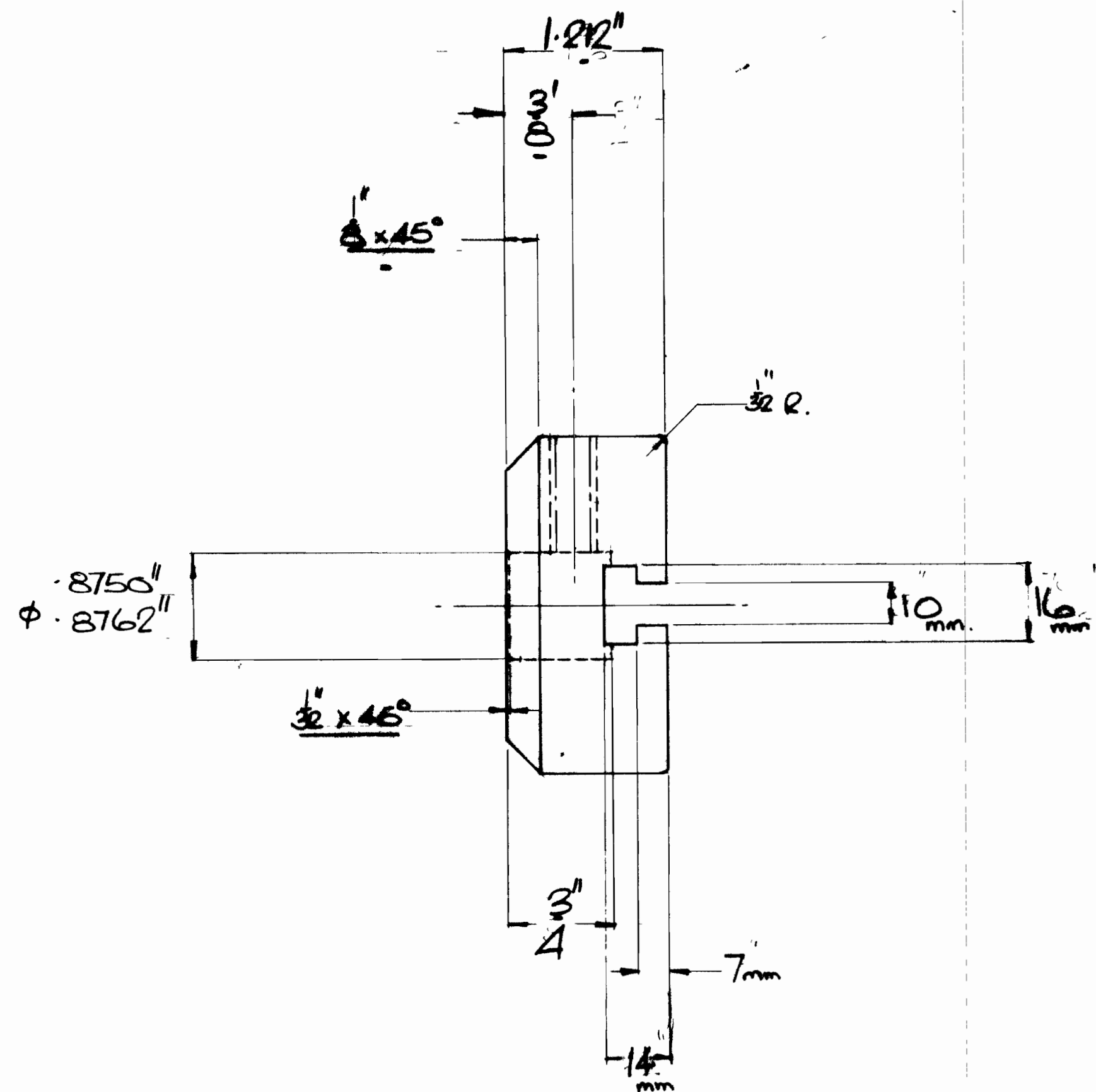
DRAWN	TRACES	ORDERS	APPROVED	DATE	SCALE
11.				21.176	FULL

DRG. No.

IF IN DOUBT ASK.

3RD ANGLE PROJECTION.

DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 250 SHAPER - DRIVING DISC for TABLE FEED.

No.	DESCRIPTION	DATE	APPROVED
	ALTERATIONS		

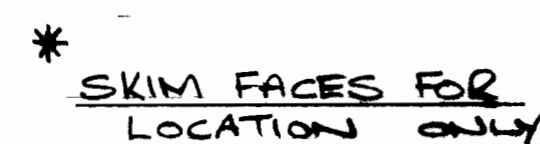
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
 ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
 ACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

MATL. MILD STEEL.
 MATL. SIZE $\phi 2 \frac{3}{4} \times 1 \frac{1}{2}$
 No. REQ. 1.
 MACHINE AT W
 GRIND AT G

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				21.4.75	FULL

DRAWING No. RS.100/117.

DRG. No.

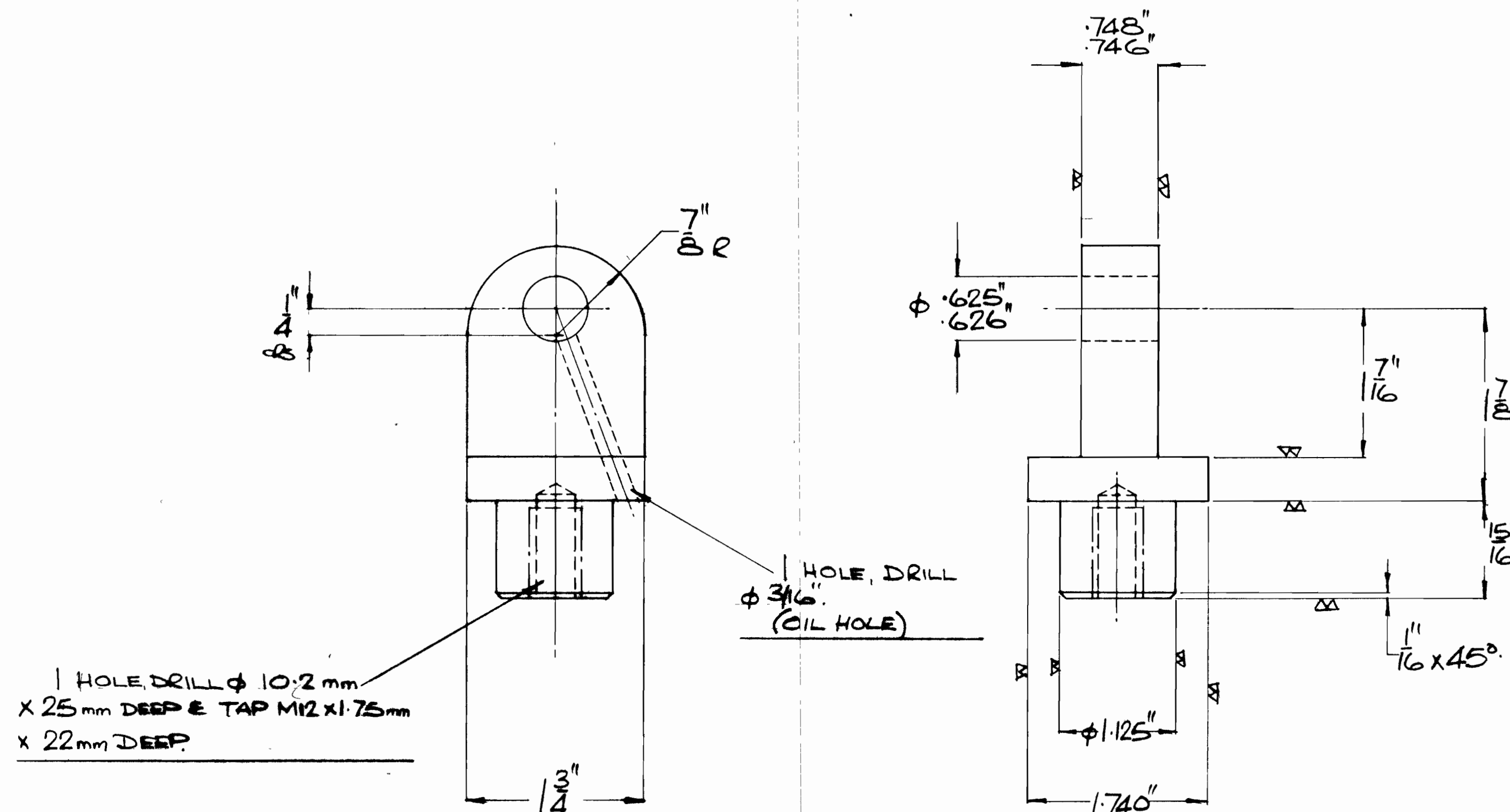


ROCKER ARM.

DRAWING No. RS.100/121

IF IN DOUBT ASK.

DRG.No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE

VICEROYAL 10" SHAPER - ANCHOR PIVOT FOR RAM

No.	DESCRIPTION	DATE	APPROVED
	ALTERATIONS		

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

RATIONAL $\pm .005$ 4 PLACE DECIMAL $\pm .0005$

MATL CAST IRON

MATL SIZE CASTING

No. REQD. 1

MACHINE AT W

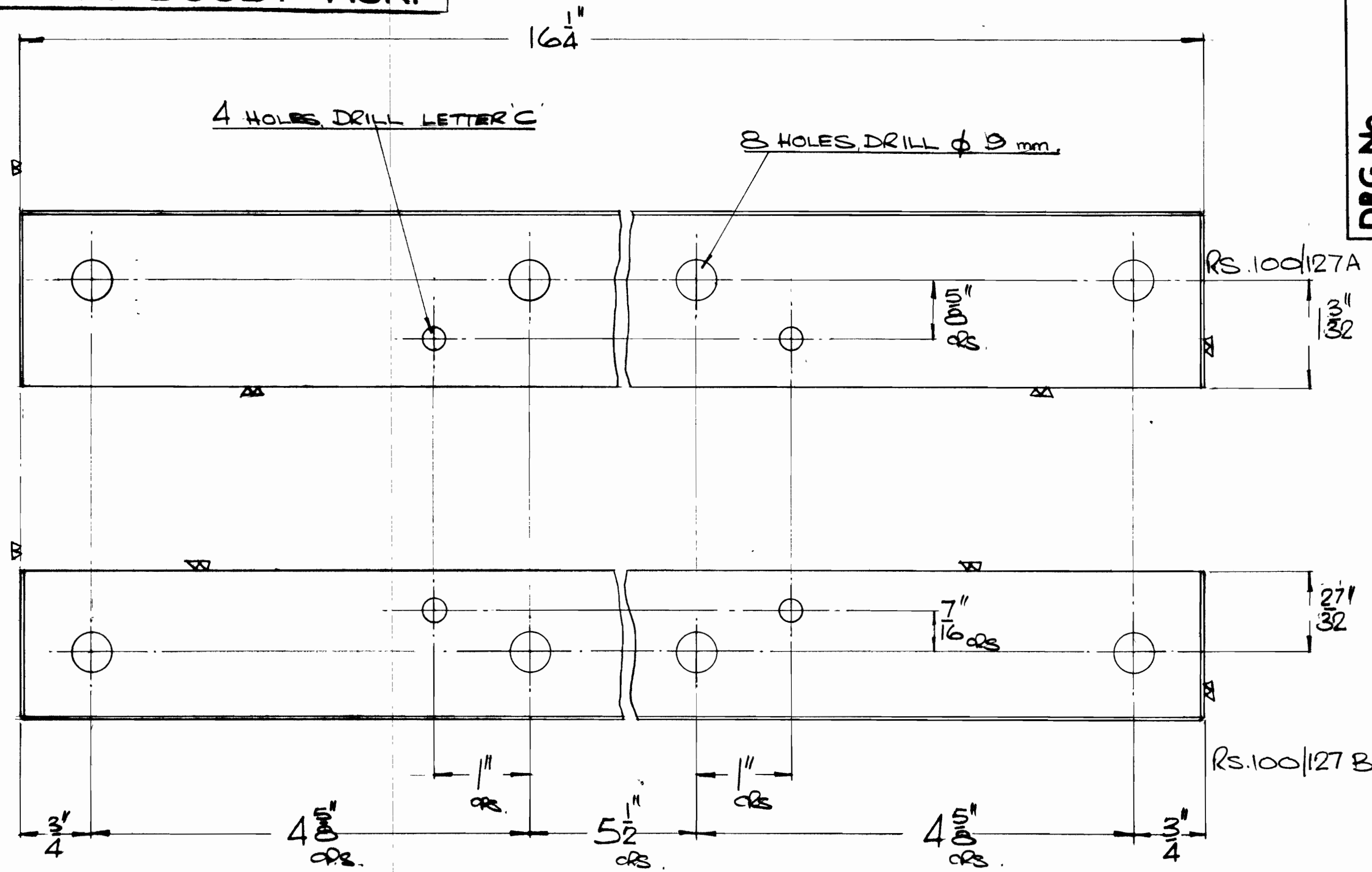
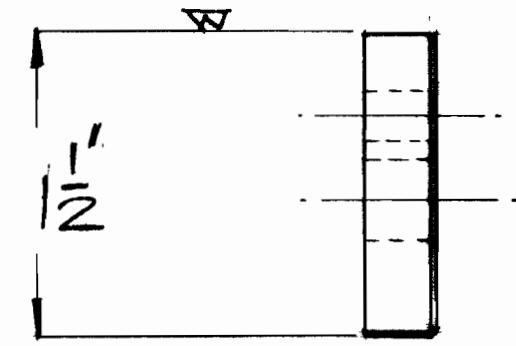
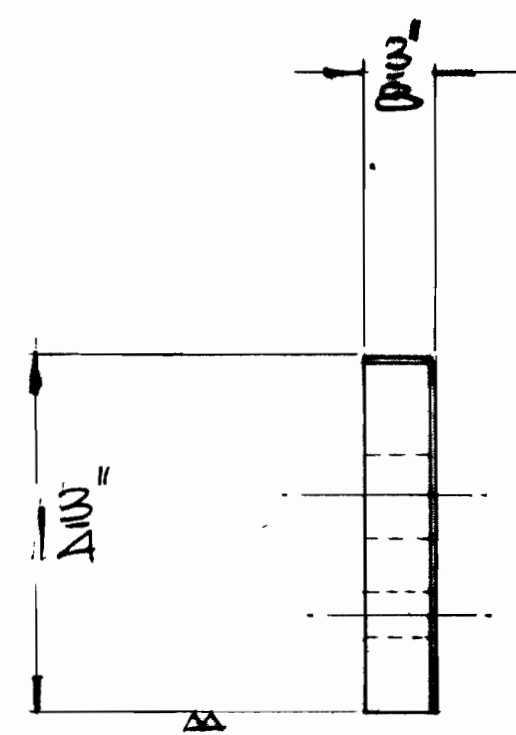
BRAND AT G

