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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

D
C
B
A

Sample Spool (A1)
PVC-glued spool
Holes in ends clocked
~90° to holes in core

Sample Coil Assembly (A2 and A3)
Sample spool wrapped with
~1000 ft of .047" ID either
Teflon tubing (A2) or
Copper tubing (A3)
Coils should have 9 layers with ~2 to 3 ft
exposed at each end.
Tubing should not be stretched,
kinked or otherwise damaged.

Carefully tape
to spool end
without kinking

PVC glued

Ø .840 stock OD
1/2" Sch 80 pipe
gray PVC pipe

2X Ø .136 thru to $\varnothing$
tap #8-32 UNC-2B

Ø .528 stock ID
thru

.50 both ends

1.50
both ends

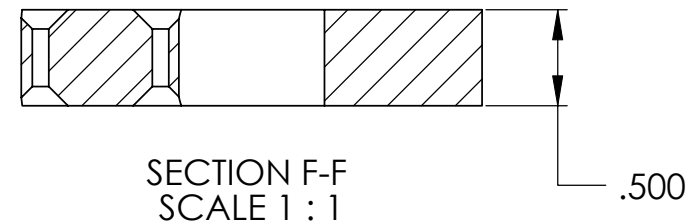
Ø .750
nom. ID
Ø .745
(both ends)

24.75

2X Ø .086 thru
90° ∇ .10
both sides

Ø .758 thru

Ø 2.40
Must easily slide
thru unmachined
2-1/2" PVC pipe



2	2/sp		OS spool end	1/2" PVC plate
1	1/sp		OS spool core	1/2" Sch 80 Gray PVC pipe
A3	1		OS Copper Sample Coil	wound with ~1000 ft of .082/.047 OD/ID copper tubing
A2	1		OS Teflon Sample Coil	wound with ~1000 ft of .082/.047 OD/ID Teflon tubing
A1	1		OS sample spool	Assembly rigidly glued
Item No.	Qty	Part No.	Description	Material Specification

Bill of Materials

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS	DATE	Monterey Bay Aquarium Research Institute	
Inspector		1 PLACE DIM $\pm 1/16$	2 PLACE DIM $\pm .02$	3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$	DRAWN Hans Jannasch	06/12/09	MBARI	
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		7700 Sandholdt RD.	
Engineer						CHECKED		Moss Landing, CA 95039	
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.		PH: (831) 775-1700	
						PROJECT		PVC OsmoSampler Coils	
						NSF OsmoSamplers		(for Juan de Fuca 2009)	
Application						WEIGHT		SIZE B	DWG. NO. 232jaha-pvcOS-JdF-2009
DO NOT SCALE DRAWING		SCALE 1:3		CAD FILE: Tornado/chem/SWfiles		SHEET 1 OF 1		REV.	

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