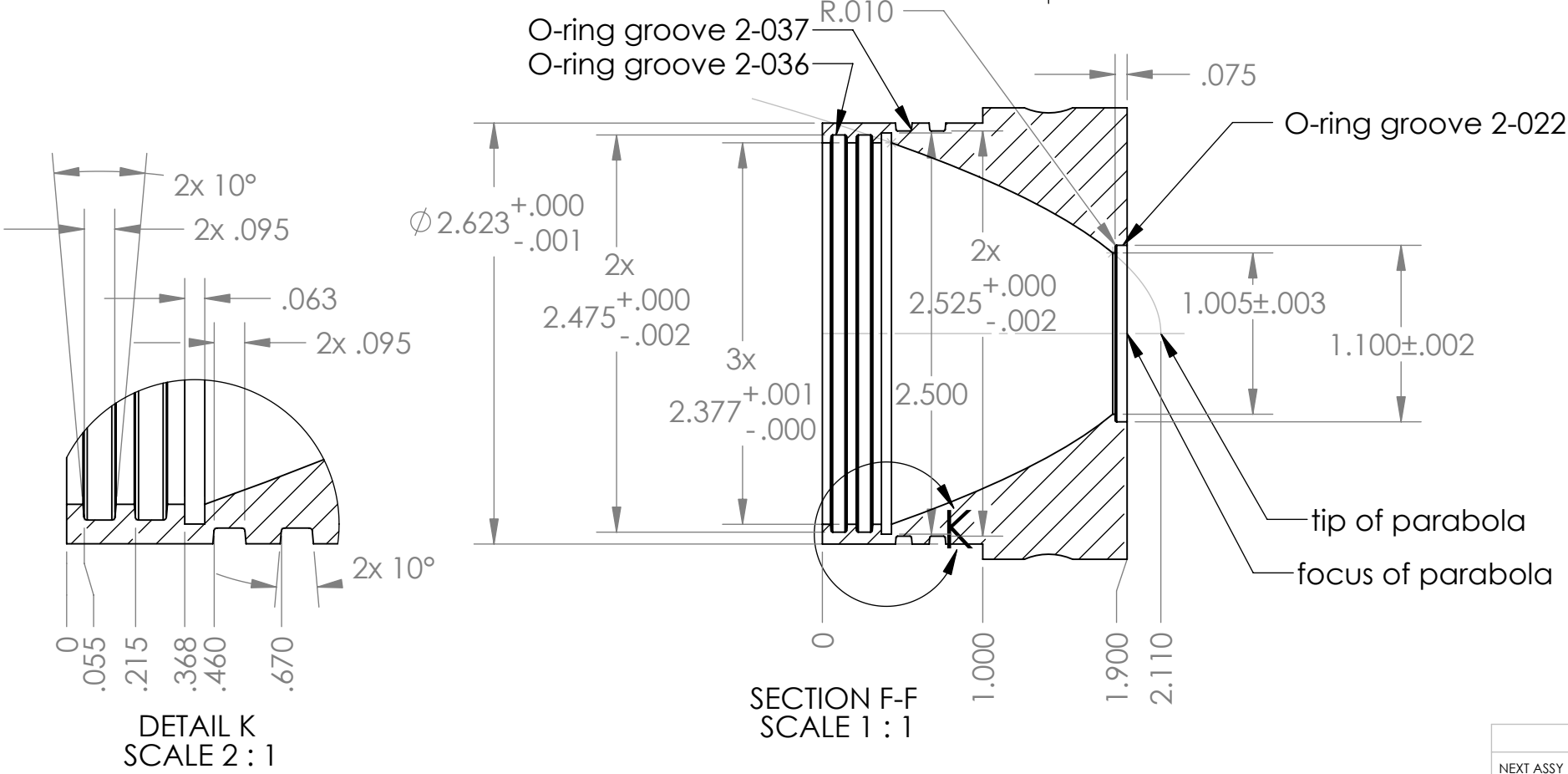
