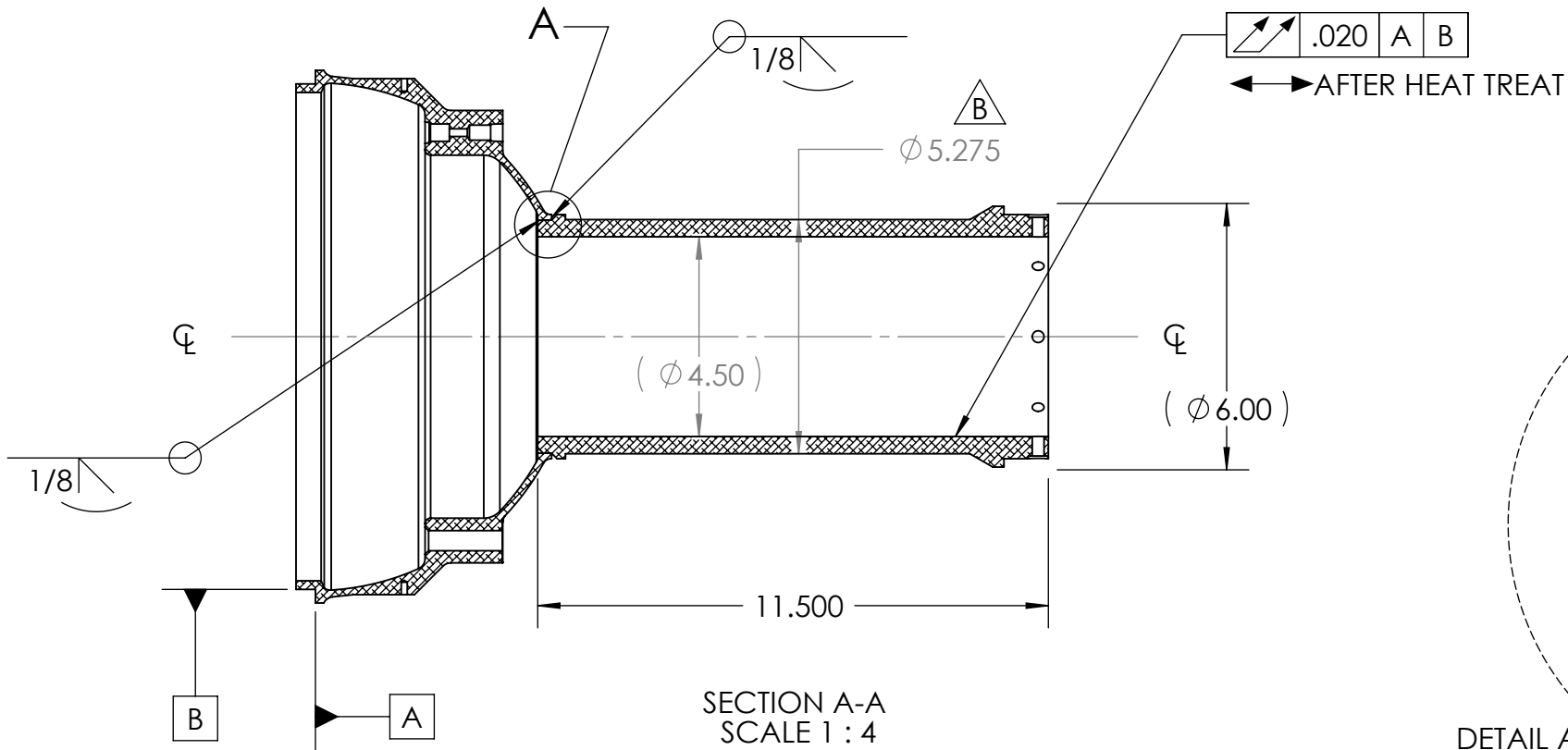
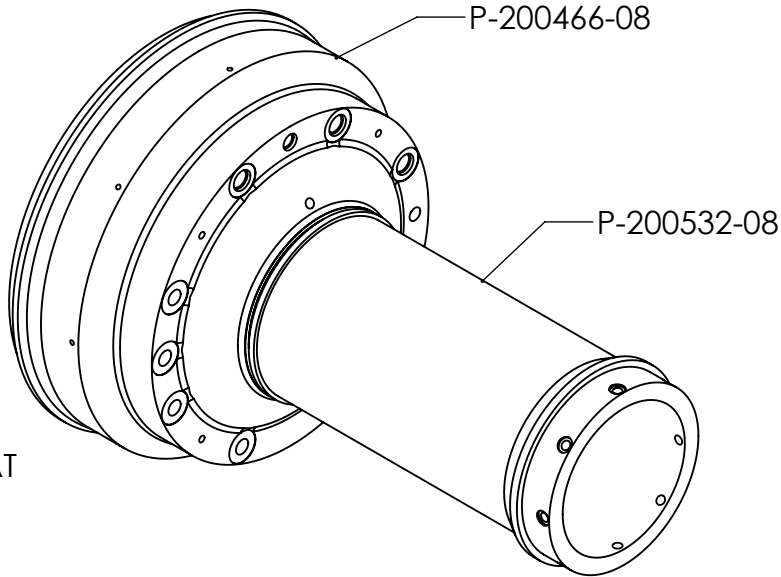
