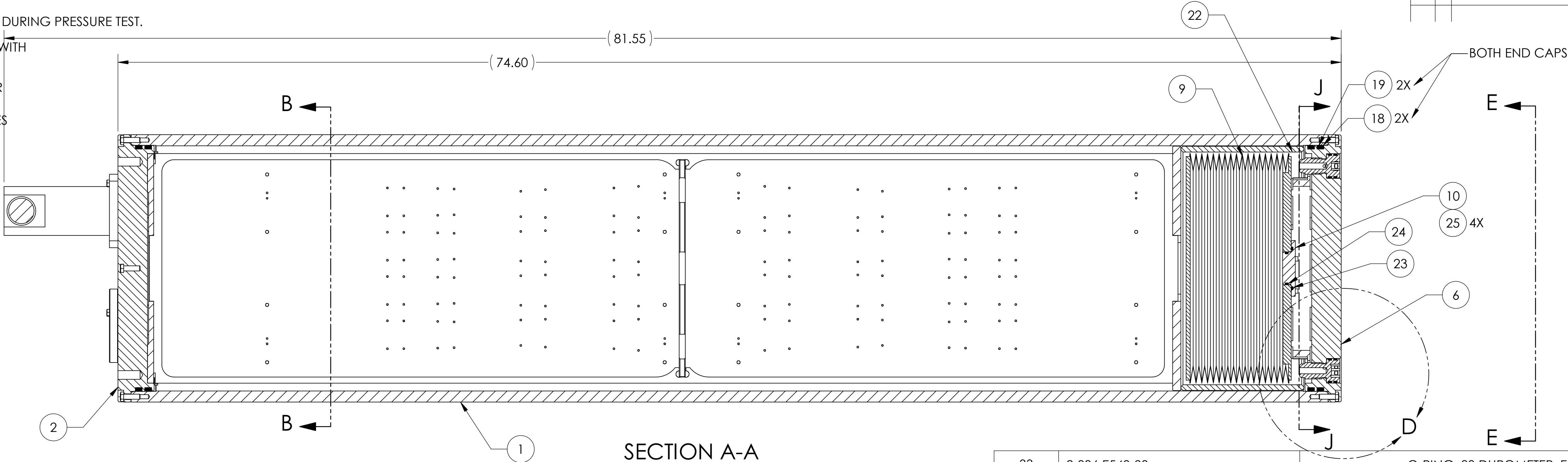
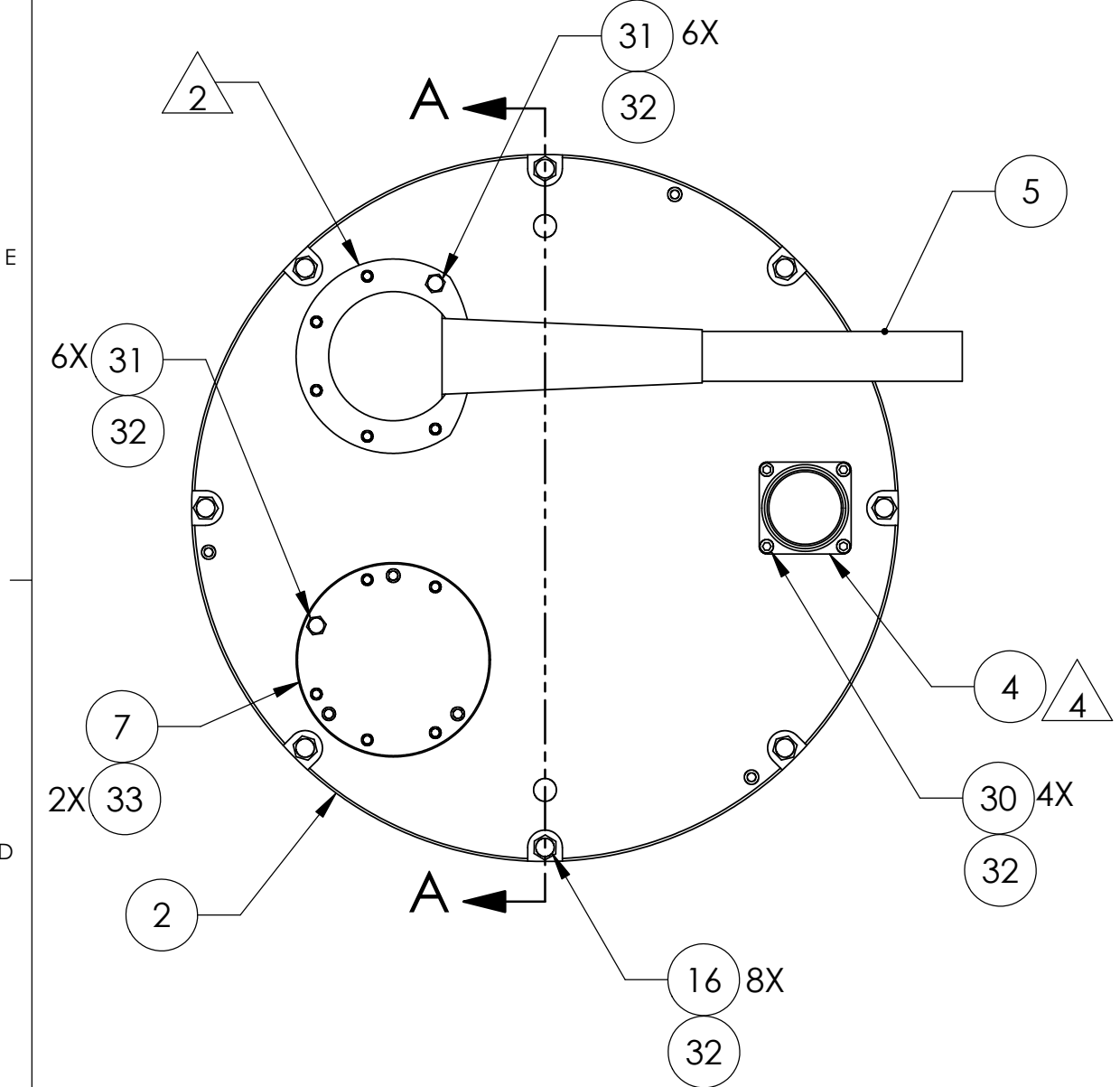


