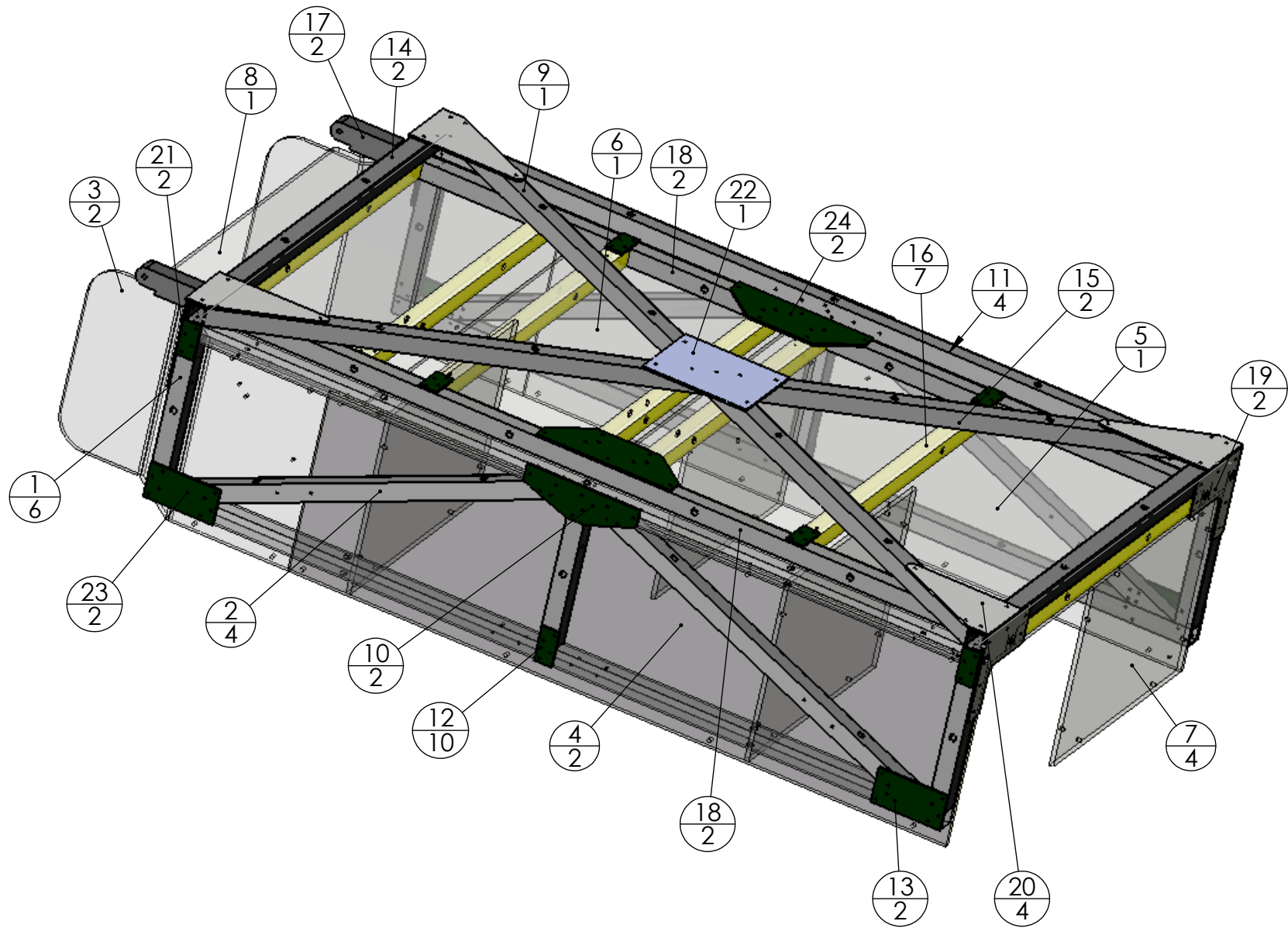


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		
	ADD'L DETAILING	7/29/08	JS