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV				7.4.75	FULL

DRAWING No. RS.100/124.

IF IN DOUBT ASK.

DRG.No.



ALL CHAMFERS $\frac{1}{32} \times 45^\circ$

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 250 SHAPER — RAM SLIDE PLATES

2822/21.10.2.B.11.			
No.	DESCRIPTION	DATE	DATE
	ALTERATIONS		

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
RATIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

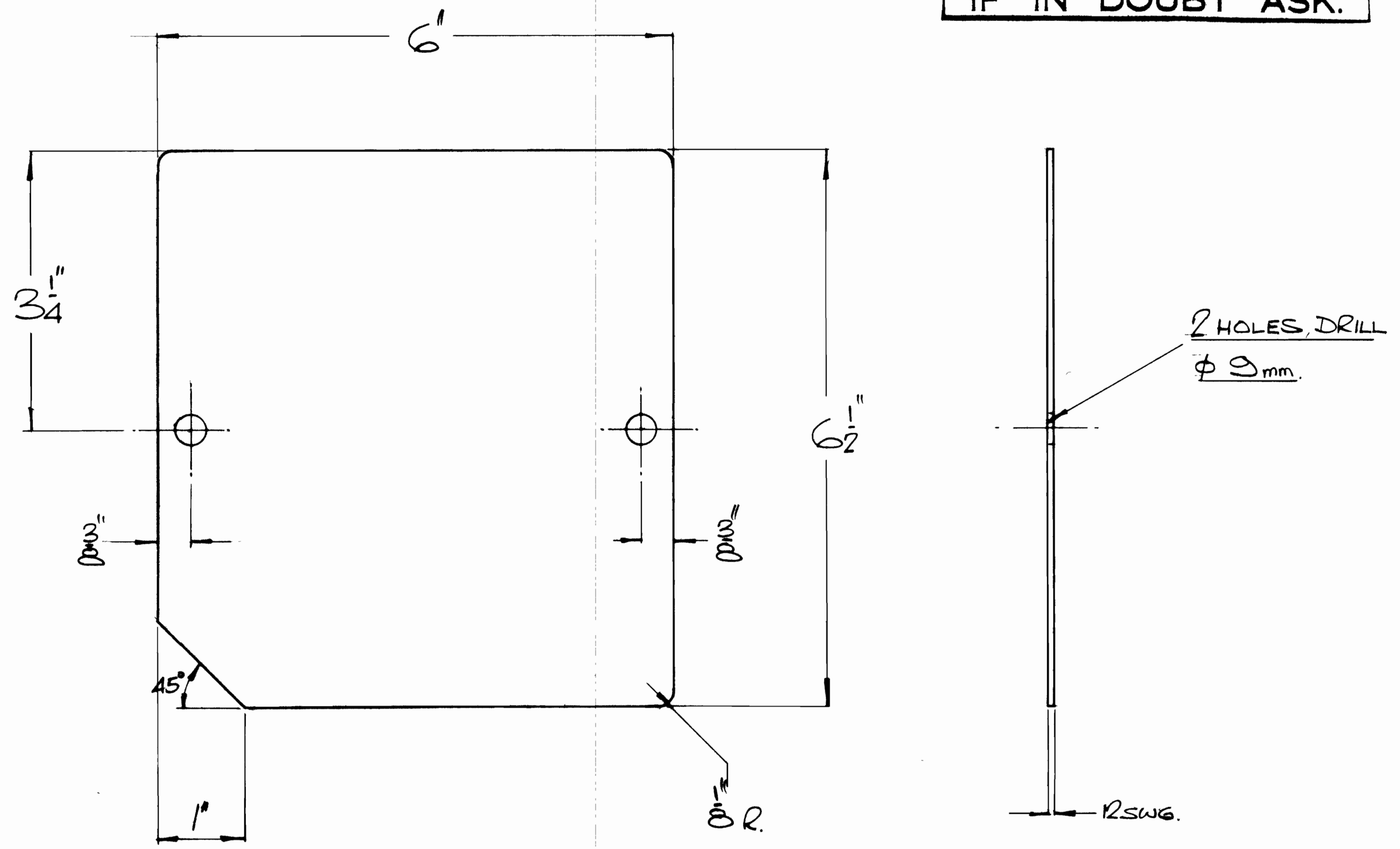
MATL MILD STEEL FLAT.
MAYL SIZE $1 \frac{3}{4} \times 1 \frac{1}{2} \times 3 \frac{1}{2}$
No. REQ. 1 EACH.
MACHINE AT W
BRAND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV				17.4.75	FULL

DRAWING No. RS.100/127A & B.

IF IN DOUBT ASK.

DRG.No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL SHAPER - BODY DOOR.

No.	DESCRIPTION	CHKD	DATE
	ALTERATIONS		

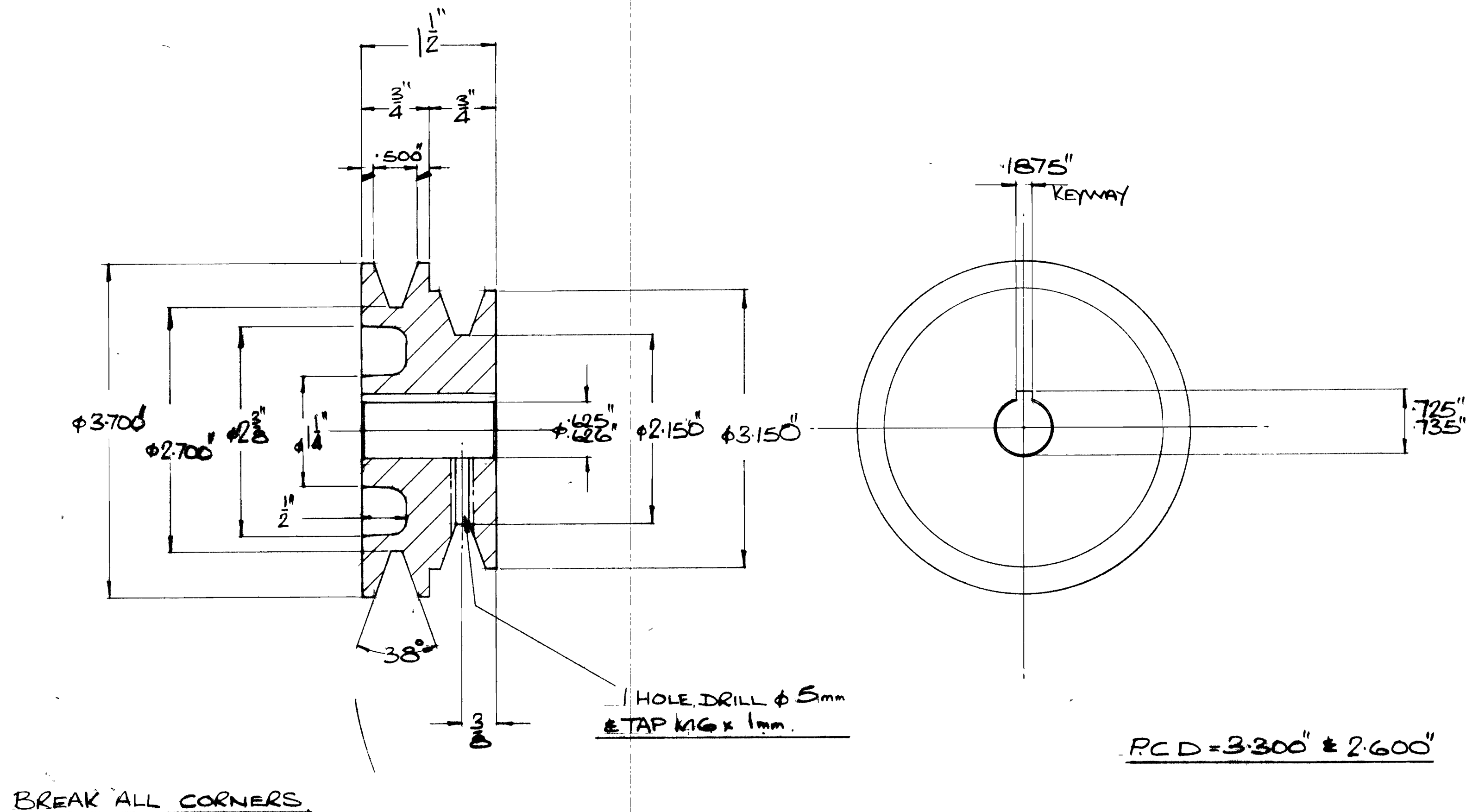
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005''$
ACTIONAL $\pm .010''$ 4 PLACE DECIMAL $\pm .0005''$

MATL SHEET STEEL.
MAYL SIZE 12 SWG.
No. REQD. 1.
MACHINE AT VV
GRIND AT G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				25/10/75	Full.
DRAWING No. RS.100/139.					

IF IN DOUBT ASK.

DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 10" SHAPER - MOTOR PULLEY (1425 REV/MIN)

No.	DESCRIPTION	DATE	BY
	ALTERATIONS		

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$ "

ACTIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0005$ "

