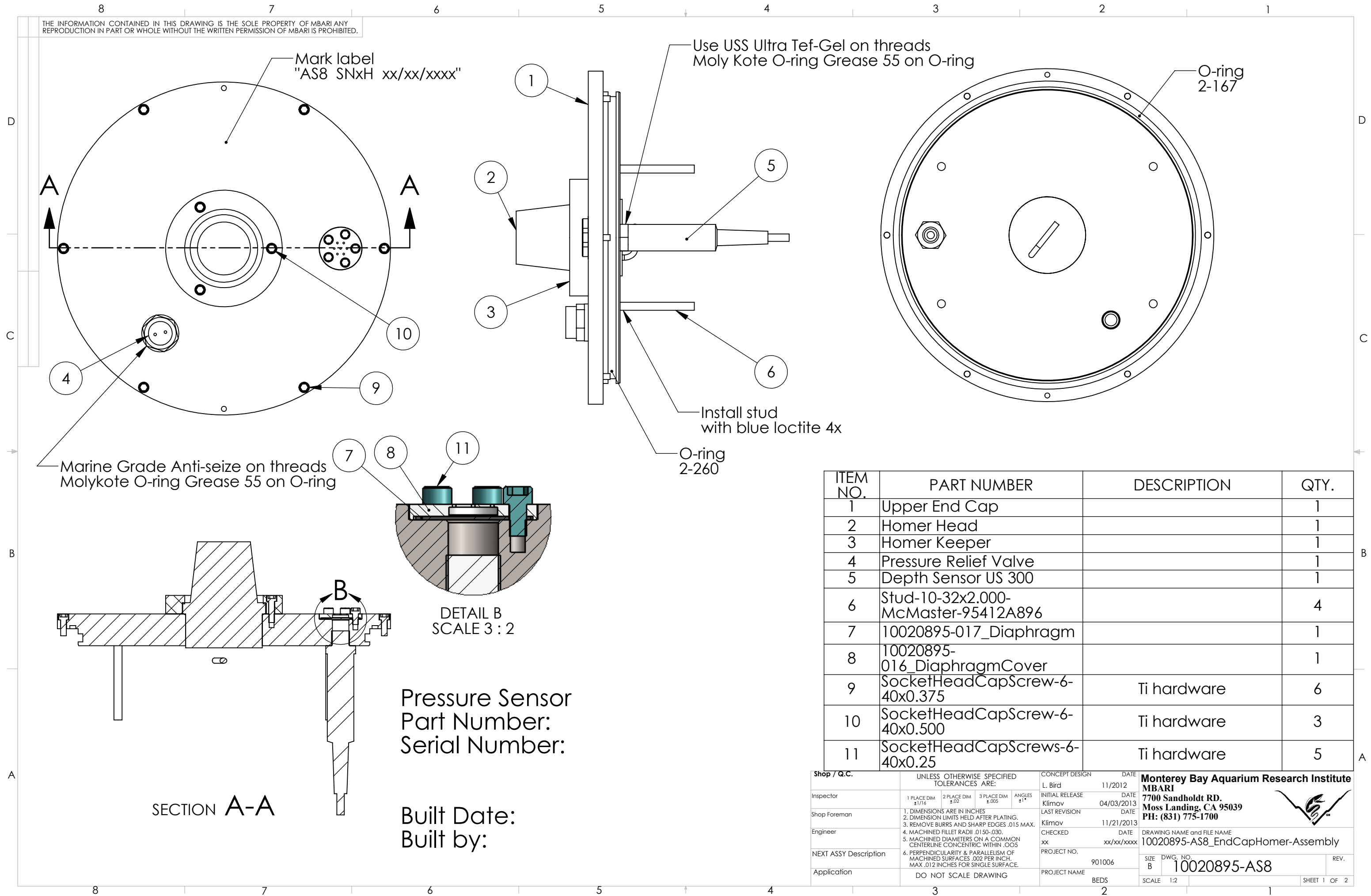


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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Upper End Cap		1
2	Homer Head		1
3	Homer Keeper		1
4	Pressure Relief Valve		1
5	Depth Sensor US 300		1
6	Stud-10-32x2.000-McMaster-95412A896		4
7	10020895-017_Diaphragm		1
8	10020895-016_DiaphragmCover		1
9	SocketHeadCapScrew-6-40x0.375	Ti hardware	6
10	SocketHeadCapScrew-6-40x0.500	Ti hardware	3
11	SocketHeadCapScrews-6-40x0.25	Ti hardware	5