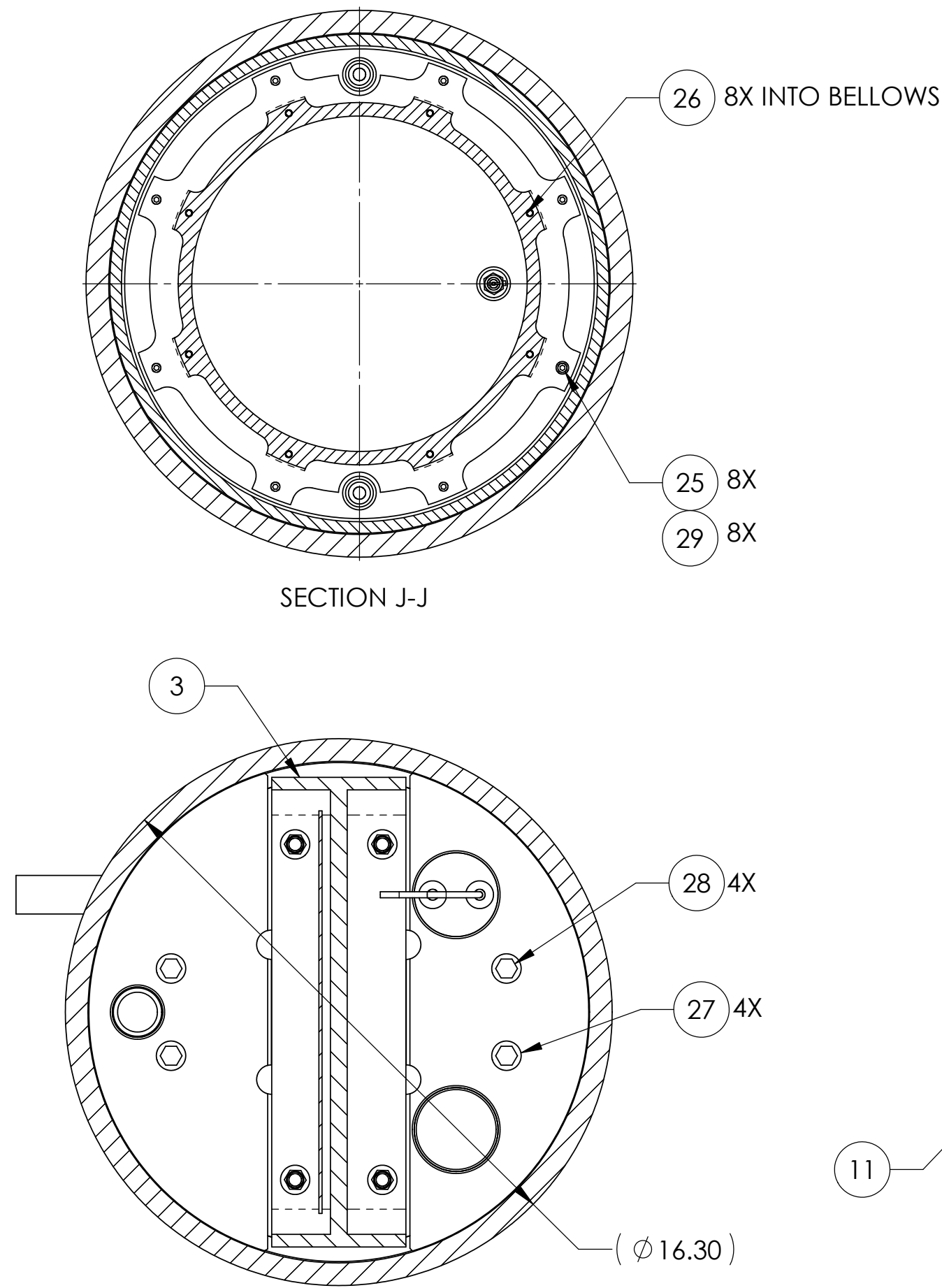
- NOTES UNLESS OTHERWISE SPECIFIED:
- ITEM 8, BELLOWS, TO BE SET TO A FIXED LENGTH AND SEALED PER MANUFACTURING ROUTING SPECIFICATION MR110418.
 - INSTALL P/N 110536-001 TEST PLUG IN PLACE OF PENETRATOR DURING PRESSURE TEST.
 - USE P/N 110549 FC77 FILL SYSTEM ADAPTER TO FILL HOUSING WITH DIELECTRIC FLUID.
 - INSTALL SEACON DUMMY SEALING PLUG P/N MINR-DSPL FOR PRESSURE TEST AND HANDLING PROTECTION.
 - THIS PART IS INCLUDED IN PARTS LIST FOR ASSEMBLY PURPOSES ONLY AND IS PURCHASED UNDER SP110504 AND HAS WIRES ATTACHED FROM SUPPLIER.
 - IDENTIFY WITH PART NUMBER 110418-100 AND REVISION LETTER.