MATL. CAST IRON

MATL. CASTING

No. REC'D. 1

MACHINE AT W

GRIND AT S

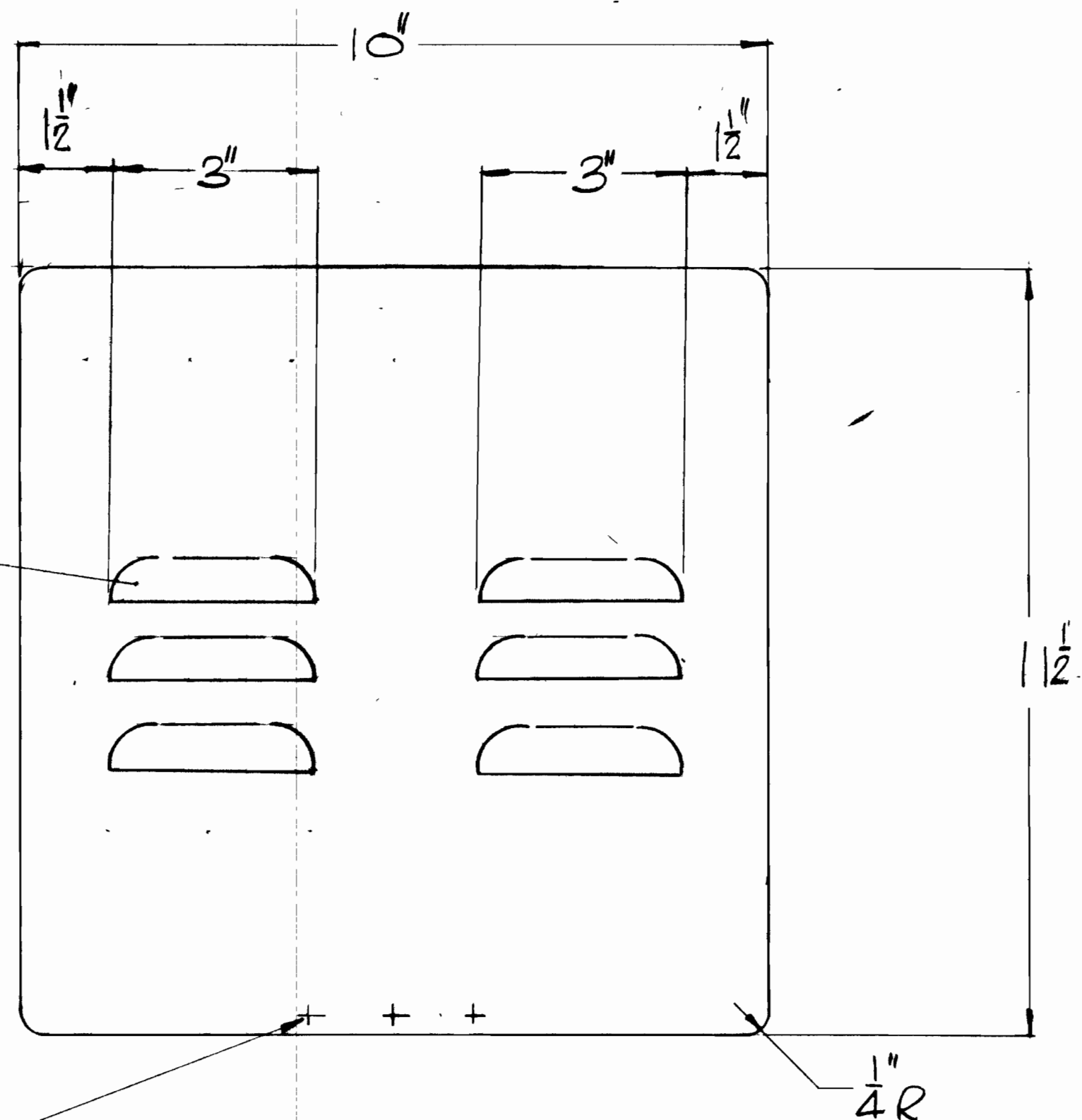
DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				7475	FULL

DRAWING No. RE.100/205.

DRG. No.

6 LOUVERS AS SHOWN
(VERTICALLY CENTRAL)

3 HOLES MARK OFF TO SUIT
HINGE ON ASSEMBLY.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

ROYAL 250 SHAPER - CABINET DOOR.

No.	DESCRIPTION	DATE	BY
	ALTERATIONS		

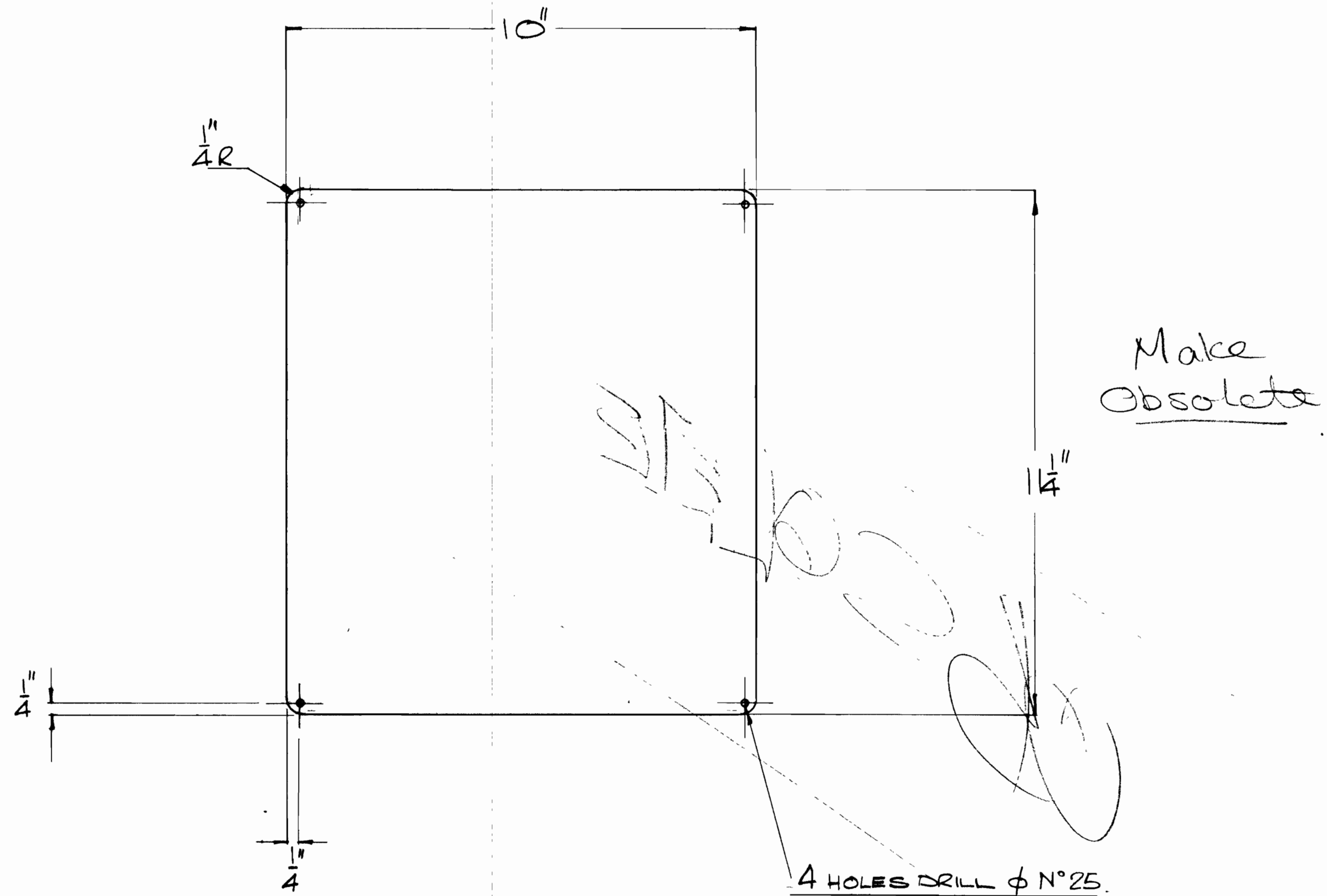
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$
FRACTIONAL $\pm \frac{1}{64}$ 4 PLACE DECIMAL $\pm .0001$

MATL. 16 S.W.G.
MATL. SIZE 10" x 11 1/2"
No. REQS. 2
MACHINE AT W
GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				22.5.75	1/2 x Full

DRAWING No. RS.100/206.

DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

ROYAL 250 SHAPER - MOTOR INSPECTION COVER.

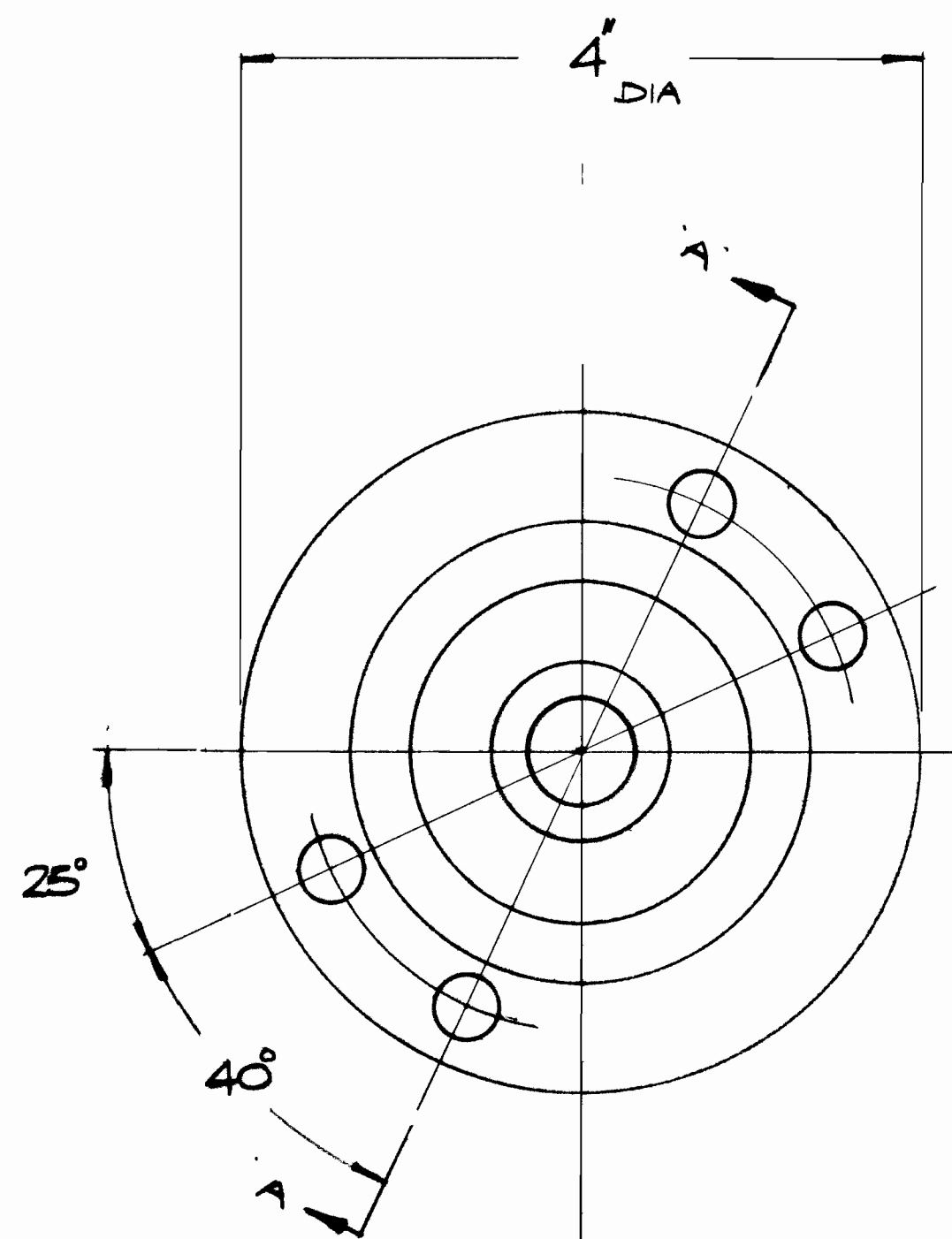
No.	DESCRIPTION	DATE	APPROVED
	ALTERATIONS		

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$ "
FRACTIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0001$ "

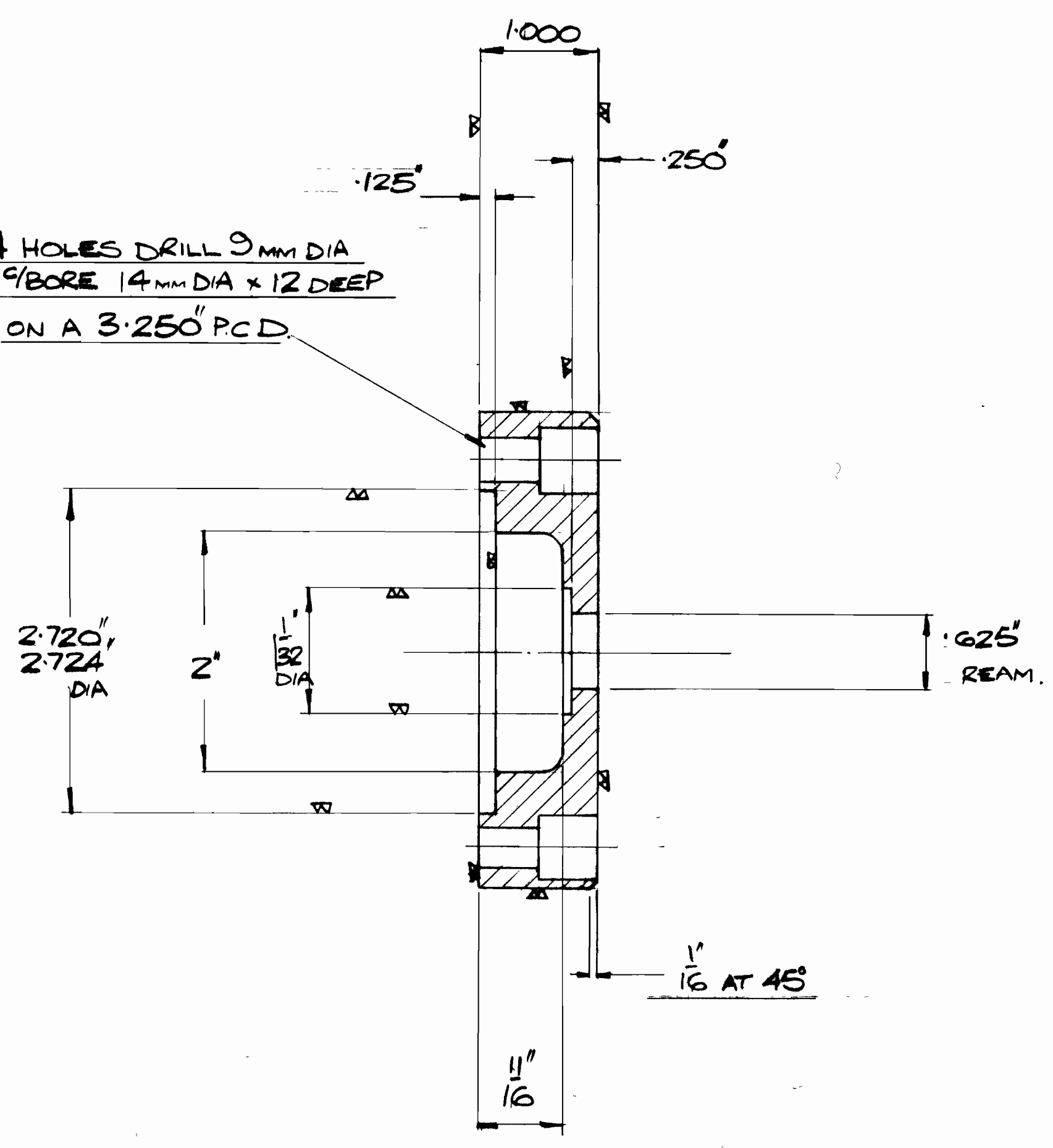
MATL K6 S.W.G.
MATERIAL SIZE 10" x 11 1/4"
No. REQD. 1
MACHINE AT W
GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				22575	1/2 x Full

DRAWING No. RS.100/209.



