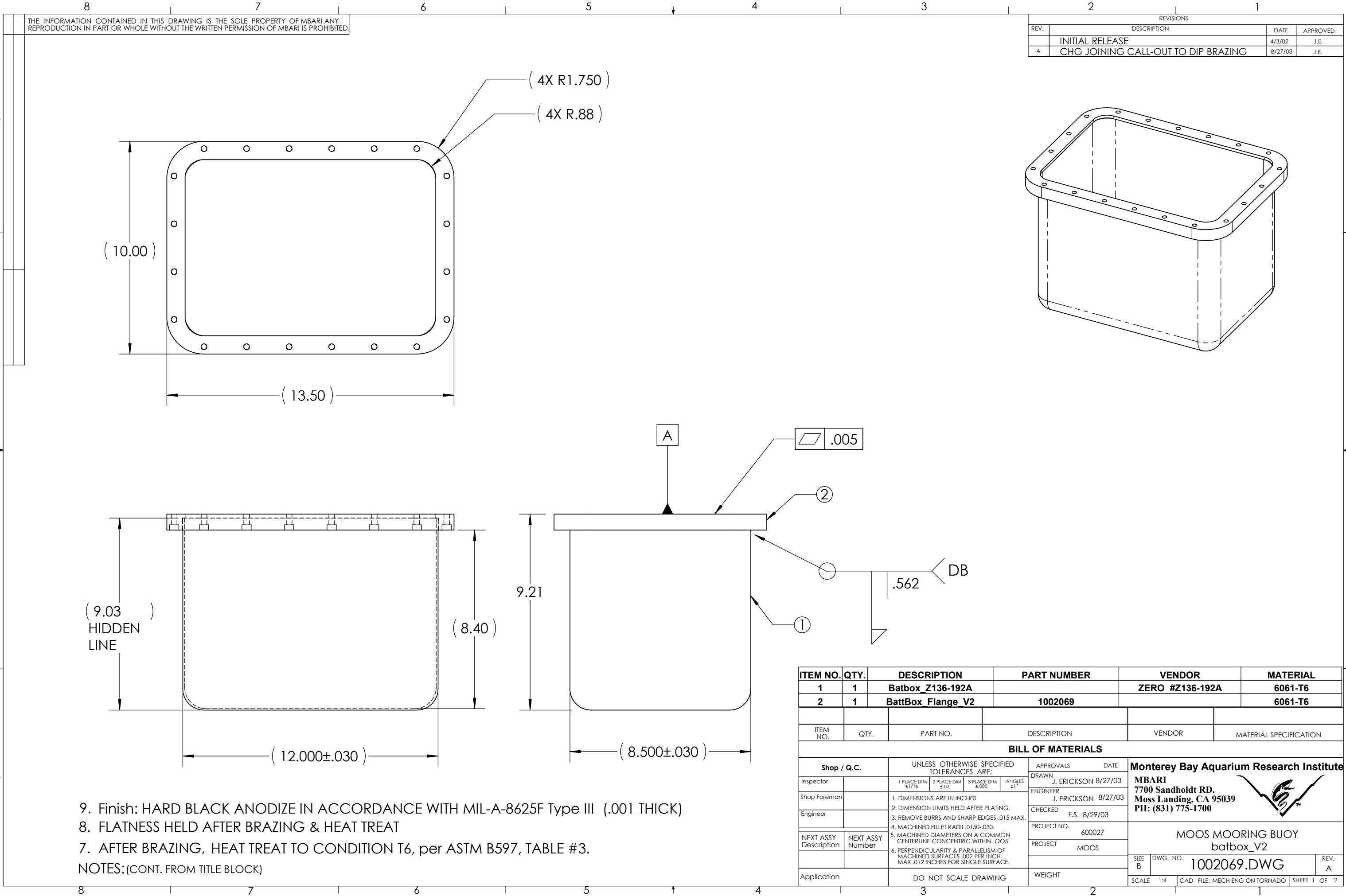




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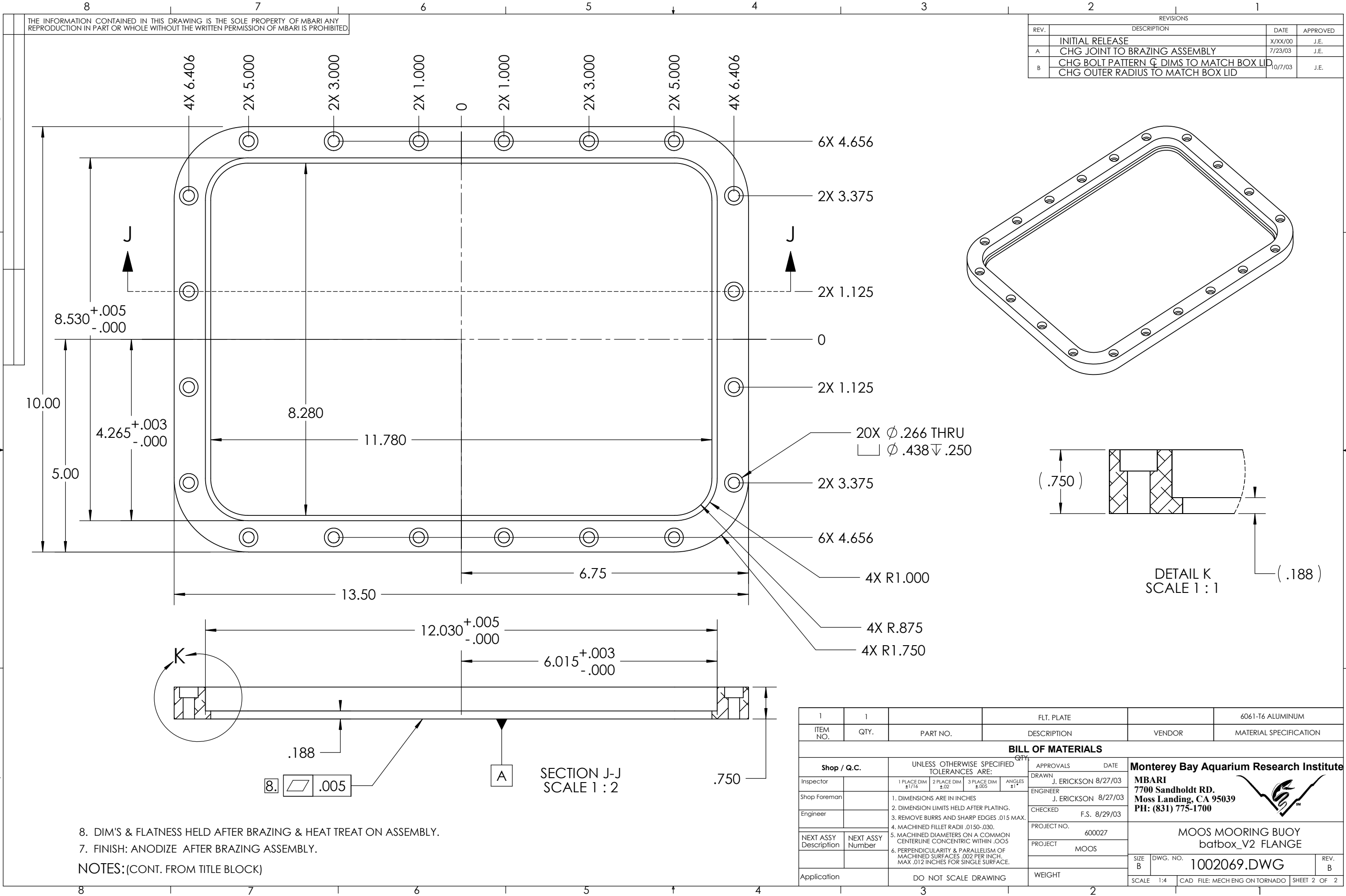
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	4/3/02	J.E.
A	CHG JOINING CALL-OUT TO DIP BRAZING	8/27/03	J.E.