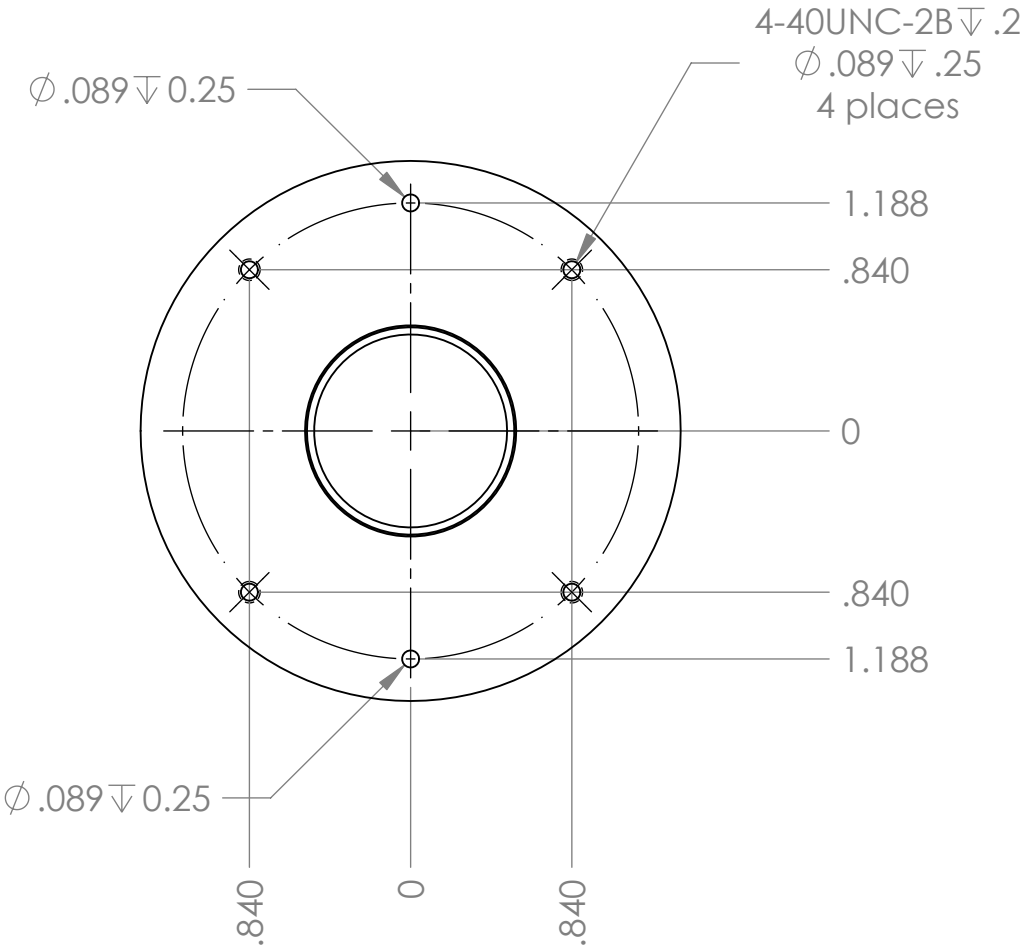
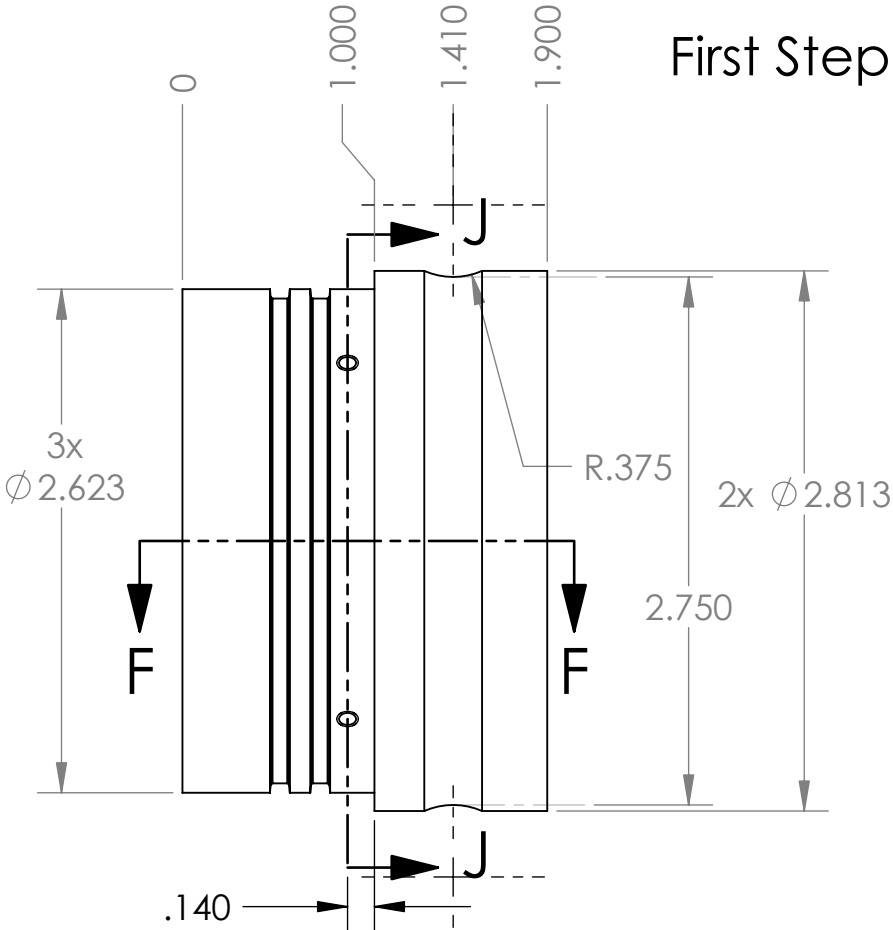
