

NOTES UNLESS OTHERWISE SPECIFIED:

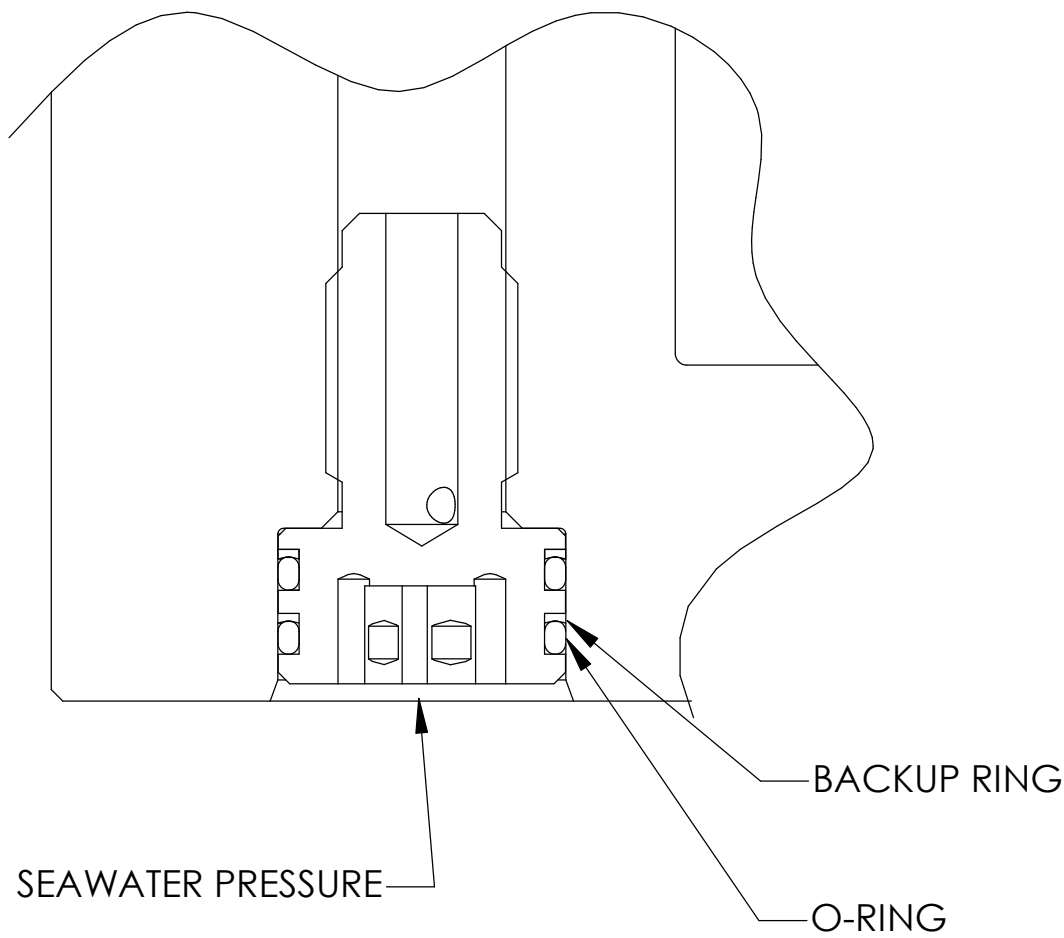
