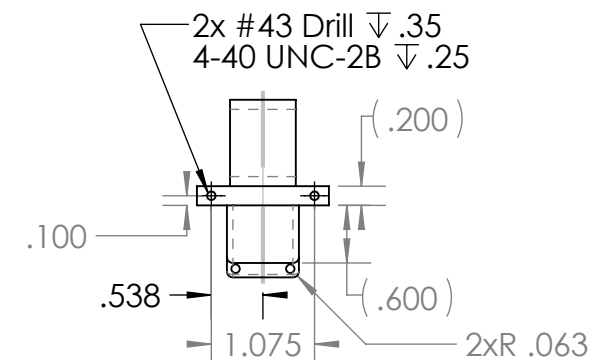
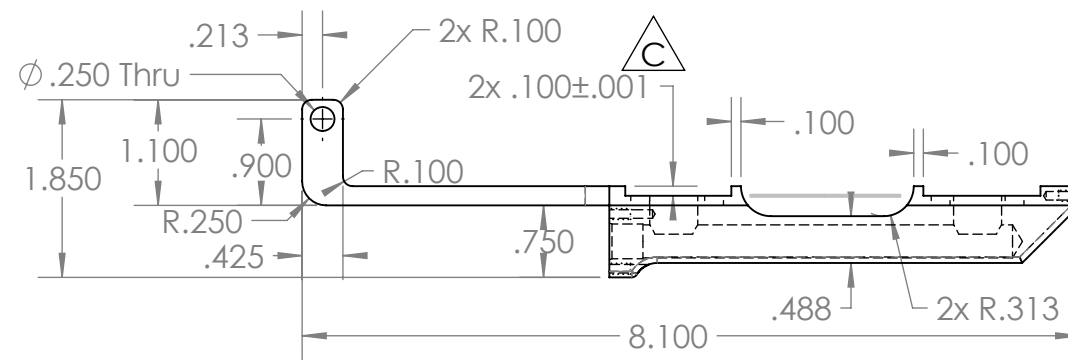
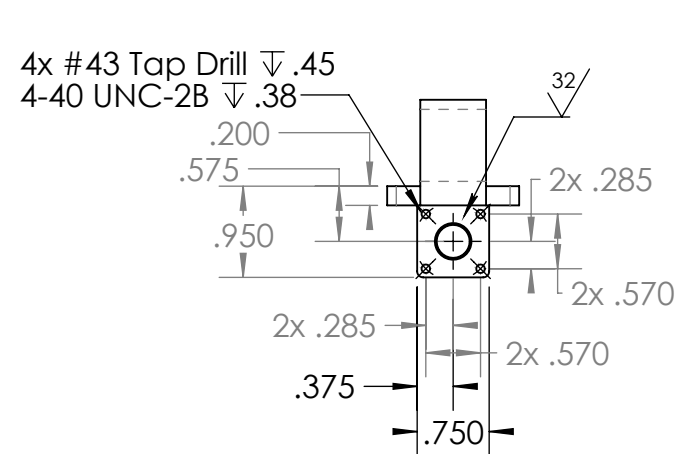
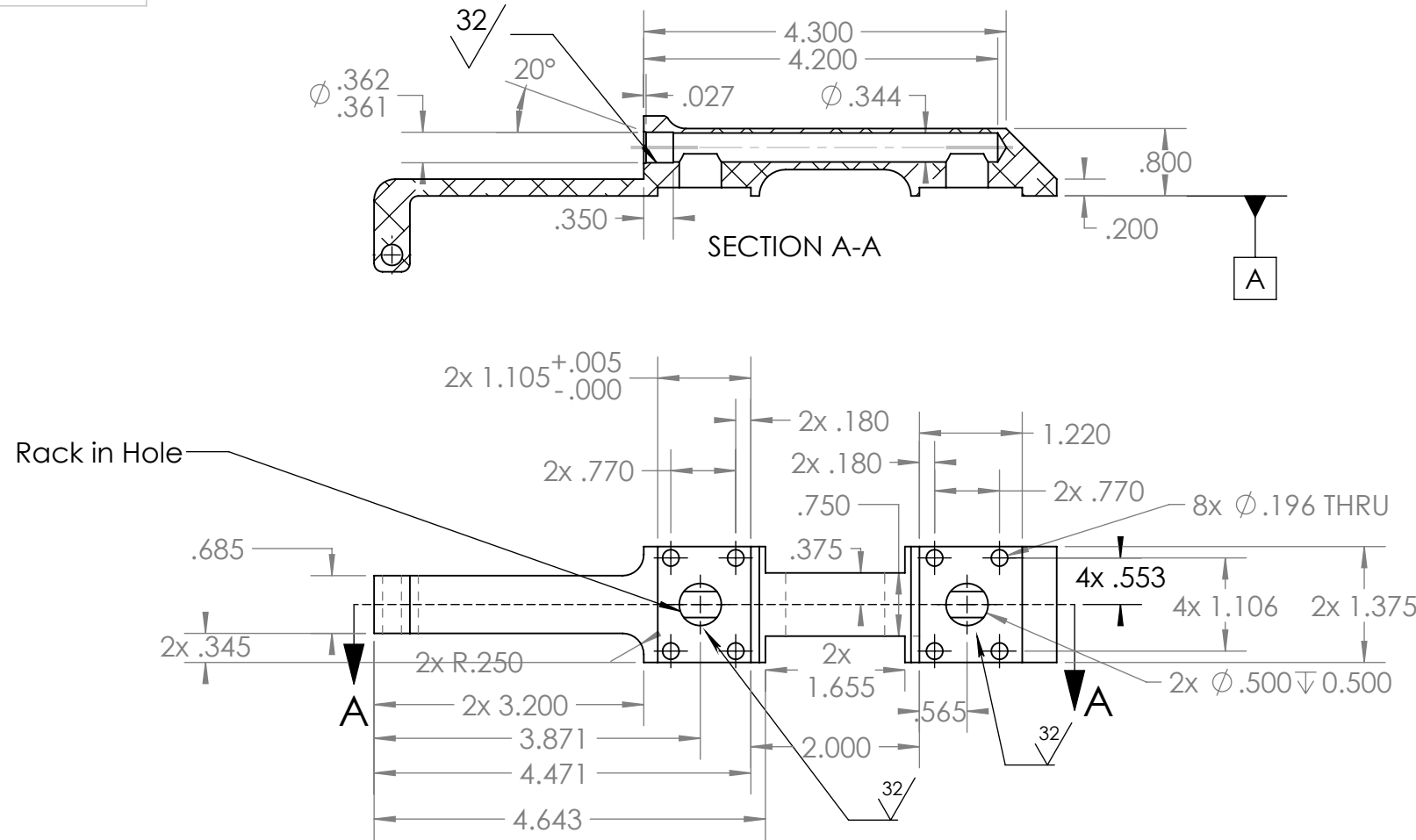
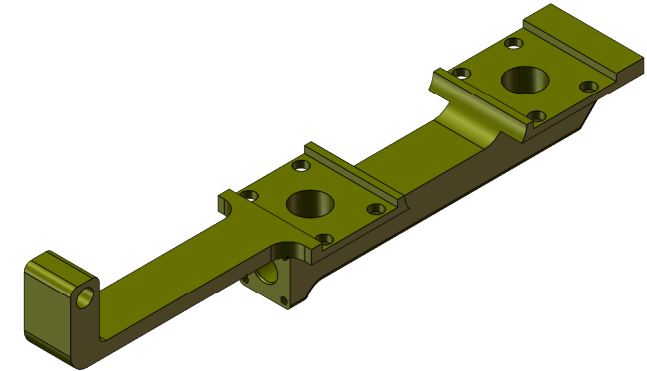