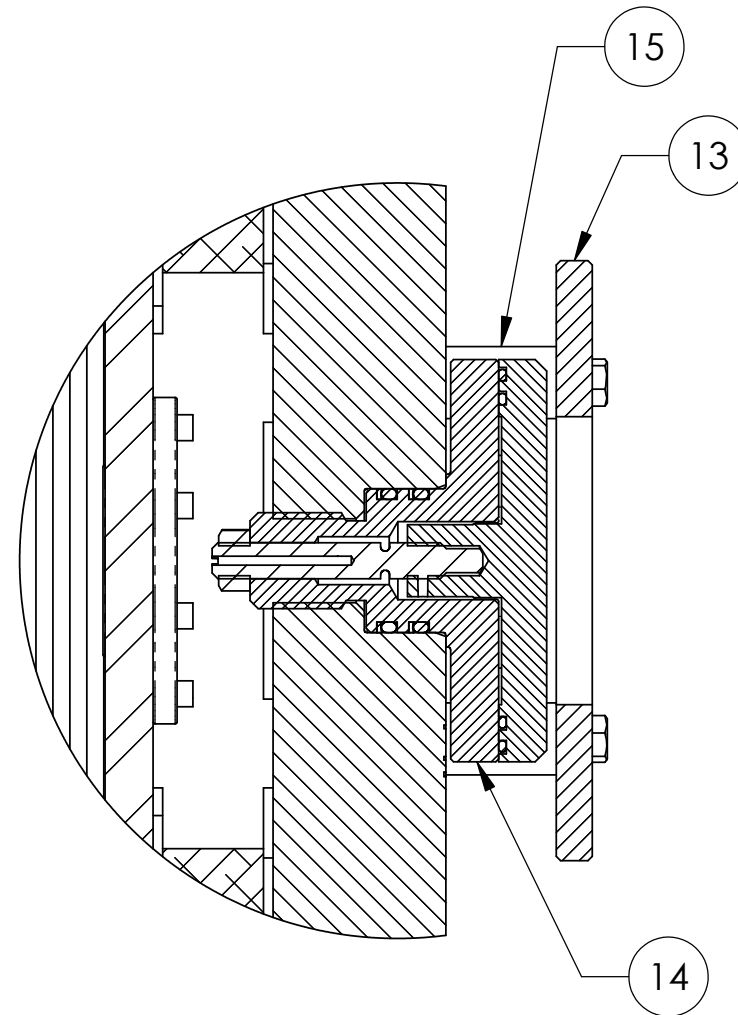
SECTION A-A



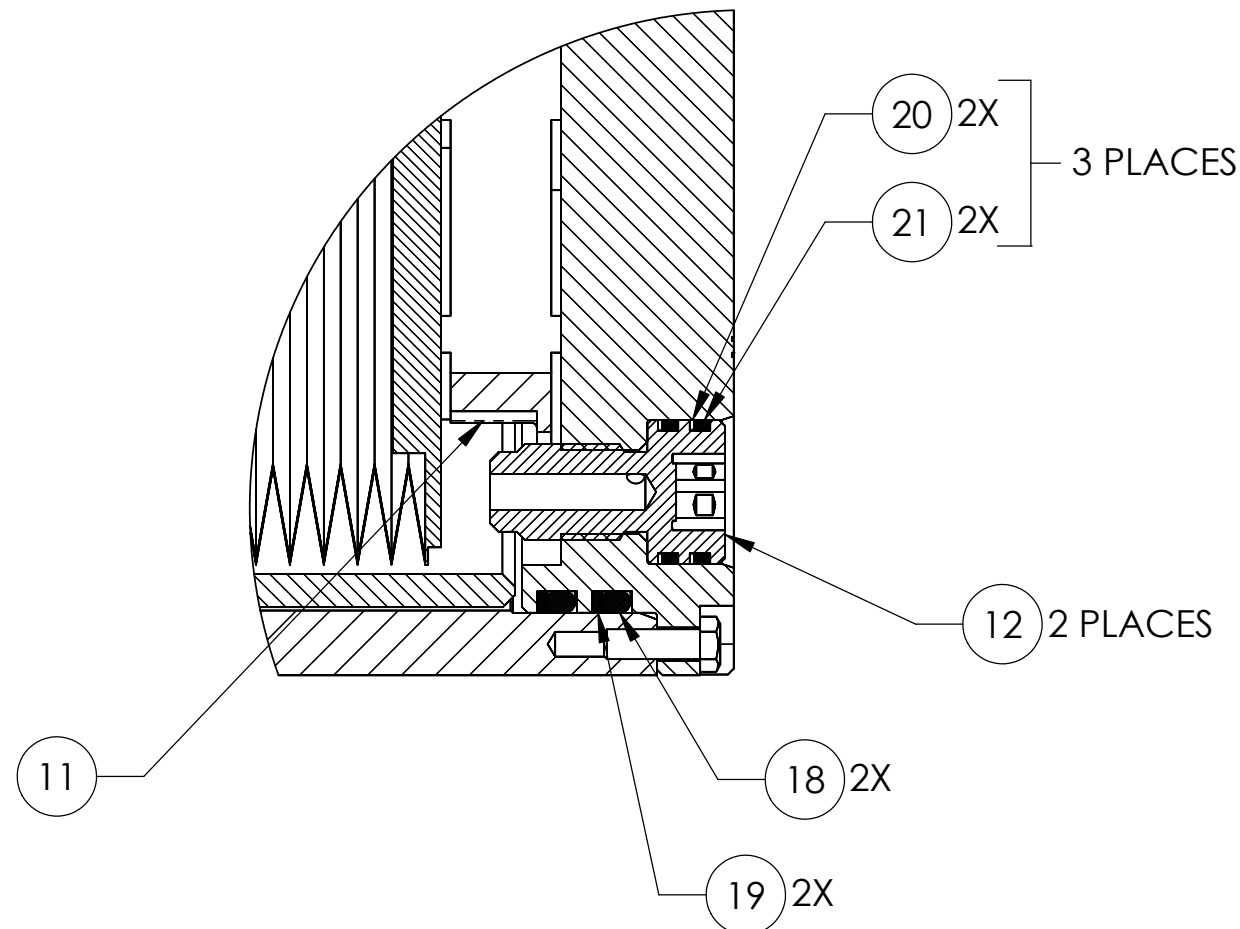
SECTION J-J



SECTION B-B



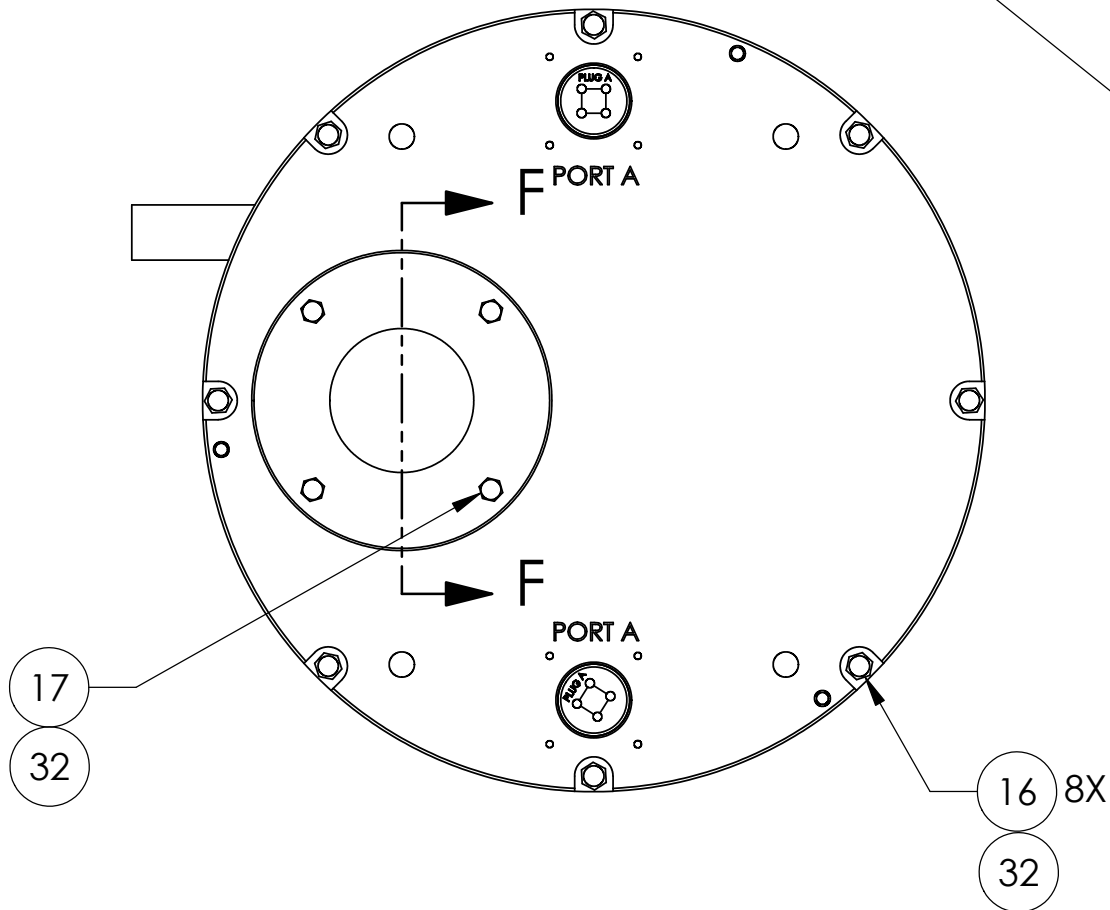
SECTION F-F
SCALE 1 : 2



DETAIL D
SCALE 1 : 2

ALTERNATE ACCEPTABLE P/N: 8-457 E652-90

ALTERNATE ACCEPTABLE P/N: 2-457 B612-70



SECTION E-E

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
33	2-036 E540-80	O-RING, 80 DUROMETER, EP	2
32	LOCTITE 242	THREAD LOCKING COMPOUND	1
31	SCREW, HEX HD, M6 X 1 X 20mm LG GR 2 TITANIUM	SCREW, HEX HD, M6 X 1 X 20mm LG CP GR 2 TITANIUM ALLOY	12
30	SCREW, SOC HD, .190-24UNC X .38 LG CP GR 2 TITANIUM	SCREW, SOC HD, .190-24UNC X .38 LG CP GR 2 TITANIUM	4
29	98019A325	WASHER, FLAT, #8, SS, MIL SPEC -807	1
28	92865A624	SCREW, HEX HD, .375-16UNC X 1 LG, GRD 5, MCMMASTER	4
27	92141A031	3/8 FLAT WASHER SS MCMMASTER	4
26	92196A201	SOC HD SCREW .164-32 X .1.25 LG SS MCMMASTER	8
25	91251A194	SOC HD SCREW .164-32 X .500 LG ALLOY STEEL MCMMASTER	12
24	2-224 E540-80	O-RING, 80 DUROMETER, EP	1
23	2-228 E540-80	O-RING, 80 DUROMETER, EP	1
22	110594-001 XA	GUIDE SLEEVE, MV HOUSING BELLOWS	1
21	2-218 E540-80	O-RING, 80 DUROMETER, EP	6
20	8-218 E652-90	BACK-UP RING, 90 DUROMETER, EP	6
19	8-458 E652-90	BACKUP RING, 90 DUROMETER, EP	4
18	2-458 B612-70	O-RING, 70 DUROMETER - BUTYL	4
17	SCREW, HEX HD, .250-20 X 1.75 LG CP GR 2 TITANIUM	SCREW, HEX HD, .250-20 X 1.75 LG CP GR 2 TITANIUM	4
16	SCREW, HEX HD, .312-18UNC X 1 LG 64Ti	SCREW, HEX HD, .312-18UNC X 1" LG 6AL-4V TITANIUM ALLOY	16
15	110525-001 A	SPACER, PROTECTIVE DISK	4
14	110527-100 A	VALVE ASSEMBLY, PRESSURE RELIEF - C.P. GR 2 TITANIUM BODY	1
13	110524-001 A	PROTECTIVE DISK	1
12	110407-001 A	PLUG A, FILL PORT - C.P. GR. 2 TITANIUM	2
11	110519-001 A	MOUNTING FLANGE, BELLOWS	1
10	110510-002 A	FILL PORT PLUG	1
9	110510-100 A	MARS BELLOWS	1
8	FC-77	DIELECTRIC FLUID, FLUORINERT 3M CUSTOMER FURNISHED	1
7	110520-001 A	PLUG, FUTURE MV PENETRATOR	1
6	110417-001 B	END CAP, MV HOUSING BELLOWS END	1
5	ODI P-N 1033241	HI-POWER PENETRATOR, ODI DOCUMENT NO. 59007	1
4	MINR 84-FCRL-PBOF-P	SEACON MINI-CON FCR FLANGED CONNECTOR RECEPTACLE	1
