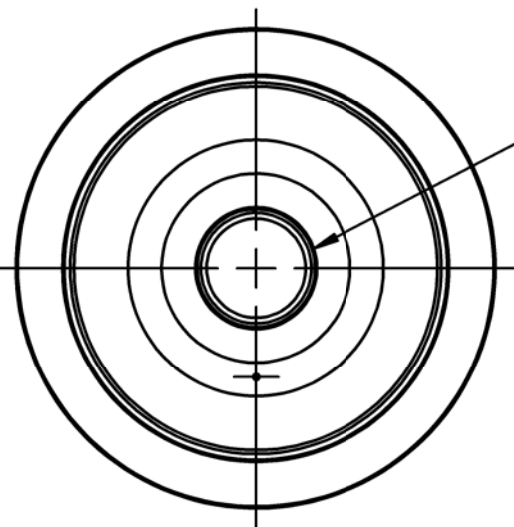


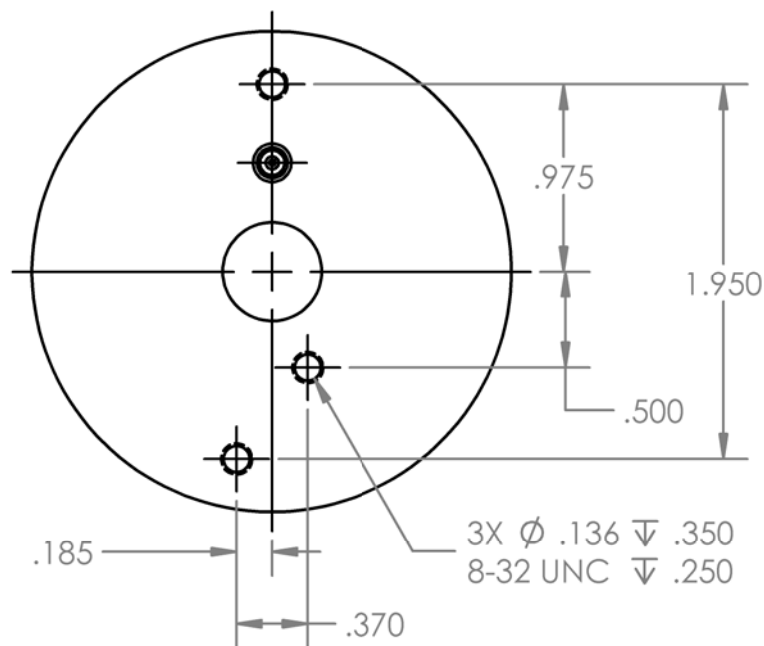
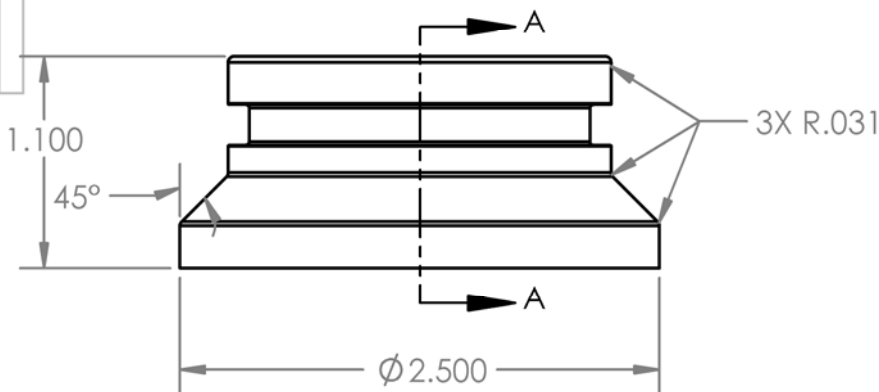
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
B	INITIAL RELEASE	MMM DD, YYYY	Gene M