9. Finish: HARD BLACK ANODIZE IN ACCORDANCE WITH MIL-A-8625F Type III (.001 THICK)
8. FLATNESS HELD AFTER BRAZING & HEAT TREAT
7. AFTER BRAZING, HEAT TREAT TO CONDITION T6, per ASTM B597, TABLE #3.
NOTES:(CONT. FROM TITLE BLOCK)

ITEM NO.	QTY.	DESCRIPTION	PART NUMBER	VENDOR	MATERIAL
1	1	Batbox_Z136-192A		ZERO #Z136-192A	6061-T6
2	1	BattBox_Flange_V2	1002069		6061-T6
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			
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.			
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.			
		4. MACHINED FILLET RADII .0150-.030.			
NEXT ASSY Description	NEXT ASSY Number	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	
				SIZE B	DWG. NO. 1002069.DWG
				SCALE 1:4	CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 2

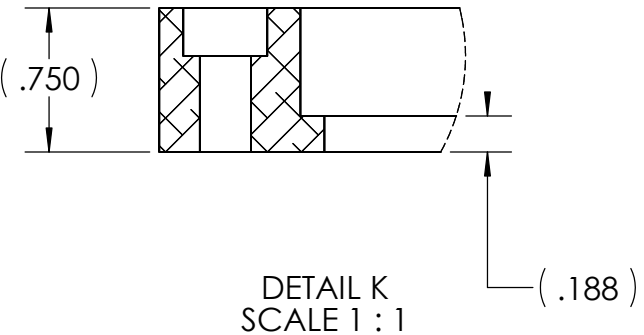
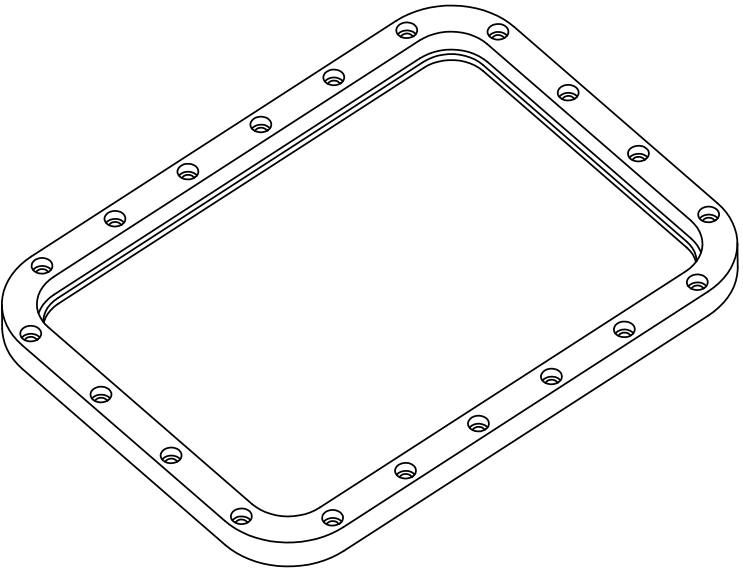
Monterey Bay Aquarium Research Institute
MBARI
7700 Sandholdt RD.
Moss Landing, CA 95039
PH: (831) 775-1700

MOOS MOORING BUOY
batbox_V2



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/00	J.E.
A	CHG JOINT TO BRAZING ASSEMBLY	7/23/03	J.E.
B	CHG BOLT PATTERN & DIMS TO MATCH BOX LID	10/7/03	J.E.
	CHG OUTER RADIUS TO MATCH BOX LID		



8. DIM'S & FLATNESS HELD AFTER BRAZING & HEAT TREAT ON ASSEMBLY.
7. FINISH: ANODIZE AFTER BRAZING ASSEMBLY.
NOTES:(CONT. FROM TITLE BLOCK)

1	1		FLT. PLATE		6061-T6 ALUMINUM
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 8/27/03	
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.		ENGINEER J. ERICKSON 8/27/03	
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED F.S. 8/29/03	
		4. MACHINED FILLET RADII .0150-.030.		PROJECT NO. 600027	
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT MOOS	
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.			
Application		DO NOT SCALE DRAWING		WEIGHT	
			SCALE 1:4		CAD FILE: MECH ENG ON TORNADO
			SHEET 2 OF 2		

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MOOS MOORING BUOY
batbox_V2 FLANGE

1002069.DWG