3	110518-100 A	MV POWER ELECTRONICS ASSEMBLY	1
2	110416-001 B	END CAP, MV HOUSING PENETRATOR	1
1	110412-001 C	HOUSING, MV POWER	1

DO NOT SCALE DRAWING
INTERPRET DIMENSIONS AND TOLERANCES IAW ASME Y14.5M-1994
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
ANGULAR ± .5°
FRACTION ± 1/8
DECIMAL .X ± .06 .XX ± .03 .XXX ± .015
HOLES < Ø .500 ± .006 + .006 - .001
SURFACE 125 /
ROUGHNESS
BREAK EDGES .005 - .020
CHAMFER OR RADIUS
FILLET RADII .015 MAX

110505	40008/MARS
NEXT ASSY	USED ON
APPLICATION	

QTY REQD		QTY REQD	FSCM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION						
PARTS LIST											
CONTRACT NO.				APPROVALS	DATE						
SEE PARTS LIST				DRAWN	TURNER	13 AUG 04	MV POWER HOUSING ASSEMBLY				
				CHECKED	P. DEXTER	24 OCT 04					
				ISSUED	KEEFER	28 OCT 04					
FINISH							SIZE	CAGE CODE	DWG NO.	REV.	
							D	6T914	110418	A	
				ORIG RELEASE	28 OCT 04	SCALE		1:4	REF: 110390	SHEET	1 OF 1

REVISIONS			
ZONE	REV.	DESCRIPTION	DATE
	A	INITIAL RELEASE PER ECO 42485	28 OCT 04

110418



MV POWER HOUSING
ASSEMBLY