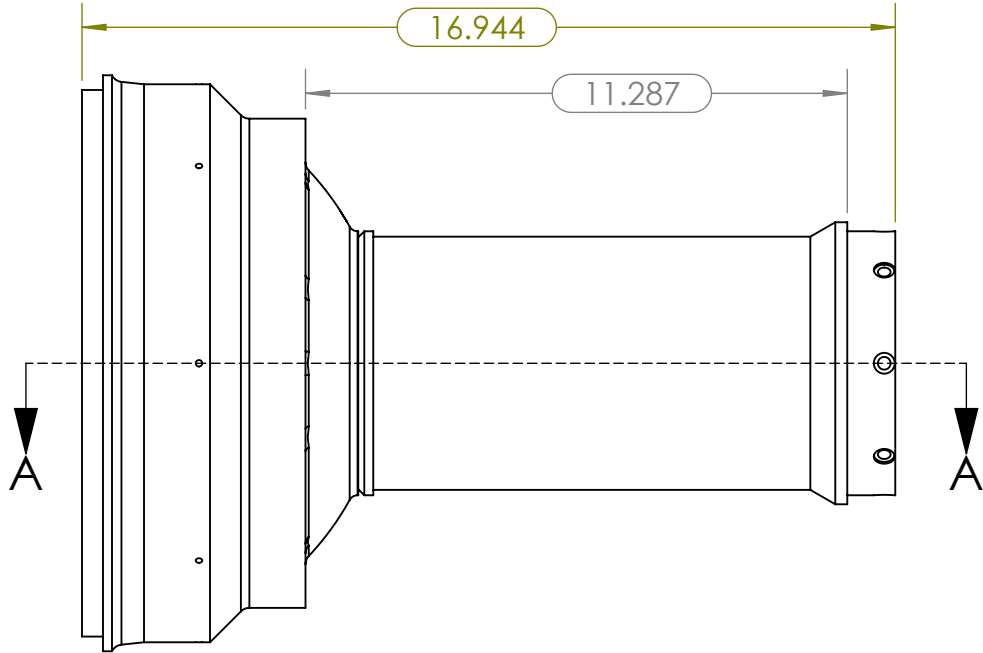
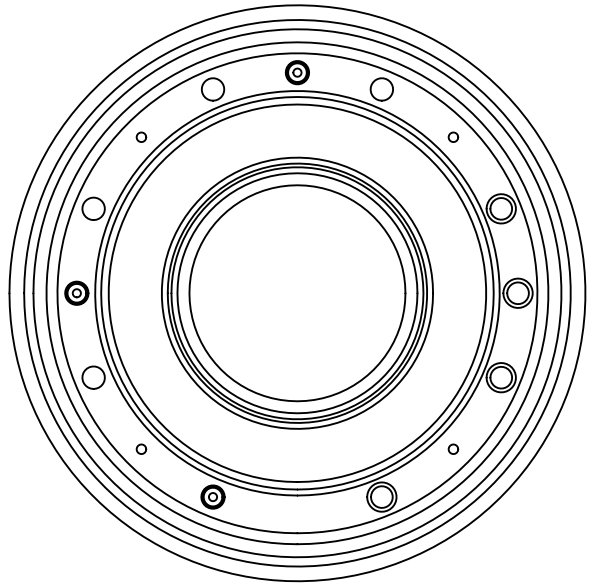