4 HOLES DRILL 9 MM DIA
 & BORE 14 MM DIA x 12 DEEP
 ON A 3.250" P.C.D.



SECTION A-A

DRG. No.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY 250 SHAPER - MATRIX CLUTCH CAP

No.	DESCRIPTION	DRG. APPD.	DATE
	ALTERATIONS		

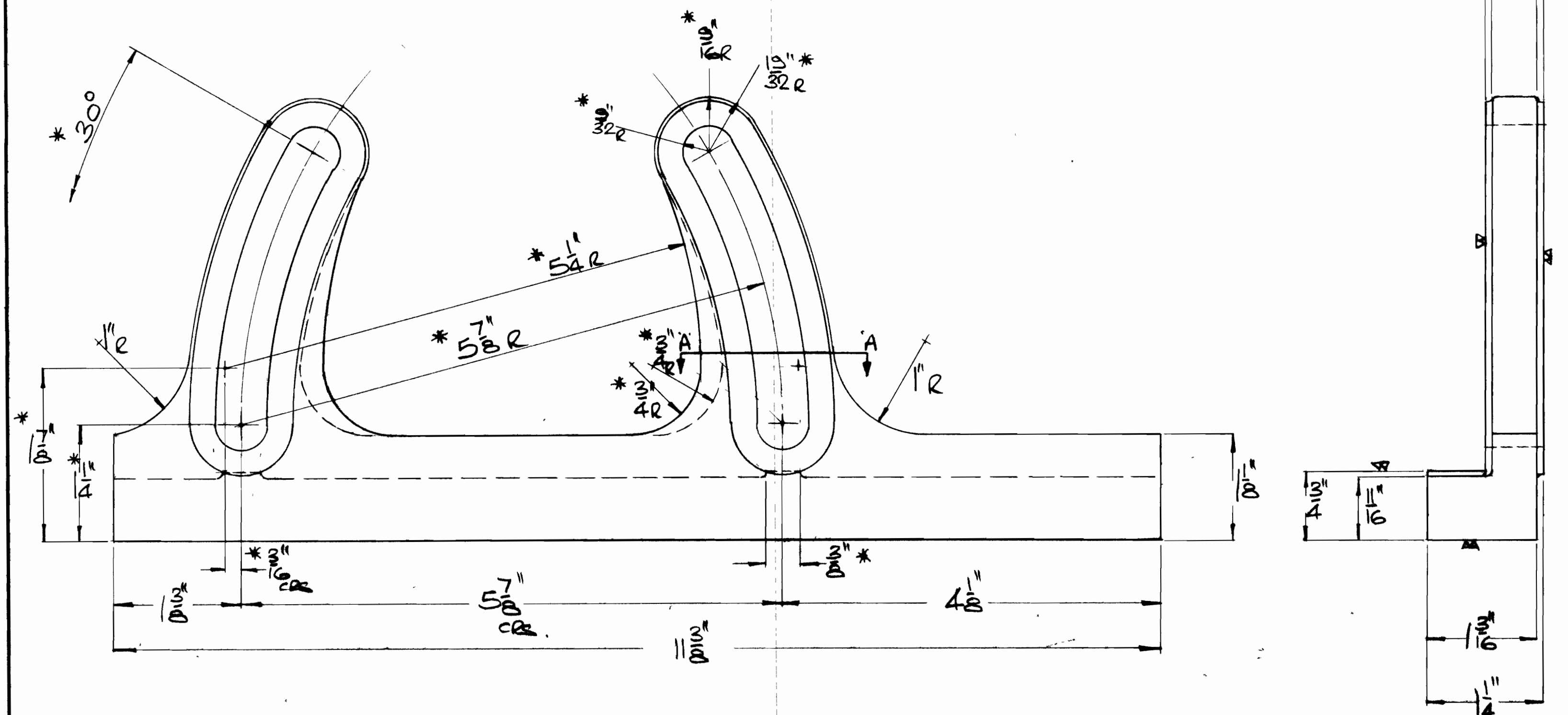
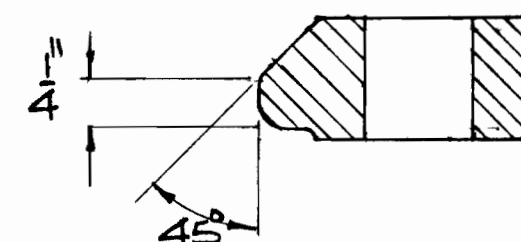
ALL DIMENSIONS ON DIMENSIONS UNLESS OTHERWISE STATED.
 ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
 FRACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

MATL. CAST IRON.
 MATL. SIZE CASTING.
 No. REQD. ONE.
 MACHINE AT W.
 GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				19.12.79	FULL
DRAWING 100/308.					

* THESE DIMENSION ARE EQUAL
FOR BOTH SIDES.

SECTION A.A



DRG.No.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 10" SHAPER - TABLE SUPPORT BRACKET

No.	DESCRIPTION	CHG.	DATE
	ALTERATIONS		

ON DIMENSIONS UNLESS
OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005"$

RACTIONAL $\pm \frac{1}{64}"$ 4 PLACE DECIMAL $\pm .0005"$

MATL C.I. GRADE 14.

MATL SIZE CASTING.

No. REQD 1

MACHINE AT W

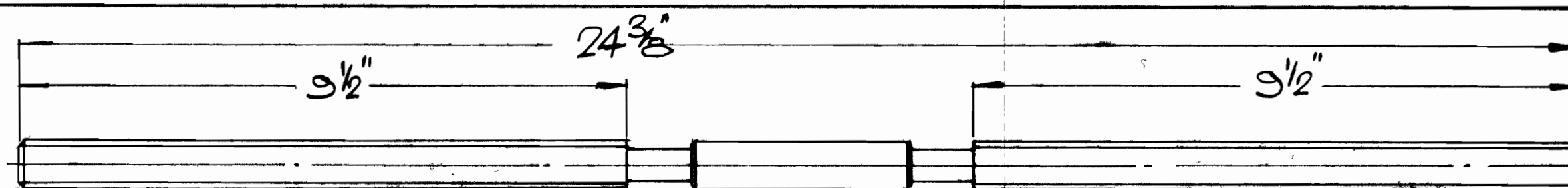
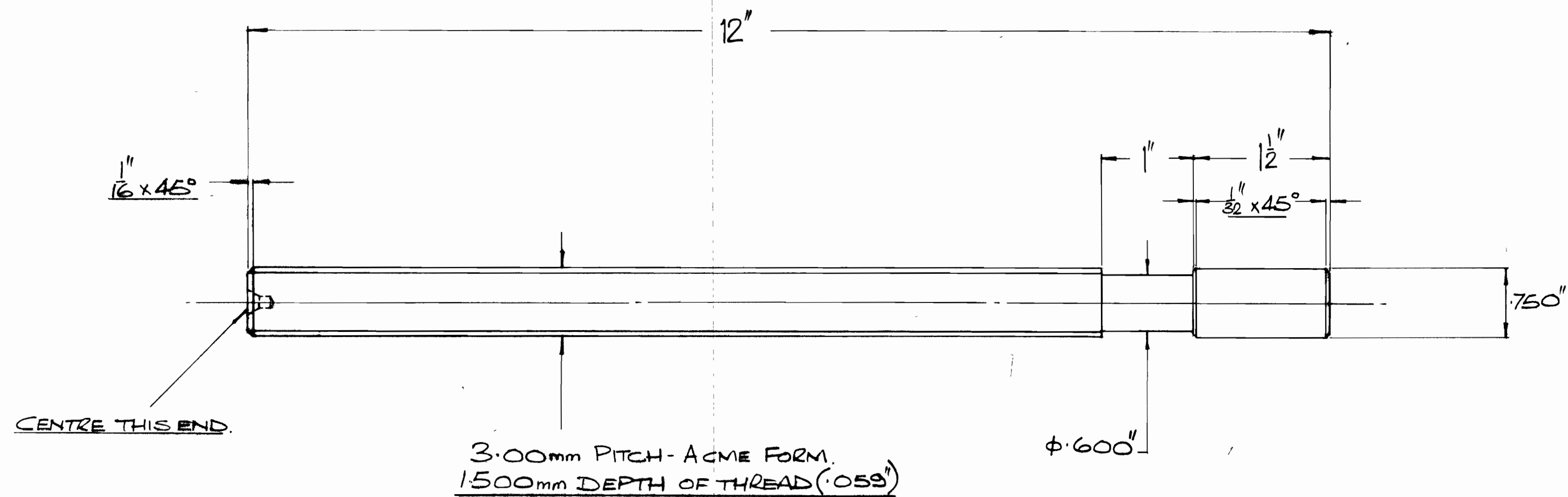
GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				5.3.75	FULL

DRAWING No. RS.100/404

IF IN DOUBT ASK.

DRG.No.



2 MACHINED AS ONE UNIT UNTIL
COMPLETION OF THREAD

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE

VICEROYAL 250 SHAPER - VERTICAL FEED LEADSCREW.

No.	DESCRIPTION	DATE	APPROVED
	ALTERATIONS		

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

LINEAR ± 1/32" 3 PLACE DECIMAL ± .005"

ACTIONAL ± .010" 4 PLACE DECIMAL ± .0005"

MATL. EN.1A. GROUND.

MATL. SIZE φ3/4" x 12 1/8" L.

No. REQ. ()

MACHINE AT W

GRIND AT 'G'

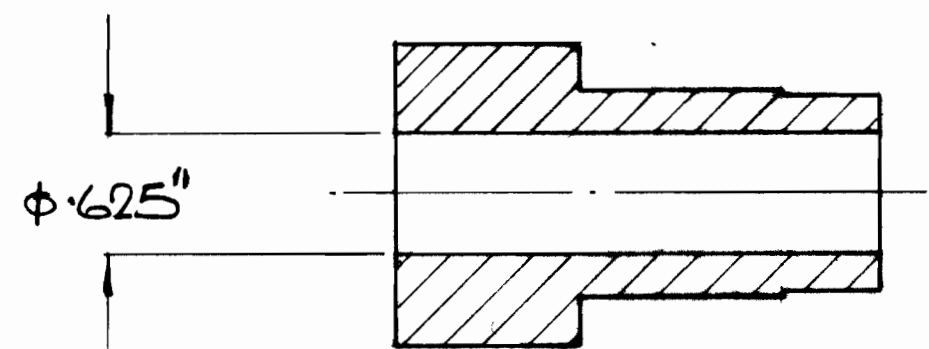
DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				28.4.75	1/2 Full.

DRAWING No. RS.100/408

IF IN DOUBT ASK.