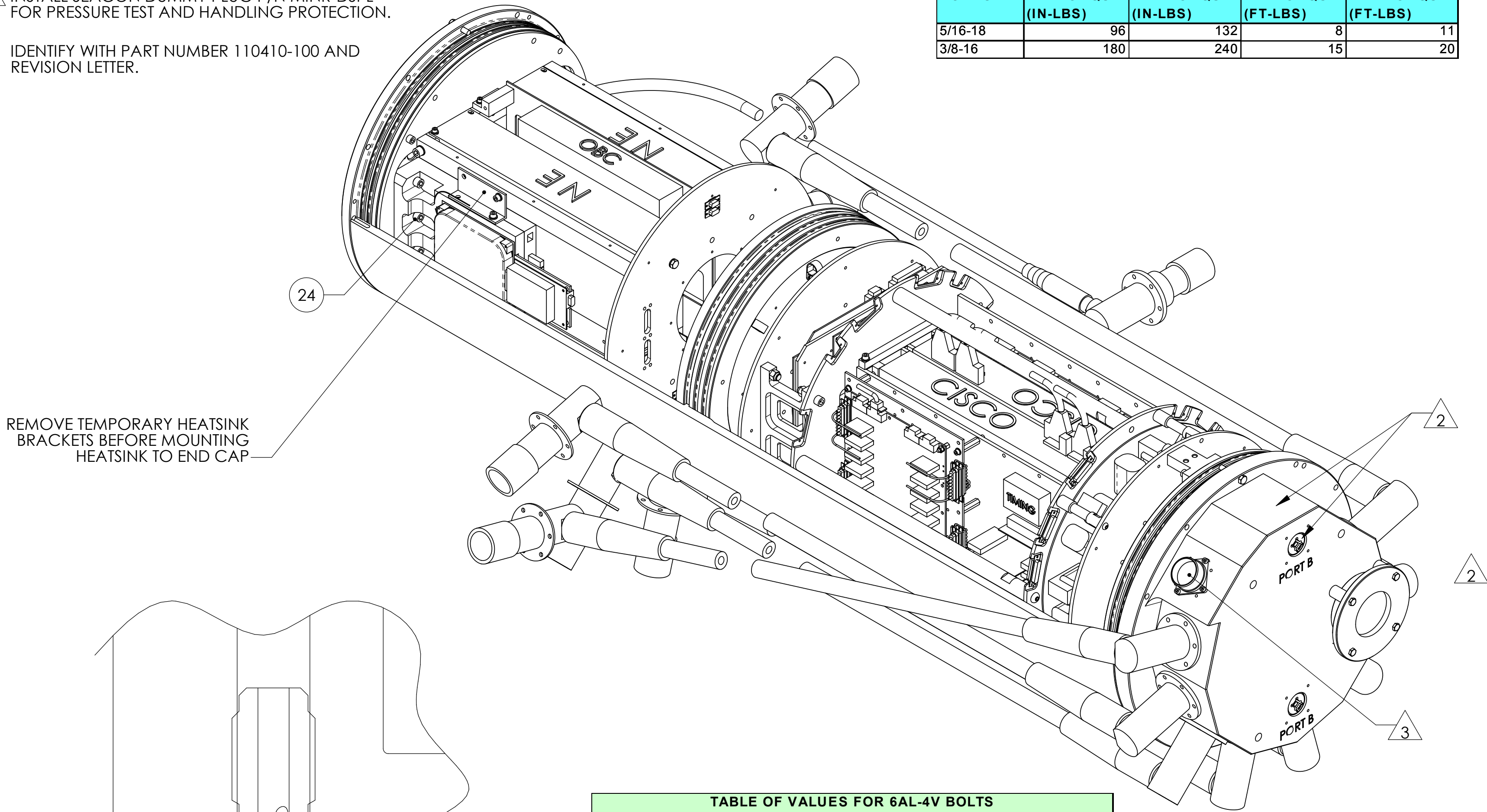
1. USE CASTOR OIL TO LUBE O-RINGS FOR INSTALLATION.

