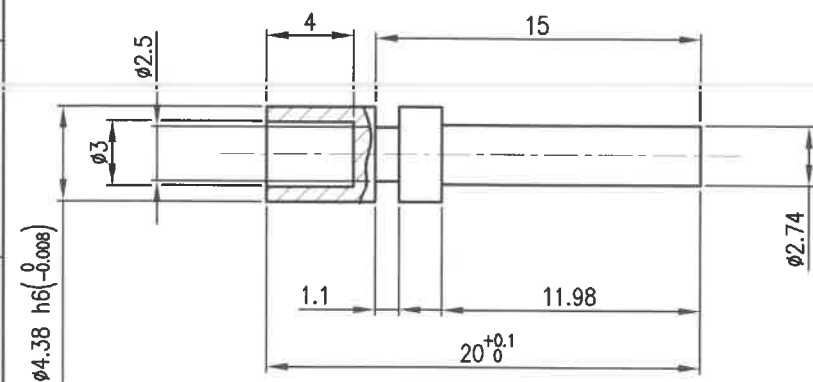


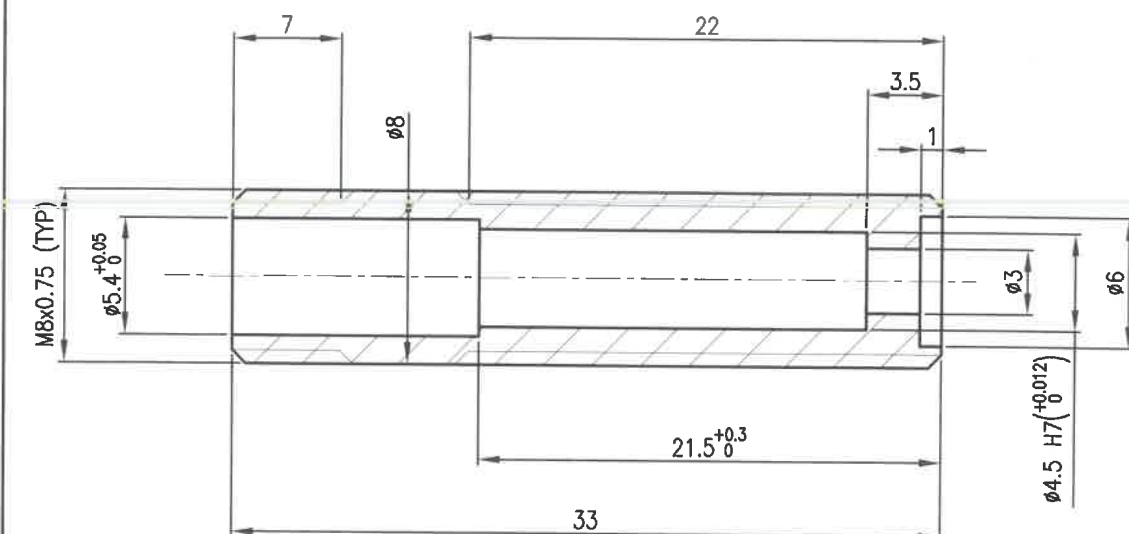
1. REMOVE ALL SHARP EDGES.
2. MATERIAL: STAINLESS STEEL 304 OR 316.
3. DIMENSIONS SHALL BE MEASURED WITH VERNIER OR MICROMETER.



N7/ [✓]

ITEM 3

1. REMOVE ALL SHARP EDGES.
2. MATERIAL: BRASS TO BS 2874; CZ121 Pb3 COND. M.
3. PASSIVATE IN ACCORDANCE WITH DEF. STAN. 03-12/1.
4. DIMENSIONS SHALL BE MEASURED WITH VERNIER OR MICROMETER.



N7/ []

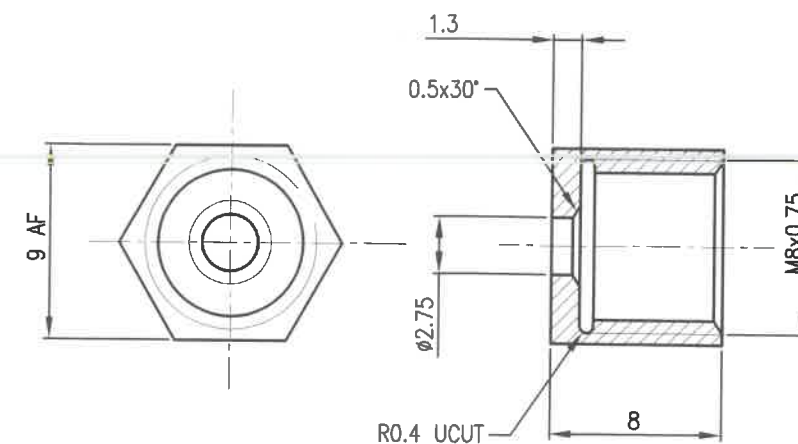
ITEM 1

Should a Tenderer/Vendor not be able to meet the requirements of this document, it must declared in writing to the Buying Manager at the time of tendering/receipt of an order.

DO NOT SCALE
ALL DIMENSIONS ARE IN mm



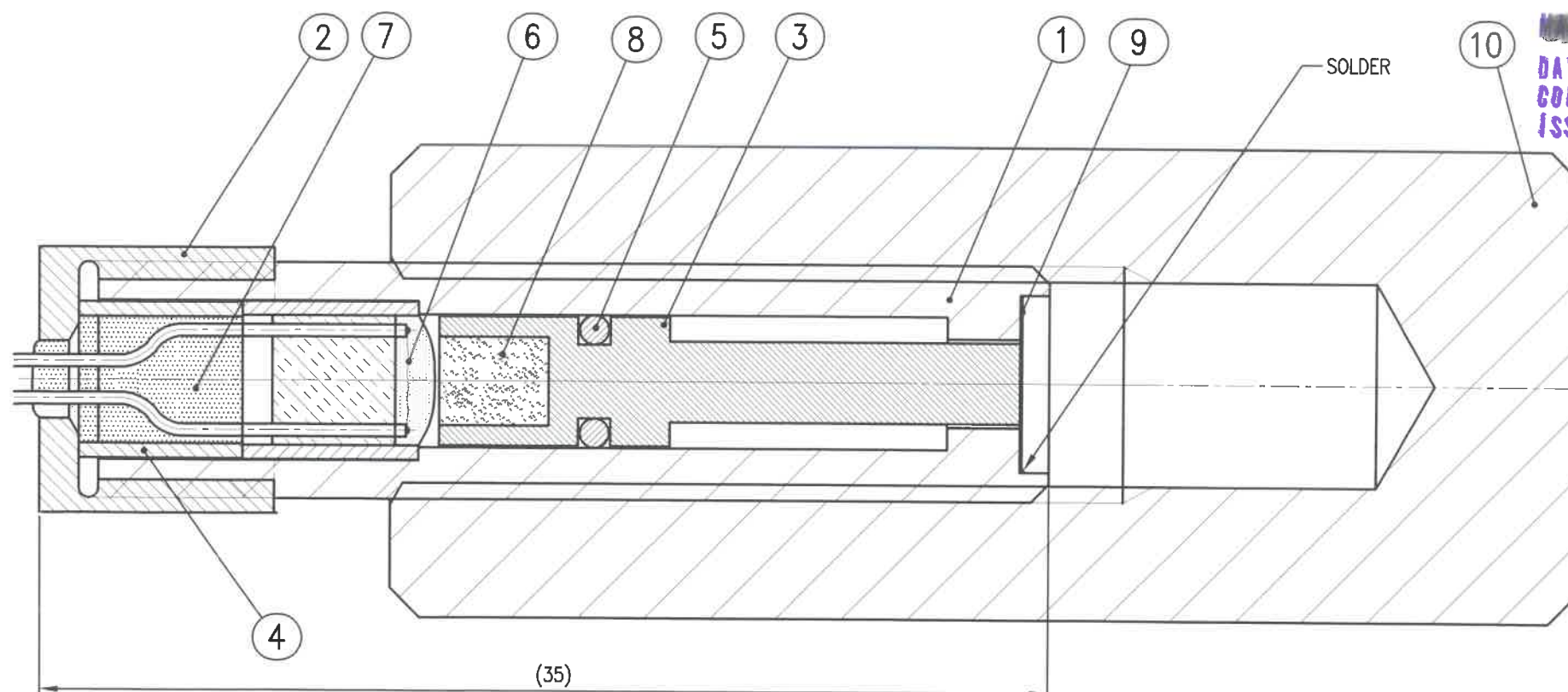
1. REMOVE ALL SHARP EDGES.
2. MATERIAL: BRASS TO BS 2874: CZ121 Pb3 COND. M.
3. PASSIVATE IN ACCORDANCE WITH DEF. STAN. 03-12/1.
4. DIMENSIONS SHALL BE MEASURED WITH VERNIER OR MICROMETER.



