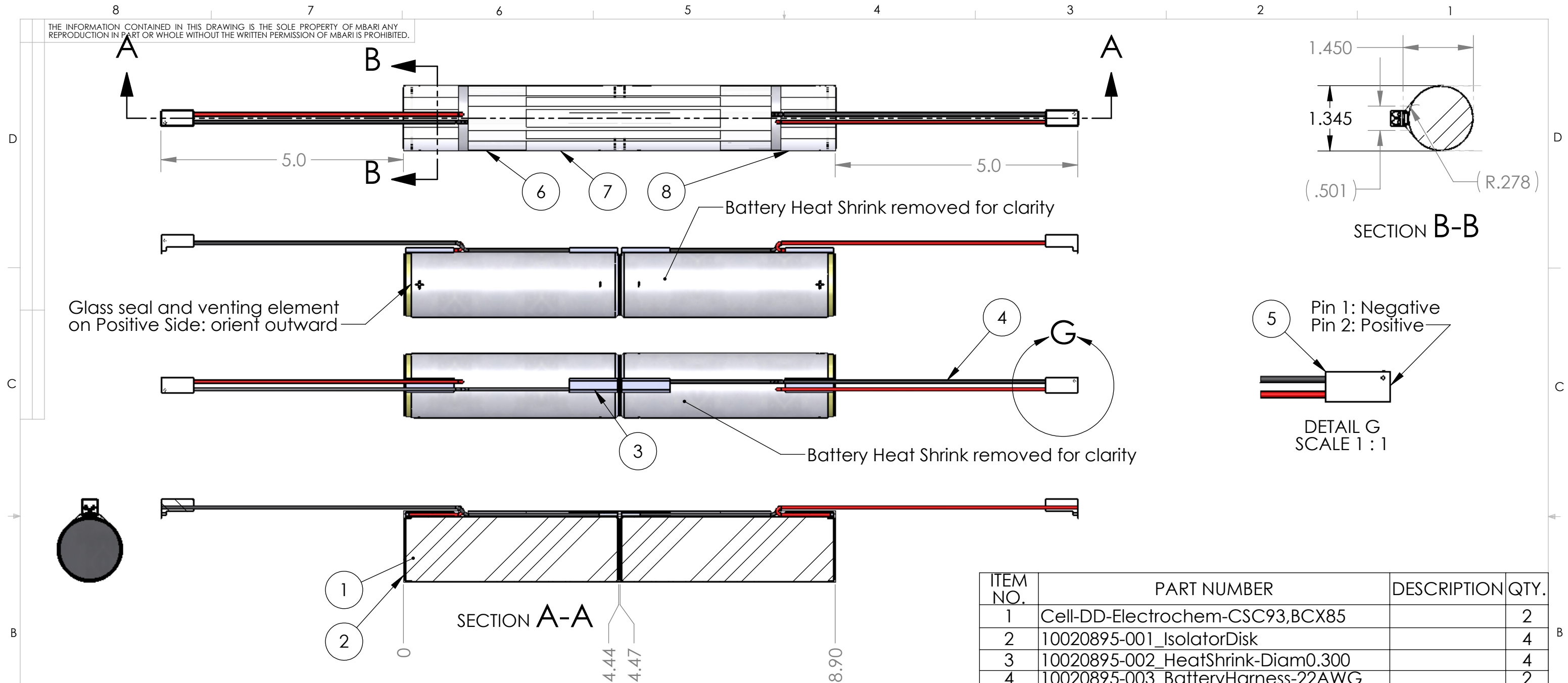


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Glass seal and venting element
on Positive Side: orient outward

