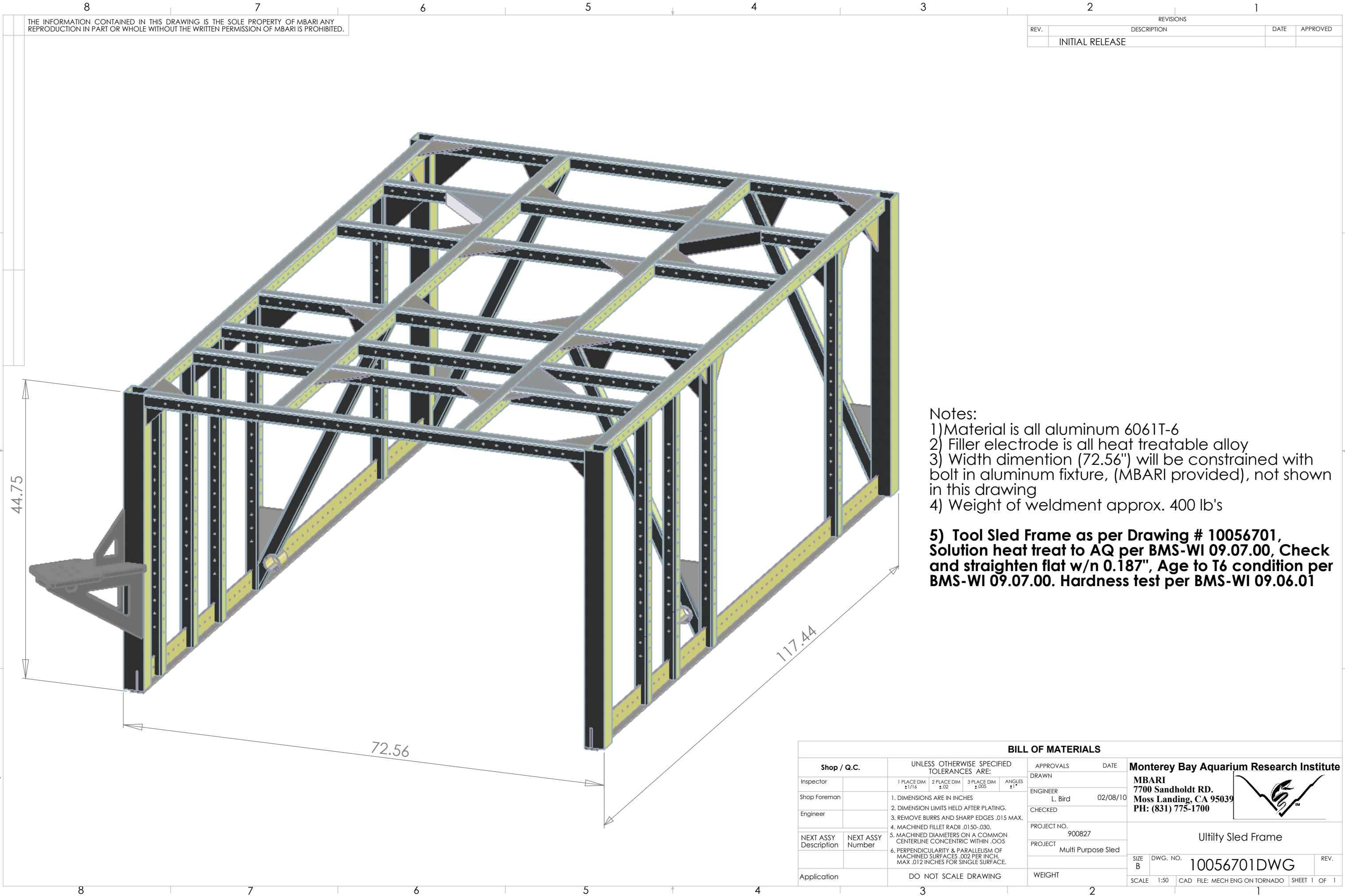




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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

- Notes:
- 1) Material is all aluminum 6061T-6
 - 2) Filler electrode is all heat treatable alloy
 - 3) Width dimension (72.56") will be constrained with bolt in aluminum fixture, (MBARI provided), not shown in this drawing
 - 4) Weight of weldment approx. 400 lb's

5) Tool Sled Frame as per Drawing # 10056701, Solution heat treat to AQ per BMS-WI 09.07.00, Check and straighten flat w/n 0.187", Age to T6 condition per BMS-WI 09.07.00. Hardness test per BMS-WI 09.06.01

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					
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		02/08/10			
Engineer						CHECKED					
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.		900827		Utility Sled Frame	
						PROJECT		Multi Purpose Sled			
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B		DWG. NO.	REV.
								SCALE 1:50		CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 1