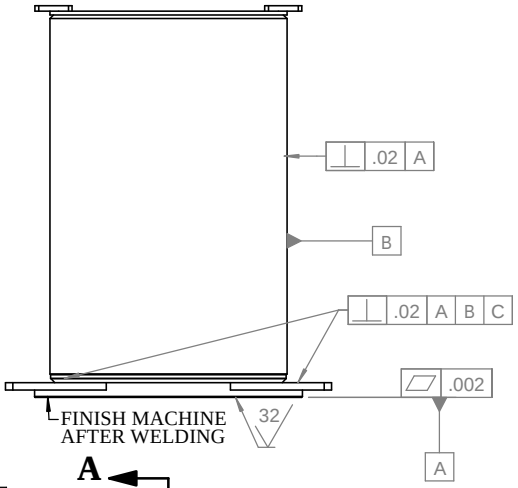
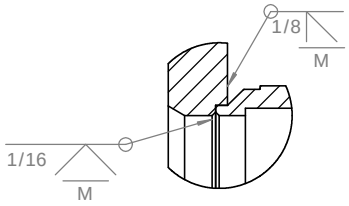
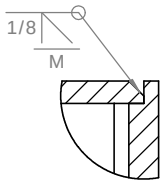
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	4/8/02	

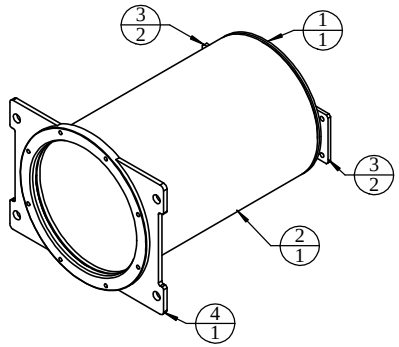


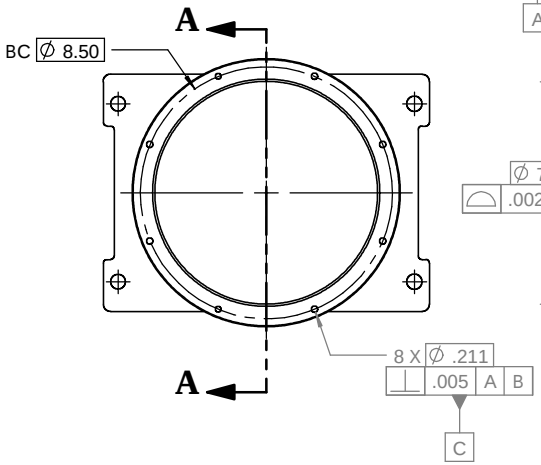


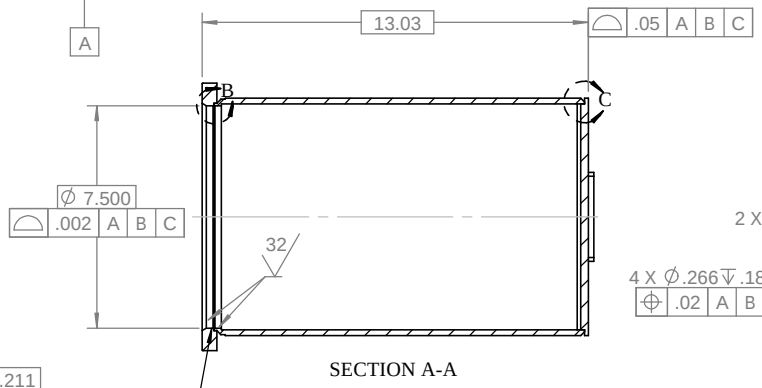
DETAIL B
SCALE 1 : 1



DETAIL C
SCALE 1 : 1

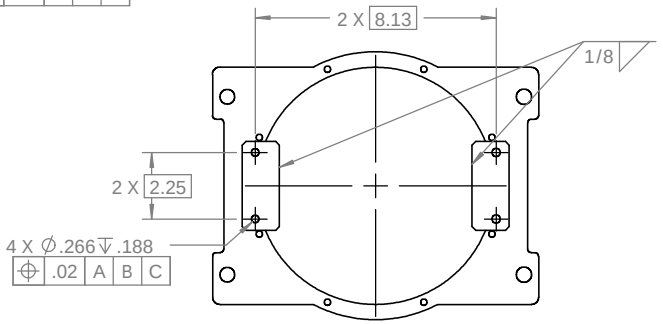






SECTION A-A

FINISH MACHINE TO SIZE
AFTER WELDING



ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	NMC can base	1001462DWG
2	1	NMC can tube	1001459DWG
3	2	anode mount plate	1001464DWG
4	1	NMC can flange	1001463DWG

NOTES:
1. Inert gas purge internal voulme of housing during welding.
2. Finish machine o-ring face and bore after welding.
3. Fixture as necessary to maintain flatness and squareness.
4 Finish 32 all exterior surfaces.
5. Pressure test to 10 PSI for 4 hrs after welding use 1001461DWG to test max pressure drop of .1 PSI allowed.
6. Magneplate _____ after testing.
7. Prior to welding degrease and mechanicly remove surface oxidation with a .020" wire brush within 2 hrs of welding.

BILL OF MATERIALS

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	APPROVALS DATE
Inspector		1 PLACE DIM ±1/16 · 2 PLACE DIM ±.02 · 3 PLACE DIM ±.005 · ANGLES ±1°	DRAWN C OKUDA 4/8/02
Shop Foreman		1. DIMENSIONS ARE IN INCHES	ENGINEER C OKUDA 4/8/02
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.	CHECKED
NEXT ASSY Description	NEXT ASSY Number	3. REMOVE BURRS AND SHARP EDGES .015 MAX.	PROJECT NO. 600029
		4. MACHINED FILLET RADII .0150-.030.	PROJECT NMC
		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005	
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX .012 INCHES FOR SINGLE SURFACE.	
Application		DO NOT SCALE DRAWING	WEIGHT

Monterey Bay Aquarium Research Institute
MBARI
7700 Sandholdt RD.
Moss Landing, CA 95039
PH: (831) 775-1700

NMC CAN WELDMENT

SIZE	DWG. NO.	REV.
B	1001465DWG	–

SCALE 1:4 | CAD FILE: MECH ENG ON TORNADO | SHEET 1 OF 1