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Prototype notes 3/19/2019 Klimov
Need 2 parts for pressure testing

Decrease
diameter to
0.400"

REVISIONS				
REV.	DESCRIPTION		DATE	APPROVED
	INITIAL RELEASE		5/25/04	
REVISIONS				
ff	REV.	DESCRIPTION	DATE	APPROVED
B1	A	CHG Fiber Hole Dia. frm .062 to .040	9/21/2018	J.E.

GROOVE .050
X .025 DEEP

(2.65)
2.000

.265

.075

.650

BOTTOM

R.02

OUTER ϕ .740
SMOOTHED EDGE
FOR 2-017 ORING

.015 $\pm$.002

DETAIL A
SCALE 10 : 1

63

R0.032" MAX

125

8X .01 CNTRS NK

A

(.60)

(ϕ .610)

1.800

.650 BORE

SECTION B-B
SCALE 2 : 1

(.410)

.02 x 45° CHMFR

Decrease
diameter to
0.400"

TOP

BOTTOM VIEW

Diameter 0.111"
1 central hole,
instead of 4 holes

4X ϕ .040 THRU
(#60)

ϕ .240 B.C

ϕ .410

ϕ .623^{+.000}_{-.002}

(ϕ .740- ORING LAND)
SEE DETAIL A

ϕ .870

8. Mates to MinK-FCR

7. PROJECT LIBRARY:\901506 DeepPIV\
ME Drawings\FiberConnections\Test

FIBER OPTIC PENETRATION FOR LRS/DORISS			316 SS	
ITEM NO.	QTY	PART NO.	DESCRIPTION	MATERIAL SPECIFICATION
BILL OF MATERIALS				
UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			APPROVALS	DATE
1 PLACE DIM $\pm$ 1/16	2 PLACE DIM $\pm$.02	3 PLACE DIM $\pm$.005	ANGLES $\pm$ 1°	
1. DIMENSIONS ARE IN INCHES			DRAWN	10/10/18
2. DIMENSION LIMITS HELD AFTER PLATING.			J. Erickson	
3. REMOVE BURRS AND SHARP EDGES .015 MAX.			ENGINEER	
4. MACHINED FILLET RADII .0150-.030.			J.Erickson	X/XX/XX
5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005			CHECKED	
6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.			PROJECT NO.	901506
			PROJECT	PIV
			WEIGHT	
DO NOT SCALE DRAWING			FIBER OPTIC CABLE PLUG	
			SIZE B	DWG. NO. P-1002444-18
			SCALE 1:1	CAD FILE: SHEET 1 OF 1