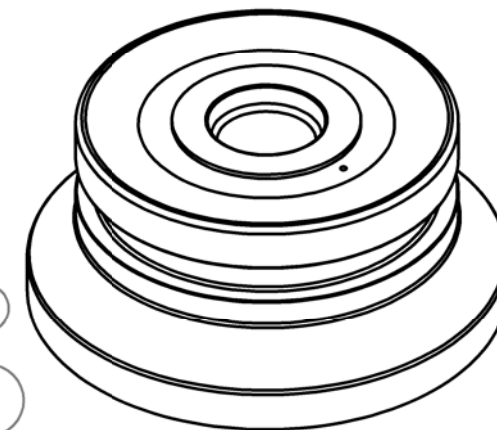
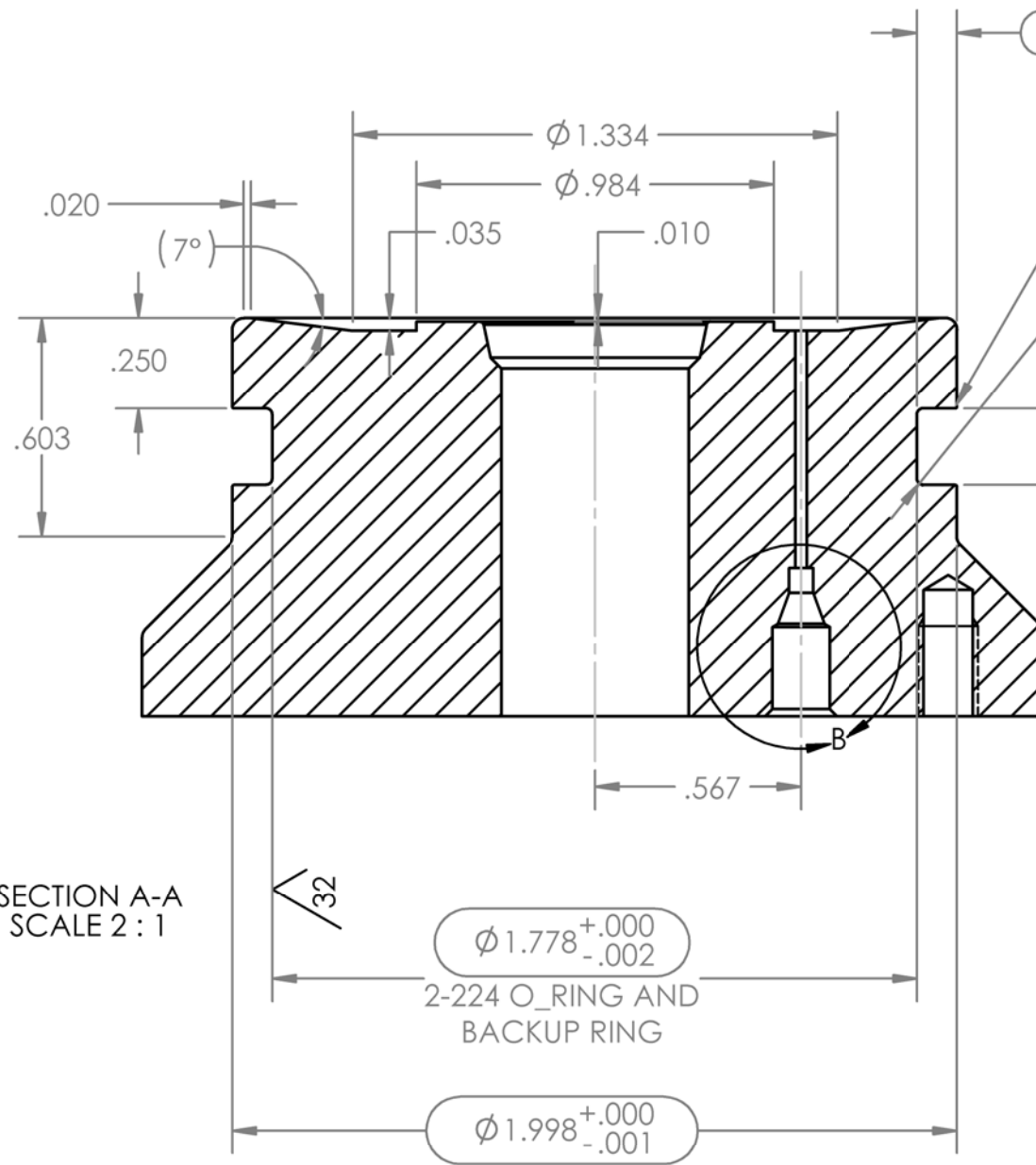
D
C
B
A



SAE J1926/1-6 PORT
9/16-18 UNF DRILL THRU
Ø.969 ±0.000-0.010



SECTION A-A
SCALE 2 : 1



2X BREAK
APP. R.005

2X R.025
R.010

3/32
GAGE BALL

.160±.002 TO
TOP OF BALL

Ø.067+.002
-.001

40°±1°

135°
118°

DRILL POINT

.195 MIN
FULL THREAD

DETAIL B
SCALE 4 : 1

- NOTES:
Mat'l: Titanium, 6Al-4V with certs
Unless otherwise specified:
1. Concentricity of all diameters: 0.004 TIR
2. Cut threads only, no forming taps allowed
3. OK to use porting tool for 10-32 coned port

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 Gene M.
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.	ENGINEER Gene M.
			CHECKED
			PROJECT NO. 901217
			PROJECT Chem Sensors
		DO NOT SCALE DRAWING	MAT'L
			2
Monterey Bay Aquarium Research Institute			
MBARI			
7700 Sandholdt Rd. Moss Landing, CA 95039 831 775-1922			
END CAP, PT CHAMBER			
SIZE B	DWG. NO. 1-20082015-901206	REV. B	
SCALE 1:2	CAD FILE:	SHEET 1 OF 1	