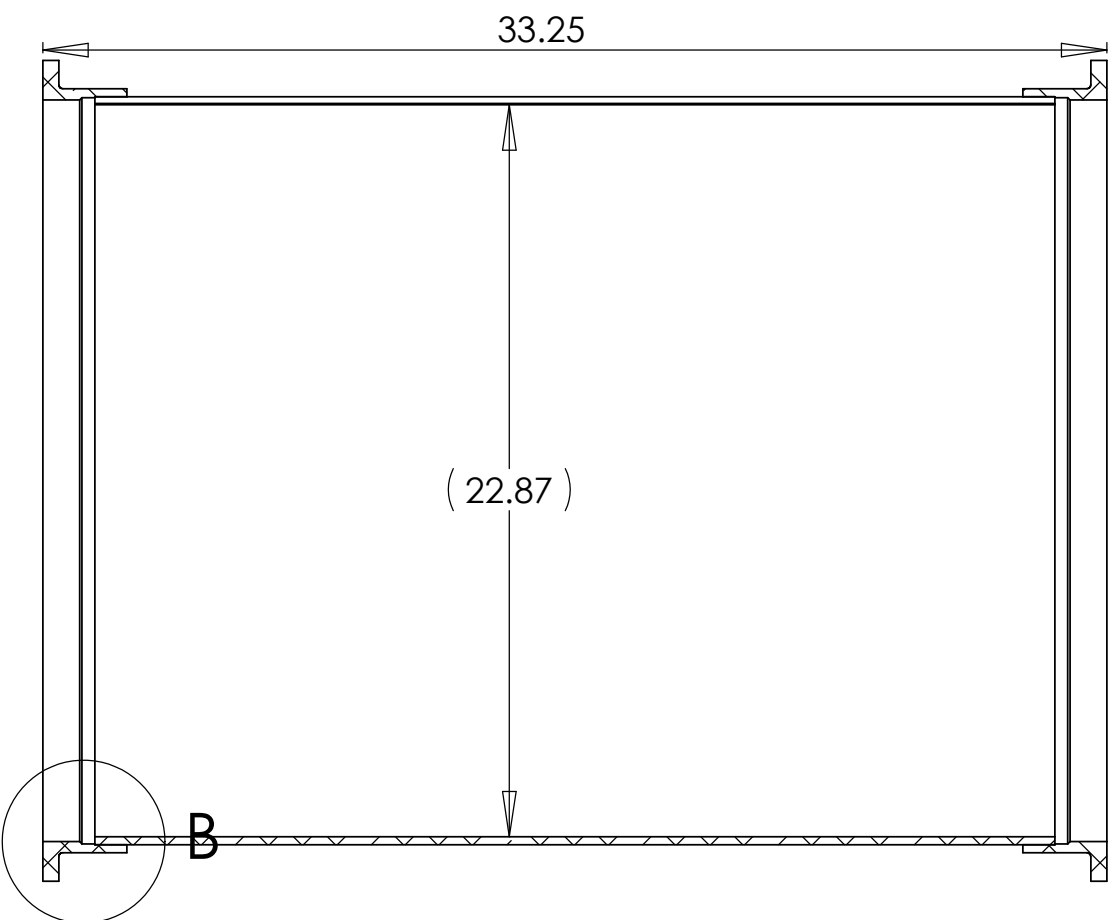




SECTION A-A
SCALE 1 : 6

MANUFACTURING PROCEDURE:

1. FLANGED RINGS (DRAWING # 100323) WILL BE WELDED TO ROLLED TUBE (DRAWING# 1003025) AS SPECIFIED
2. FILLER MATERIAL WILL BE ROCKMOUNT NEPTUNE TIG
3. PARTS WILL BE THOROUGHLY CLEANED WITH ACETONE PRIOR TO WELDING
4. WELDS WILL BE CLEAN, SMOOTH, AND FREE FROM POROSITY
5. TUNGSTEN INCLUSIONS WILL BE GROUND AND REWELDED
6. WELDEMENT WILL BE INSPECTED DIMENSIONALLY AND FOR WELD QUALITY, REPORT REQUIRED
7. **WELDEMENT WILL BE STRESS RELIEVED AND SOLUTION HEAT TREATED. FLAT, PARALLEL, AND STRAIGHT +/- .062. AGE TO T-6 CONDITION. FIXTURE IF NECESSARY. DOCUMENTATION REQUIRED**
8. NEXT ASSEMBLY DRAWING # 1003024



DETAIL B
SCALE 1 : 1.5

BILL OF MATERIALS										
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS 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 L. BIRD	02/08/06			
Shop Foreman		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX. 4. MACHINED FILET 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				
Engineer						CHECKED				
NEXT ASSY Description		NEXT ASSY Number		PROJECT NO.		900312		HOUSING WELD ASSEMBLY		
				PROJECT		ESP				
						SIZE B	DWG. NO.	REV.		
Application		DO NOT SCALE DRAWING				WEIGHT		1003026DWG		
								SCALE 1:10	CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 1