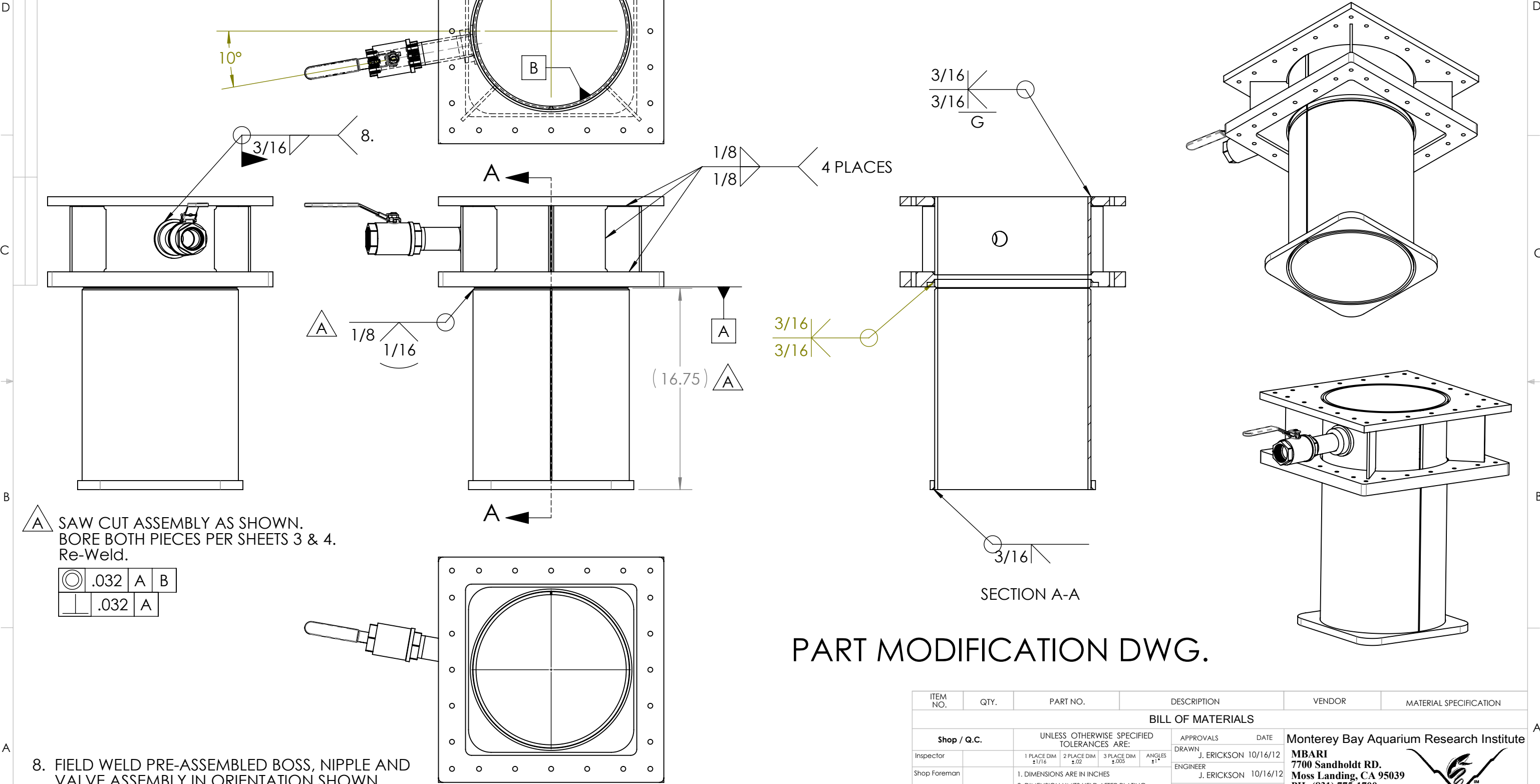


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REVISIONS				
INITIAL RELEASE		REVISIONS	X/XX/01	J.E.
ZONE	REV.	DESCRIPTION	DATE	APPROVED
B3, B4	A	SAW CUT, BORE (SHT 3, SHT4), RE-WELDB1	2/25/2016	J.E.B1

