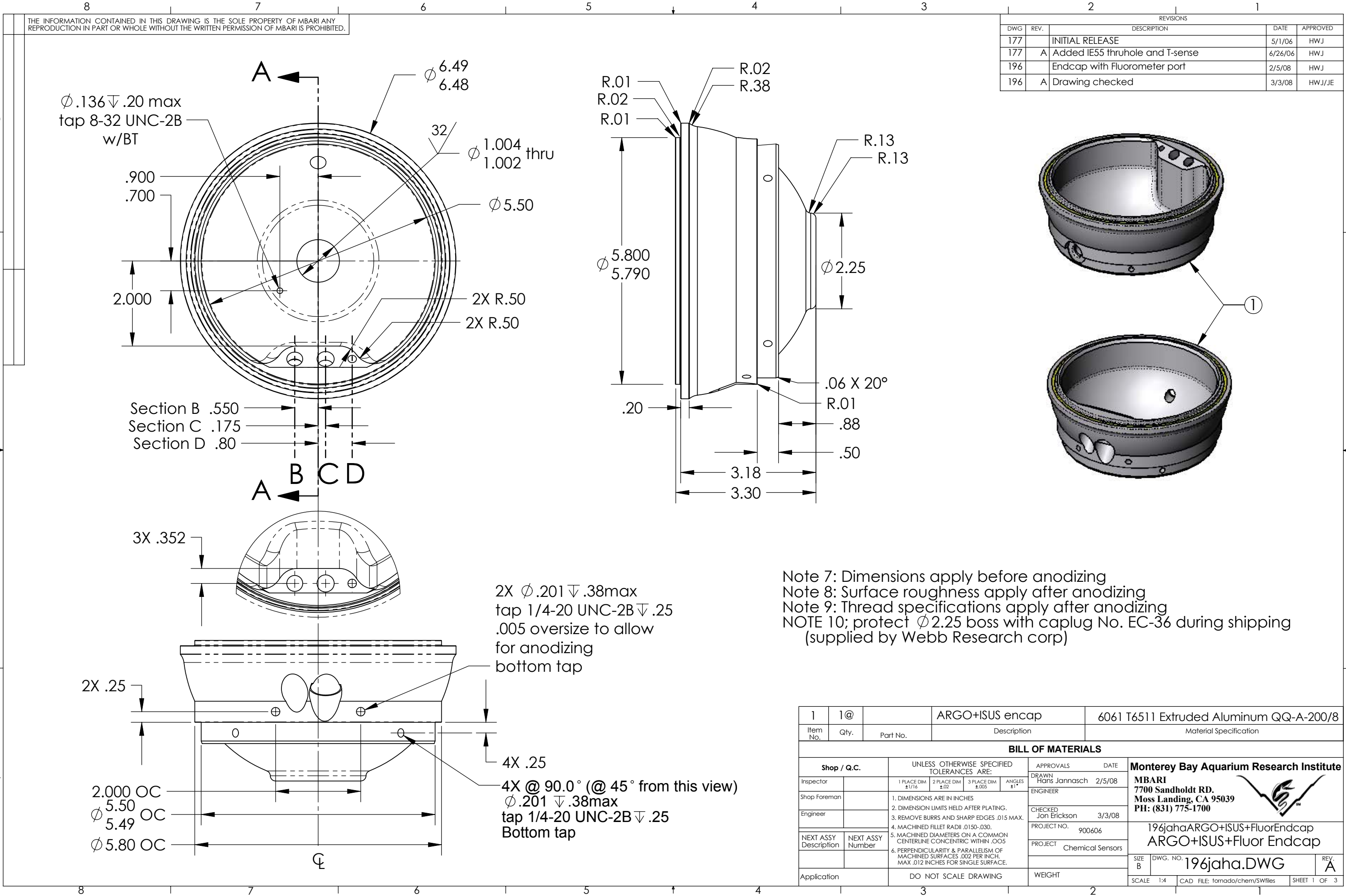




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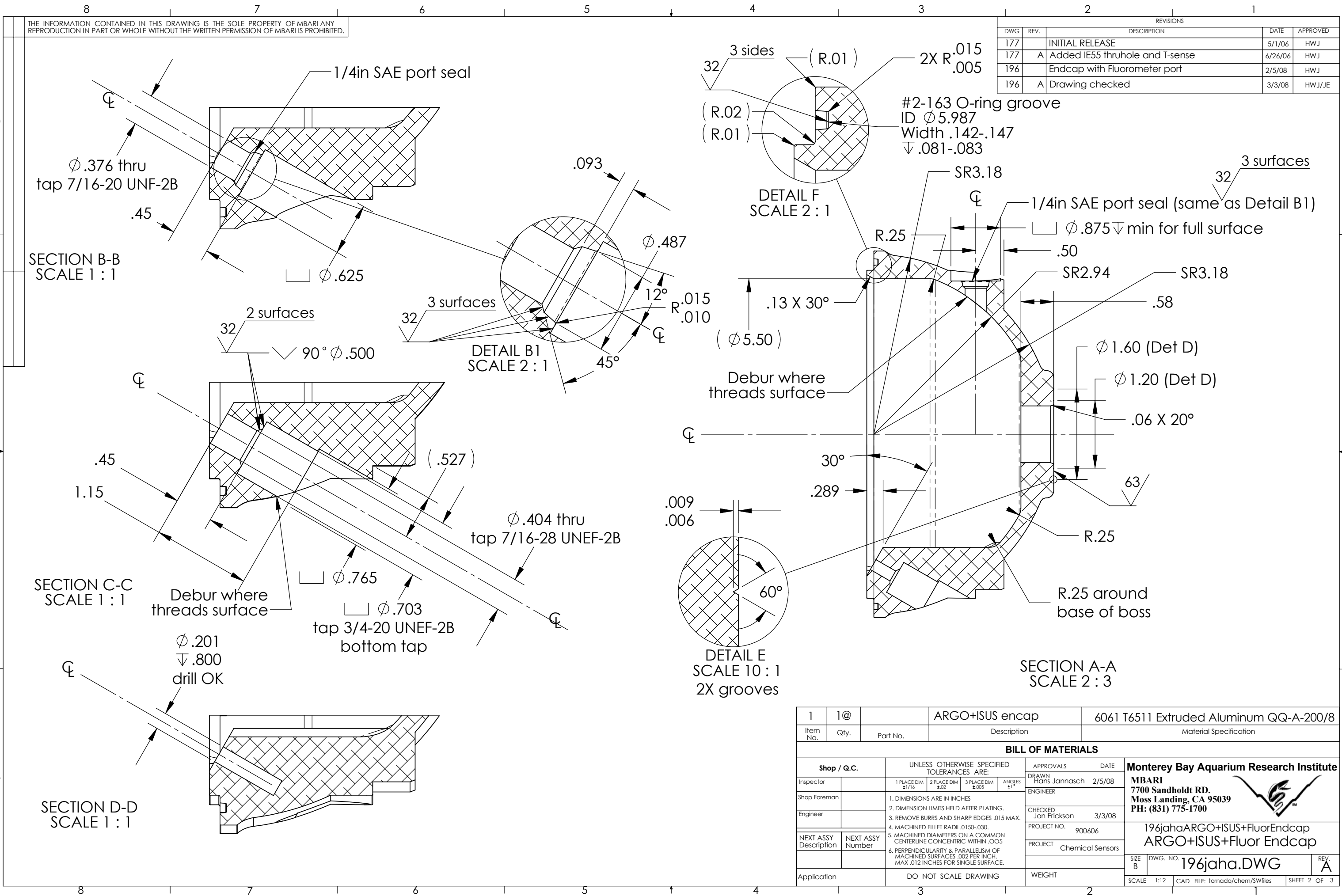
REVISIONS				
DWG	REV.	DESCRIPTION	DATE	APPROVED
177		INITIAL RELEASE	5/1/06	HWJ
177	A	Added IE55 thruhole and T-sense	6/26/06	HWJ
196		Endcap with Fluorometer port	2/5/08	HWJ
196	A	Drawing checked	3/3/08	HWJ/JE

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	DRAWN Hans Jannasch 2/5/08	
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 3/3/08	
NEXT ASSY Description					PROJECT NO. 900606	
NEXT ASSY Number					PROJECT Chemical Sensors	
Application		DO NOT SCALE DRAWING			WEIGHT	
					SIZE B DWG. NO. 196jaha.DWG	
					REV. A	
					SCALE 1:4 CAD FILE: tornado/chem/SWfiles SHEET 1 OF 3	

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MBARI
7700 Sandholdt RD.
Moss Landing, CA 95039
PH: (831) 775-1700