Battery Heat Shrink removed for clarity

Battery Heat Shrink removed for clarity

SECTION B-B

DETAIL G
SCALE 1 : 1

SECTION A-A

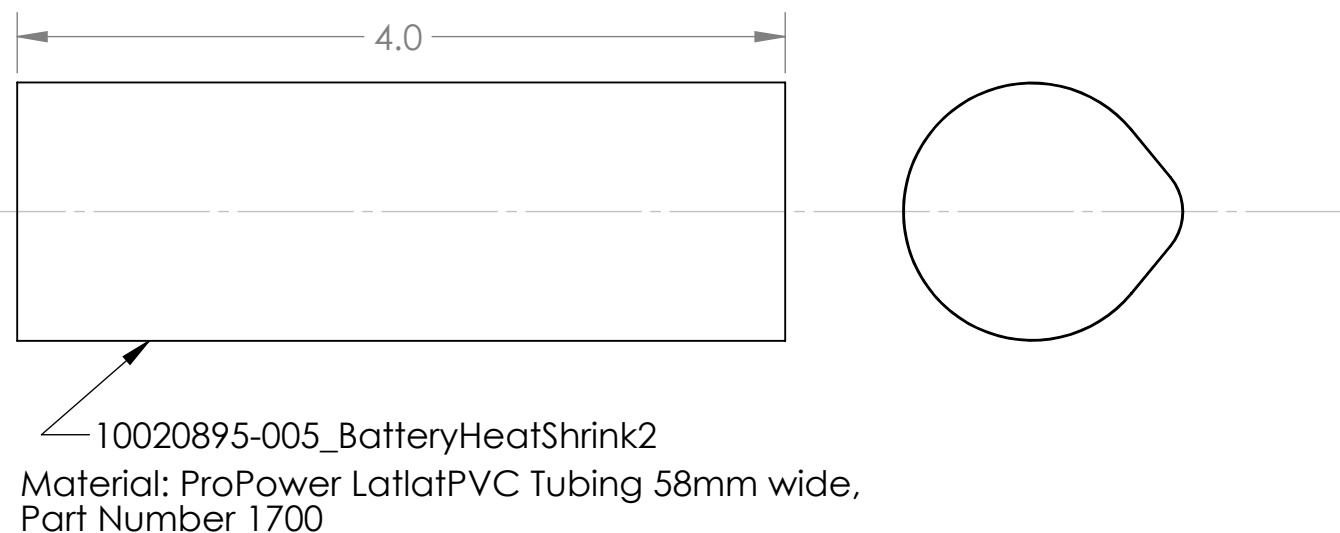
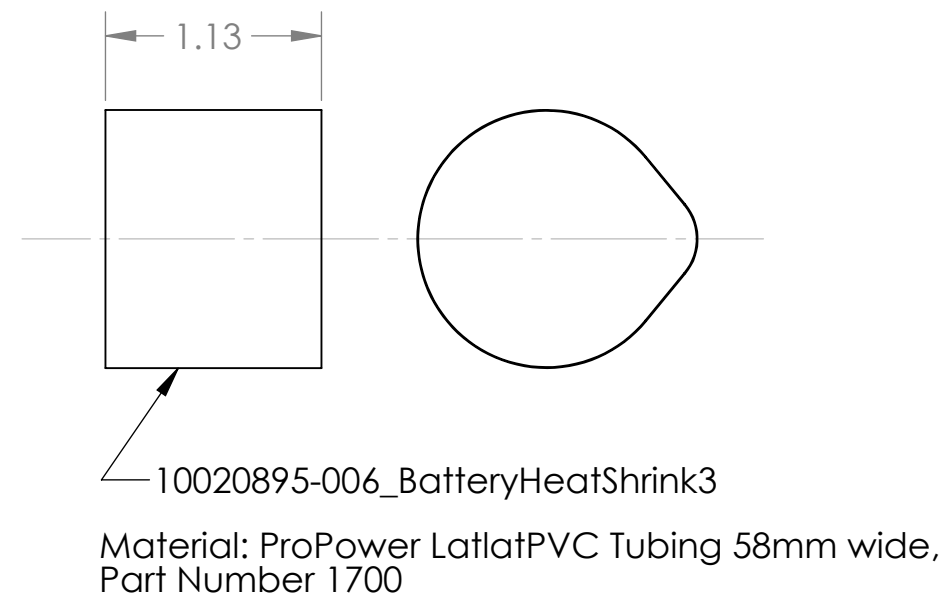
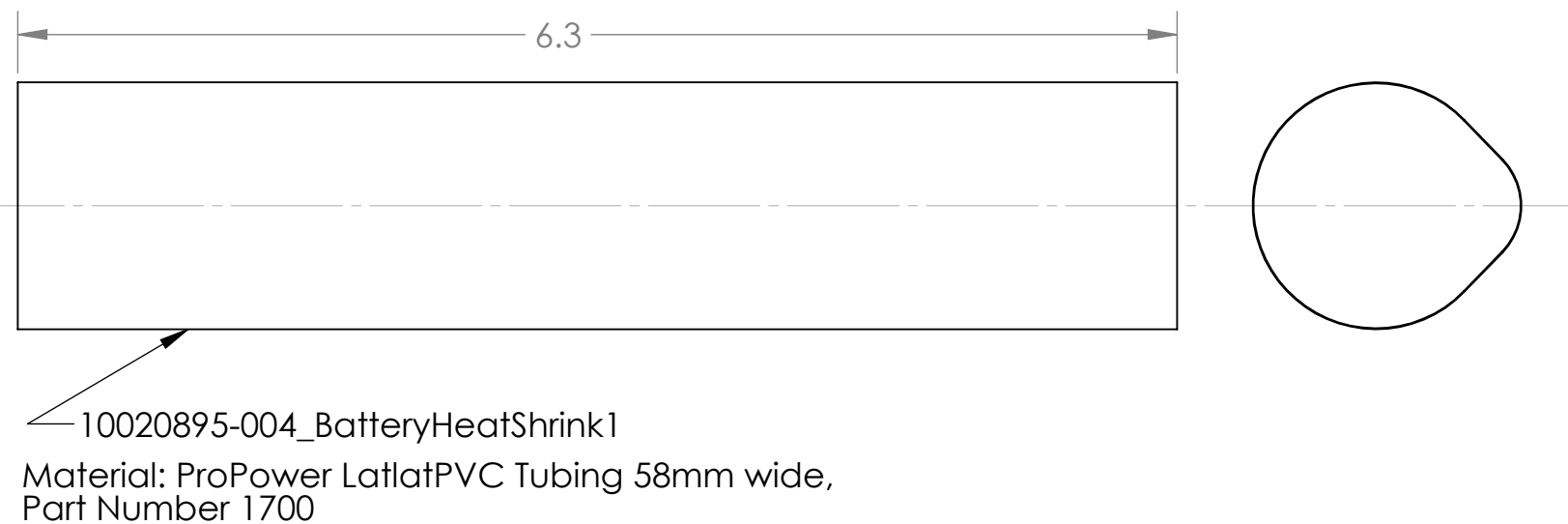
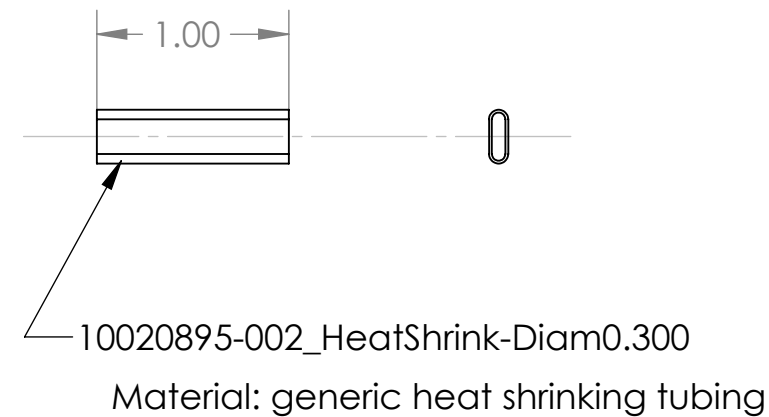
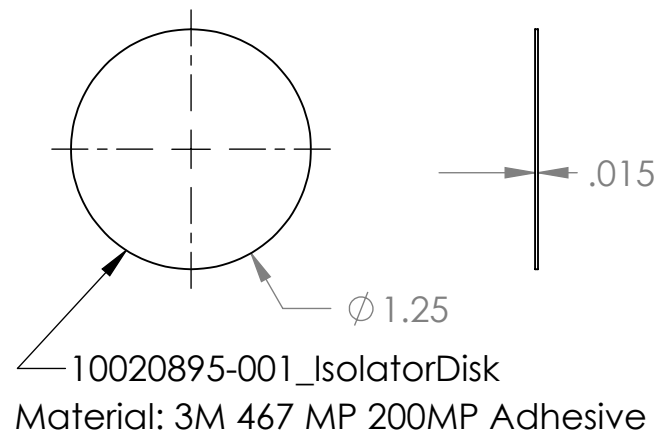
- Assembly notes:
1. Indicate Battery Code (chemistry, batch, and serial number) to the outside of the assembly
 2. Use cells with the same chemistry and part number
 3. Use cells with the same batch number and charge state
 4. Solder to the solder tabs only
 5. Handle with care, especially the "Positive" side of battery cells.
(It contains glass-to-metal seal that can be fractured)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Cell-DD-Electrochem-CSC93,BCX85		2
2	10020895-001_IsolatorDisk		4
3	10020895-002_HeatShrink-Diam0.300		4
4	10020895-003_BatteryHarness-22AWG		2
5	Conn-Recept-SL156-TE-770849-2		2
6	10020895-004_BatteryHeatShrink1		1
7	10020895-005_BatteryHeatShrink2		1
8	10020895-006_BatteryHeatShrink3		2

Rev0 (02/08/2013): Initial Release
Rev1 (02/12/2013): note to indicate batch and serial number added
Rev2 (12/23/2015): drw updated to reflect wiring exiting sideways

Shop / Q.C.	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	CONCEPT DESIGN Klimov	DATE 10/2012	Monterey Bay Aquarium Research Institute MBARI
Inspector	1 PLACE DIM $\pm 1/16$	INITIAL RELEASE Klimov	DATE 02/08/2013	7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700
Shop Foreman	2 PLACE DIM $\pm .02$	LAST REVISION Klimov	DATE 12/23/2015	
Engineer	3 PLACE DIM $\pm .005$	CHECKED xx	DATE xx/xx/xxxx	
NEXT ASSY Description	ANGLES $\pm 1^\circ$	PROJECT NO. 901006	DRAWING NAME and FILE NAME 10020895-BSA1_BatteryStickAssembly	
Application	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.	DO NOT SCALE DRAWING	SIZE B	DWG. NO. XX
		PROJECT NAME BEDS	SCALE 1:2	REV. 2
			SHEET 1 OF 2	

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Shop / Q.C.	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			CONCEPT DESIGN	DATE	Monterey Bay Aquarium Research Institute	
Inspector	1 PLACE DIM ±.1/16	2 PLACE DIM ±.005	3 PLACE DIM ±.005	ANGLES ±1°	Klimov	xx/xx/xxxx	MBARI
Shop Foreman	1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX.			INITIAL RELEASE	DATE	7700 Sandholding RD.	
Engineer	4. MACHINED FILLET RADII .0150-.030. 5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005			Klimov	xx/xx/xxxx	Moss Landing, CA 95039	
NEXT ASSY Description	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.			LAST REVISION	DATE	PH: (831) 775-1700	
Application	DO NOT SCALE DRAWING			xx	xx/xx/xxxx	DRAWING NAME and FILE NAME	
				PROJECT NO.	901006	10020895-BSA1_BatteryStickAssembly	
						SIZE	DWG. NO.
						B	XX
						SCALE	1:1
						SHEET	2 OF 2