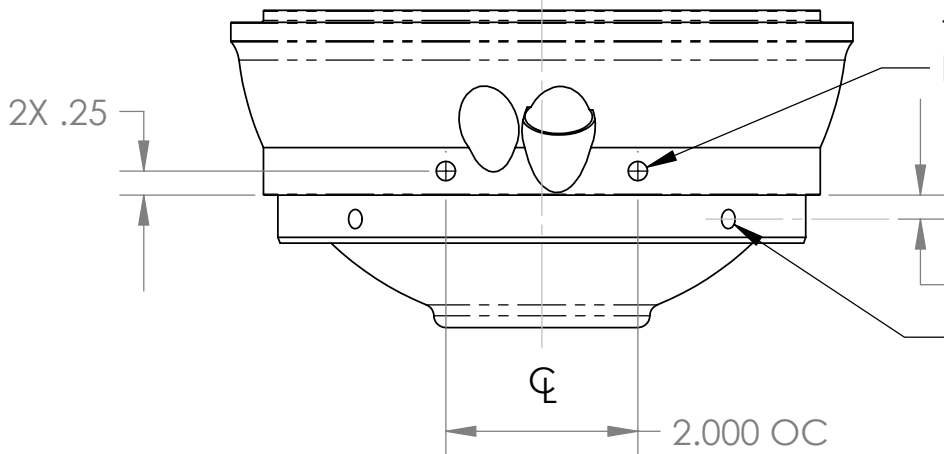
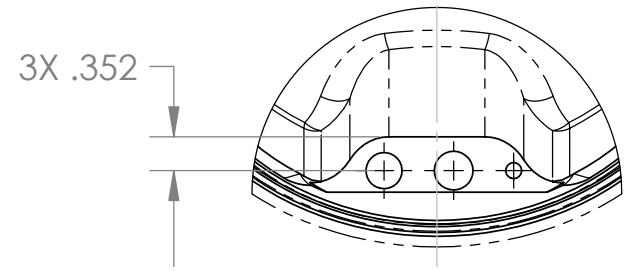
