

OCTOBER 2, 1985.

TO: SCOP SA  
ATTN: MR. MARTINAUD / MR. FARGE

SUBJECT: B2-TTR ALIGNMENT

Sorry for delay in reply of your request alignment of B2-TTR. Here enclosed procedure how to align. Please study and refer to my idea of solution mentioned last.

B2-TBI(TTR) ADJUSTMENT PROCEDURE

\*\* PLEASE FOLLOW FROM No 1. TO 11. OF STEPS.

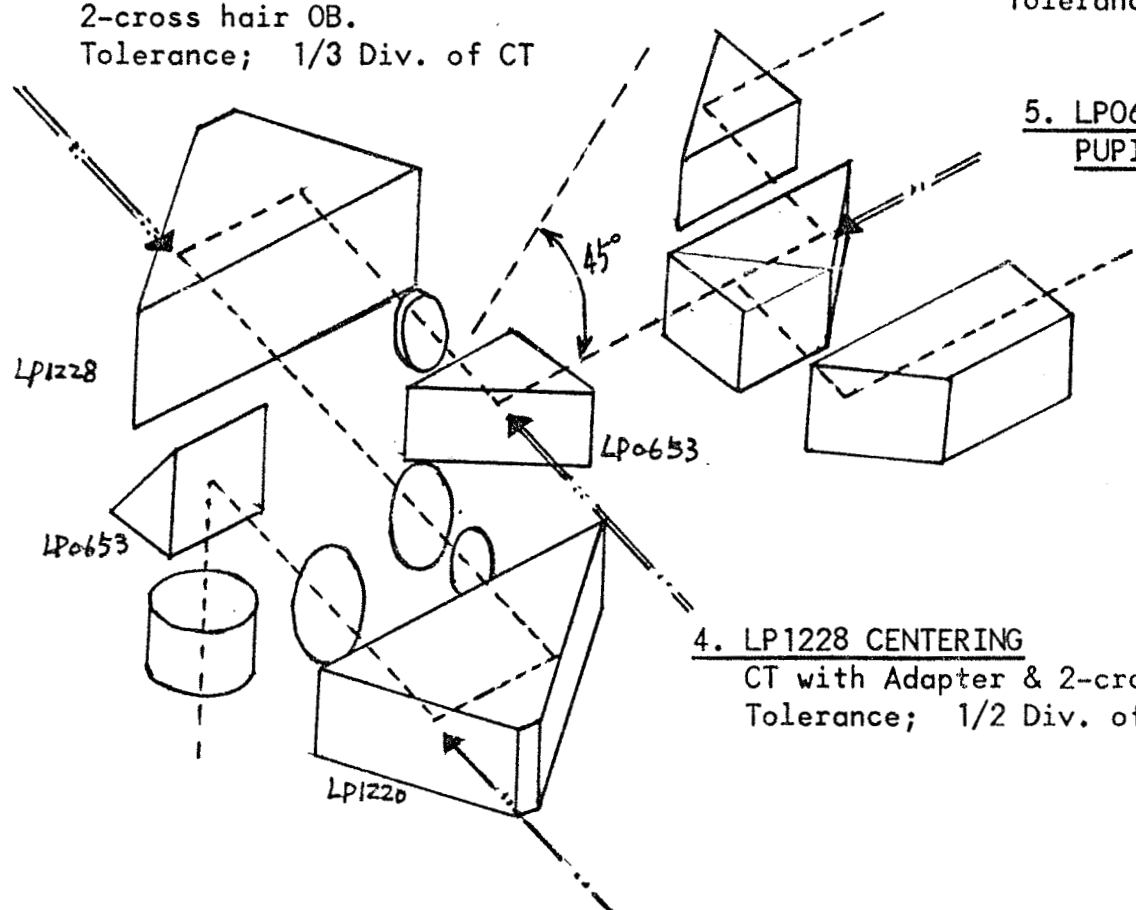
2. LP1228 CENTERING

CT(KN0029) with Adapter & 2-cross hair OB.  
Tolerance; 1/3 Div. of CT

3. LENS SLEEVE ASSEMBLY;

CT with Adapter & 2- cross hair OB.  
Tolerance; 1/4 Div. of CT

5. LP0653 CENTERING, EXIST PUPIL, PARFOCULTY ADJ.



4. LP1228 CENTERING

CT with Adapter & 2-cross hair OB.  
Tolerance; 1/2 Div. of CT.

1. LP0653 CENTERING

CT(KN0029) with Adapter & 2-cross hair OB.  
Tolerance; 1/3 Div. of CT(Scale)

6. AB2834(BODY) ASSEMBLY

Adjust Center; KN0015 Centering OB & B2kC0401 Tolerance ; As close as 0  
Pupil ; " " " Tolerance ; 20 %

Parfoculty; KN0016 Tube length /B & B2KCO401 Tolerance; 0.05 mm on OC

7. B2-BI Assembly;

Make sure the ability of align BI unit and AB2834.. And set it on the best position of optical condition temporary.