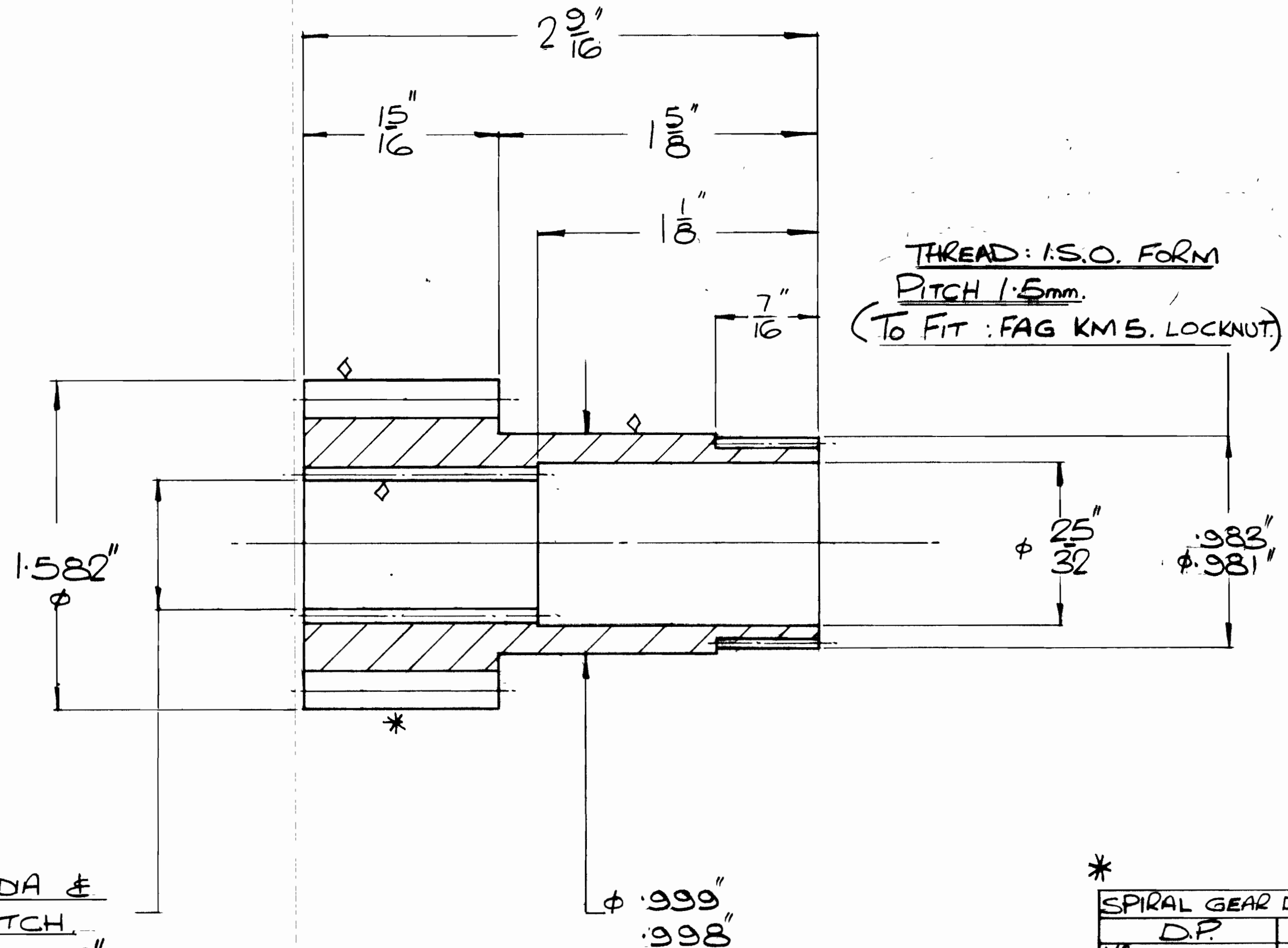
DRG. No.

PRODUCED WITH .625" BORE
SO THAT SPIRAL GEAR CAN
BE CUT & 1.0625" DIA CAN BE
TURNED TRUE.



FULL SCALE SECTION
BEFORE GEAR CUTTING.

REAM .625" DIA &
TAP 3.0 mm PITCH
ACME FORM x .069"
(1.754 mm) DEPTH OF
THREAD.



CONCENTRICITY BETWEEN DIA'S &
BORE MARKED ◇ TO BE WITHIN 0.001"

SPIRAL GEAR DATA	
D.P.	12
N° OF TEETH	12
P.C.D.	1.415"
GEAR CENTRES	1.415"
PRESSURE &	14 1/2°
TOOTH ANGLE	45°
DEPTH OF TOOTH	.1795"
LEAD OF SPIRAL	4.45°
HAND OF SPIRAL	R.H.

DENTON MACHINE TOOLS LTD. LEEDS, YORKSHIRE.

VICEROYAL SHAPER - SPIRAL GEAR NUT.

2205/75 10.11.75 IV.					
2325/76 21.12.76 AD					
No.	DESCRIPTION	DATE	BY	DATE	
ALTERATIONS					

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
ACTIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0005$ "

MATL ROS. BRONZE
MATH SIZE $\phi 1 5/8" \times 2 1/8"$
No. REQD 1
MACHINE A&L WEVER.
GRIND AT 'G'

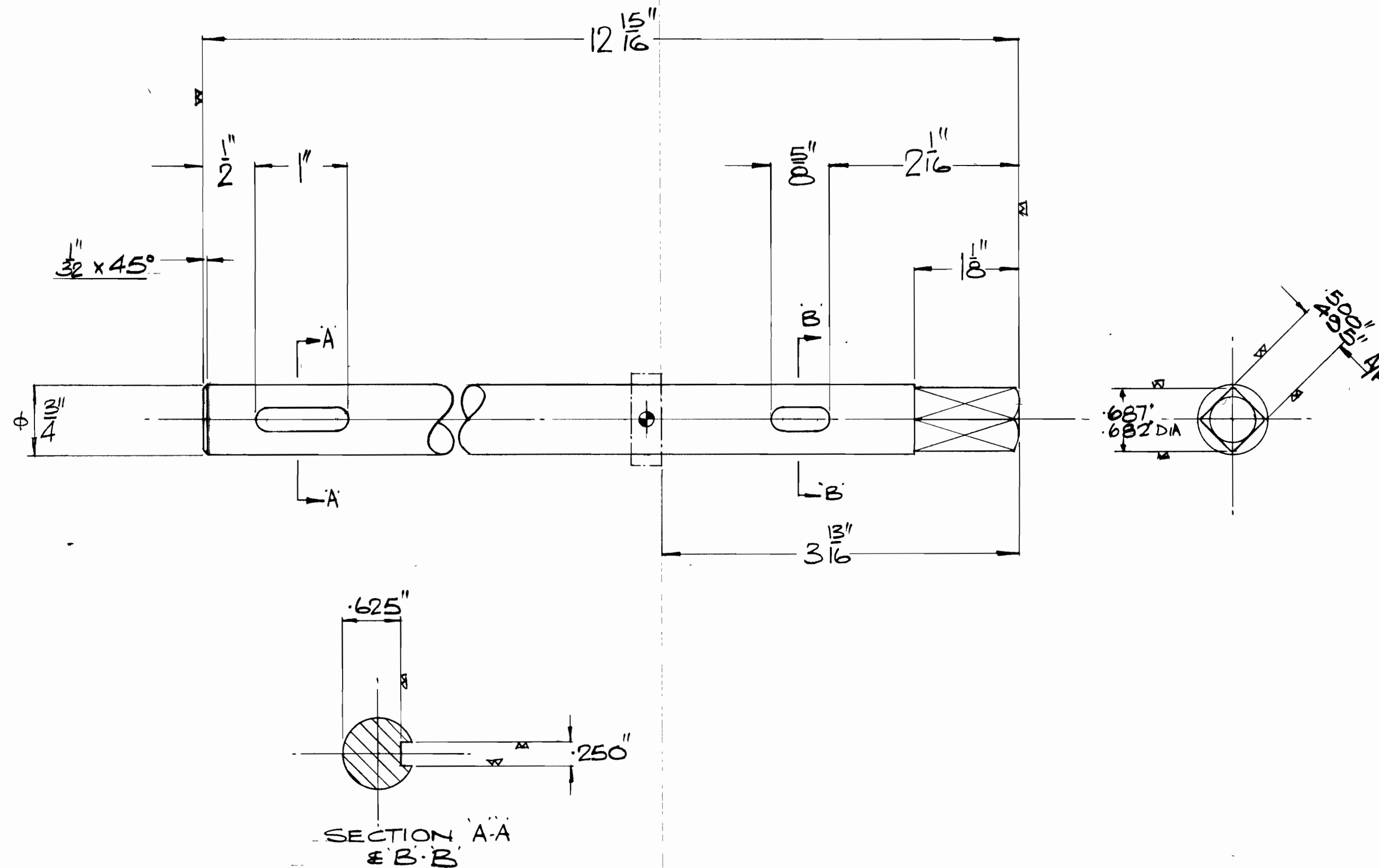
DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				10.11.75	FULL 2x FULL

DRAWING No. RS.100/409.

IF IN DOUBT ASK.

3RD ANGLE PROJECTION.

DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 250 SHAPER - VERTICAL FEED DRIVE SHAFT.

No.	2254/16.10.2.76 RD	DESCRIPTION	CHK'D	DATE

ALTERATIONS

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
 ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$ "
 RATIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0005$ "

MATL MILD STEEL
 MATL SIZE $\phi \frac{3}{4} \times 13" L$
 No. REQD. 1
 MACHINE AT W
 GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				25.475	FULL

DRAWING No. RS.100/412.

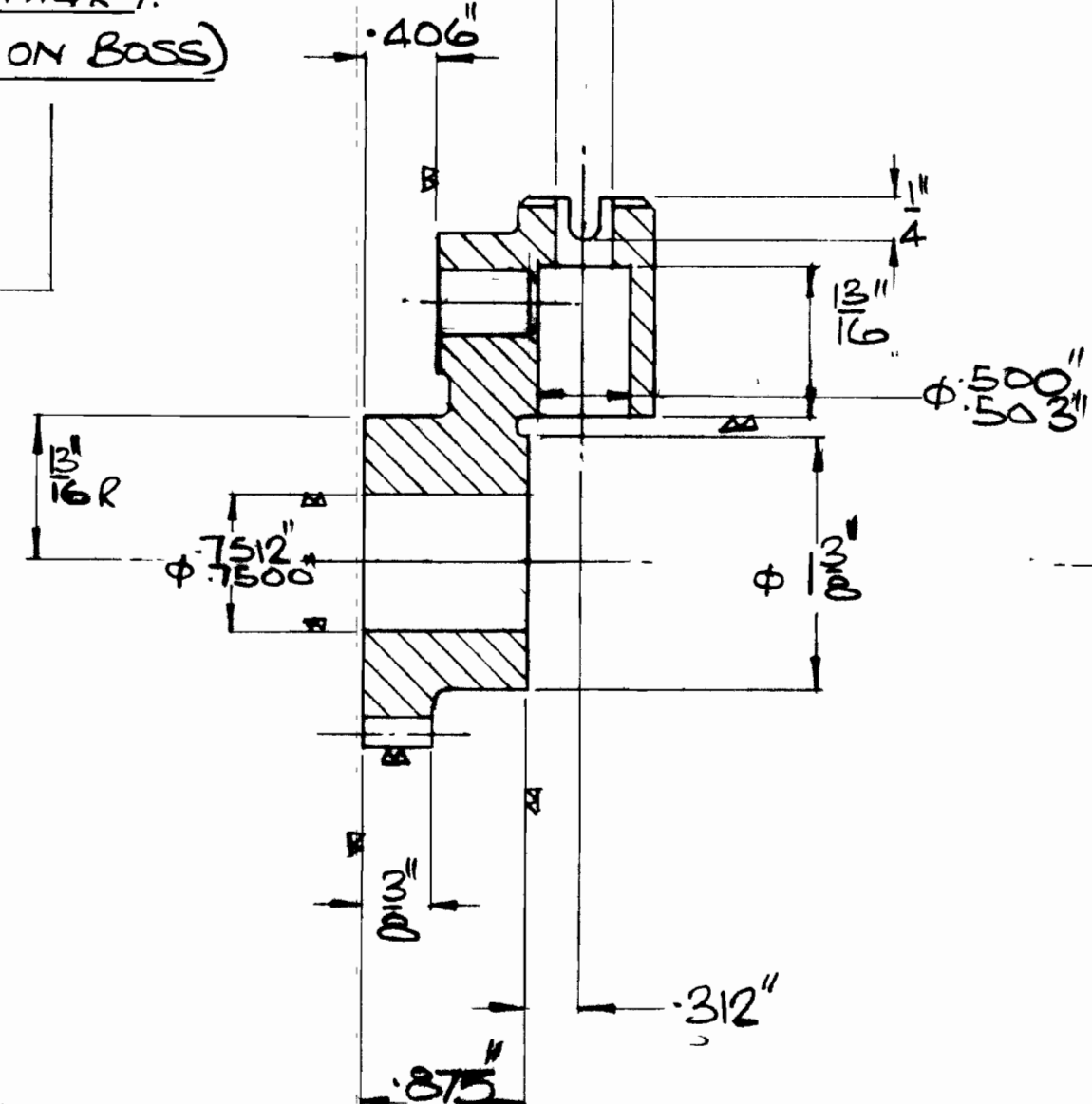
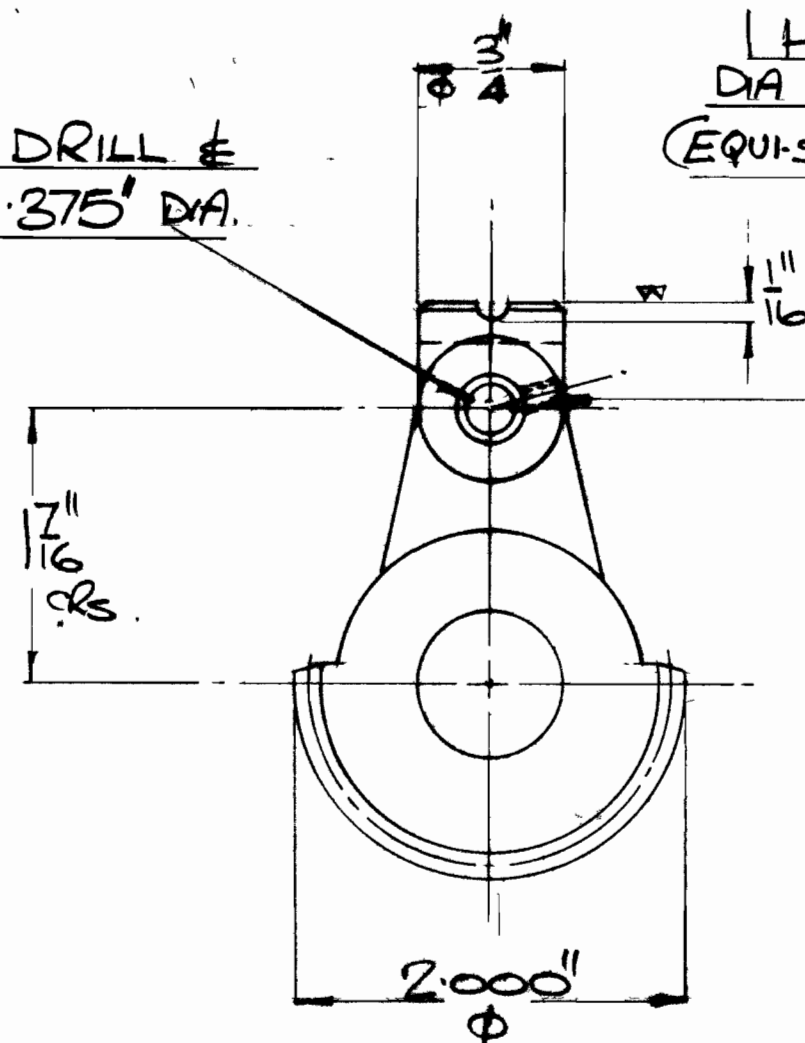
IF IN DOUBT ASK.