FOCE Flue Assembly-Wing Sections

NOTE: 2 wings req'd for full ass'y
for 2008

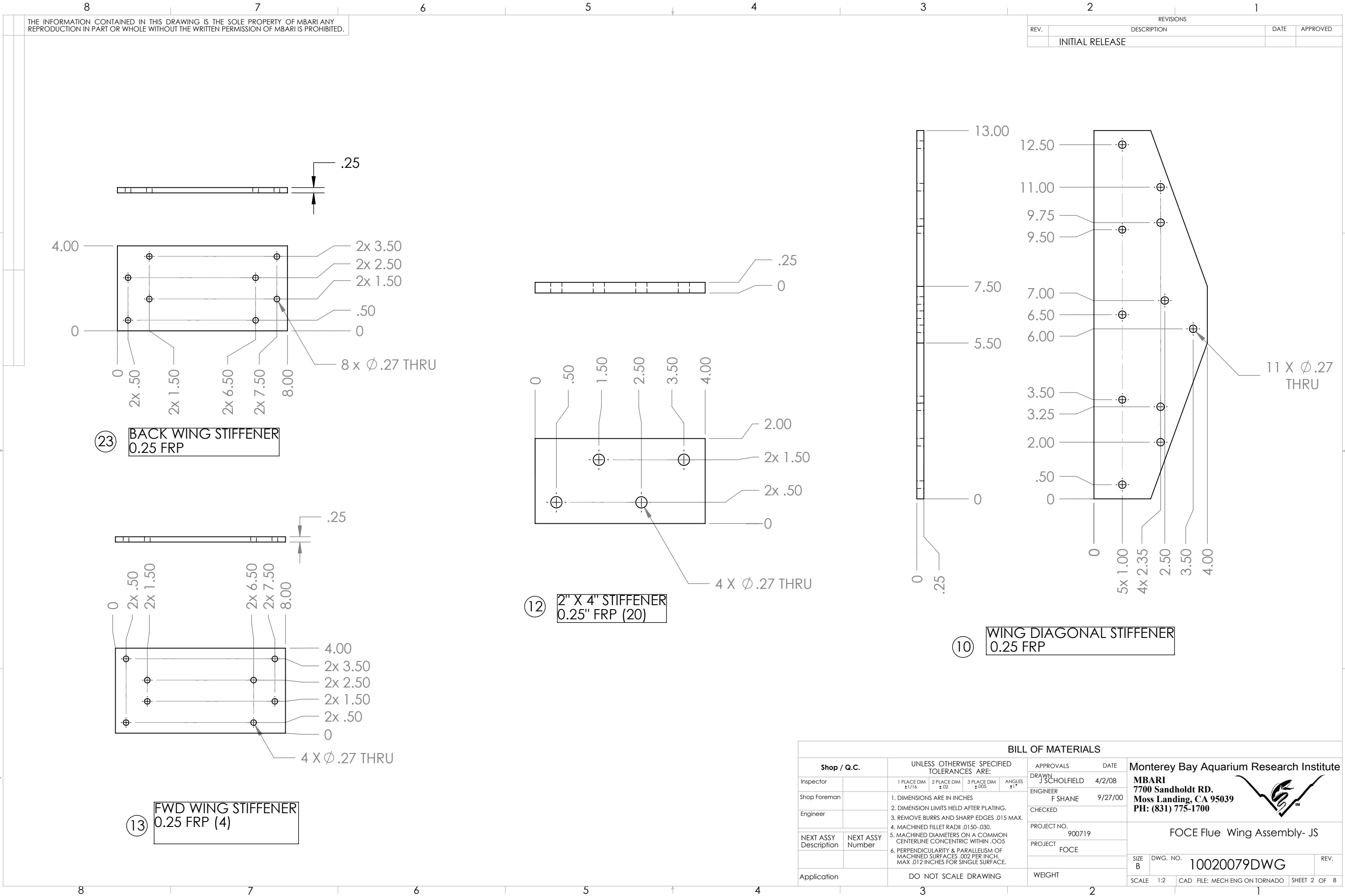


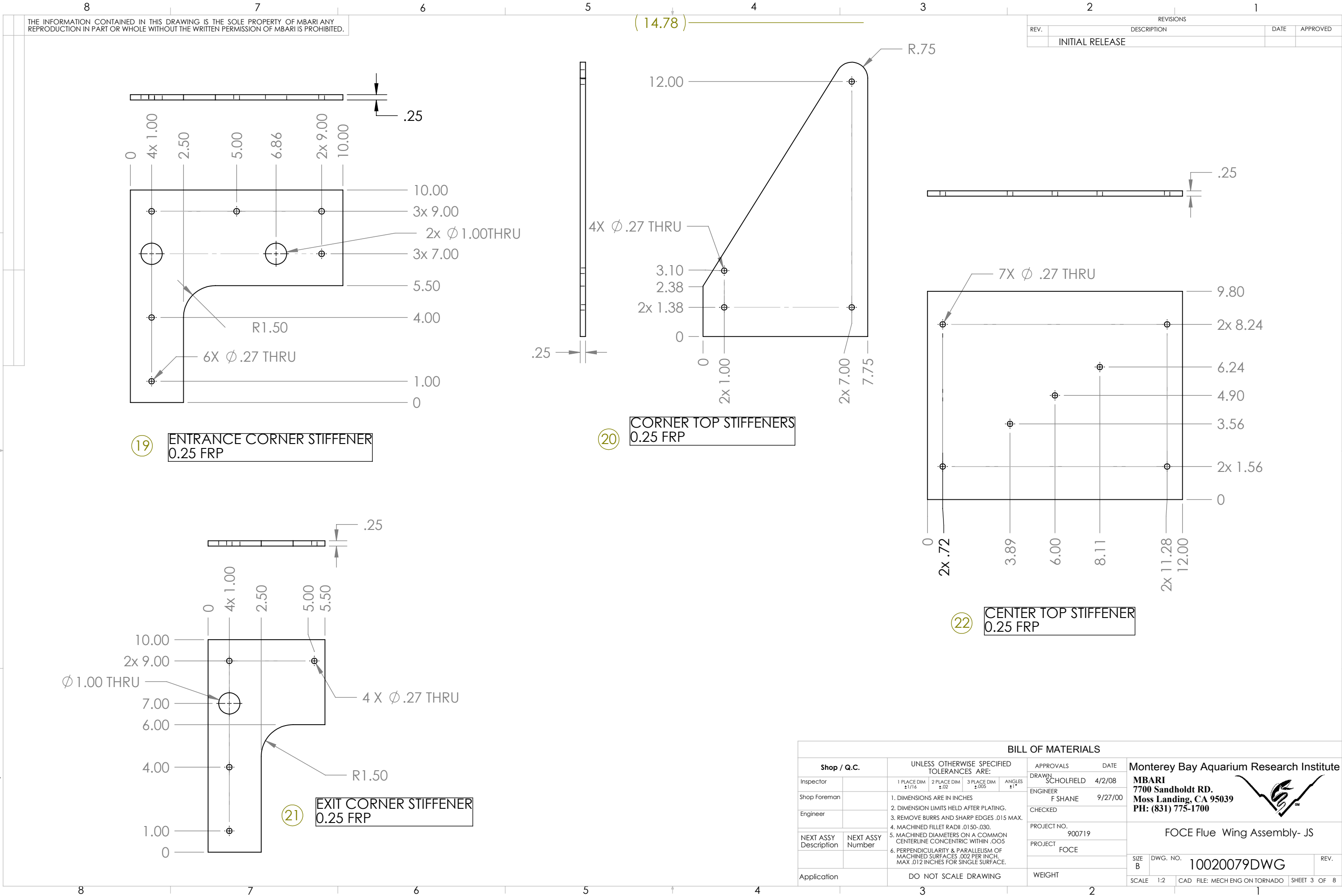
Additional notes: - Not all stiffeners shown
- Various scales used on views
- All holes are thru
- Quantities shown are for One wing ass'y,
two Wing assemblies are required for each
flue.
-All Stiffeners are FRP, 0.25"
-Clevis Pin Fixtures are UHMW
-all 2" x 2" tubing is FRP, 0.125" wall
-all panels are Polycarbonate, 0.5"
-exact fasteners TBD

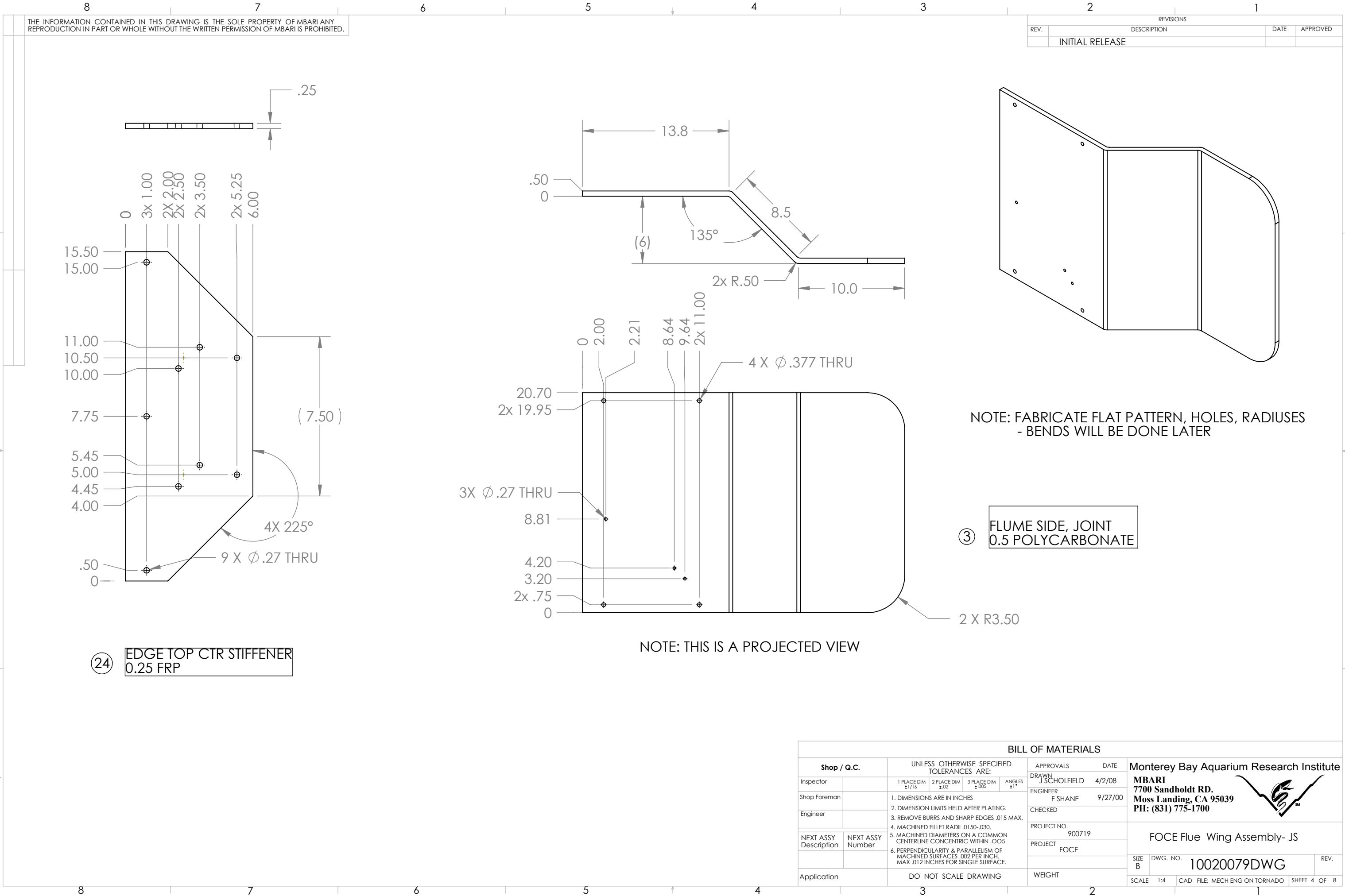
ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	FRP 16.5 x 2in x 2in		6
2	FRP Diagonal 46.06 in		4
3	flume side, joint		2
4	flume side		2
5	flume top OB		1
6	flume mid-top		1
7	flume baffle		4
8	flume top InB		1
9	Diagonal FRP 105.3945		1
10	Wing Diagonal Stiffening Plate		2
11	FRP 92 x 2in x 2in		4
12	2 in x 4 in x .25 in Stiffening Plate		10
13	2 in x 6 in x .25 in WING St Plate		2
14	FRP 58 x 2in x 2in		2
15	Short Diagonal FRP for 105.3945		2
16	FRP 42.4 x 2in x 2in		7
17	UHMW Clevis Pin		2
18	FRP 93.3 x 2in x 2in		2
19	wing entrance corner sup't		2
20	wing top,corner sup't		4
21	wing exit corner sup't		2
22	center top stiffener		1
23	2 in x 6 in x .25 in WING St Plate		2
24	edge topctr Stiffening Plate		2