8. GEAR UNIT ASSEMBLY

Adjust inclination of image.

Assemble gear and check inclination of image Tolerance; 20'(Sec)

9. TENSION ADJUSTMENT INCLING

Assemble AB2835 temporary & adjust tension watching the center of BI stay.

Tolerance; North to South 600g to 1200g, South to North Under 2500g

After adjusted, Faston set screws of AB2835.

10. INCLINATION OF IMARGE CHECK

Tolerance; 20'(Sec) KN0004, Inclination checker and BH2 model.  
± 2 Dig. at OC-pin position.

11. ASSEMBLE ALL ( EXCEPT BI & PHOTO TUBE )

12. B2-BI & PHOTO TUBE ADJUSTMENT

\*Please refer to B2-BI(TR) Adjustment in Repair Manual BH2.

Tolerance of Parfoculty; ± 0.1 mm with KN0016 (or Short OB type KN0007)  
BI(Right Side) and Photo.

Tolerance of Centering ; 0.2 mm at OC (North, South & Outside)  
0.4 mm at OC (Inside)

\*Another side must be setted 0

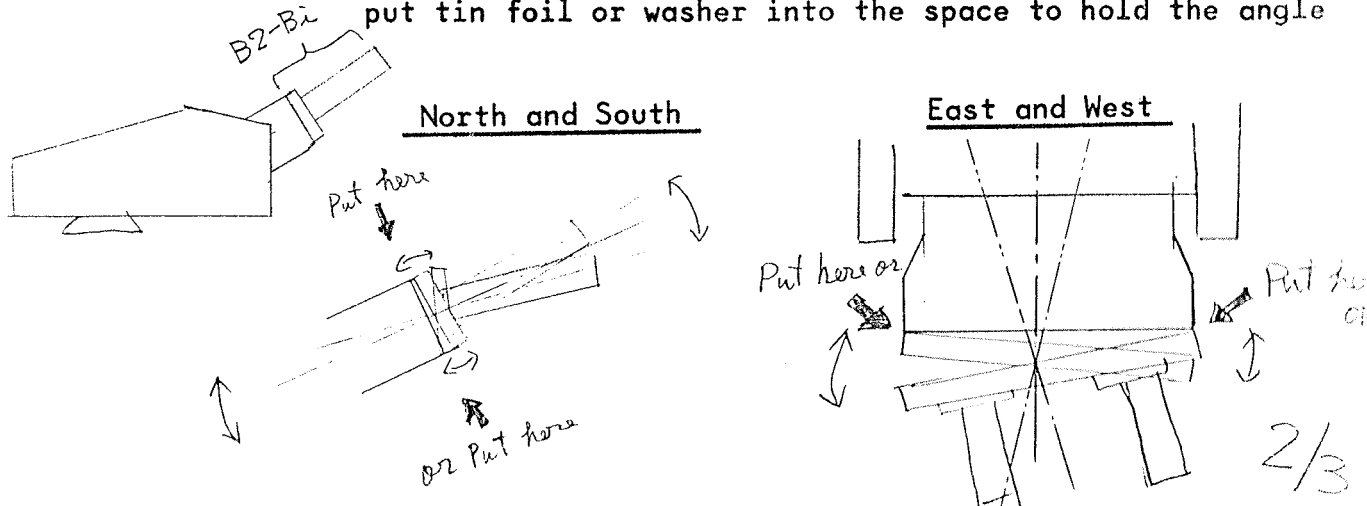
13. ASSEMBLE ALL (END)

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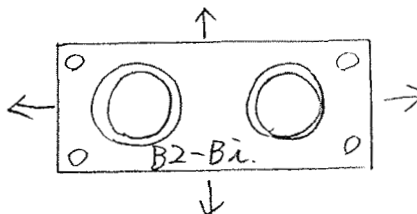
\*\*\* NOTE \*\*\* (SIMPLE WAY OF ALIGNMENT)

I believe the difficulty of TTR alignment is Image erector part, if you touch it without knowing alignment, eccentric movement will show up and hard to realign without Jig & Tool. Here mentioned easier way without touching Image erector part is as follows;

1. ALIGN EXSIT PUPIL : Incline Bi unit and find the best position. and then, put tin foil or washer into the space to hold the angle



2. ALIGN CENTER : Slide B2-BI unit and bring eyepiece cross to OB(KN0015) or (KN0005)cross, keeping the angle of BI unit for Exsit pupil



\*\* In case, Still TTR is out of tolerance, Please return it to Hamburg, We will repair and return to you. The special JIG & TOOL are ordered to O/T.

We are at your service at all times.

I am looking forward to hearing good news from you  
Best regards

T. Imai