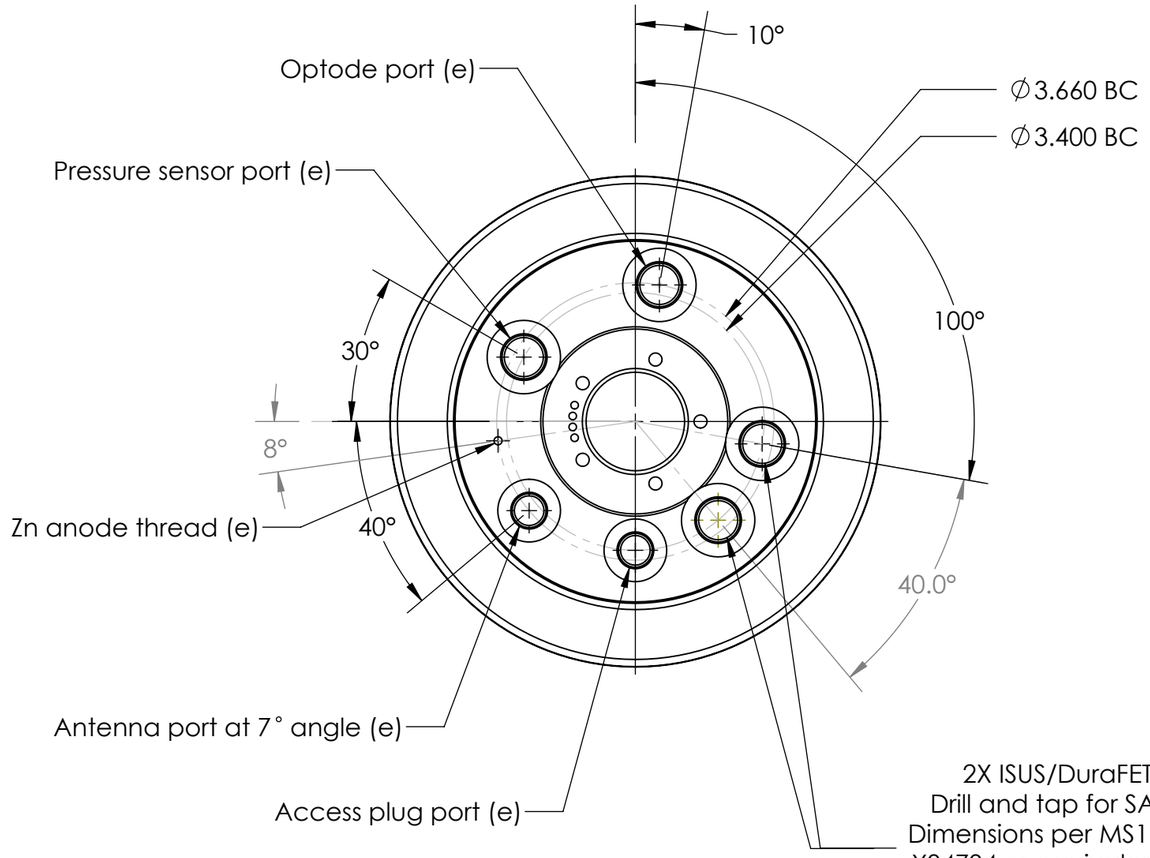
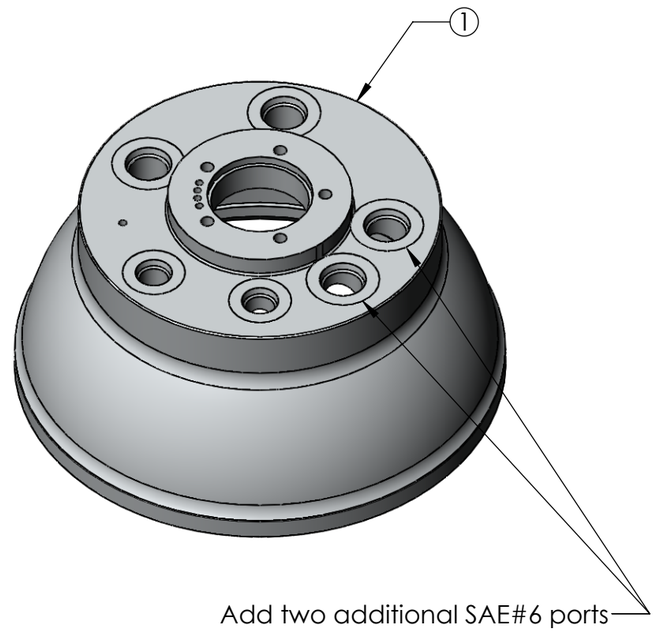
| REVISIONS | | | |
|---|---|---|---|
| REV. | DESCRIPTION | DATE | APPROVED |
| | INITIAL RELEASE | | |
| A | Dual SAE#6 ports | 6/22/12 | hwj |




2X ISUS/DuraFET Probe ports on R1.7
Drill and tap for SAE Boss fitting size No. 6.
Dimensions per MS16142. Use Parker Tool No. Y34734 or equivalent hydraulic port contour cutter. Tap thru for 9/16-18 UNF-2B.
Tap .005 oversize (to account for anodizing).

**Modifications to APEX top endcap**
Based on Webb Drawing No 2583
(End Cap, Upper APEX, Iridium + Optode Version)
Add two extra hole before anodizing
All other features, specifications and anodizing per Webb drawing

| Item No. | Qty | Part No. | Description | Material Specification |
|---|---|---|---|---|
| 1 | 1 | | Upper APEX Endcap, Iridium, Optode and ISUS version | 6061 Extruded Aluminum T6511 |

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° | | DRAWN Hans Jannasch | 10/7/08 |
| Shop Foreman | | 1. DIMENSIONS ARE IN INCHES | | ENGINEER | |
| Engineer | | 2. DIMENSION LIMITS HELD AFTER PLATING. | | CHECKED Jon Erickson | 10/31/08 |
| | | 3. REMOVE BURRS AND SHARP EDGES .015 MAX. | | PROJECT NO. 701818 | |
| NEXT ASSY Description | NEXT ASSY Number | 4. MACHINED FILLET RADII .0150-.030. | | PROJECT NSF Floats | |
| | | 5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .OO5 | | | |
| | | 6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX .012 INCHES FOR SINGLE SURFACE. | | | |
| Application | | DO NOT SCALE DRAWING | | WEIGHT | |

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Moss Landing, CA 95039
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APEX+ISUS Ver 2a
Top Endcap Modifications

| SIZE | DWG. NO. | REV |
|---|---|---|
| B | 208jahaAPEX+ISUSv2TopEndCapMods | A |

SCALE 1:3 | CAD FILE: Tornado/chem/SWfiles | SHEET 1 OF 1