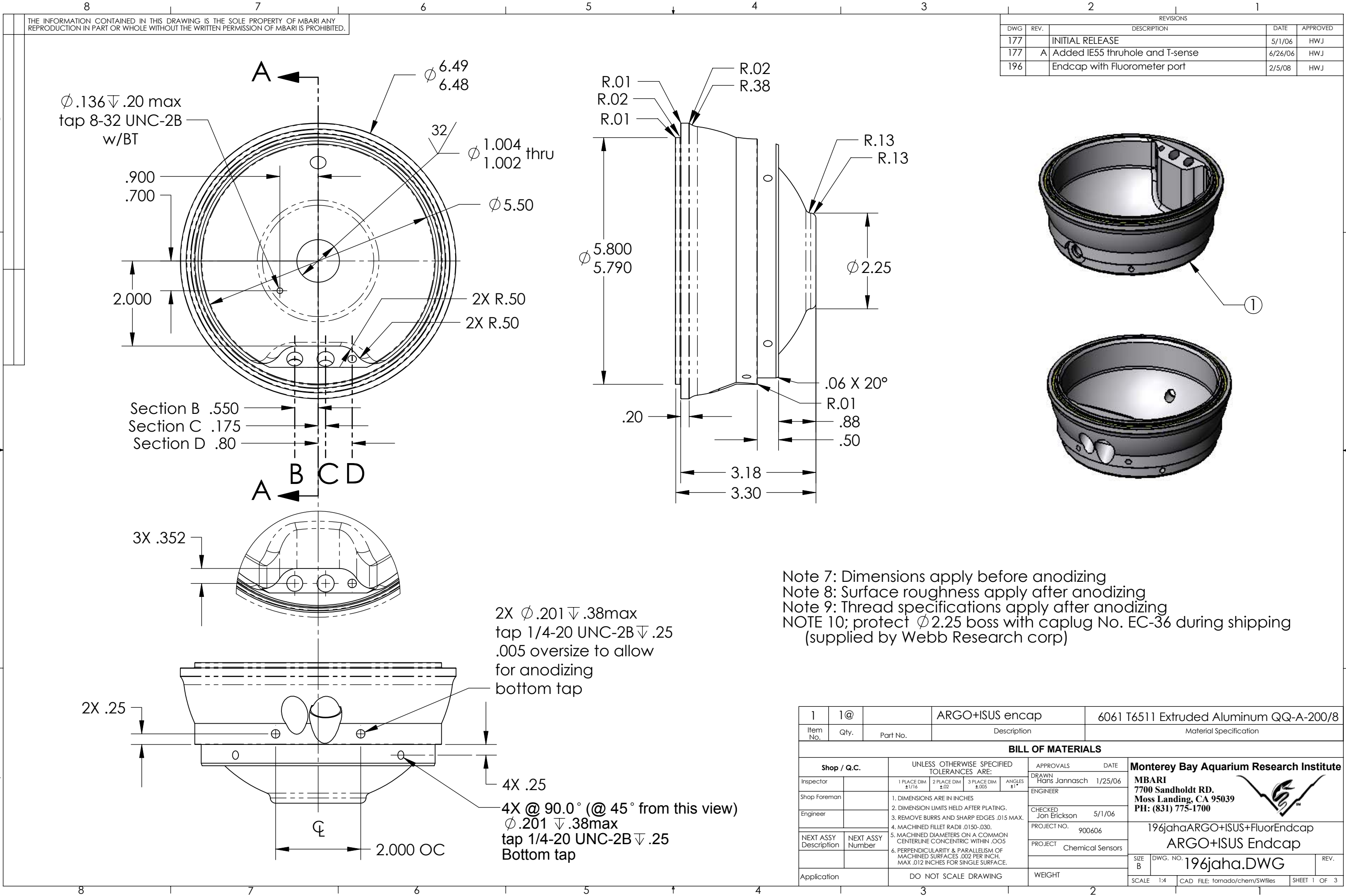




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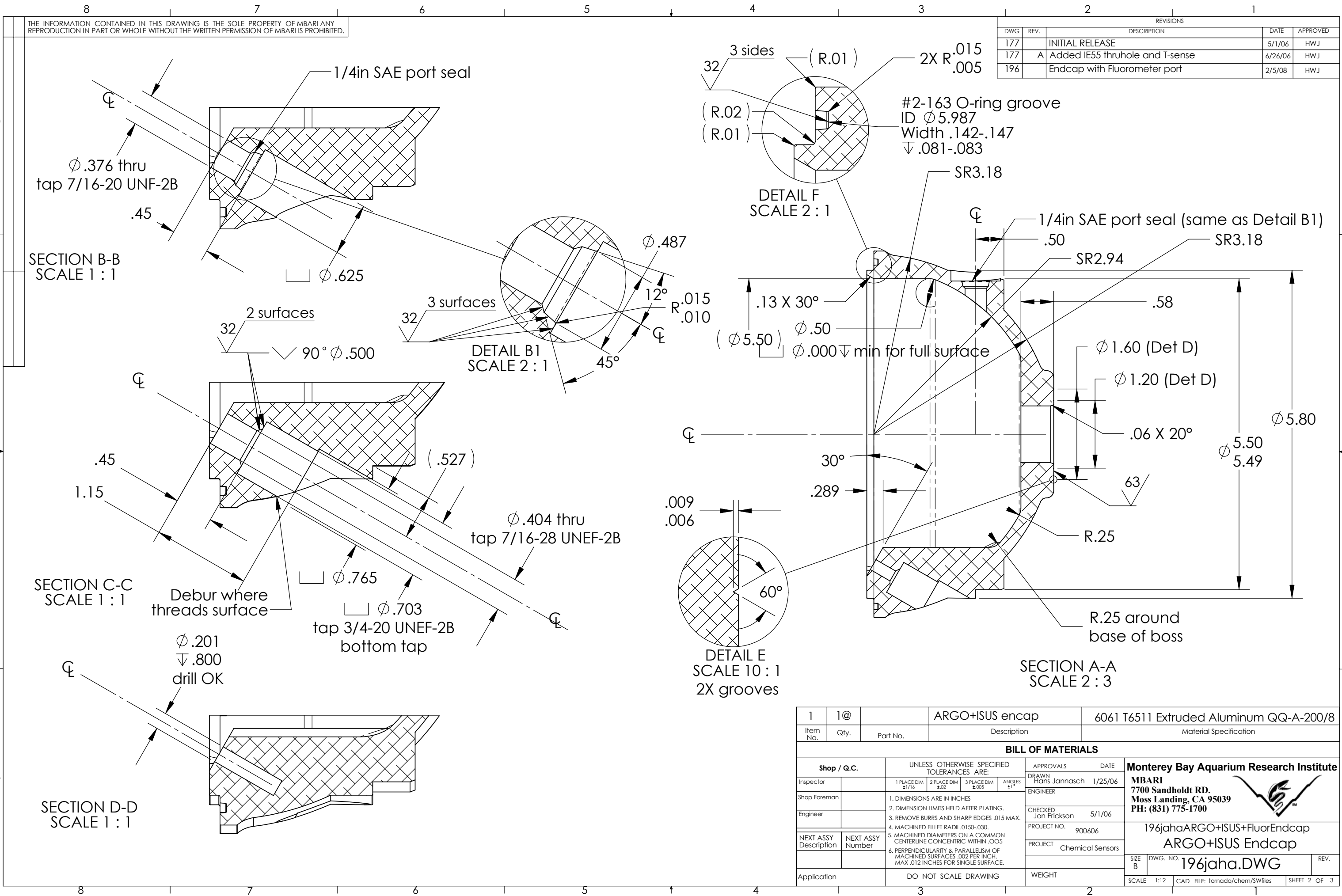
REVISIONS				
DWG	REV.	DESCRIPTION	DATE	APPROVED
177		INITIAL RELEASE	5/1/06	HWJ
177	A	Added IE55 thruhole and T-sense	6/26/06	HWJ
196		Endcap with Fluorometer port	2/5/08	HWJ

Note 7: Dimensions apply before anodizing
Note 8: Surface roughness apply after anodizing
Note 9: Thread specifications apply after anodizing
NOTE 10; protect $\phi 2.25$ boss with caplug No. EC-36 during shipping (supplied by Webb Research corp)

1	1@	ARGO+ISUS encap			6061 T6511 Extruded Aluminum QQ-A-200/8			
Item No.	Qty.	Part No.	Description			Material Specification		
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 1/25/06		
Shop Foreman		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		
Engineer						CHECKED Jon Erickson 5/1/06		
NEXT ASSY Description						NEXT ASSY Number		PROJECT NO. 900606
						PROJECT Chemical Sensors		
						SIZE B DWG. NO. 196jaha.DWG		
Application		DO NOT SCALE DRAWING			WEIGHT		REV.	
							SCALE 1:4	CAD FILE: tornado/chem/SWfiles
							SHEET 1 OF 3	

Monterey Bay Aquarium Research Institute
MBARI
7700 Sandholdt RD.
Moss Landing, CA 95039
PH: (831) 775-1700

196jahaARGO+ISUS+FluorEndcap
ARGO+ISUS Endcap



REVISIONS				
DWG	REV.	DESCRIPTION	DATE	APPROVED
177		INITIAL RELEASE	5/1/06	HWJ
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1		1@		ARGO+ISUS encap			6061 T6511 Extruded Aluminum QQ-A-200/8				
Item No.		Qty.		Part No.		Description			Material Specification		
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 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.				DRAWN Hans Jannasch		1/25/06	
Engineer								ENGINEER			
								CHECKED Jon Erickson		5/1/06	
NEXT ASSY Description		NEXT ASSY Number		PROJECT NO.				900606		196jahaARGO+ISUS+FluorEndcap ARGO+ISUS Endcap	
				PROJECT				Chemical Sensors			
Application				DO NOT SCALE DRAWING				WEIGHT		SIZE B	
										DWG. NO.	
										196jaha.DWG	
								SCALE 1:12		CAD FILE: tornado/chem/SWfiles	
										SHEET 2 OF 3	

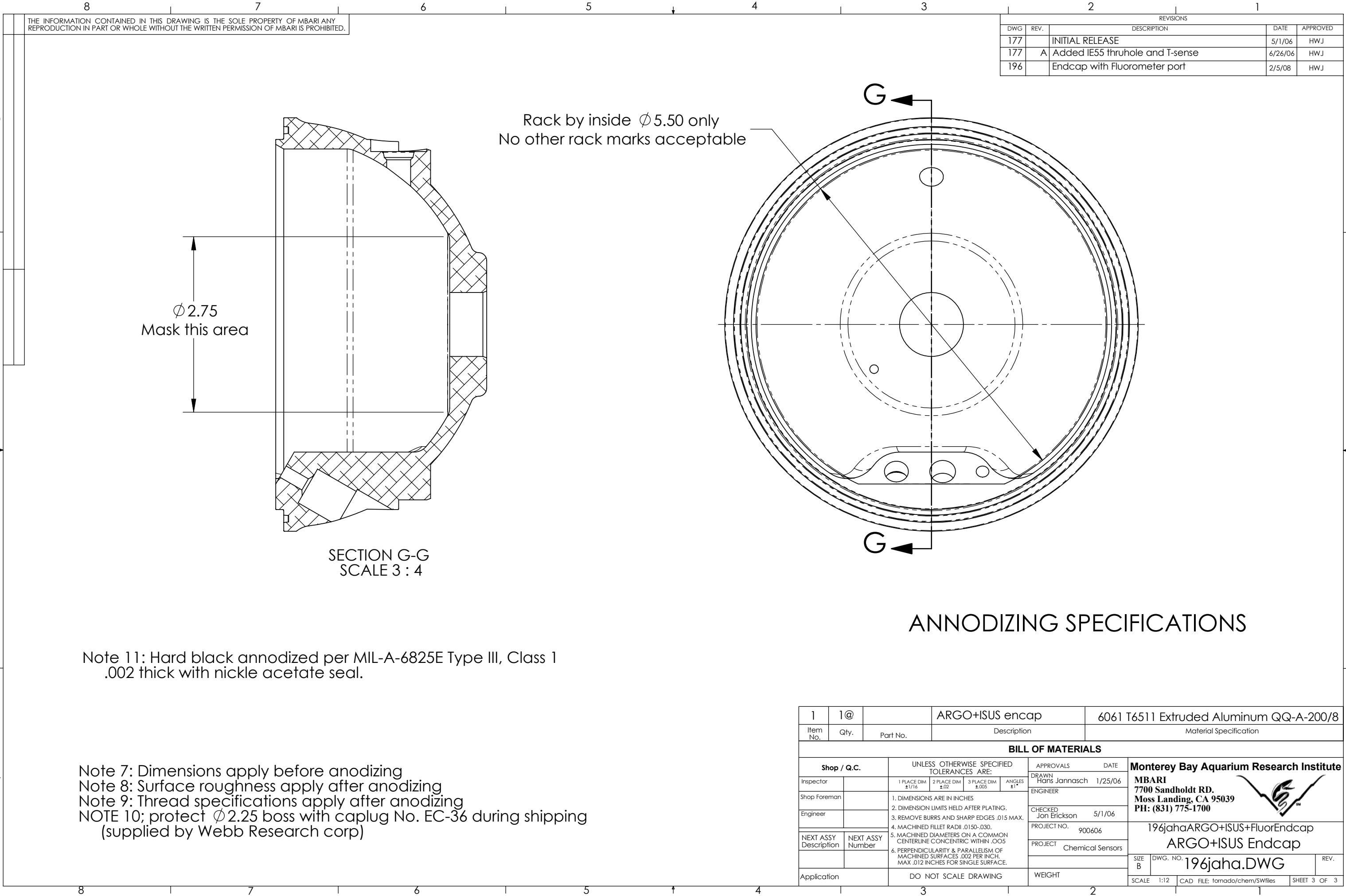
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196jahaARGO+ISUS+FluorEndcap

ARGO+ISUS Endcap



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REVISIONS				
DWG	REV.	DESCRIPTION	DATE	APPROVED
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177	A	Added IE55 thruhole and T-sense	6/26/06	HWJ
196		Endcap with Fluorometer port	2/5/08	HWJ

Ø 2.75
Mask this area

Rack by inside Ø 5.50 only
No other rack marks acceptable

SECTION G-G
SCALE 3 : 4

ANNODIZING SPECIFICATIONS

Note 11: Hard black annodized per MIL-A-6825E Type III, Class 1
.002 thick with nickle acetate seal.

Note 7: Dimensions apply before anodizing
Note 8: Surface roughness apply after anodizing
Note 9: Thread specifications apply after anodizing
NOTE 10; protect Ø 2.25 boss with caplug No. EC-36 during shipping
(supplied by Webb Research corp)

1	1@		ARGO+ISUS encap	6061 T6511 Extruded Aluminum QQ-A-200/8
Item No.	Qty.	Part No.	Description	Material Specification
BILL OF MATERIALS				
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS DATE
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	DRAWN Hans Jannasch 1/25/06
Shop Foreman		3 PLACE DIM ±.005	ANGLES ±1°	ENGINEER
Engineer		1. DIMENSIONS ARE IN INCHES		CHECKED Jon Erickson 5/1/06
		2. DIMENSION LIMITS HELD AFTER PLATING.		PROJECT NO. 900606
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		PROJECT Chemical Sensors
		4. MACHINED FILLET RADII .0150-.030.		
NEXT ASSY Description	NEXT ASSY Number	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.		
Application		DO NOT SCALE DRAWING		WEIGHT
			SCALE 1:12	DWG. NO. 196jaha.DWG
			CAD FILE: tornado/chem/SWfiles	REV.
			SHEET 3 OF 3	

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