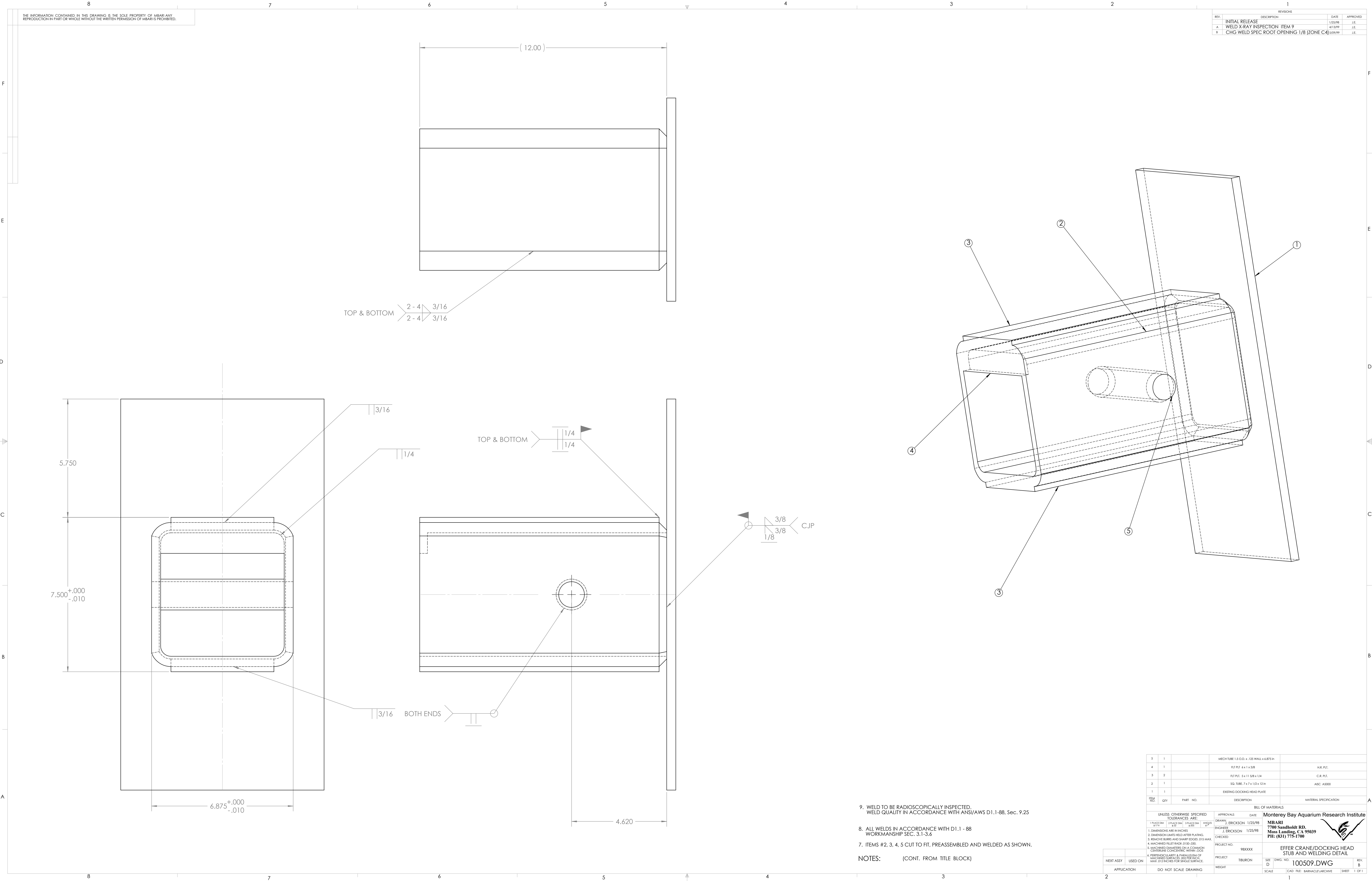




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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE	1/25/98	J.E.
B	WELD X-RAY INSPECTION ITEM 9	4/13/99	J.E.
8	CHG WELD SPEC ROOT OPENING 1/8 (ZONE C4)	5/09/99	J.E.

9. WELD TO BE RADIOSCOPICALLY INSPECTED.
WELD QUALITY IN ACCORDANCE WITH ANSI/AWS D1.1-88, Sec. 9.25

8. ALL WELDS IN ACCORDANCE WITH D1.1 - 88
WORKMANSHIP SEC. 3.1-3.6

7. ITEMS #2, 3, 4, 5 CUT TO FIT, PREASSEMBLED AND WELDED AS SHOWN.

NOTES: (CONT. FROM TITLE BLOCK)

5	1		MECH TUBE 1.5 O.D. x .125 WALL x 6.875 in	
4	1		FLT PLT 6 x 1 x 3/8	H.R. PLT
3	2		FLT PLT 5 x 11 5/8 x 1/4	C.R. PLT
2	1		SG. TUBE 7 x 7 x 1/2 x 12 in	ASCC A5000
1	1		EXISTING DOCKING HEAD PLATE	
ITEM NO.	QTY	PART NO.	DESCRIPTION	MATERIAL SPECIFICATION

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE		BILL OF MATERIALS	
1. PLACE DIM. FIGS.	2. PLACE DIM. FIGS.	3. PLACE DIM. FIGS.	4. PLACE DIM. FIGS.	DRAWN BY	ENGINEER	1/25/98	1/25/98	Monterey Bay Aquarium Research Institute	
1. DIMENSIONS ARE IN INCHES				J.E. ERICKSON		1/25/98		MBARI	
2. DIMENSION LIMITS WELD AFTER PLATING				J.E. ERICKSON		1/25/98		7700 Sandholdt RD.	
3. REMOVE BURRS AND SHARP EDGES .015 MAX.				CHECKED				Moss Landing, CA 95039	
4. MACHINED FLLET RADII .015-.030				PROJECT NO.		98XXXX		PH: (831) 775-1700	
5. HORIZONTALITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH MAX. .013 INCHES PER SQUARE SURFACE.				PROJECT		TIBURON		EFFECT CRANE/DOCKING HEAD STUB AND WELDING DETAIL	
NEXT ASSY		USED ON		WEIGHT		SIZE		DWG. NO. 100509.DWG	
APPLICATION		DO NOT SCALE DRAWING				SCALE		1	

