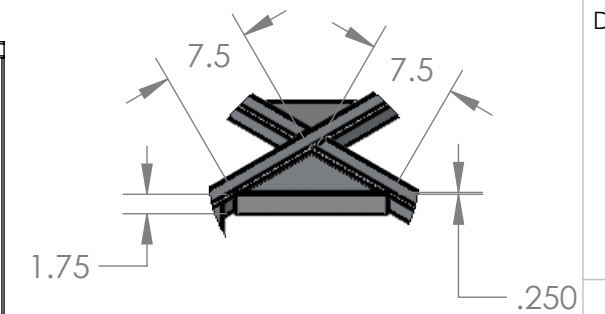
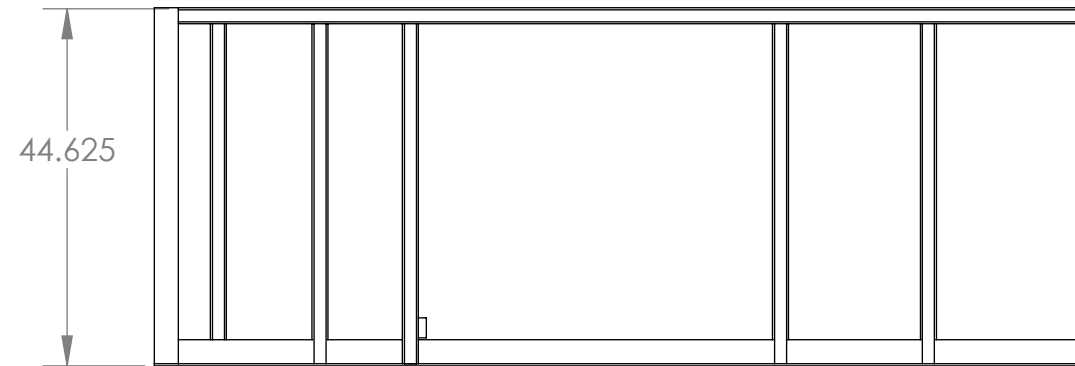
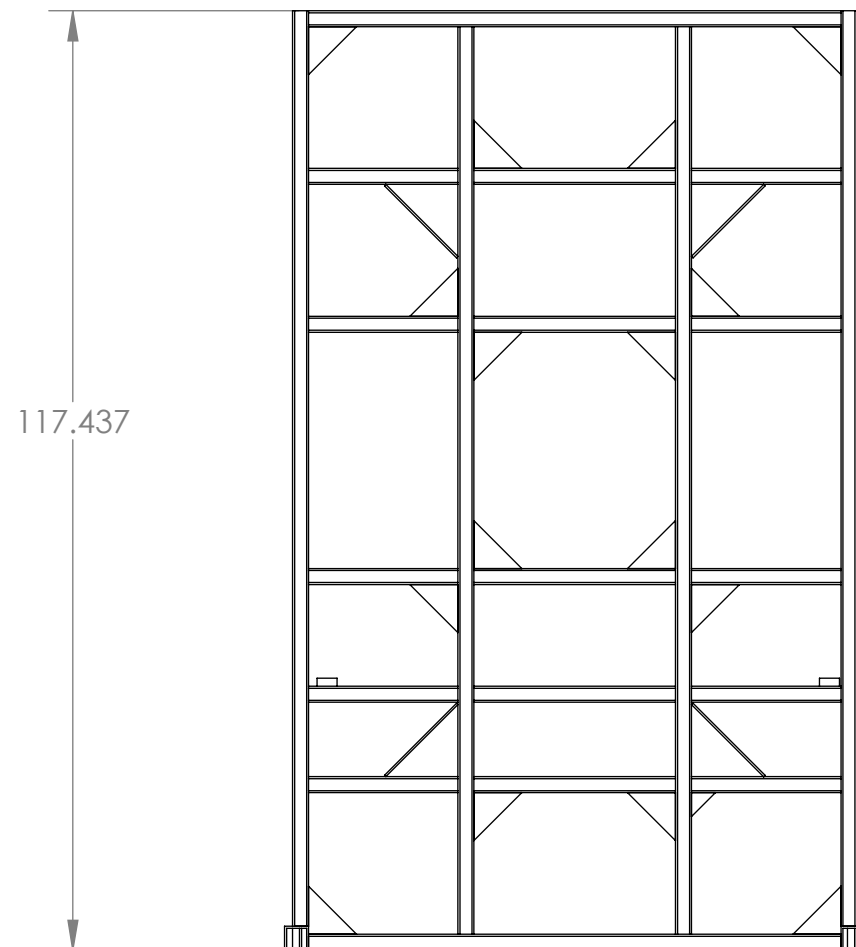