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INITIAL RELEASE		REVISIONS		REVISIONS	
ZONE	REV.	DESCRIPTION	X/XX/YY DATE	BY APPROVED	
	A	Added SF, changed 6-32 tapped to Ø0.2 thru	5/28/09		
	B	Increased width of slot from 1.210 to 1.230	6/1/09		
B-7	C	Changed port to Impulse MKS ADDED +/- .001 TOL.	5/20/11	BH	



11. Q.C. (INSPECTION) REPORT REQUIRED FOR EACH PIECE.

10. Rack as noted

9. FINISH: CLEAR HARD ANODIZE IN ACCORDANCE WITH MIL-A-8625F TYPE III (001" THICK)

8. BREAK ALL SHARP EDGES TO 0.01 IN TUMBLER

7. PROJECT LIBRARY:\900739.LRAUV\Project.Drawings\Project.ME.Dwgs\LRAUV\Tail section\CS Actuators

NOTES:

1	2	P-200708-09	CS LDA Strong Back	MBARI	6061-T6 Alloy
ITEM NO.	QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL
BILL OF MATERIALS					
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS DATE	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°
Shop Foreman		1. DIMENSIONS ARE IN INCHES			
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.			
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.			
		4. MACHINED FILLET RADII .0150-.030.			
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC .005			
	A-200711-13	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX. .012 INCHES FOR SINGLE SURFACE.			
Application		DO NOT SCALE DRAWING		WEIGHT	
				DRAWN B. Hobson 4/12/09 ENGINEER B. Hobson 4/12/09 CHECKED PROJECT NO. 901110 PROJECT Tethys LRAUV SIZE B DWG. NO. P-200708-09.DWG REV. C SCALE 1:2 CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 1	