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REVISIONS				
INITIAL RELEASE			X/XX/01	J.E.
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
B8	A	ADDED O-RING CNTR LINE DIM, SHEET 2	1/15/2009	J.E.
C4	B	ADDED TUBE O.D. DIM $\varnothing$ 5.275, SHEET 1, SHEET 2	1/23/2009	J.E.
A8	C	CHG B957 TABLE #3 TO B918-01, TABLE #2	2/6/2009	J.E.
B2	D	CHG. O-RING DIM FRM 5.156 TO 5.166 +.005/-000 (SHEET 2 OF 2)	5/24/2010	J.E.
	E	CHG. ANODIZE MASKING (SHEET 2 OF 2)	4/14/2011	J.E.



SECTION A-A
SCALE 1 : 4

DETAIL A
SCALE 2 : 1

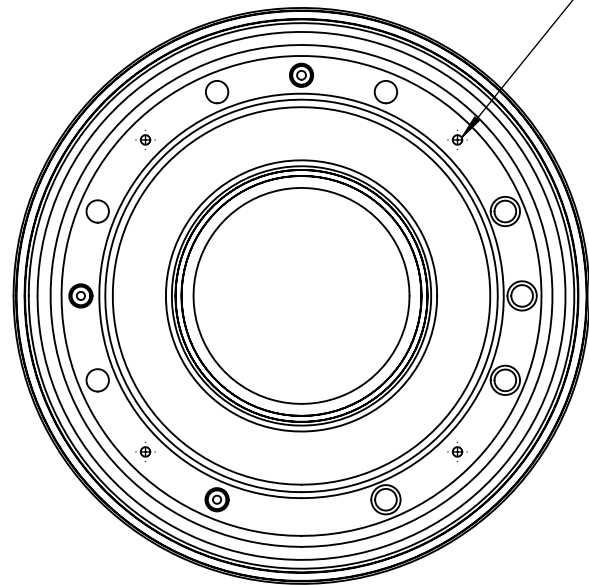
9. Q.C. (INSPECTION) REPORT REQUIRED FOR EACH PIECE.
8. 6061 ALUMINUM WELDMENT: USE 4000 SERIES WELDING ROD. POST WELD HEAT TREAT TO CONDITION T6, per ASTM B918-01, TABLE #2.
7. PROJECT LIBRARY:\900739.LRAUV\Project.Drawings\Project.ME.Dwgs\LRAUV
- NOTES: (CONT. FROM TITLE BLOCK)

BILL OF MATERIALS				
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS
Inspector		1 PLACE DIM $\pm$ 1/16	2 PLACE DIM $\pm$.02	DATE
Shop Foreman		3 PLACE DIM $\pm$.005	ANGLES $\pm$ 1°	DRAWN J. ERICKSON 8/05/08
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.		
NEXT ASSY Description	NEXT ASSY Number	CHECKED R.T. 4/18/08		
		PROJECT NO. 900739		
		PROJECT LRAUV		
Application		WEIGHT 11.45lb.		
		DO NOT SCALE DRAWING		

Monterey Bay Aquarium Research Institute				
MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700				
TETHYS - LRAUV				
Aft Dome / Motor Tube Weldment				
SIZE B	DWG. NO.	A-200578-08.DWG		
SCALE 1:8	CAD FILE: MECH ENG ON TORNADO	SHEET 1	OF 2	REV. E

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



INSIDE VIEW

4X MASK 1/4-20 THREADS [9] E

2X $\phi 11.367^{+.000}_{-.002}$

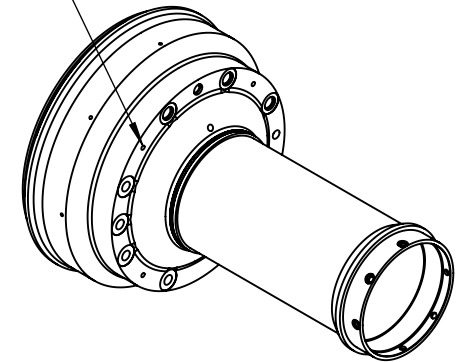
.005 A B

B

B
 $\phi 5.275$

E

[9] 4X MASK 1/4-20 THREADS



DETAIL D
SCALE 1.5 : 1

.031 X 15°

(.056 X 20°)

(.429)

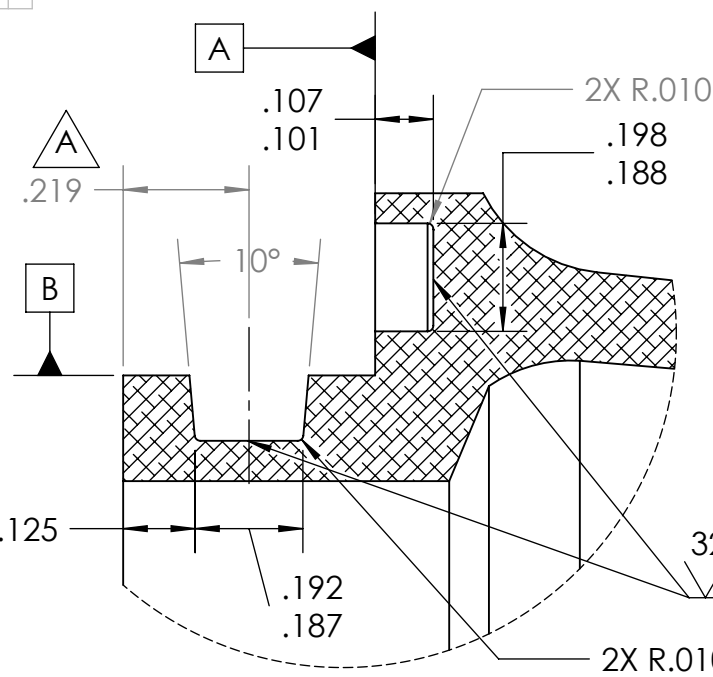
$\phi 5.166^{+.005}_{-.000}$
WELDMENT REV.D