ITEM 2

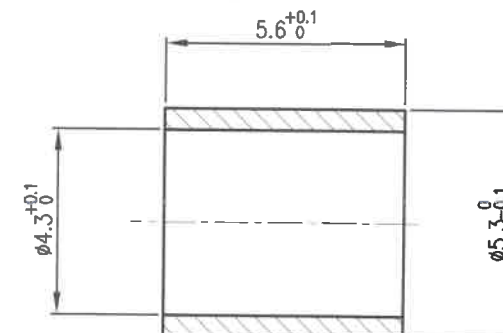
N7/ []

NOTE: 1. MATERIAL: COPPER STRIP 0.08±0.01 TO BS2870 GRADE C101 OR C102 WITH SILVER CONTENT 0.04 TO 0.08% TENSILE STRENGTH 250 MPa MIN.
2. CAVITY TO BE FILLED WITH ARALDITE SEALER AW (01106008904) AND HARDENER HW 2934 (01106008904) OR SIMILAR RESIN.
3. RESISTANCE 0.9-1.3 Ohm.



—SOLDER

DATE : 2023.06.06
COPY NO 11
ISSUE BY, J



N7/ [✓]

~~ITEM 5~~ ITEM 4

NOTE: 1. REMOVE ALL SHARP EDGES.
2. MATERIAL: BRASS TO BS 2874: CZ121 Pb3 COND. M.
3. DIMENSIONS SHALL BE MEASURED WITH VERNIER OR MICROMETER.

10	PROTECTION CAP M1227	06153-000001-203002	00189050005		
9	BLOW-OUT DISC Ø5.9		00189050408	SEE NOTE 1	
8	MP200 17 - 21mg	175 0037	01175003702		
7	PLASTO DOME POTTING			SEE NOTE 2	
6	POLE PIECE ASSY.	05419-010104x202001	00189011704		
5	SEAL O-RING	ID 2.5x1			
4	SLEEVE	SEE ITEM 5			
3	PISTON M1227	SEE ITEM 3	00189050310		
2	CAP BRASS	SEE ITEM 2	00189050201		
1	BODY M1227	SEE ITEM 1	00189050103		
ITEM No.	DESCRIPTION	REMARKS OR DRG. No.	CODE No.	REMARKS	

✓ [✓] [✓]

HRC

METRON ACTUATOR M1227

MATERIAL SEE ITEM LIST

GENERAL TOLERANCES (UNLESS OTHERWISE STATED)

LENGTHS AND DIAMETERS								ANGLES		RADI					
0	6	30	120	315	1000	2000	4000	0'	30'	1	6	30	100	300	
TO	TO	TO	TO	TO	TO	TO	AND	TO	AND	TO	TO	TO	TO	TO	
6	TO	120	315	1000	2000	4000	MORE	30'	MORE	6	30	100	300	1000	
±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±30"	±1"	±.5	±1.0	±1.5	±2.0	±3.0	

ALL GEOMETRIC
TOLERANCES TO
BE WITHIN 0,1



DRAWN JJO	12-10-08	CHECKED FWJ	13-03-12
FINALIZED JJO	13-03-05	APPROVED JJB	13-03-12
PROJECT LEADER		CODE No. 00189047108	
SCREEN PRG No.		CAD No. 00304961	

NEXT ASSY	REPLACES DRG. No.
-----------	-------------------

TITLE	CARTRIDGE METRON ACTUATOR	M1227A1
-------	---------------------------	---------

DRG No.	06153-000001-201001
---------	---------------------

2	DATE BY
---	---------

DETAILS

ITEM 7 UPDATED & ITEM 12 REMOVED,
SEE JOB No. 03/E001/17PC

DATE.

FJW	APP.
-----	------

E	RE
---	----

REV.
B

NOTE:
1. REMOVE ALL SHARP EDGES.

DO NOT SCALE
ALL DIMENSIONS ARE IN mm.

REV.

APP.

DATE.

DONE BY

DETAILS

N7/ [✓][✓]

HRC

PRODUCT METRON ACTUATOR M1227

JOB No. KB/136/12PC

MATERIAL ALUMINIUM 6082 COND. T

MACHINE

DRAWN JJO 12-10-24

CHECKED FJW 12-10-30

FINALIZED

APPROVED MGW 12-10-30

PROJECT LEADER GB 12-10-31

CODE No. 00189050005

SCREEN DRG. No.

CAD No. 00304788

NEXT ASSY 06153-000001-201001

REPLACES DRG. No.

TITLE PROTECTION CAP M1227

DRG No. 06153-000001-203002

REV.

GENERAL TOLERANCES (UNLESS OTHERWISE STATED)										ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1														
LENGTHS AND DIAMETERS								ANGLES		RADII														
0 TO 6	6 TO 30	30 TO 120	120 TO 315	315 TO 1000	1000 TO 2000	2000 TO 4000	4000 AND MORE	0° TO 30°	30° AND MORE	1 TO 6	6 TO 30	30 TO 100	100 TO 300	300 TO 1000										
±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2,0	±3,0	±30'	±1°	±0,5	±1,0	±1,5	±2,0	±3,0										