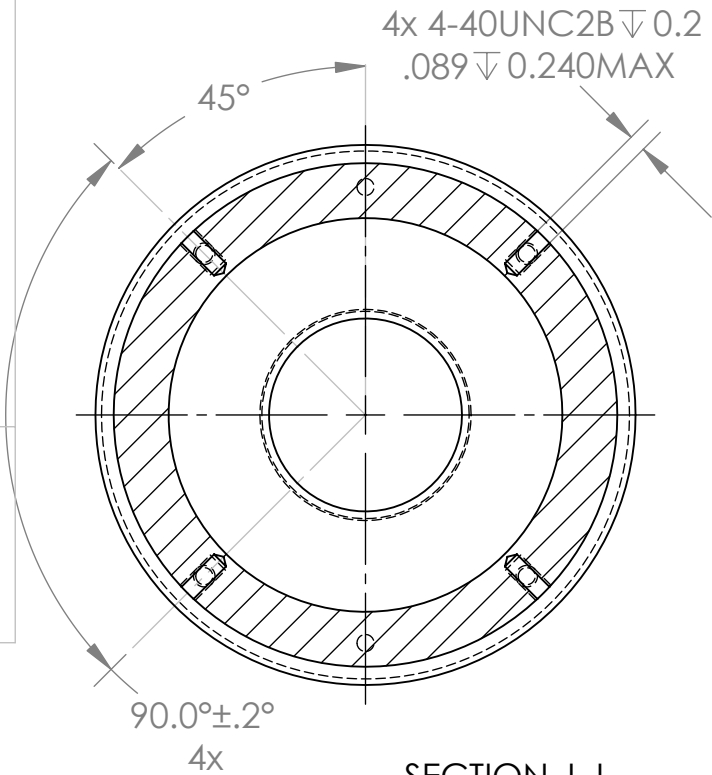