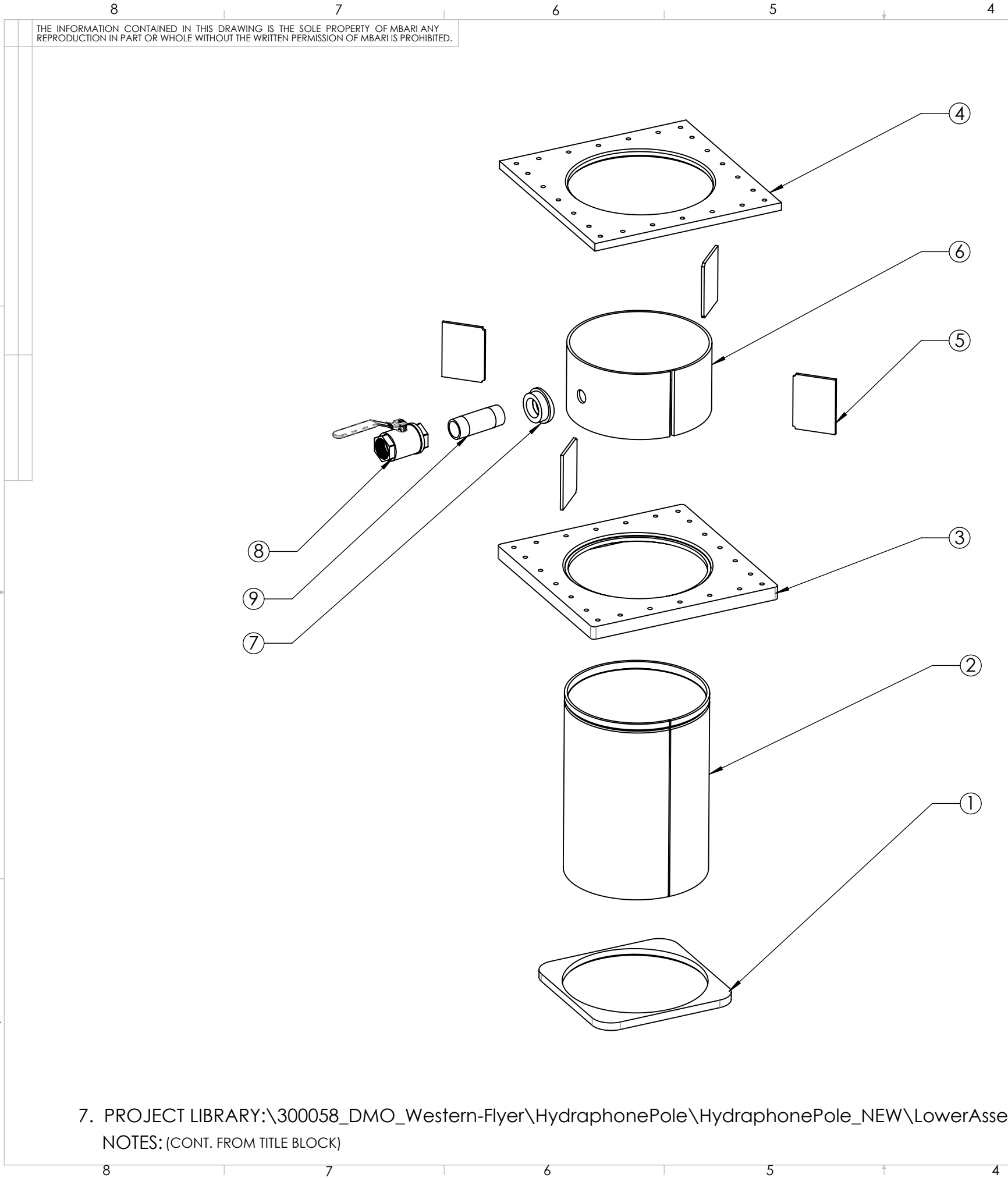


8. FIELD WELD PRE-ASSEMBLED BOSS, NIPPLE AND VALVE ASSEMBLY IN ORIENTATION SHOWN.
7. PROJECT LIBRARY:\300058_DMO_Western-Flyer\HydraphonePole\HydraphonePole_NEW\LowerAssem

NOTES: (CONT. FROM TITLE BLOCK)

PART MODIFICATION DWG.