3RD ANGLE PROJECTION.

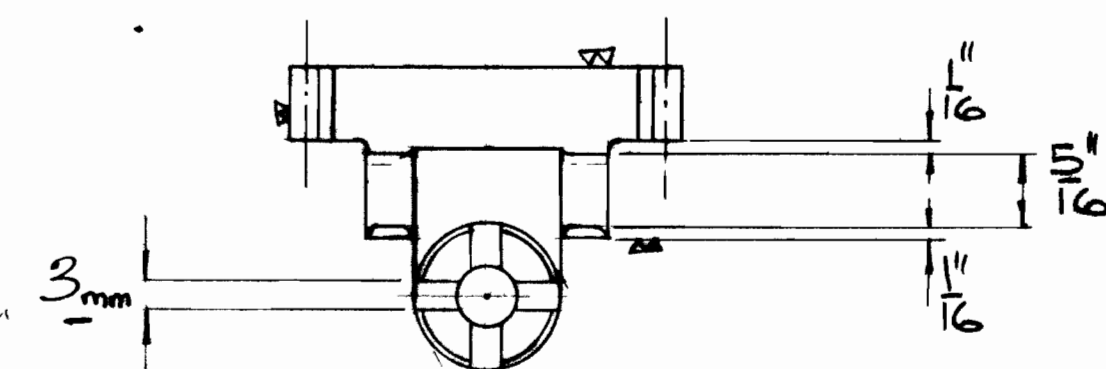
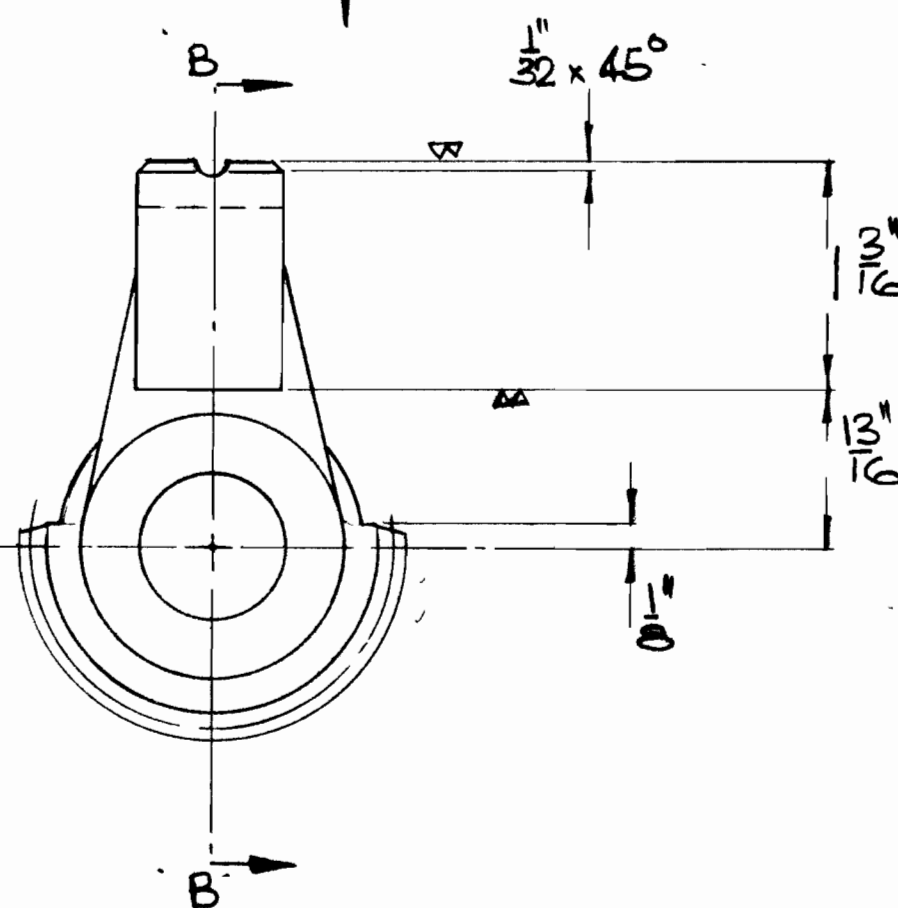
HOLE DRILL &
REAM .375" DIA.

HOLE DRILL 3.8mm
DIA & TAP M4x.7.
(EQUI-SPACED ON BOSS)

DRILL
Ø LETTER 'O'



SECTION B-B.



VIEW ON ARROW A

GEAR DATA	
D.P.	16
Nº OF TEETH	30
P.C.D.	1.875"
ROOT DIA	1.730"
DEPTH OF TOOTH	.1348"
PRESS 4	147

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 10" SHAPER - TOP & BOTTOM
ROCKERS FOR FEED PAWL.

No.	2264/76 23276 IV	DATE	
DESCRIPTION		DATE	
ALTERATIONS		DATE	

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .000^\circ$
ACTUAL $\pm .000^\circ$ 4 PLACE DECIMAL $\pm .0000^\circ$

MATERIAL GRADE 14
MATERIAL CASTING
MATERIAL 1.
MATERIAL AT 400
GRIND AT G

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				5.3.75	FULL

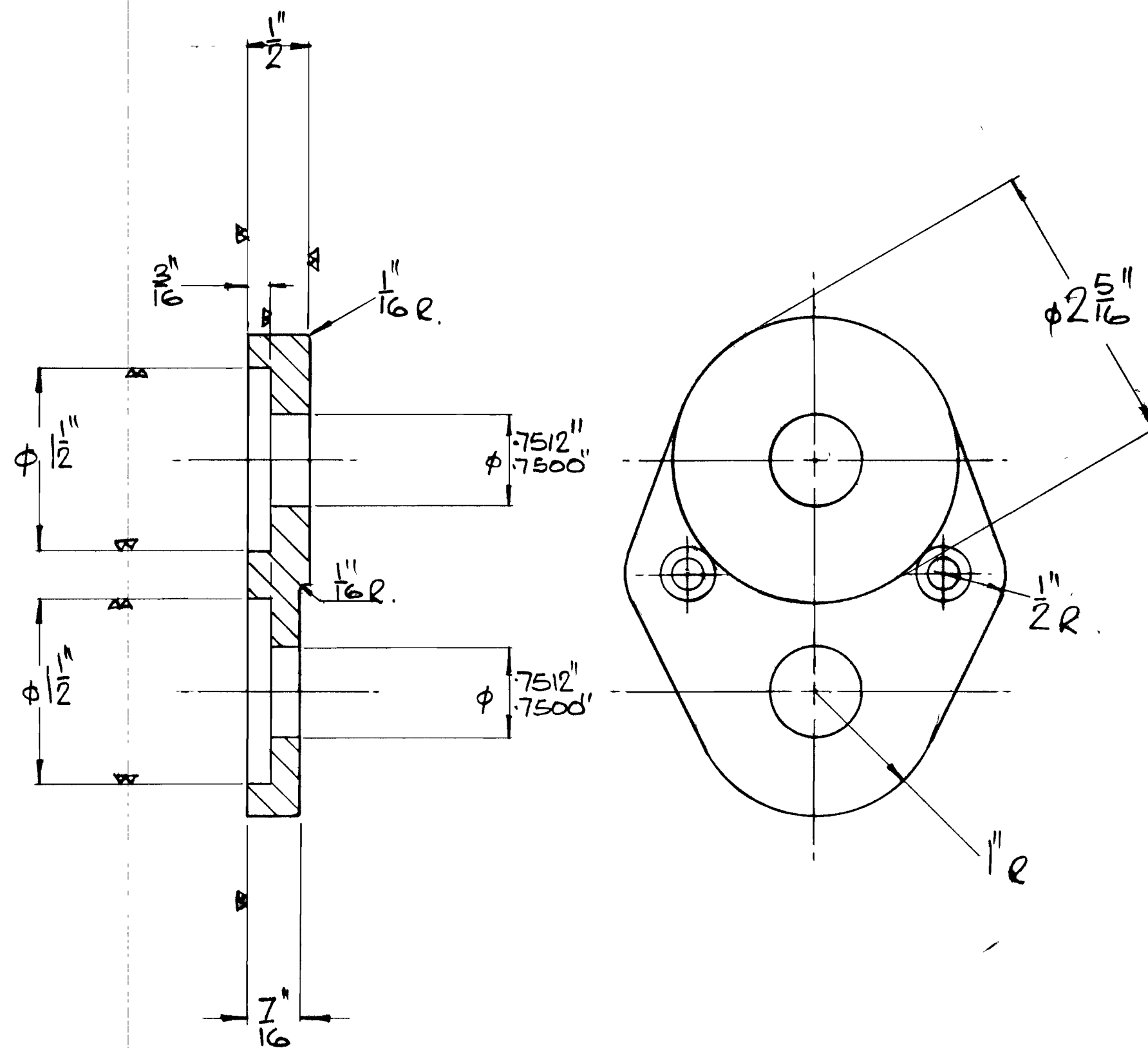
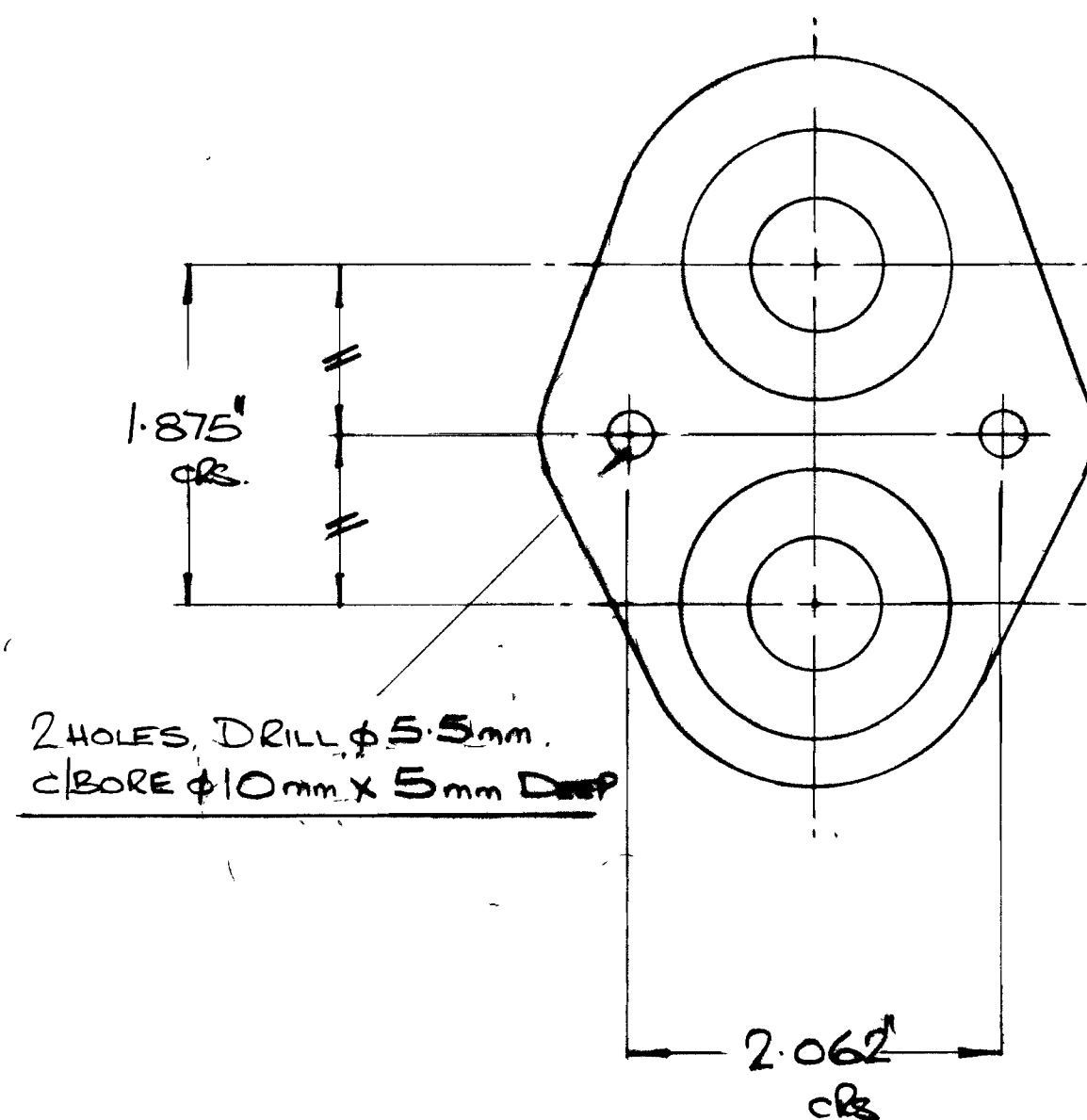
DRAWING No. RS.100/414