D

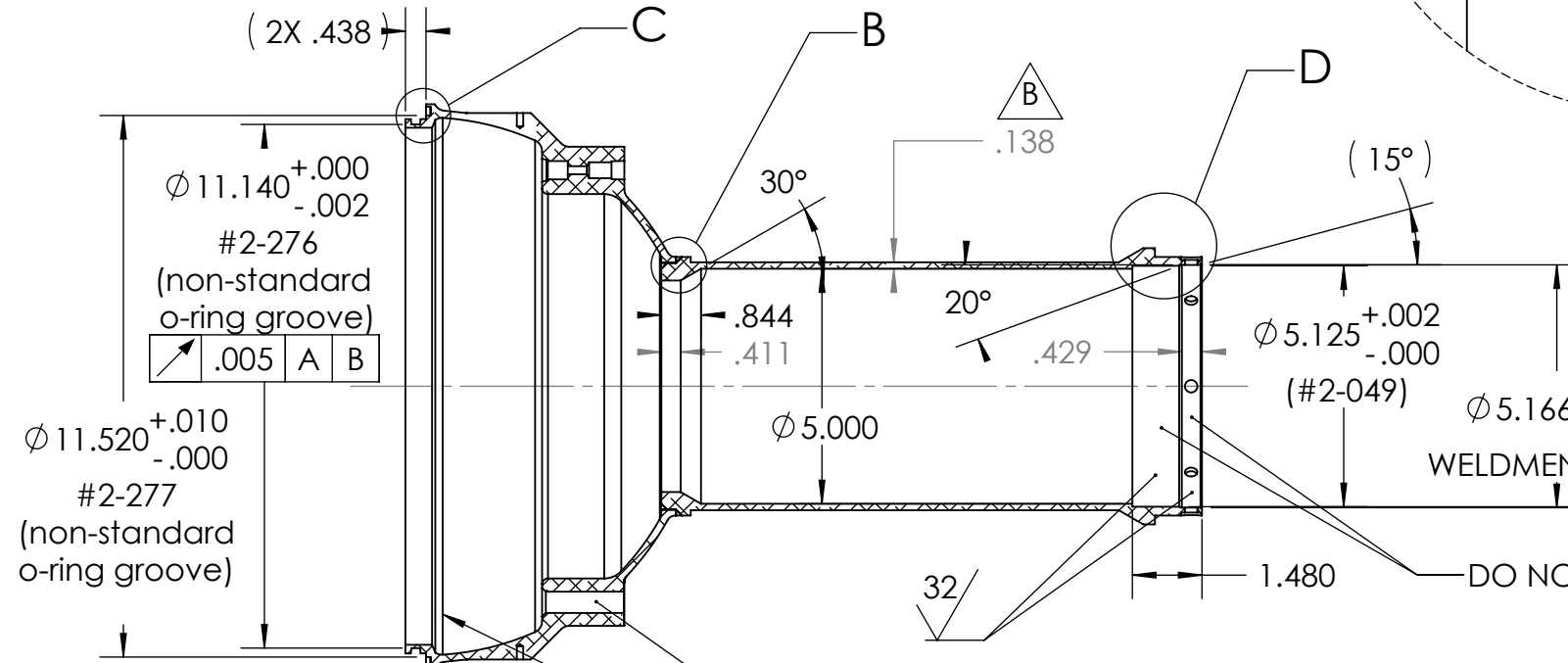
.010 A B

DO NOT RACK THIS SURFACE [9]

SECTION B-B
SCALE 1 : 4

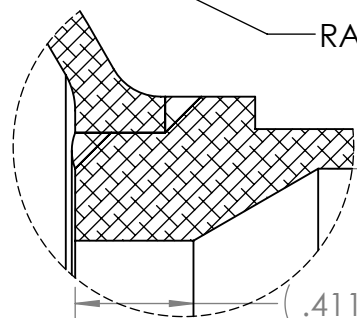


DETAIL C
SCALE 3 : 1



4X DO NOT RACK THIS SURFACE [9]

RACK HERE [9]



DETAIL B
SCALE 1.5 : 1

9. Finish: HARD BLACK ANODIZE IN ACCORDANCE WITH MIL-A-8625F Type III (.001 THICK) MASK SURFACES & FEATURES, RACKING AS NOTED.

8. Q.C. (INSPECTION) REPORT REQUIRED FOR EACH PIECE.

7. PROJECT LIBRARY:\900739.LRAUV\Project.Drawings\Project.ME.Dwgs\LRAUV

NOTES: (CONT. FROM TITLE BLOCK)

BILL OF MATERIALS			
Shop / Q.C.		APPROVALS	DATE
Inspector		DRAWN	J. ERICKSON 8/05/08
Shop Foreman		ENGINEER	J. ERICKSON 8/05/08
Engineer		CHECKED	R.T. 4/18/08
NEXT ASSY Description	NEXT ASSY Number	PROJECT NO.	900739
Application	DO NOT SCALE DRAWING	PROJECT	LRAUV
		WEIGHT	11.45 lb.

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			
1 PLACE DIM $\pm 1/16$	2 PLACE DIM $\pm .02$	3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$
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.			

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Aft Dome / Motor Tube - Final Machining			
SIZE B	DWG. NO. A-200578-08.DWG	REV. E	
SCALE 1:8	CAD FILE: MECH ENG ON TORNADO	SHEET 2 OF 2	