Shop / Q.C.	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	CONCEPT DESIGN L. Bird	DATE 11/2012	Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700	
Inspector	1 PLACE DIM $\pm .1/16$	INITIAL RELEASE Klimov	DATE 04/03/2013		
Shop Foreman	2 PLACE DIM $\pm .02$	LAST REVISION Klimov	DATE 11/21/2013	DRAWING NAME and FILE NAME 10020895-AS8_EndCapHomer-Assembly	
Engineer	3 PLACE DIM $\pm .005$	CHECKED xx	DATE xx/xx/xxxx		
NEXT ASSY Description	ANGLES $\pm 1^\circ$	PROJECT NO. 901006	PROJECT NAME BEDS	SIZE B	DWG. NO. 10020895-AS8
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	SCALE 1:2	SHEET 1	OF 2

Diaphragm installation sequence:

1. Position instrument with AS8 assembly facing up
2. Fill pressuce sensor cavity almost to the top surface with silicone oil _____
3. Using back stick of a Q-tip stick, get rid of air bubbles in pressure sensor channel (Be careful not to damage membrane) and screws holes 5x.
4. Lubricate rubber diaphragm with same oil 2 sides
5. Position Diaphragm and Diaphragm Cover in the cavity then align holes using the same Q-tip stick.
6. By pressing on Diaphragm Cover with side-to-side motion, squeeze excess oil from under Diaphragm.

Record Intitial Pressure _____

7. Get screws in, until barely touching.
8. Start torquing screws by 1/4 turn at the time, in cross pattern, jumping over 1 screw clockwise, untill all set.
9. Loosen all 5x screws just enouth to get Diaphragm Cover free but not loose so air could not get in.
10. Repeat step 8;

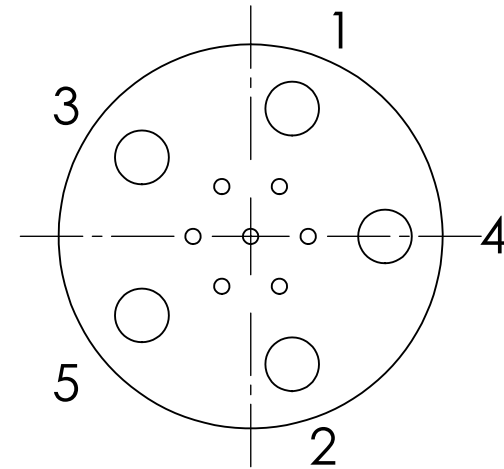
Record Final Pressure _____

11. Read pressure some time later (2 Hours suggested)_____

Record Pressure _____

12. Read pressure some time later (overnight suggestet)_____

Record Pressure _____



Step 8
screw tightening sequence

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°	ref sheet 1	ref sheet 1												
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.				INITIAL RELEASE		DATE		DRAWING NAME and FILE NAME 10020895-AS8_EndCapHomer-Assembly									
Engineer						ref sheet 1		ref sheet 1											
NEXT ASSY Description						LAST REVISION		DATE											
Application						ref sheet 1		ref sheet 1											
						DO NOT SCALE DRAWING				PROJECT NAME		DATE		SIZE		DWG. NO.		REV.	
										PROJECT NO.		ref sheet 1		B		ref sheet 1			
										PROJECT NAME		ref sheet 1		SCALE		2:1		SHEET 2 OF 2	