- 2 INSTALL FLUORINERT THRU FILL PORT AND FILL TO THE BOTTOM OF THE PORT WITH THE HOUSING HORIZONTAL LENGTHWISE AND SURFACE INDICATED ALSO HORIZONTAL.

- 3 INSTALL SEACON DUMMY PLUG P/N MINR-DSPL FOR PRESSURE TEST AND HANDLING PROTECTION.

4. IDENTIFY WITH PART NUMBER 110410-100 AND REVISION LETTER.

TABLE OF VALUES FOR ALLOY BOLTS				
BOLT SIZE	MIN TORQUE (IN-LBS)	MAX TORQUE (IN-LBS)	MIN TORQUE (FT-LBS)	MAX TORQUE (FT-LBS)
5/16-18	96	132	8	11
3/8-16	180	240	15	20



TYPICAL O-RING INSTALLATION

TABLE OF VALUES FOR 6AL-4V BOLTS					
BOLT SIZE	MIN TORQUE (IN-LBS)	MAX TORQUE (IN-LBS)	MIN TORQUE (FT-LBS)	MAX TORQUE (FT-LBS)	
M6	47.00	51.00	3.92	4.25	
8 - 32	15.00	16.00	1.25	1.33	
10 - 24	22.00	23.00	1.83	1.92	
1/4 - 20	52.00	56.00	4.33	4.67	
5/16 - 18	106.00	115.00	8.83	9.58	
TABLE OF VALUES FOR CP GRADE 2 BOLTS					
BOLT SIZE	MIN TORQUE (IN-LBS)	MAX TORQUE (IN-LBS)	MIN TORQUE (FT-LBS)	MAX TORQUE (FT-LBS)	
M4	5.00	5.00	0.42	0.42	
8 - 32	5.00	5.00	0.42	0.42	
10 - 24	7.00	8.00	0.58	0.67	
1/4 - 20	17.00	19.00	1.42	1.58	
5/16 - 18	35.00	38.00	2.92	3.17	

45	2-016 E540-80	O-RING, 80 DUROMETER, EP	2
44	8-218 E652-90	BACK-UP RING, 90 DUROMETER, EP	10
43	2-218 E540-80	O-RING, 80 DUROMETER, EP	10
42	1033249	SCIENCE CABLE, ODI 59043 LONG	4
41	1034823	SCIENCE CABLE, ODI 59043 SHORT	4
40	Ti SH SCR M4x0.7 x 12mm LG CP Gr 2	SOC HD SCREW M4x0.7 x 12mm LG TITANIUM CP Gr 2	8
39	Ti SH SCR M6x1.0 x 12mm LG 6AL-4V	SOC HD SCREW M6x1.0 x 12mm LG Titanium 6AL-4V	48
38	Ti SH SCR .190-24UNC X .38 LG 6AL-4V	SOC HD SCREW .190-24 X .38 LG Titanium 6AL-4V	4
37	Ti HH SCR .312-18UNCX1.75 6AL-4V	TITANIUM HEX HEAD CAP SCREW 5/16-18 UNC X 1.75L, 6AL-4V	12
36	Ti HH SCR .312-18UNCX1.25 6AL-4V	HEX HEAD CAP SCREW 5/16-18 UNC X 1.25L, 6AL-4V Ti	12
ITEM NO.	PART NUMBER	DESCRIPTION	110410 FOR DRAWING/QTY.

SOLIDWORKS FILE: 110410 SH 1 REV A

35	91251A197	SOC HD SCREW .164-32 X .75 LG ALLOY McMASTER	2
34	91251A580	SOC HD SCREW 5/16-18 X 5/8 LG ALLOY McMASTER	8
33	91259A707	SOC HD SHOULDER SCREW, 1/2 DIA X 1/2 LG ALLOY 3/8-16 McMASTER	3
32	91251A585	SOC HD SCREW .312-18 X 1.25 LG ALLOY McMASTER	6
31	8876T52	CABLE CLAMP, NYLON, 1 1/4 DIA McMASTER-CARR	20
30	91831A009	8-32 LOCK NUT, SS McMASTER	100
29	91400A197	SCREW, PAN HD PHILLIPS, #8-32 X 3/4" LG SS McMASTER-CARR	100
28	98019A325	WASHER, FLAT, #8, SS, MIL SPEC -807	100
28	8876T33	CABLE CLAMP, NYLON, 3/4 DIA McMASTER-CARR	20
26	2-464 B612-70	O-RING, 70 DUROMETER - BUTYL	4
25	8-464 E652-90	BACKUP RING, 90 DURO, EP	4
24	91251A628	SOC HD SCREW .375-16 X 1.50 LG ALLOY McMASTER	6
23	98017A200	FLAT WASHER, MIL SPEC #C616, .625 OD X .390 ID X .06 THK	6
22	OFTGS-1-05-YY	OPTICAL FIBRE GRIPPER SADDLE	1
21	Ti HH SCR.250-20UNCX1.75L,6AL-4V	SCREW, HEX HEAD, .250-20UNC X 1.75, TITANIUM 6AL-4V	4
20	Ti HH SCR.250-20UNCX1.75L, CP GR 2	SCREW, HEX HEAD, .250-20UNC X 1.75 LG TITANIUM CP GR 2	4
19	FC-77	"DIELECTRIC FLUID, FLUORINERT, 3M CUST FURNISHED" (LV)	1
18	MINR-8FO-6#16-FCRL		1
17	ODI P-N 1033240 (PENETRATOR)	FIBER OPTIC CABLE ASSY, ODI DOCUMENT NO. 59006	1
16	110686-001 XA	RETAINING WASHER, LV POWER CHASSIS	1
15	110682-001 A	THERMAL PAD, HEATSINK, EDFA	2
14	110665-001 XA	MOUNTING BRACKET, LV CHASSIS	3
13	110593-001 XA	FIBER SUPPORT, END CAP	1
12	110550-001 XA	PLUG, LV OPTICAL CONNECTOR	1
11	110525-001 A	SPACER, PROTECTIVE DISK	8
10	110524-001 A	PROTECTIVE DISK	2
9	110522-001 A	PLUG B, FILL PORT - 6AL-4V TITANIUM	2
8	110407-001 A	PLUG A, FILL PORT - C.P. GR. 2 TITANIUM	1
7	110406-001 B	END CAP, COMMS HOUSING	1
6	110405-100 B	END CAP, LV/COMMS HOUSING	1
5	110527-100 A	VALVE ASSEMBLY, PRESSURE RELIEF - C.P. GR 2 TITANIUM BODY	1
4	110531-100 REV A	VALVE ASSEMBLY, PRESSURE RELIEF - 6AL-4V TITANIUM	1
3	110555-100 A	LV POWER ELECTRONICS ASSEMBLY	1
2	110556-100 A	COMMS ELECTRONICS ASSEMBLY	1
1	110563-100 XA	LV POWER/COMMS HOUSING-DIVIDER BULKHEAD SUBASSEMBLY	1
ITEM NO.	PART NUMBER	DESCRIPTION	110410 FOR DRAWING/QTY.