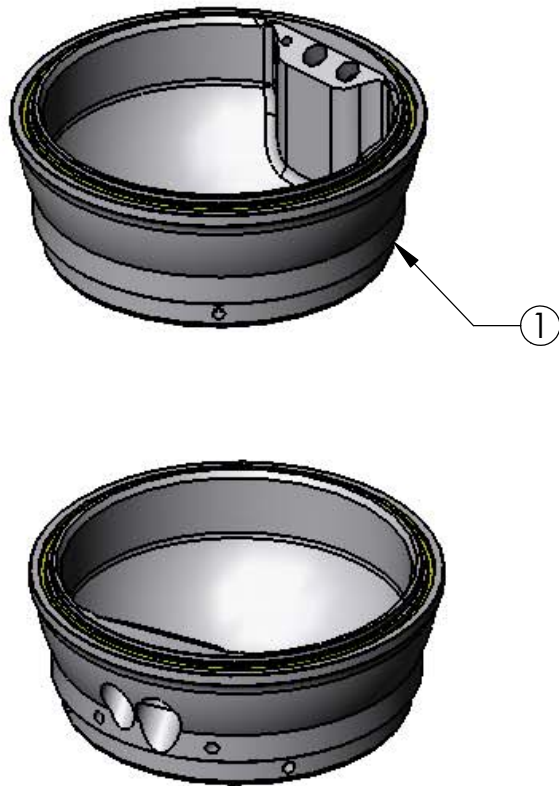
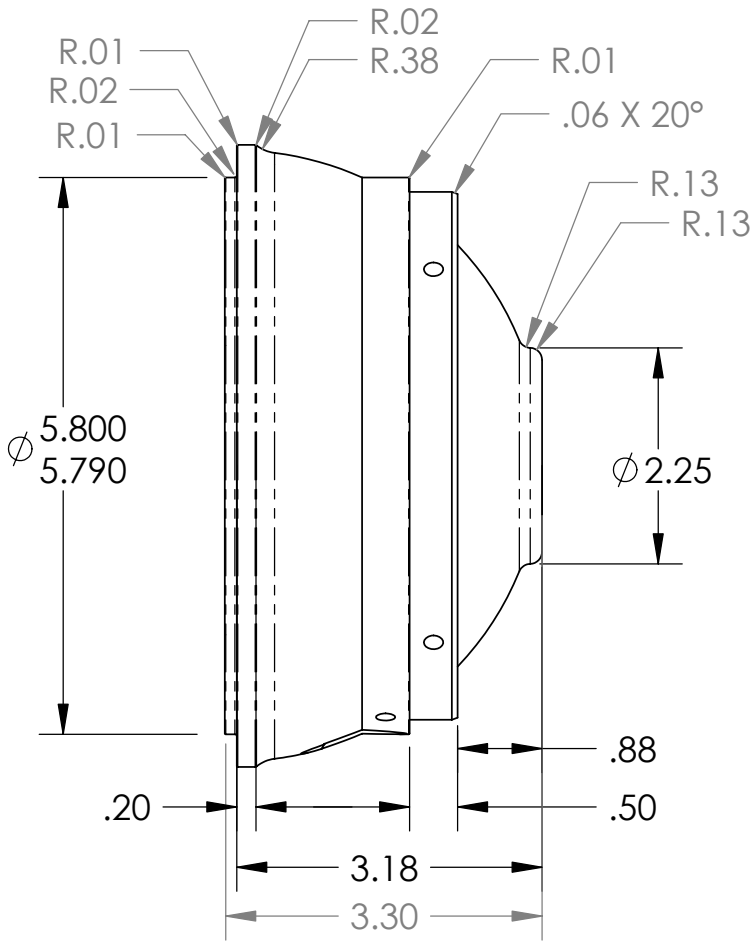
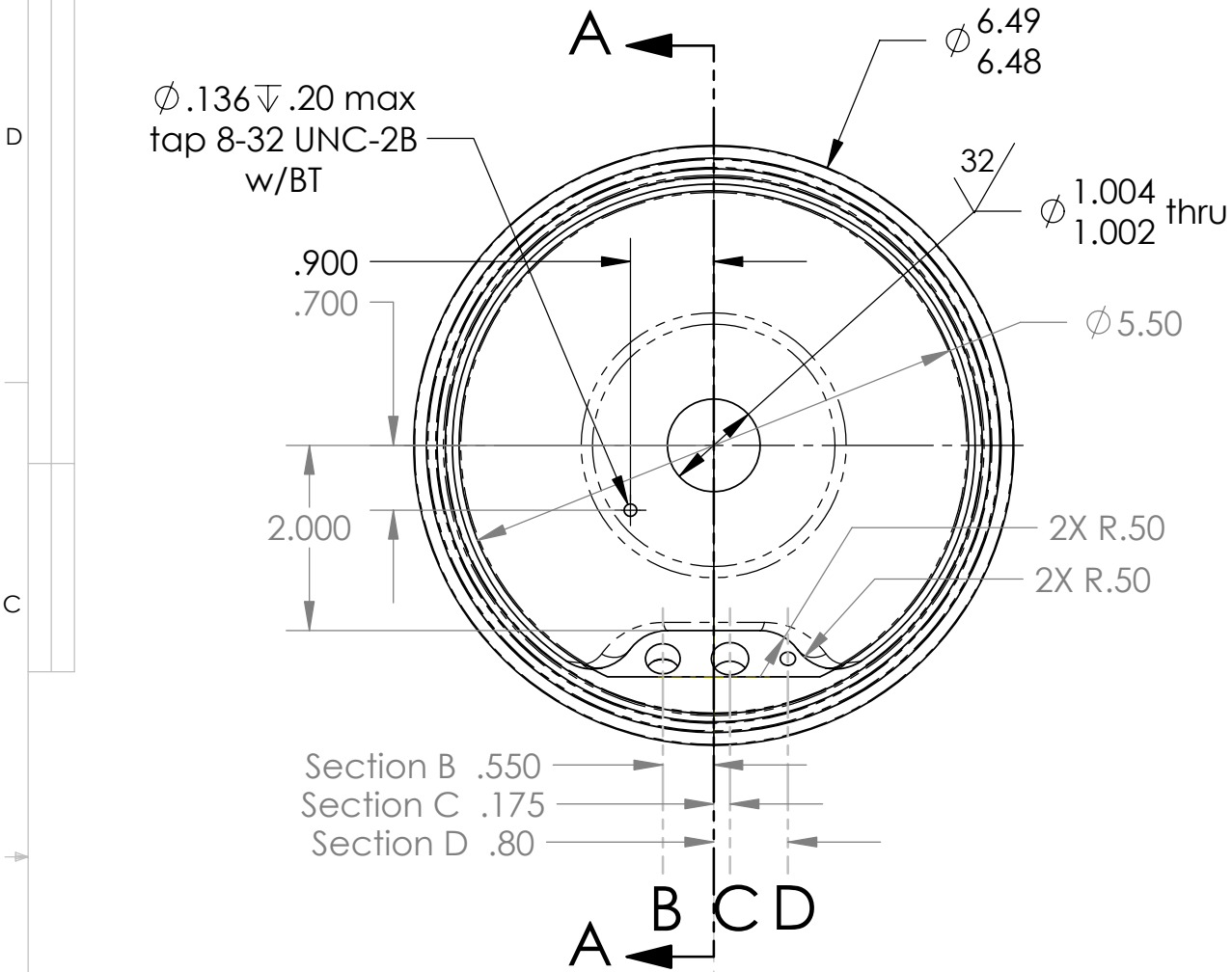


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	5/1/06	HWJ
A	Added IE55 thruhole and T-sense	6/26/06	HWJ



2X $\phi .201 \nabla .38$ max
tap 1/4-20 UNC-2B $\nabla .25$
.005 oversize to allow
for anodizing
bottom tap

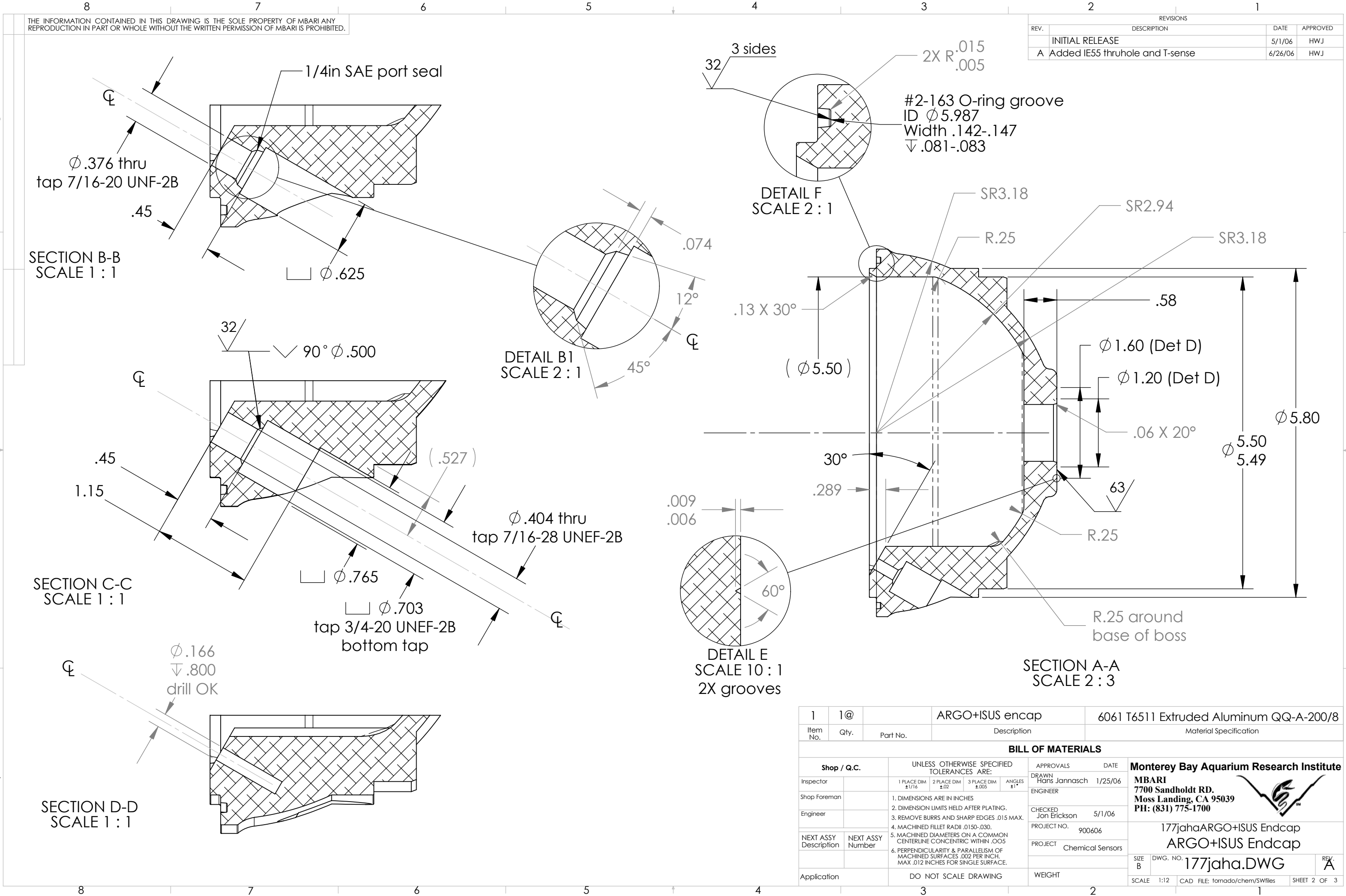
4X $\phi .25$
4X @ 90.0° (@ 45° from this view)
 $\phi .201 \nabla .38$ max
tap 1/4-20 UNC-2B $\nabla .25$
Bottom tap

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		Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700 			
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		CHECKED Jon Erickson 5/1/06					
Engineer						PROJECT NO.		900606					
NEXT ASSY Description						NEXT ASSY Number		PROJECT				Chemical Sensors	
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B		DWG. NO. 177jaha.DWG		REV. A	
		3				2		SCALE 1:4		CAD FILE: tornado/chem/SWfiles		SHEET 1 OF 3	

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177jahaARGO+ISUS Endcap
ARGO+ISUS Endcap



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
INITIAL RELEASE		5/1/06	HWJ
A	Added IE55 thruhole and T-sense	6/26/06	HWJ

SECTION B-B
SCALE 1 : 1

SECTION C-C
SCALE 1 : 1

SECTION D-D
SCALE 1 : 1

DETAIL F
SCALE 2 : 1

DETAIL B1
SCALE 2 : 1

DETAIL E
SCALE 10 : 1
2X grooves

SECTION A-A
SCALE 2 : 3

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
				PROJECT	Chemical Sensors
				SIZE B	DWG. NO.
Application		DO NOT SCALE DRAWING		WEIGHT	
				SCALE 1:12	CAD FILE: tornado/chem/SWfiles
				SHEET 2 OF 3	

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ARGO+ISUS Endcap

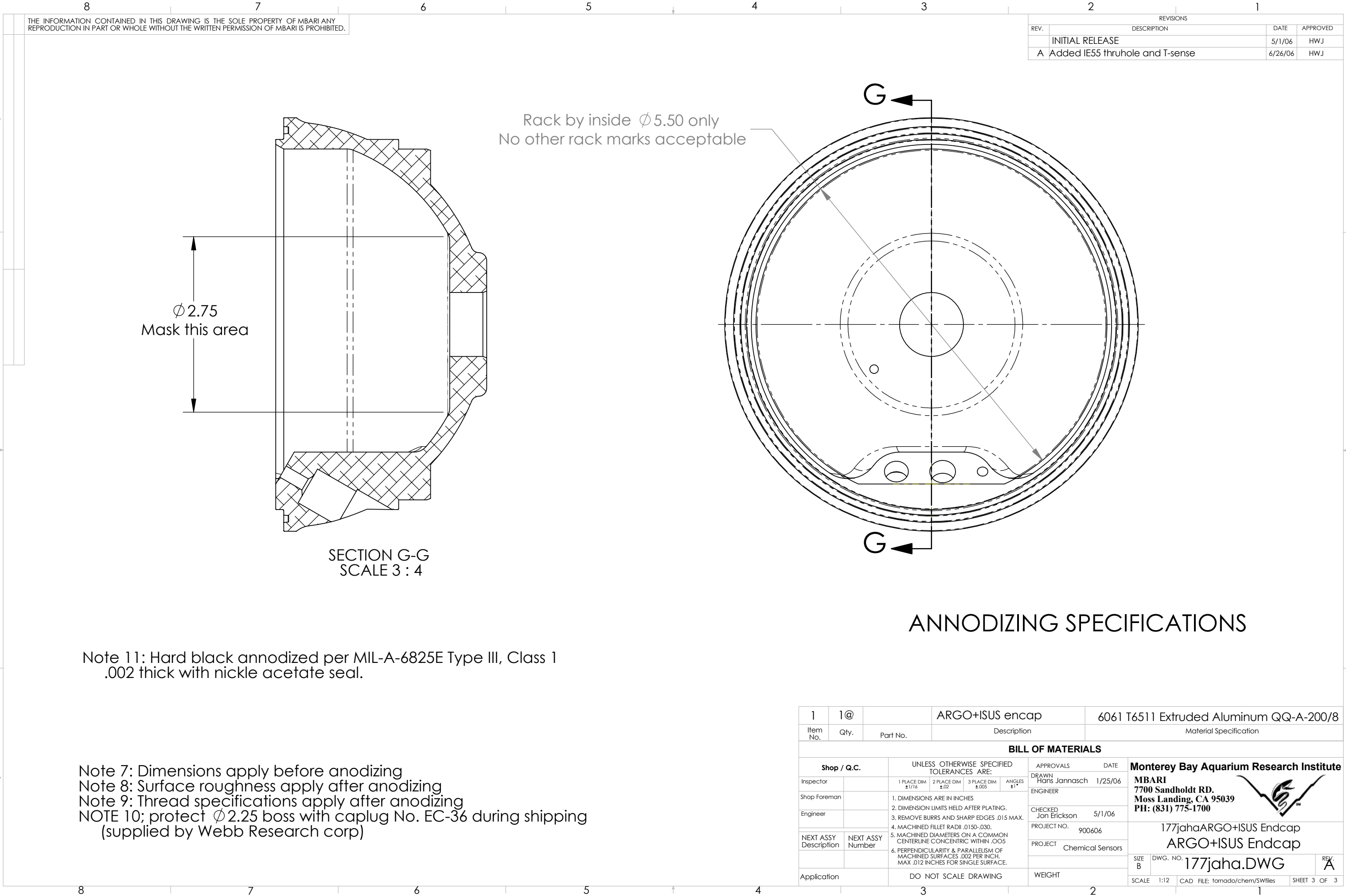
177jaha.DWG

REV. A

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REV. A



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	5/1/06	HWJ
A	Added IE55 thruhole and T-sense	6/26/06	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 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.		CHECKED Jon Erickson 5/1/06
NEXT ASSY Description	NEXT ASSY Number			PROJECT 900606
				PROJECT Chemical Sensors
				WEIGHT
				SIZE B
				DWG. NO. 177jaha.DWG
				REV. A
				SCALE 1:12
				CAD FILE: tornado/chem/SWfiles
				SHEET 3 OF 3

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