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

First Step - machining

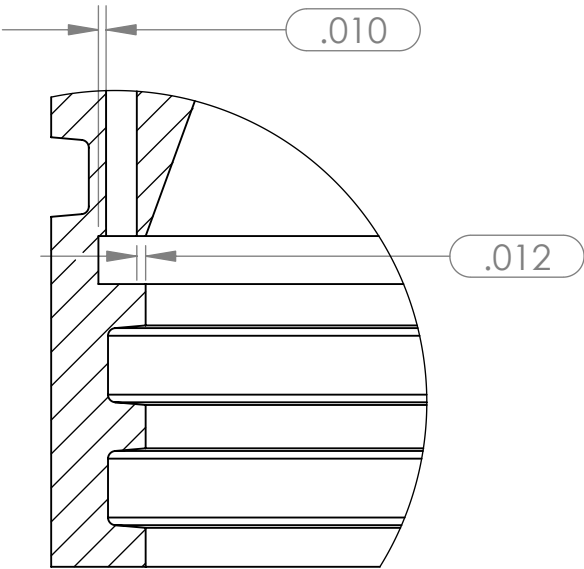
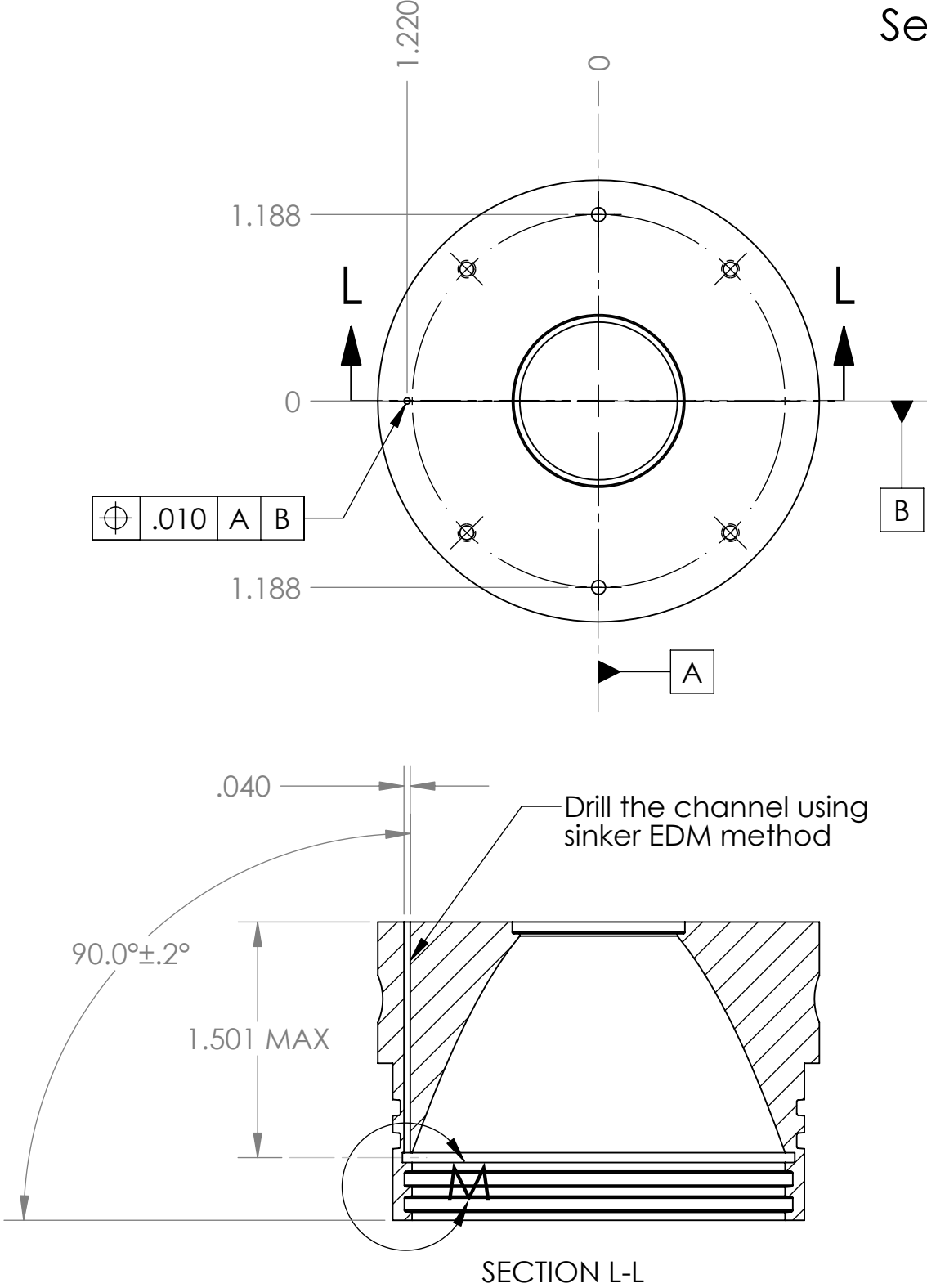


