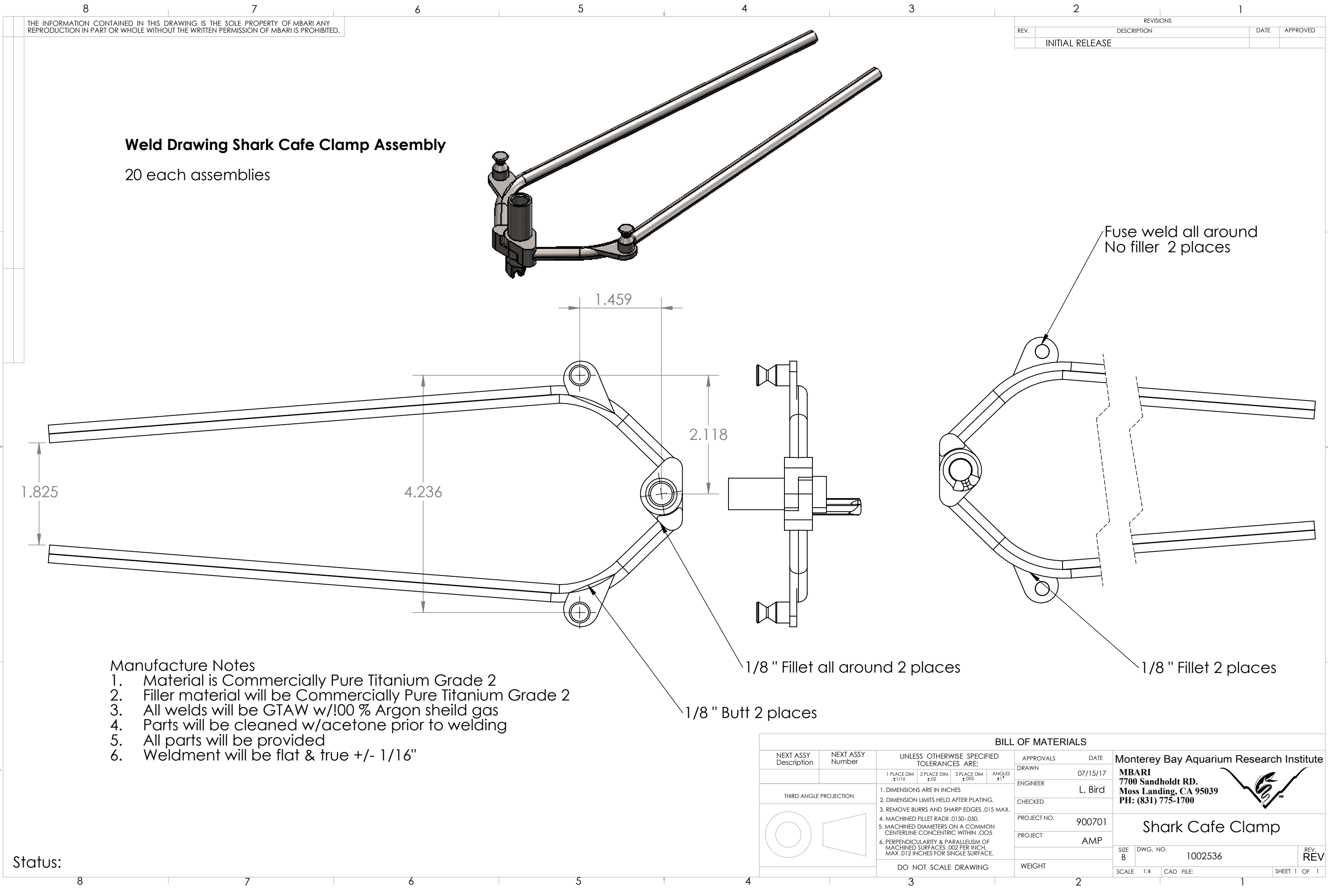




THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MBARI ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MBARI IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

Weld Drawing Shark Cafe Clamp Assembly

20 each assemblies

Fuse weld all around
No filler 2 places

1.825

4.236

1.459

2.118

1/8 " Fillet all around 2 places

1/8 " Fillet 2 places

1/8 " Butt 2 places

Manufacture Notes

1. Material is Commercially Pure Titanium Grade 2
2. Filler material will be Commercially Pure Titanium Grade 2
3. All welds will be GTAW w/!00 % Argon shield gas
4. Parts will be cleaned w/acetone prior to welding
5. All parts will be provided
6. Weldment will be flat & true +/- 1/16"

BILL OF MATERIALS

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		07/15/17	
							ENGINEER		L. Bird	
							CHECKED			
							PROJECT NO.		900701	
							PROJECT		AMP	