DRG.No.

IF IN DOUBT ASK.

3RD ANGLE PROJECTION.

DRG. No.



DRILL ON N/C MACHINE

DENFORD MACHINE TOOLS LTD. WILKINS, YORKSHIRE.

VICEROYAL 10" SHAPER - BEARING PLATE

No.	DESCRIPTION	DATE	BY
	ALTERATIONS		

UNITS OF DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
ACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0001$

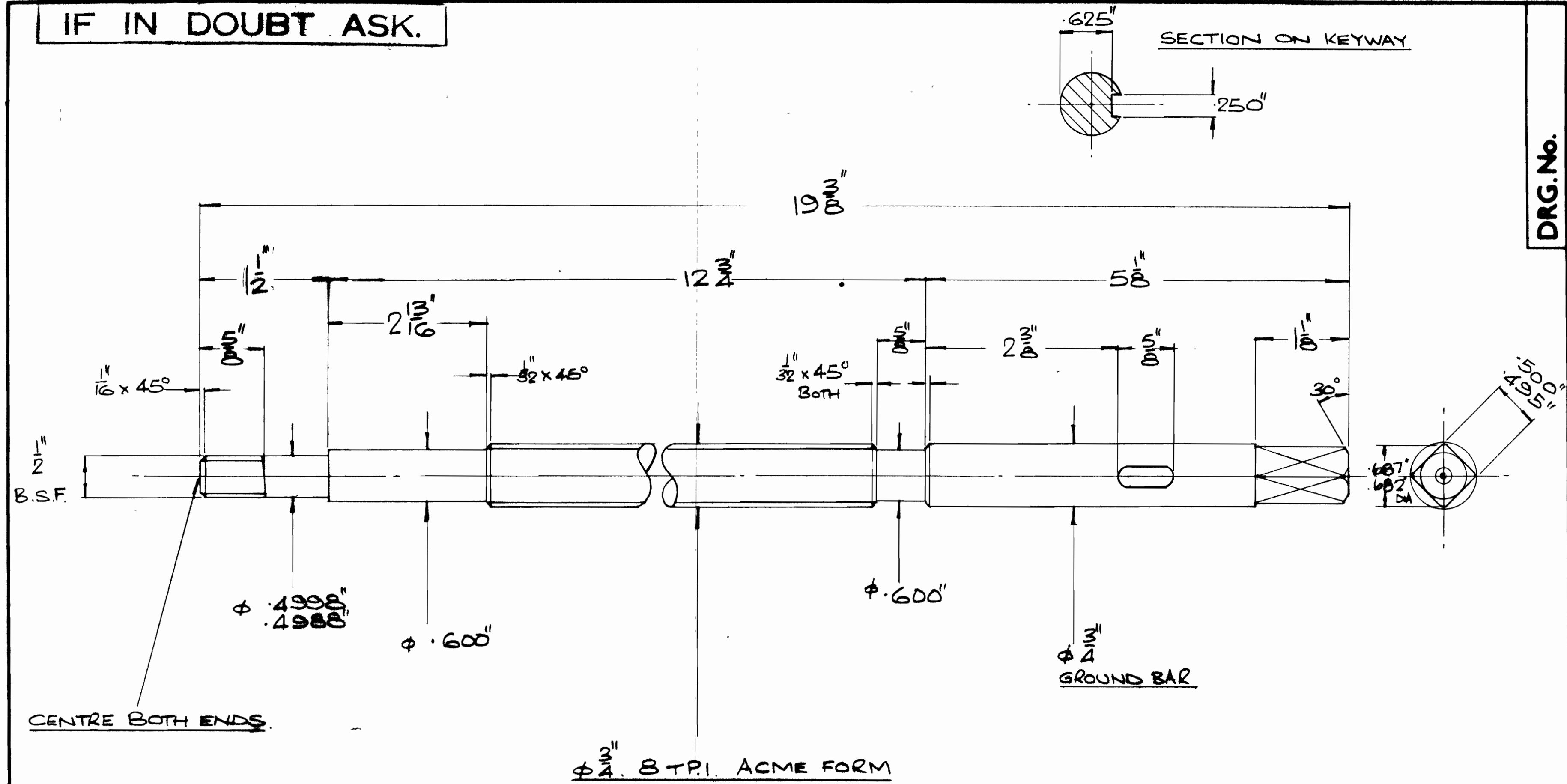
MATERIAL CASTING
GRADE 14
MATERIAL SIZE
1
10 NE AT 00

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				5.3.75	FULL

DRAWING No. RS.100/419

IF IN DOUBT ASK.

DRG.No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 10" SHAPER - CROSS SLIDE SCREW ENGLISH

2254/16.10.2.7.10					
2815/80 24 11.80					
No.	DESCRIPTION	DATE			

ALTERATIONS

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

FRACTIONAL $\pm .005$ 4 PLACE DECIMAL $\pm .0005$

MATL. EN1A - GROUND

MATL. SIZE $\phi 7.50" \times 18 \frac{1}{2}"$

No. REQ. 1

MACHINE ALL OVER

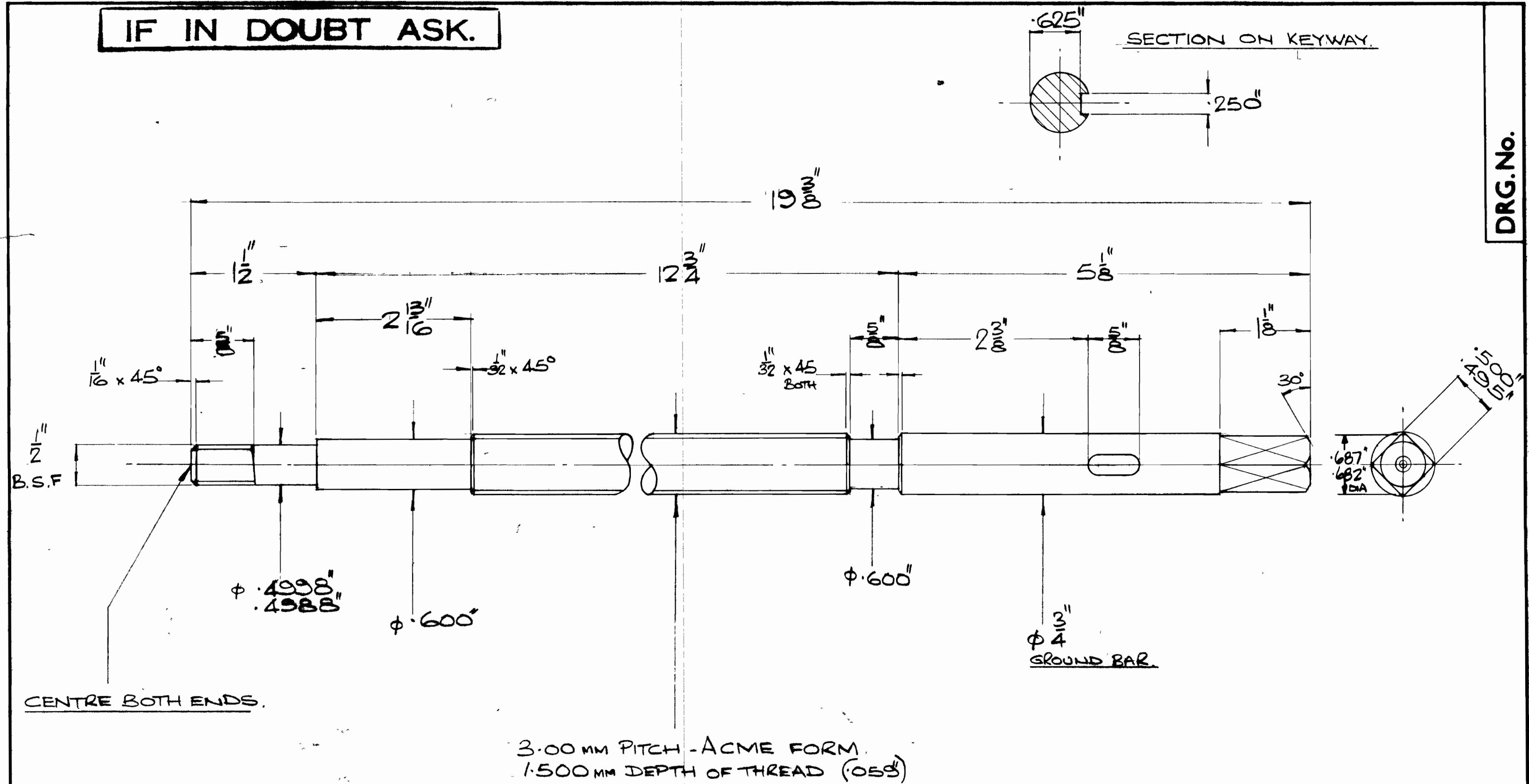
GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV				7.3.75	FULL

DRAWING No. RS.100/421 E.

IF IN DOUBT ASK.

DRG.No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROYAL 10" SHAPER - CROSS SLIDE SCREW METRIC

22.54/16.10.2.76.8.					
28.15/80.24.11.90.11.					
No.	DESCRIPTION	DATE	CHG.	APP.	DATE
ALTERATIONS					

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

FRACTIONAL $\pm .005$ 4 PLACE DECIMAL $\pm .0005$

MATL EN.1A - GROUND.

MATL SIZE $\phi .750" \times 19 \frac{1}{2}"$

No. REQ.