Rev4(5/20/2007): Initial Release for fabrication 2ea

1		1 Ea.		Front Sensor Reflector		6Al-4V Ti					
ITEM NO.		QTY		PART NO.		DESCRIPTION		MATERIAL SPECIFICATION			
BILL OF MATERIALS											
UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE		Monterey Bay Aquarium Research Institute 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (408) 775-1700 1002892-023 - Front Sensor Reflector			
1 PLACE DIM ±1/16		2 PLACE DIM ±.02		3 PLACE DIM ±.005		ANGLES ±1°				DRAWN F. Shane 28Feb07	
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 F. Shane 28Feb07		CHECKED Klimov 5/20/2007				1002892-023 - Front Sensor Reflector	
				PROJECT NO. 900392		PROJECT BIOSA					
DO NOT SCALE DRAWING				WEIGHT		SIZE B		DWG. NO. 1002892-023		REV. 4	
						SCALE 1:4		CAD FILE: Project Library\900392Biosa		SHEET 1 OF 1	

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Second step - EDM drilling

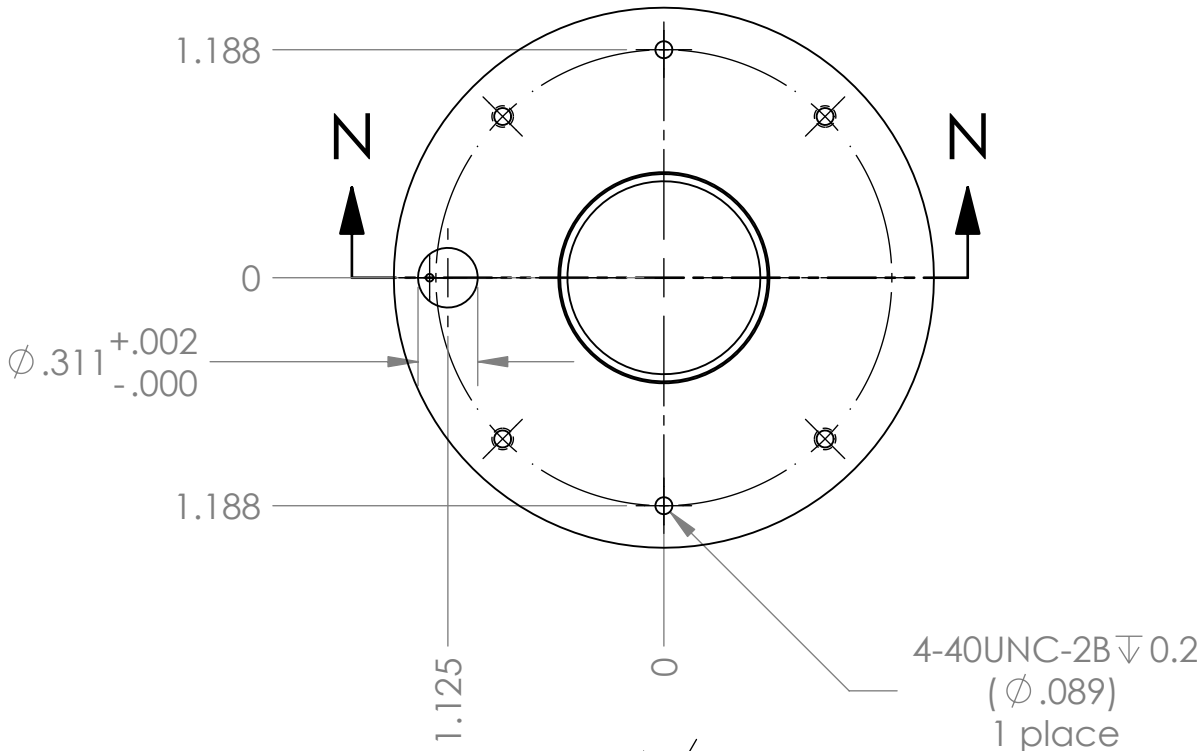


DETAIL M
SCALE 4 : 1

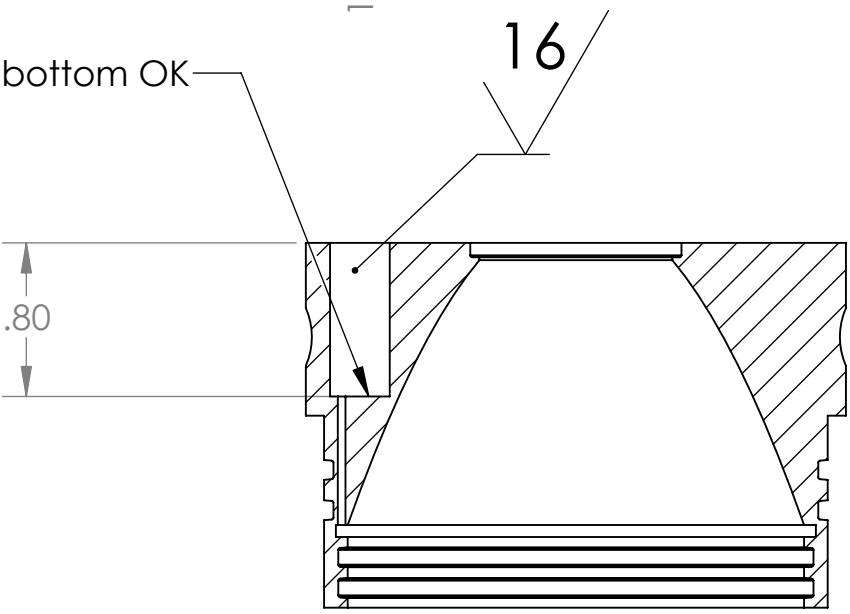
Material: 6Al-4V Ti

Shop / Q.C.	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				INITIAL RELEASE (rev 1)	xx	DATE	Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700		
Inspector	1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN Klimov	xx				
Shop Foreman	1. DIMENSIONS ARE IN INCHES				ENGINEER Klimov	xx/xx/xxxx		DRAWING NAME and MODEL FILE NAME		