BILL OF MATERIALS

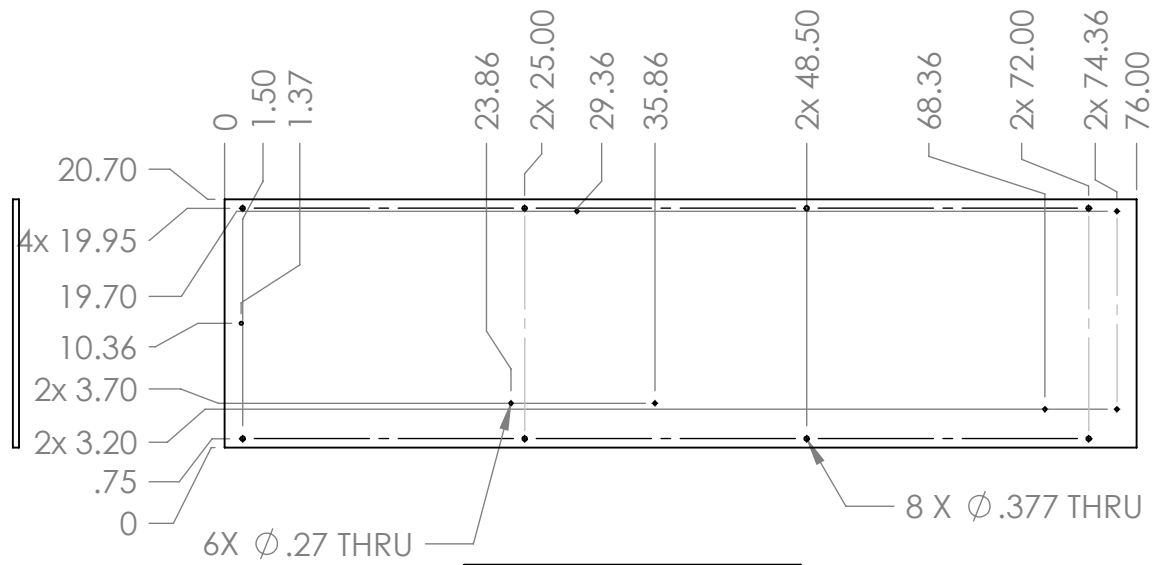
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS	DATE	Monterey Bay Aquarium Research Institute		
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN J SCHOLFIELD	4/1/08	MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700		
Shop Foreman		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 F SHANE	1/7/08			
Engineer						CHECKED				
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO. 900719				
		PROJECT FOCE		FOCE Flue Wing Assembly- JS						
Application		DO NOT SCALE DRAWING				WEIGHT	SIZE B		DWG. NO. 10020079DWG	REV.
							SCALE 1:50	CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 8	



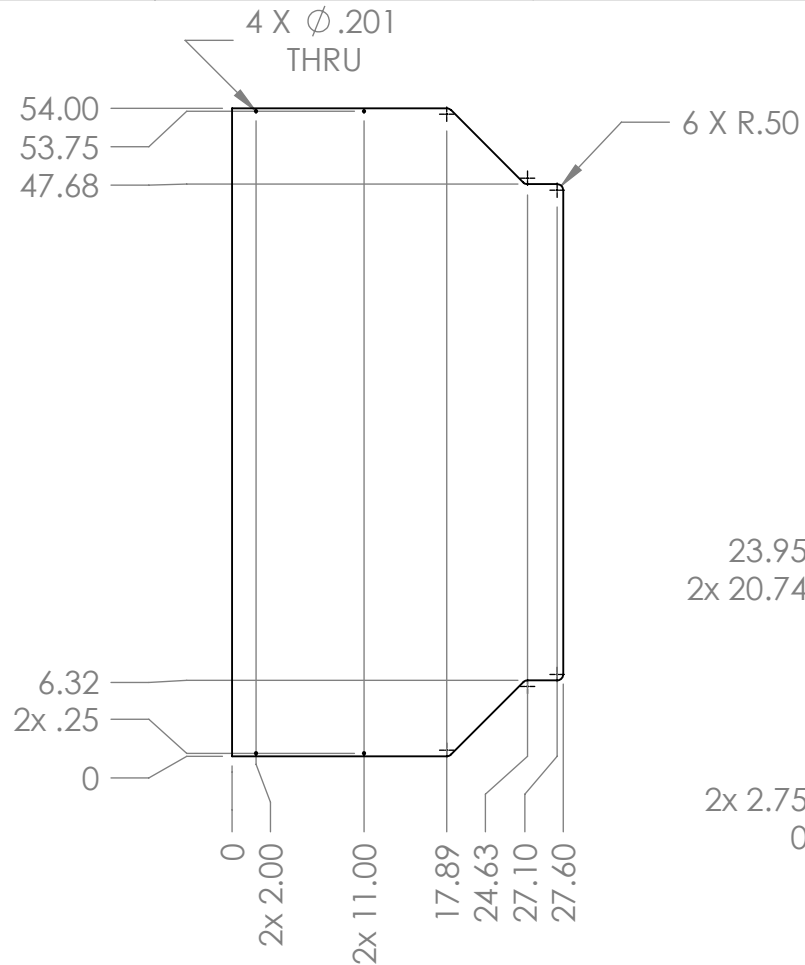




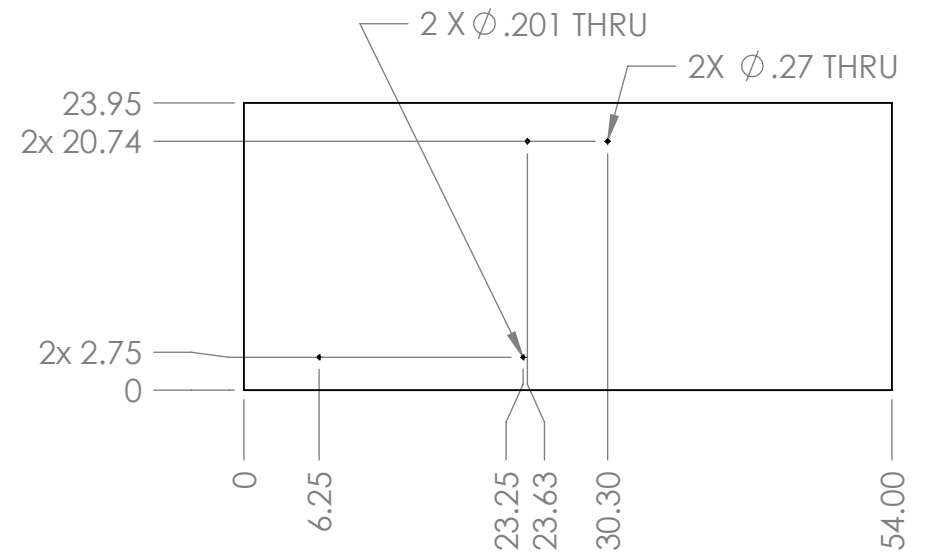
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MBARI ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MBARI IS PROHIBITED.