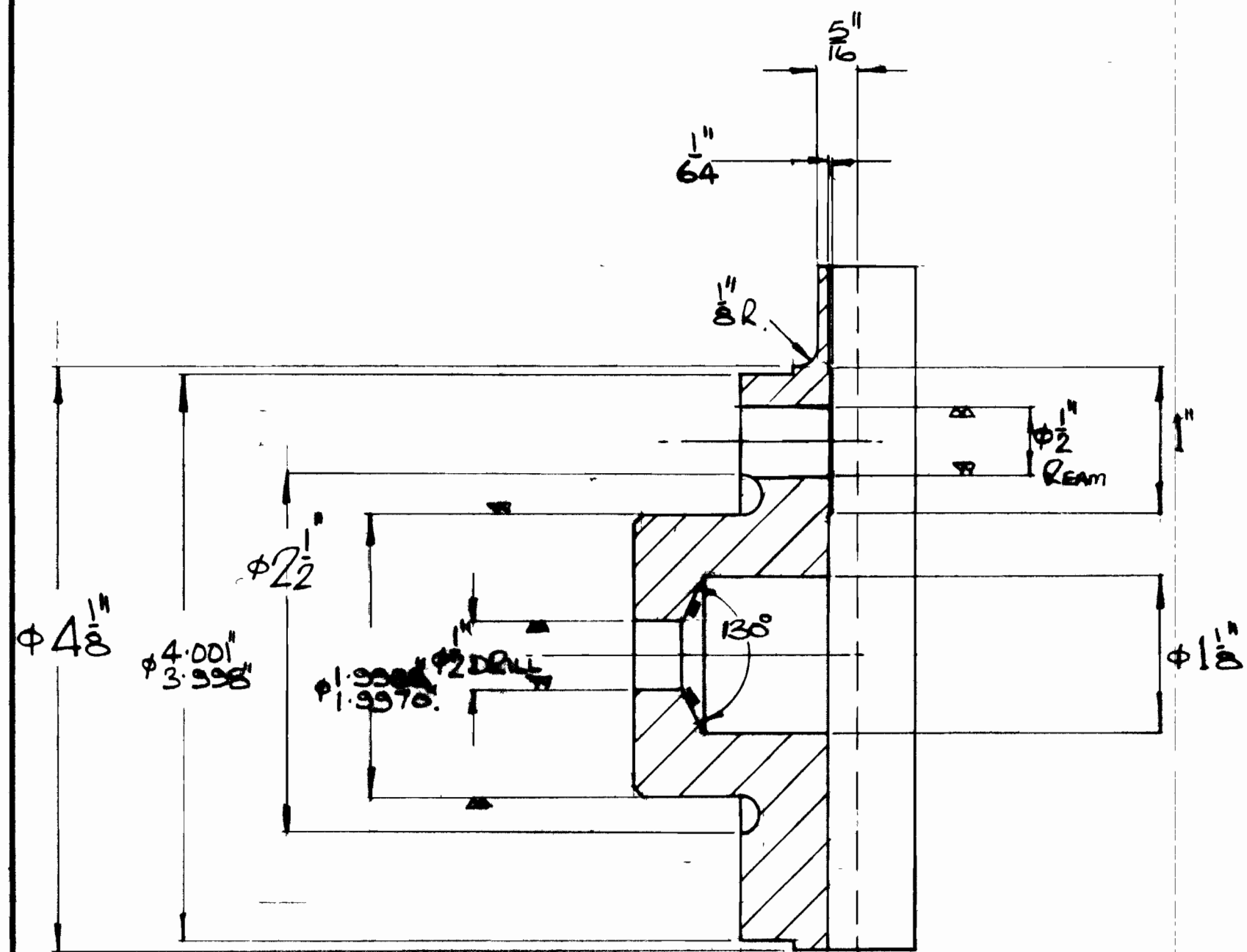
MACHINE ALL OVER

GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				7.3.75	FULL

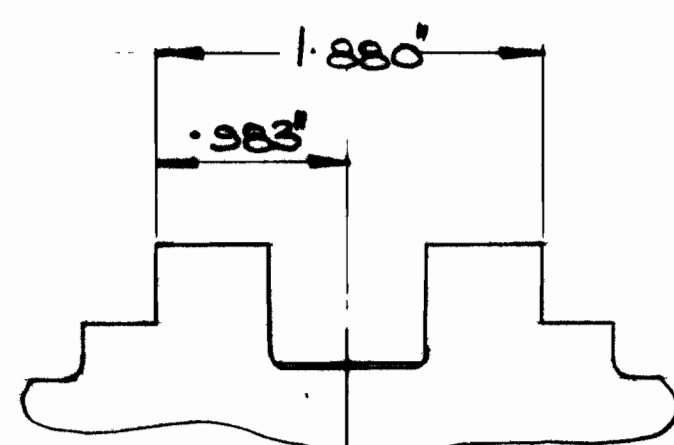
DRAWING No. RS.100/421.M.

DRG. No.

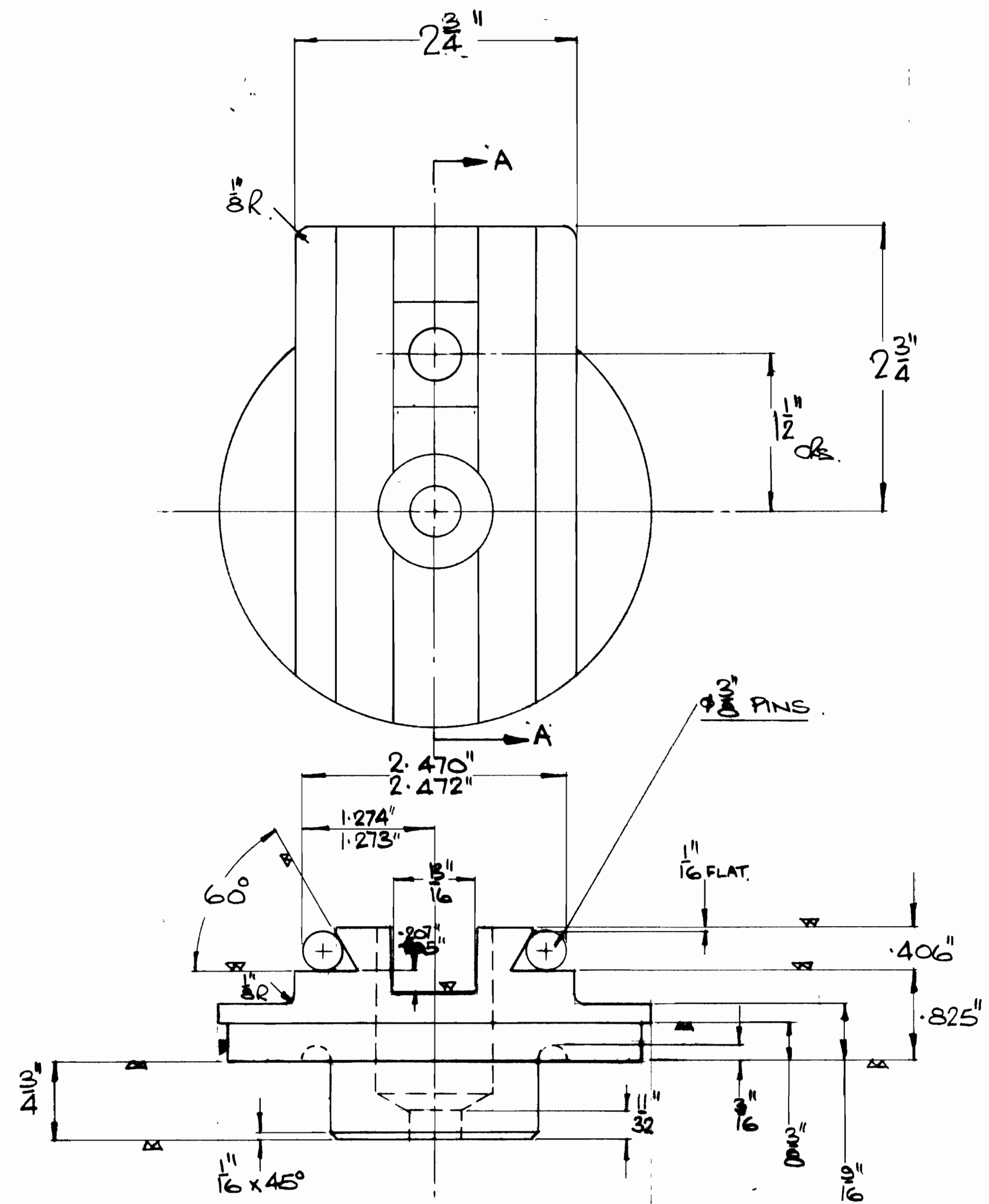


SECTION A-A

MACHINE AT W



VIEW SHOWING MACHINING DIMENSIONS PRIOR TO MACHINING VEE'S



MAT. CASTING - GRADE 14.

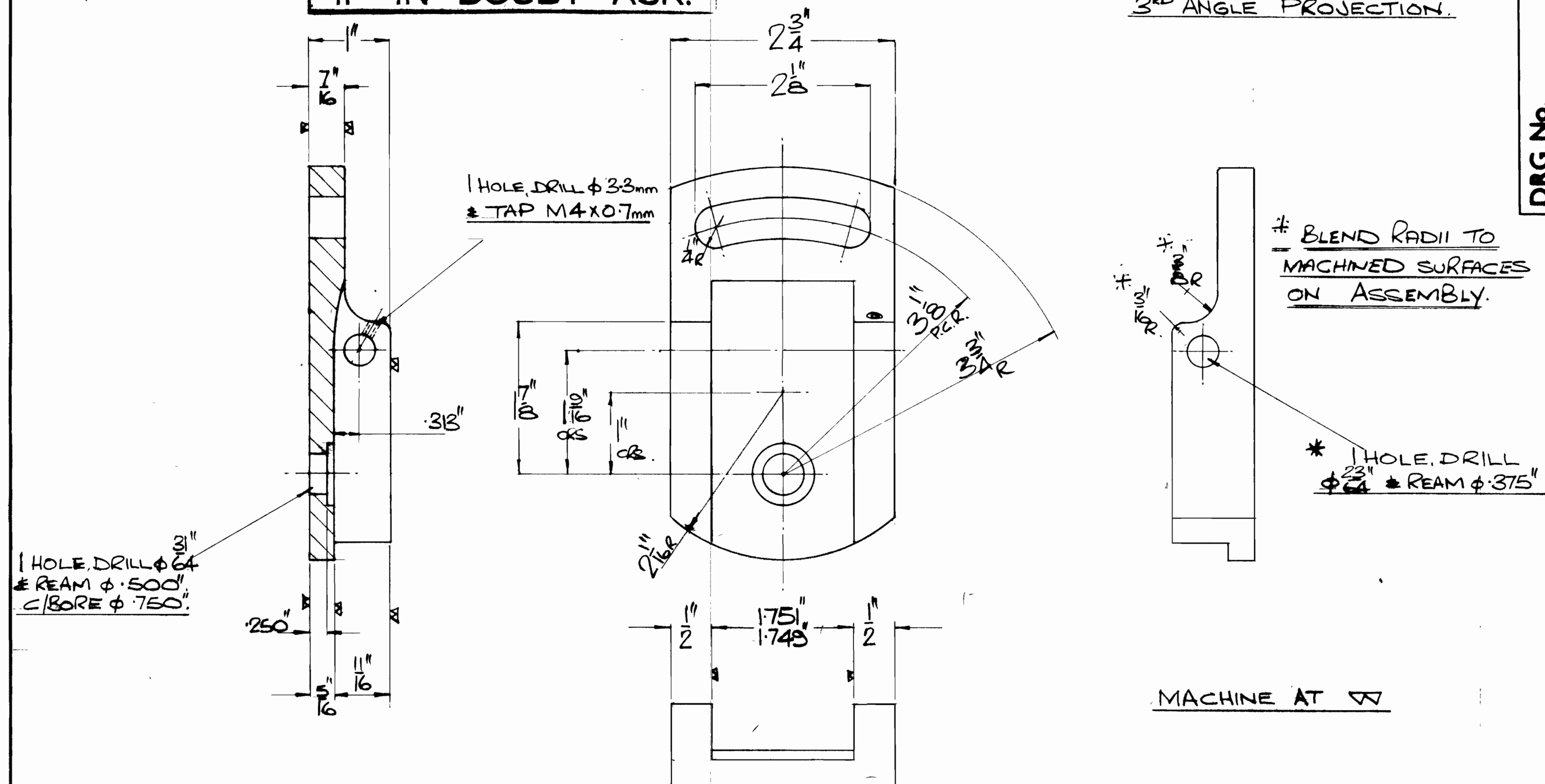
221375-261175					
No.	DESCRIPTION	CHG.	DATE		
	ALTERATIONS				

VICEROYAL 10" SHAPER
TOOLHEAD BASE

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
I.V.				19-275	FULL
DRAWING No. RS. 100/501					

3RD ANGLE PROJECTION.

DRG. No.



* DRILL & REAM WITH CLAPPER
BOX (RS.100/304) IN POSITION.

VICEROYAL 10" SHAPER - CRADLE FOR CLAPPER BOX.

246717.1-12-T7 IV										LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.		MATL. CAST IRON		DRAWN		TRACED		CHECKED		APPROVED		DATE		SCALE	
												MATL. SIZE CASTING		IV.								11-4-75		FULL	
No.		DESCRIPTION		CHG'D BY		DATE		ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$		FRACTIONAL $\pm .005$ 4 PLACE DECIMAL $\pm .0005$		No. MOD. 1		MACHINE AT W		DRAWING No. RS. 100/503.									
		ALTERATIONS																							