Engineer	2. DIMENSION LIMITS HELD AFTER PLATING.				CHECKED			1002892-023 - Front Sensor Reflector		
NEXT ASSY	3. REMOVE BURRS AND SHARP EDGES .015 MAX.				PROJECT NO.	900392		SIZE B	DWG. NO.	REV.
Application	4. MACHINED FILLET RADII .0150-.030.				PROJECT BIOSA				1002892-023	ref
	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005.							SCALE 1:1	WEIGHT	SHEET 2 OF 3
	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.									
	DO NOT SCALE DRAWING									

Third Step - boring the oil compensating cylinder
and tapping 1 hole



End mill bottom OK



SECTION N-N

Shop / Q.C.	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	INITIAL RELEASE (rev 1)	DATE xx	Monterey Bay Aquarium Research Institute		
Inspector	1 PLACE DIM $\pm 1/16$	2 PLACE DIM $\pm .02$	3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$	MBARI	
Shop Foreman	1. DIMENSIONS ARE IN INCHES				7700 Sandholdt RD.	
Engineer	2. DIMENSION LIMITS HELD AFTER PLATING.				Moss Landing, CA 95039	
NEXT ASSY	3. REMOVE BURRS AND SHARP EDGES .015 MAX.				PH: (831) 775-1700	
Application	4. MACHINED FILLET RADII .0150-.030.				DRAWING NAME and MODEL FILE NAME	
	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005.				1002892-023 - Front Sensor Reflector	
	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.				SIZE B	DWG. NO. 1002892-023
	DO NOT SCALE DRAWING				SCALE 1:1	WEIGHT
					SHEET 3 OF 3	REV. ref