110505	40008/MARS
NEXT ASSY	USED ON
APPLICATION	

DO NOT SCALE DRAWING

INTERPRET DIMENSIONS AND TOLERANCES IAW ASME Y14.5M-1994

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

ANGULAR $\pm .5^\circ$

FRACTION $\pm 1/8$

DECIMAL $.X \pm .06$
 $.XX \pm .03$
 $.XXX \pm .015$

HOLES $< \varnothing .500$ $+006$
 -001

SURFACE ROUGHNESS $125 \sqrt{\text{ }}$

BREAK EDGES .005-.020 CHAMFER OR RADIUS

FILLET RADII .015 MAX

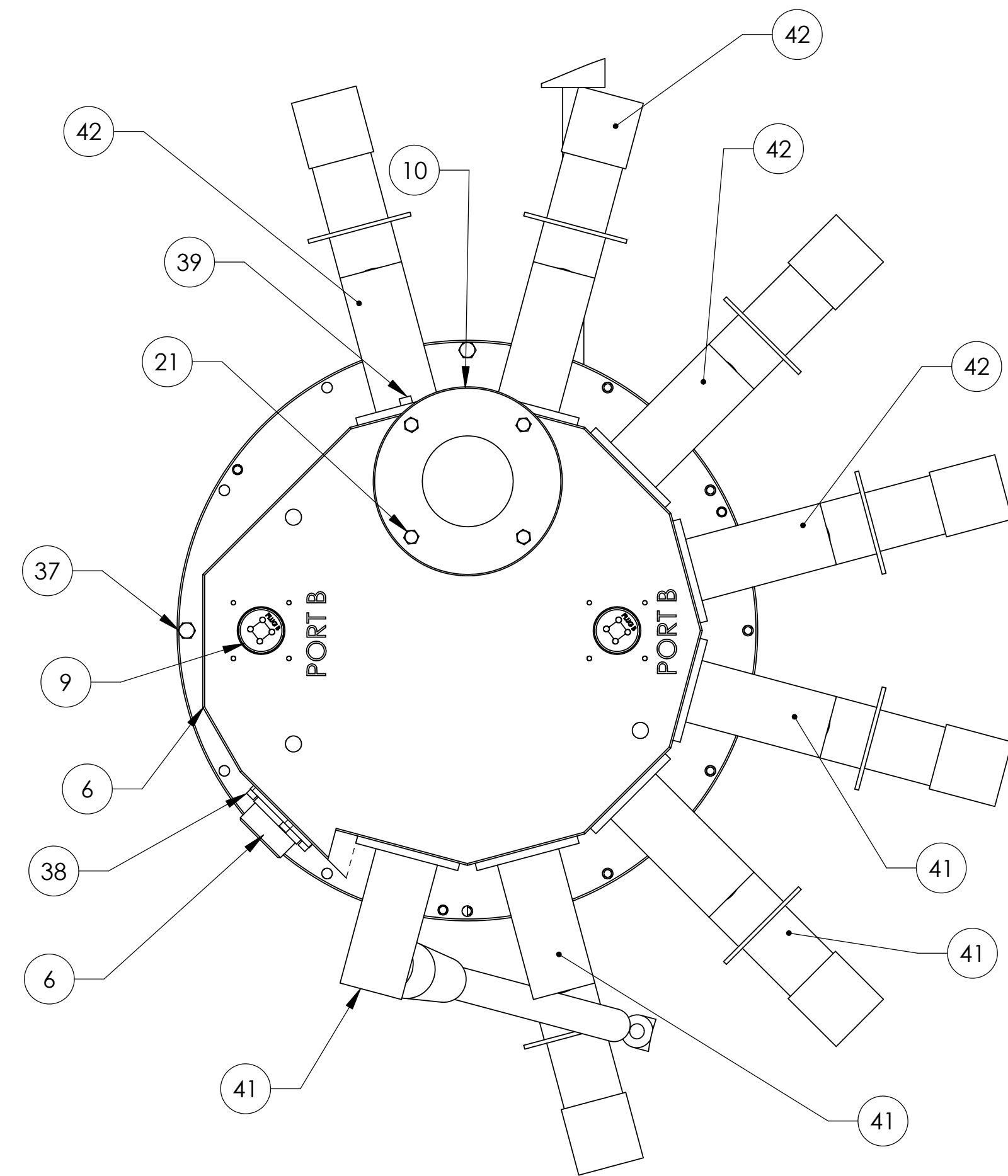
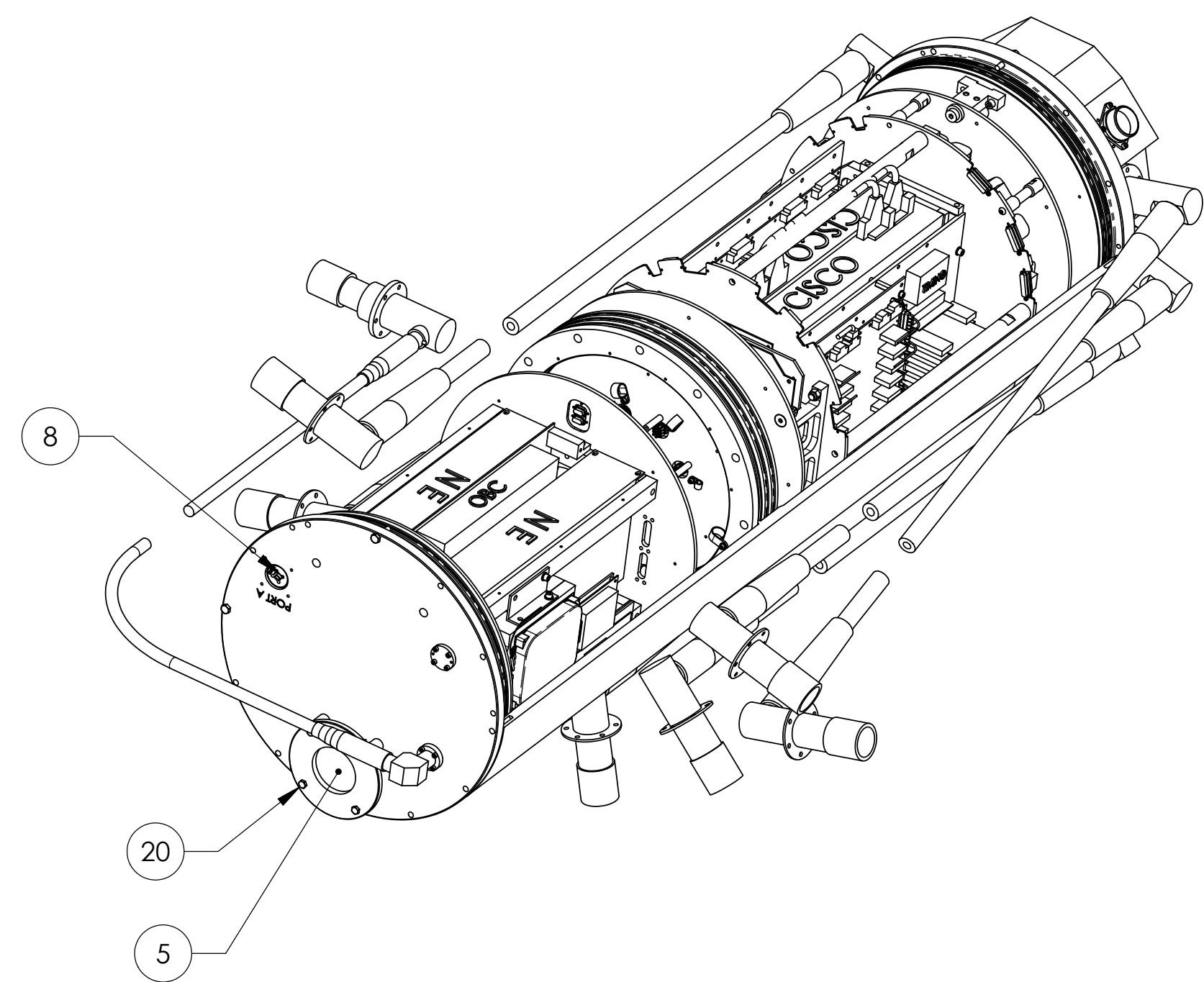
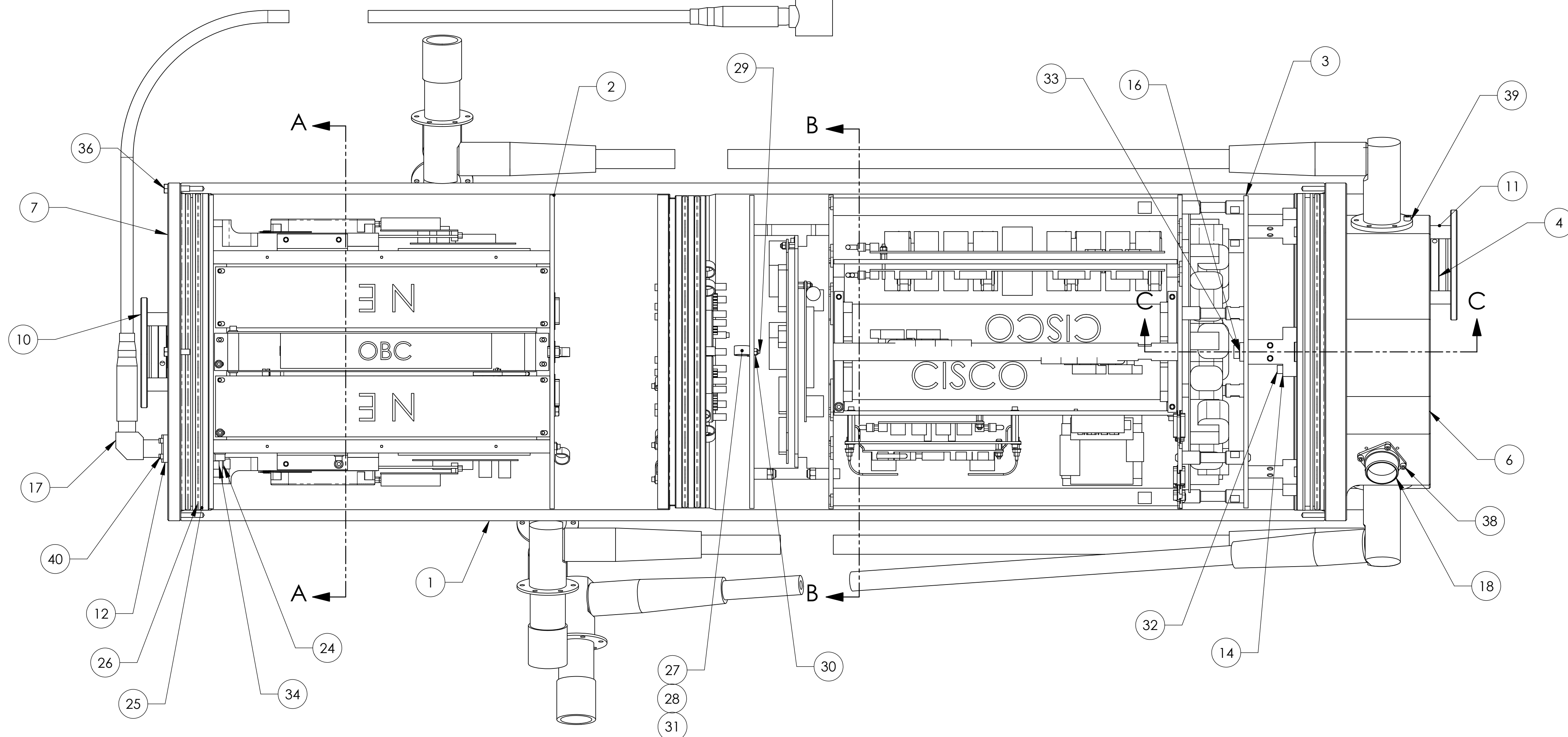
PARTS LIST									
CONTRACT NO.	APPROVALS		DATE						
MATERIAL	DRAWN	TURNER	28 SEP 04		MARS LV POWER/COMMS HOUSING ASSEMBLY				
	CHECKED								
FINISH	ISSUED	KEEFER	21 JAN 05						
			SIZE	CAGE CODE	DWG NO.			REV.	
			D	GT914	110410			B	
	ORIG RELEASE	21 JAN 05	SCALE	1:8			REF: NONE	SHEET	1 OF 1

THICK
WASHER
SHOULDER
SCREW

SECTION A-A

SECTION B-B

SECTION C-C

MARS LV POWER/COMMS
HOUSING ASSEMBLY

USED ON		DRAWN		TURNER 28 SEP 04		SIZE		CAGE CODE		DWG NO.		REV.	
40008/MARS		ISSUED		KEEFER 21 JAN 05		D		6T914		110410		B	
						SCALE		1:4		REF: NONE		SHEET	
												2	