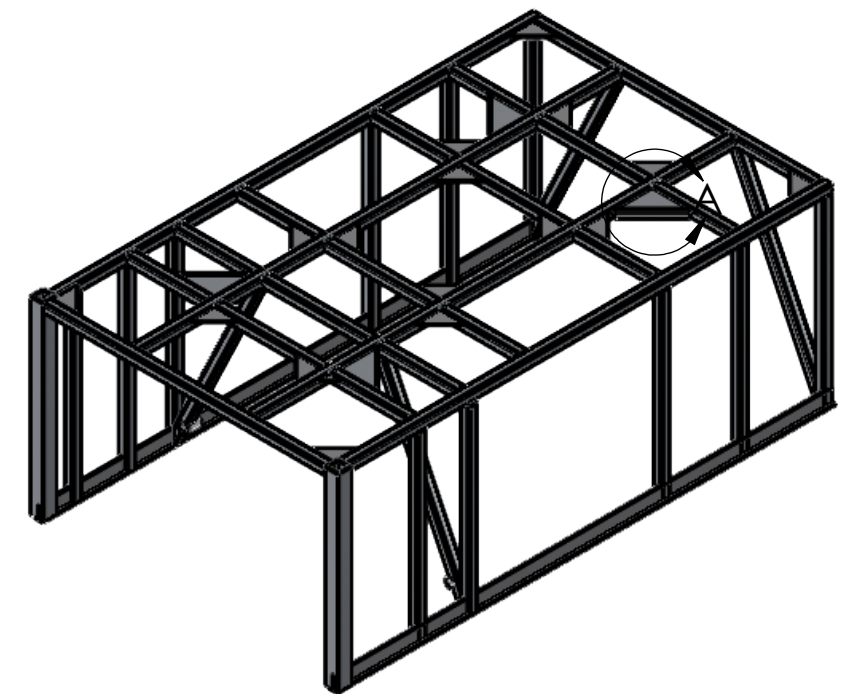


DETAIL A
SCALE 1 : 16



- 1) Tubing aluminum 6061 T-6 2X2 X .125 wall w/.250 corner radius
- 2) Tubing aluminum 6061 T-6 3X3 X .250
- 3) Gussets aluminum 6061 T-6 6x6 X .250

- 1) All material aluminum 6061 T-6
- 2) All welds to be 3/16 " minimum weld size
- 3) All parts to be thoroughly cleaned with acetone prior to welding
- 4) Filler material Rockmount Neptune TIG
- 5) Welds will be clean, smooth , and free from porosity
- 6) Tungsten inclusions will be ground free and rewelded
- 7) Tri Mix Tungsten electrode
- 8) Shield Gas to be Argon/Helium Blend
- 9) All dimensions to be +/- 3/16", to be held after welding



BILL OF MATERIALS								
NEXT ASSY Description	NEXT ASSY Number	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS	DATE	
		1 PLACE DIM ±.1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±.1°	DRAWN	3/3/2008	
THIRD ANGLE PROJECTION		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				ENGINEER	L. Bird	
						CHECKED		
						PROJECT NO.	901101	
						PROJECT	Ocean Imaging	
						SIZE B	DWG. NO. DWG 10036895	REV. REV
						SCALE 1:32	CAD FILE:	SHEET 1 OF 1

Status: