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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE		

Part File: \\atlas\ProjectLibrary\machine shop transfer\368000\10021017-Base Frame, 55 Cell battery

6 x $\varnothing$ 0.150 THRU ALL
10-24 UNC THRU ALL

8xR1.000

4xR0.250

4xR5.900

4x
1.840

2x5.219

2x6.317

9.300

2x10.200

2x7.000

9.967

12.800

(14.415)

3.355

SECTION A-A

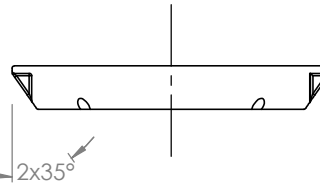
R7.950

2x1.000R

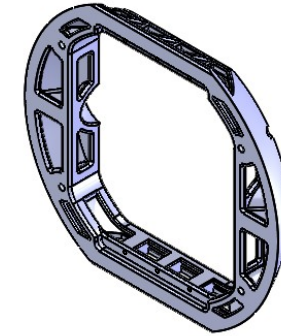
0.328

1.750

1.250



Build Direction



Material:ABS
Resolution:.010

Install Qty 4 Yardley
25020S12-16SS or Equiv

4x $\varnothing$ 0.312 THRU

See Section A-A

Roughen Surface
for bonding to glass sphere

Status:

BILL OF MATERIALS

NEXT ASSY Description		NEXT ASSY Number		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS		DATE	Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700	
				1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±°			
THIRD ANGLE PROJECTION				1. DIMENSIONS ARE IN INCHES		ENGINEER		7/22/2013	Base Frame, 55 Cell Battery	
				2. DIMENSION LIMITS HELD AFTER PLATING.		Hans J Thomas				
				3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED			SCALE 1:5	
				4. MACHINED FILLET RADII .0150-.030.		PROJECT NO.		368000		
				5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT		Battery, Li-Ion, 17in Sphere	DWG. NO. 10021017	
				6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX .012 INCHES FOR SINGLE SURFACE.		WEIGHT				
				DO NOT SCALE DRAWING					SHEET 1 OF 1	