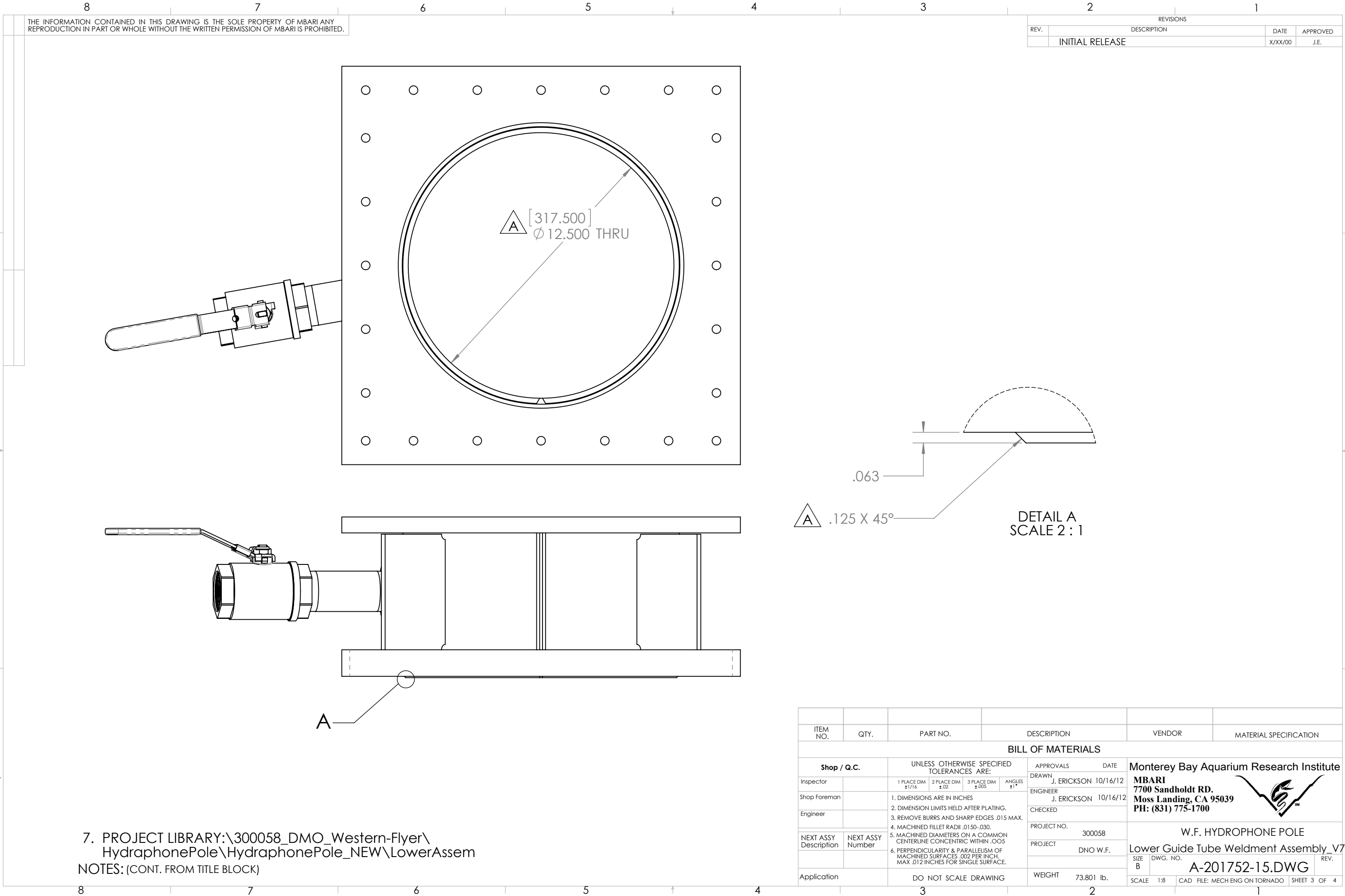
ITEM NO.	QTY.	PART NO.	DESCRIPTION	VENDOR	MATERIAL SPECIFICATION
BILL OF MATERIALS					
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS DATE	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°
Shop Foreman		1. DIMENSIONS ARE IN INCHES		DRAWN J. ERICKSON 10/16/12	
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.		ENGINEER J. ERICKSON 10/16/12	
NEXT ASSY Description		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED	
NEXT ASSY Number		4. MACHINED FILLET RADII .0150-.030.		PROJECT NO. 300058	
Application		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT DMO W.F.	
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX .012 INCHES FOR SINGLE SURFACE.		WEIGHT 73.801	
		DO NOT SCALE DRAWING		Monterey Bay Aquarium Research Institute	
				MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700	
				W.F. Hydrophone Pole	
				Lower Guide Tube Weldment Assembly_V7	
				SIZE B DWG. NO. A-201752-15.DWG	
				SCALE 1:8 CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 4	