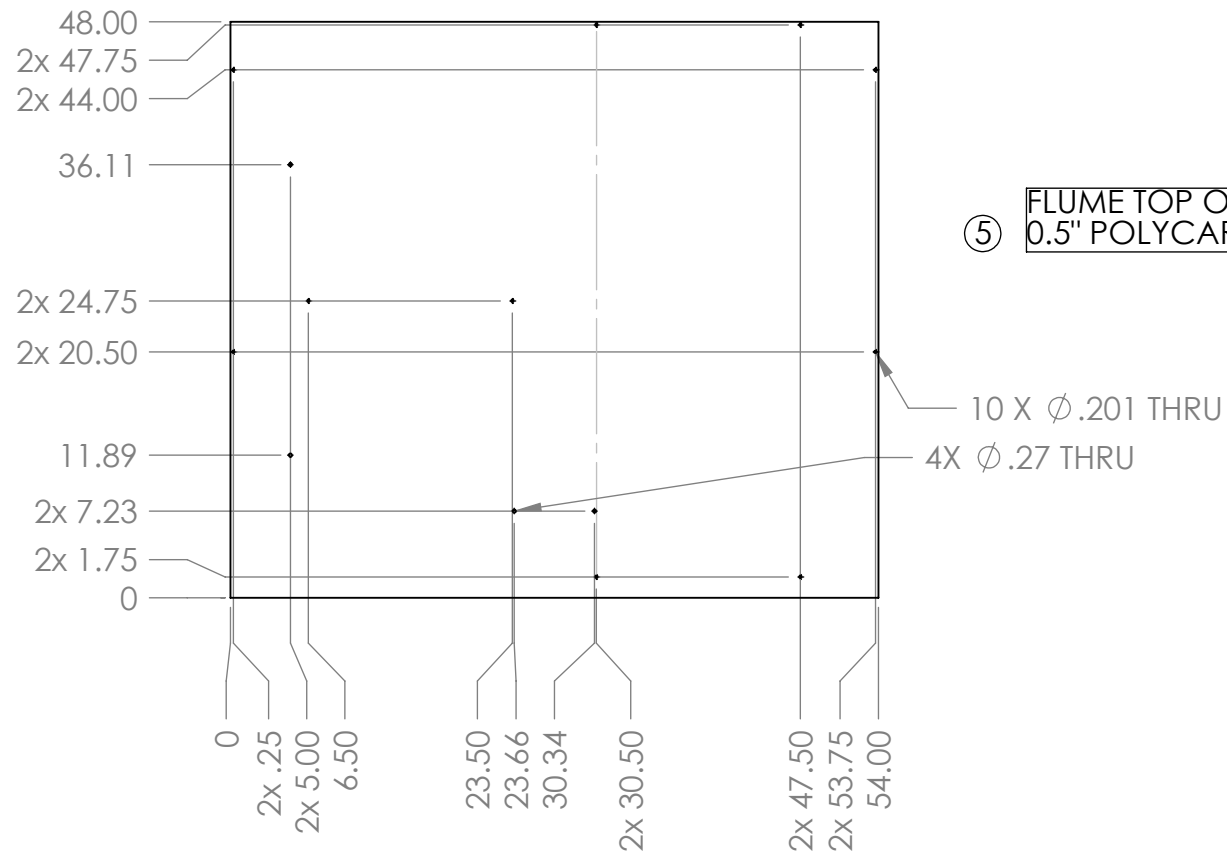
④ FLUME SIDE,
0.5" POLYCARBONATE



⑧ FLUME TOP INBOARD
0.5" POLYCARBONATE



⑥ FLUME MID-TOP
0.5" POLYCARBONATE



⑤ FLUME TOP OUTBOARD
0.5" POLYCARBONATE

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 J SCHOLFIELD		4/4/08		
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 F SHANE	9/27/00			
Engineer						CHECKED				
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO. 900719				
						PROJECT FOCE			FOCE Flue Wing Assembly- JS	
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B	DWG. NO. 10020079DWG	REV.
								SCALE 1:16	CAD FILE: MECH ENG ON TORNADO	SHEET 5 OF 8