196jahaARGO+ISUS+FluorEndcap
ARGO+ISUS+Fluor Endcap



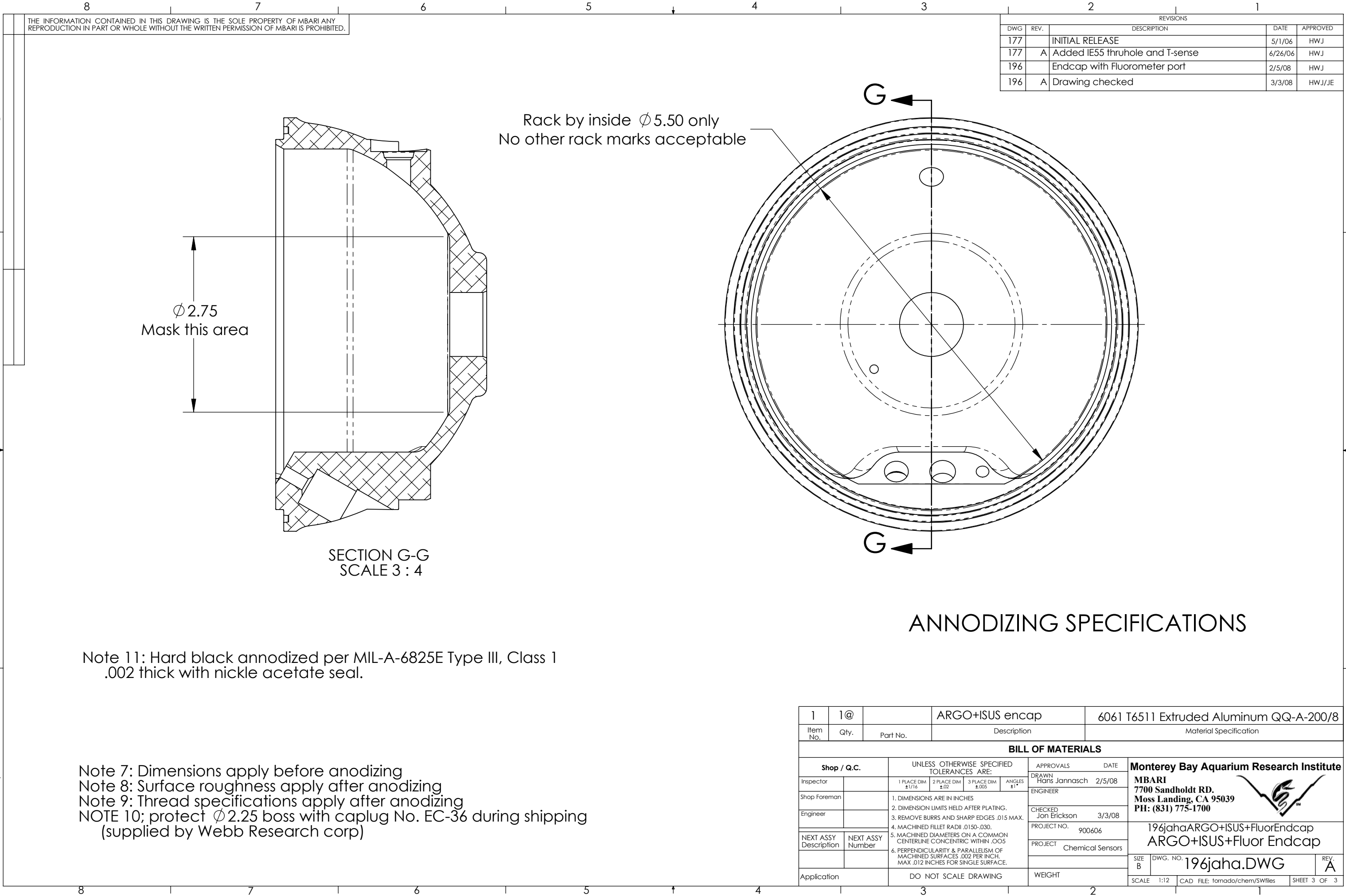
REVISIONS				
DWG	REV.	DESCRIPTION	DATE	APPROVED
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1	1@	ARGO+ISUS encap			6061 T6511 Extruded Aluminum QQ-A-200/8					
Item No.	Qty.	Part No.	Description			Material Specification				
BILL OF MATERIALS										
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			APPROVALS		DATE			
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	DRAWN Hans Jannasch		2/5/08			
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		Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700 			
Engineer					CHECKED Jon Erickson				3/3/08	
NEXT ASSY Description					NEXT ASSY Number				PROJECT NO. 900606	
				PROJECT Chemical Sensors		196jahaARGO+ISUS+FluorEndcap ARGO+ISUS+Fluor Endcap				
						SIZE B	DWG. NO. 196jaha.DWG	REV. A		
Application		DO NOT SCALE DRAWING			WEIGHT		SCALE 1:12	CAD FILE: tornado/chem/SWfiles	SHEET 2 OF 3	

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		REVISIONS		
DWG	REV.	DESCRIPTION	DATE	APPROVED
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196		Endcap with Fluorometer port	2/5/08	HWJ
196	A	Drawing checked	3/3/08	HWJ/JE

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 2/5/08
Shop Foreman		3 PLACE DIM ±.005	ANGLES ±1°	ENGINEER
Engineer		1. DIMENSIONS ARE IN INCHES		CHECKED Jon Erickson 3/3/08
		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. A
			SHEET 3 OF 3	

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