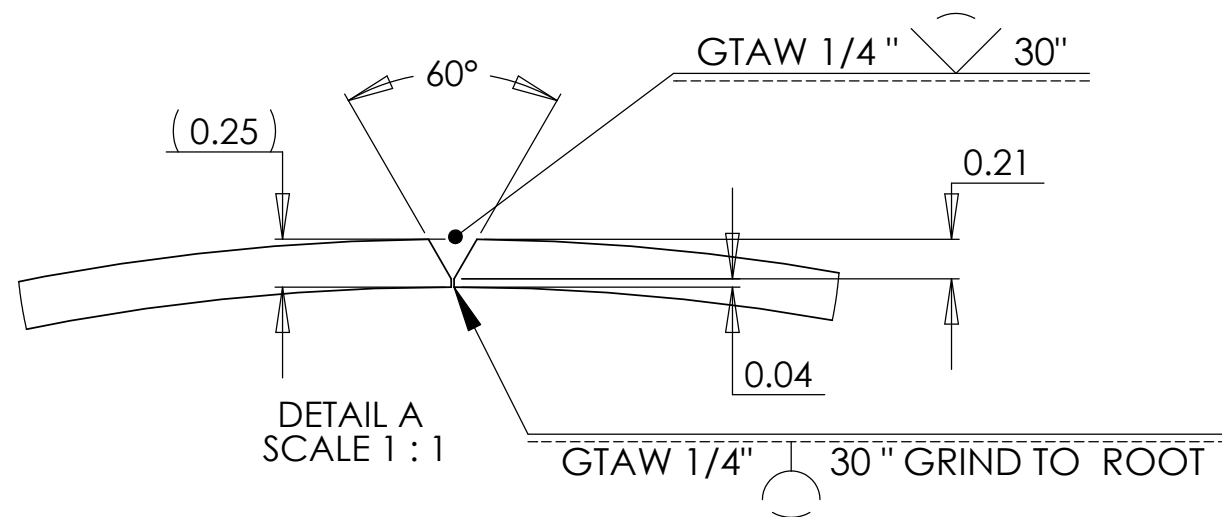


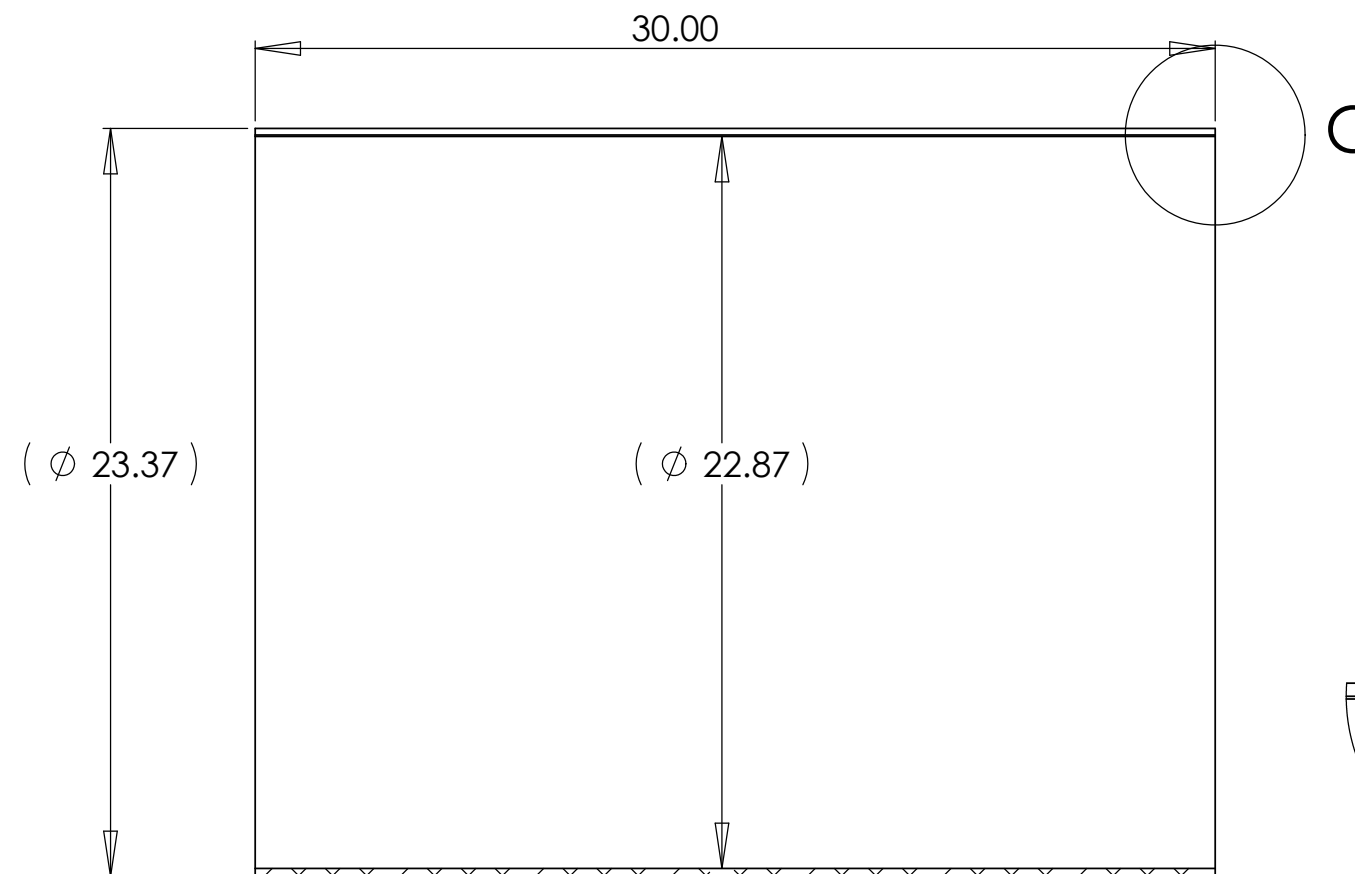
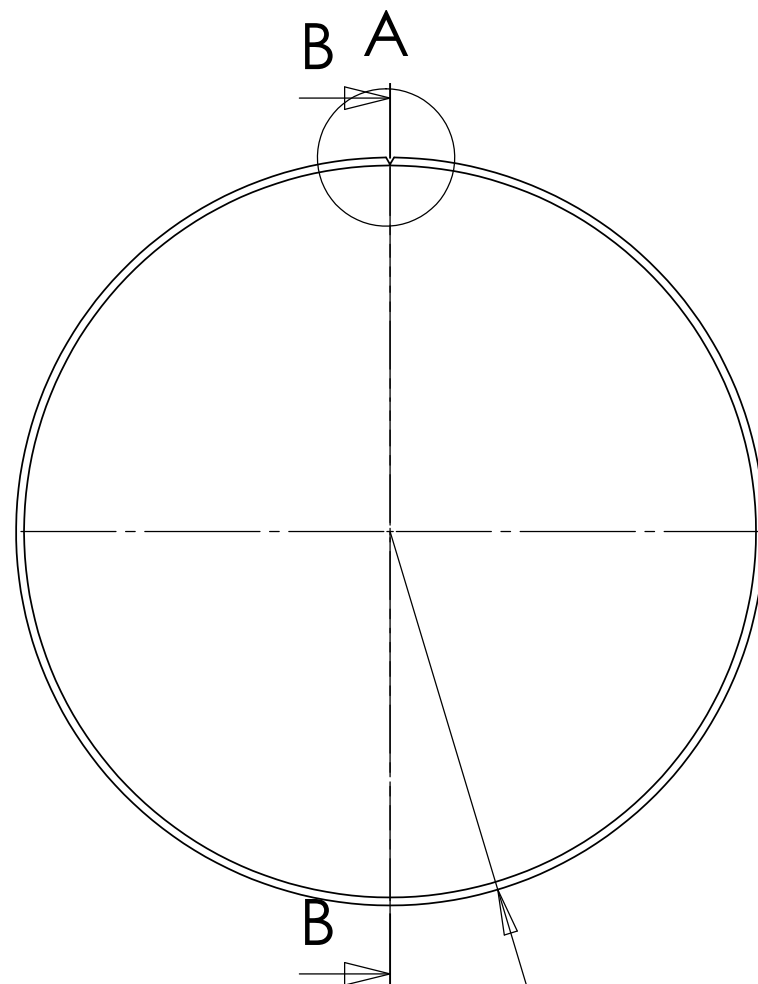
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MBARI ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MBARI IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

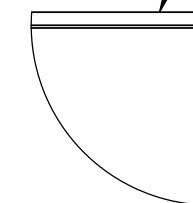


MANUFACTURING PROCEDURE:

1. MATERIAL ALUMINUM 6061 T-6 SHEET .250 THICK
2. PART WILL BE ROLLED AS SPECIFIED, FLATS CREATED IN ROLLING PROCESS WILL BE TRIMMED OR OTHERWISE ELIMINATED
3. MATERIAL MAY BE ANNEALED TO T-0 CONDITION IF REQUIRED
4. PART WILL BE WELDED AS SPECIFIED
5. FILLER MATERIAL WILL BE ROCKMOUNT NEPTUNE TIG
6. PARTS WILL BE THOROUGHLY CLEANED WITH ACETONE PRIOR TO WELDING
7. WELDS WILL BE CLEAN, SMOOTH, AND FREE FROM POROSITY
8. TUNGSTEN INCLUSIONS WILL BE GROUND AND REWELDED
9. WELDMENT WILL BE INSPECTED DIMENSIONALLY AND FOR WELD QUALITY, REPORT REQUIRED
10. NEXT ASSEMBLY SEE DRAWING #1003026



GRIND WELD FLUSH
1" BACK FROM EDGE BOTH
ENDS TO ALLOW FIT UP TO
FLANGED RING DRAWING
1003023



DETAIL C
SCALE 1 : 3

SECTION B-B
SCALE 1 : 6

Ø 23.375 +0.0 -0.062 ▽ 1.13 BOTH ENDS (MACHINE IF REQUIRED)

MATL. ALUMINUM 6061 T-6 SHEET .250 THICK

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 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				
Engineer						CHECKED				
						PROJECT NO.	900312			
NEXT ASSY Description	NEXT ASSY Number					PROJECT	ESP		MAIN TUBE WEDEMENT	
Application		DO NOT SCALE DRAWING				WEIGHT				
						SIZE B	DWG. NO.	1003025DWG		REV.
						SCALE 1:10	CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF		