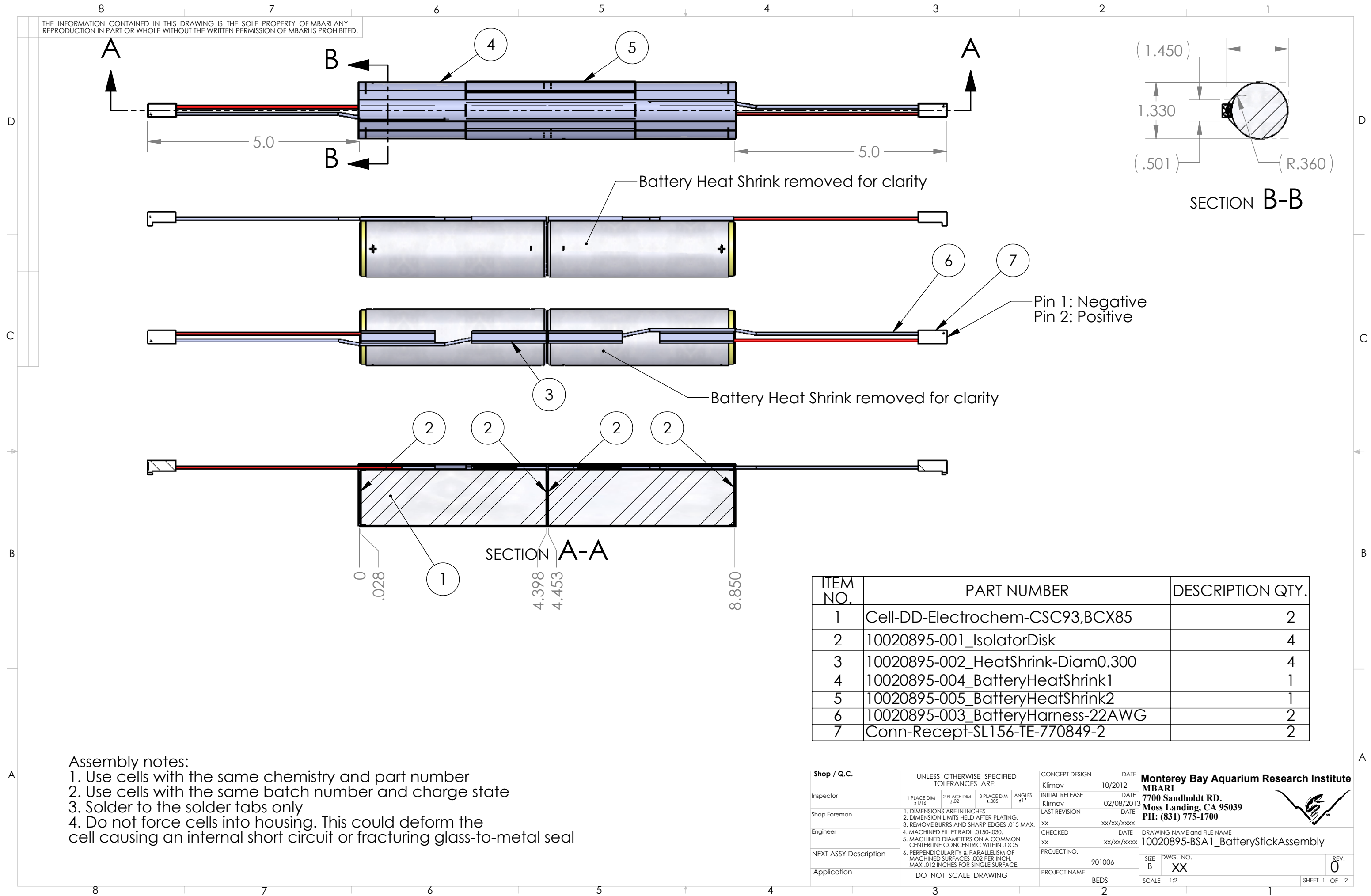


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Assembly notes:
1. Use cells with the same chemistry and part number
2. Use cells with the same batch number and charge state
3. Solder to the solder tabs only
4. Do not force cells into housing. This could deform the cell causing an internal short circuit or fracturing glass-to-metal seal

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	10020895-004_BatteryHeatShrink1		1
5	10020895-005_BatteryHeatShrink2		1
6	10020895-003_BatteryHarness-22AWG		2
7	Conn-Recept-SL156-TE-770849-2		2

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			CONCEPT DESIGN		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°	Klimov		10/2012						
		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.			INITIAL RELEASE		DATE							
					Klimov		02/08/2013							
Shop Foreman					LAST REVISION		DATE							
					xx		xx/xx/xxxx							
Engineer					CHECKED		DATE		DRAWING NAME and FILE NAME					
NEXT ASSY Description		xx		xx/xx/xxxx		10020895-BSA1_BatteryStickAssembly								
					PROJECT NO.				SIZE		DWG. NO.		REV.	
Application		DO NOT SCALE DRAWING			PROJECT NAME		901006		B		XX		0	
					BEDS				SCALE		1:2		SHEET 1 OF 2	