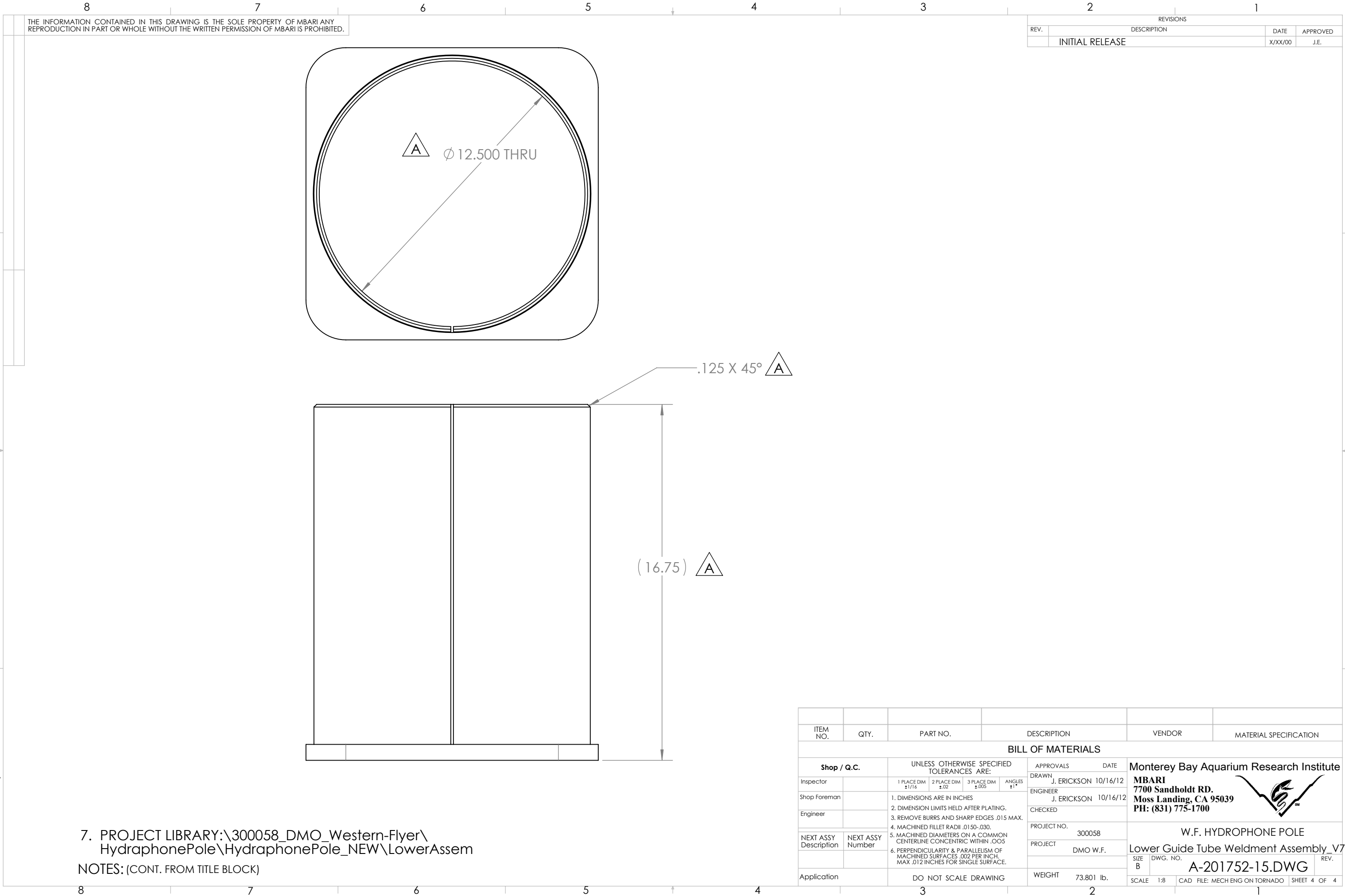


REVISIONS						
REV.	DESCRIPTION				DATE	APPROVED
	INITIAL RELEASE				X/XX/00	J.E.

9	1	xxxxx	1-1/2 Schd 80 Pipe			AISI 316
8	1	96495K25	316 S.S. Ball Valve 1-1/2" Pipe Size		McMaster-Carr	AISI 316
7	1	P-201757-15	Valve Weldment Boss	A	MBARI	5083-(H116)
6	1	P-201758-15	Mid Rolled Plate Valve Ring_V7	A	MBARI	5083-(H116)
5	4	P-201756-15	Gusset Plate	A	MBARI	5083-(H116)
4	1	P-201754-15	Lower Assem. - Mounting Flange_V7	A	MBARI	5083-(H116)
3	1	P-201755-15	Hull Main Mounting Flange Plate	A	MBARI	5083-(H116)
2	1	P-201753-15	Bott. Rolled Plate Ring - MnGuideTube_V7	A	MBARI	5083-(H116)
1	1	P-201438-12	Hull Matching Bottom Ring - MnGuideTube	A	MBARI	5083-(H116)
ITEM NO.	QTY.	Part_Number	DESCRIPTION	Revision	Vendor	MATERIAL

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	J. ERICKSON 10/16/12
Shop Foreman		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX. 4. MACHINED FILLET RADII .0150-.030. 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.				ENGINEER	J. ERICKSON 10/16/12
Engineer						CHECKED	
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	30058
		PROJECT	DMO W.F.			Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700	
Application		DO NOT SCALE DRAWING	WEIGHT	73.801 lb.			W.F. HydropHone Pole Lower Guide Tube Weldment Assembly_V7 SIZE B DWG. NO. A-201752-15.DWG REV. A
				SCALE 1:8	CAD FILE: MECH ENG ON TORNADO	SHEET 2 OF 4	





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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/00	J.E.

ITEM NO.	QTY.	PART NO.	DESCRIPTION	VENDOR	MATERIAL SPECIFICATION
BILL OF MATERIALS					
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS	DATE
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	DRAWN	J. ERICKSON 10/16/12
Shop Foreman		3 PLACE DIM ±.005	ANGLES ±1°	ENGINEER	J. ERICKSON 10/16/12
Engineer		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX. 4. MACHINED FILLET RADII .0150-.030. 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.		CHECKED	
NEXT ASSY Description	NEXT ASSY Number			PROJECT NO.	300058
				PROJECT	DMO W.F.
				WEIGHT	73.801 lb.
				SCALE	1:8
				CAD FILE:	MECH ENG ON TORNADO
				SHEET	4 OF 4

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



W.F. HYDROPHONE POLE
Lower Guide Tube Weldment Assembly_V7
SIZE B DWG. NO. A-201752-15.DWG
REV.