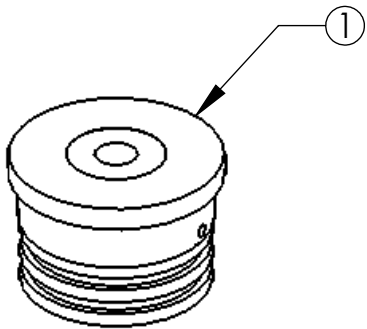
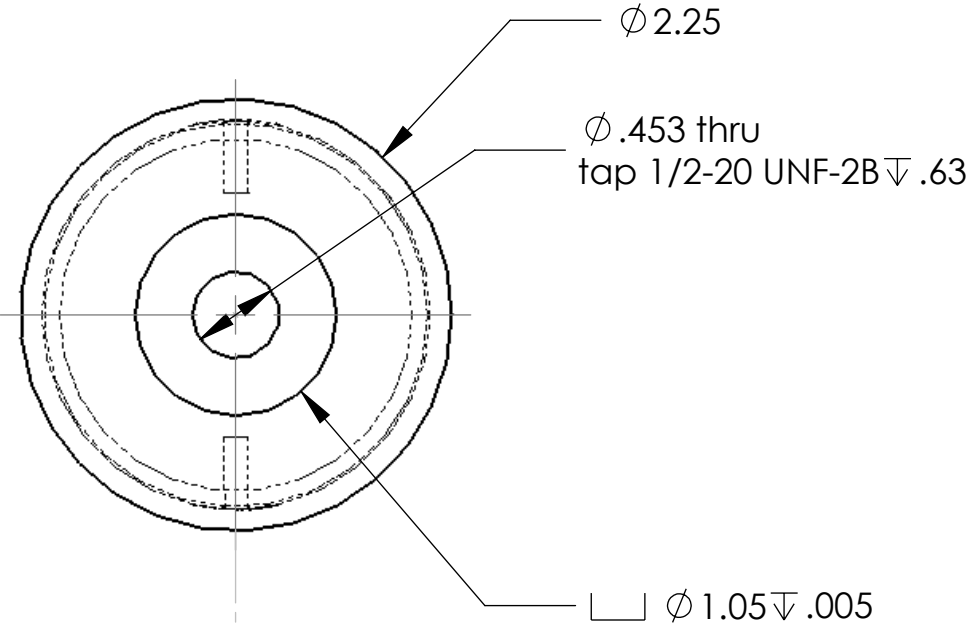
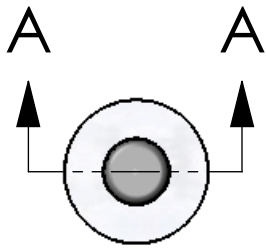


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		
A	Removed vent scREW	4/15/10	HWJ



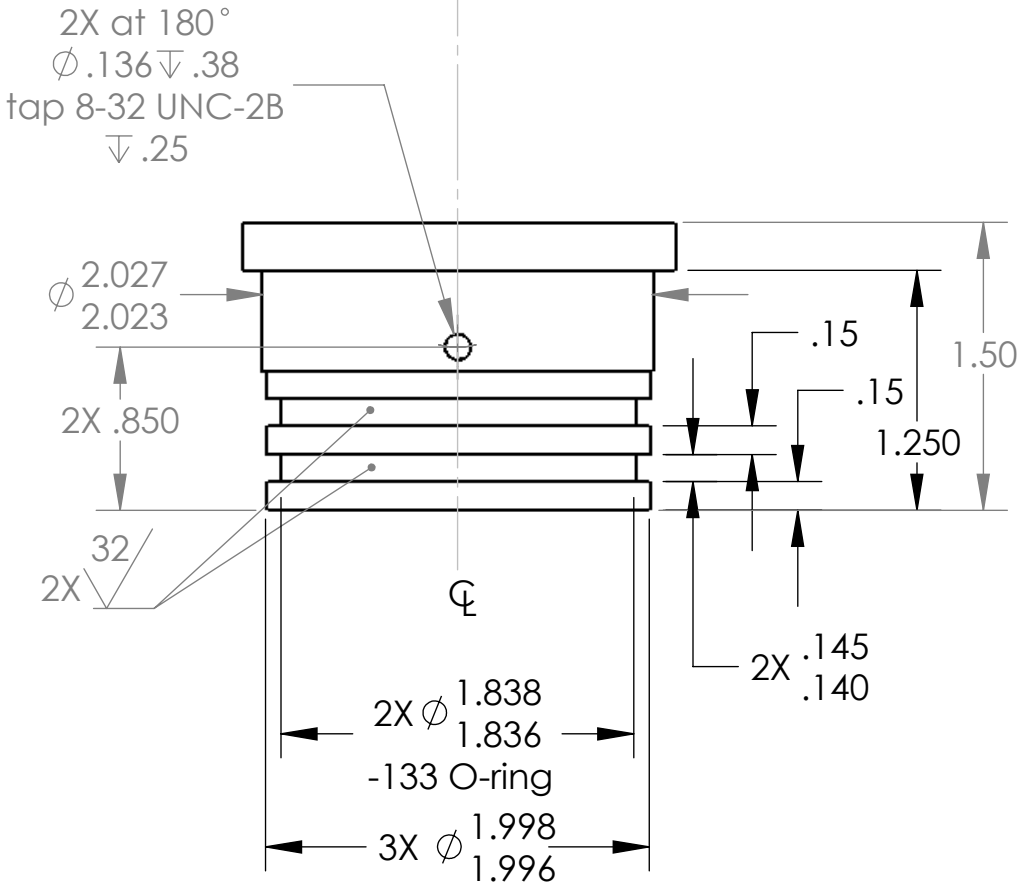
Batrry Pack Assembly

Notes:
7: Machine parts 1, 5 and 7.
8: Parts 5,6 and 7 are bonded together for Lower Battery Pack Assembly and tested to be leak-free.

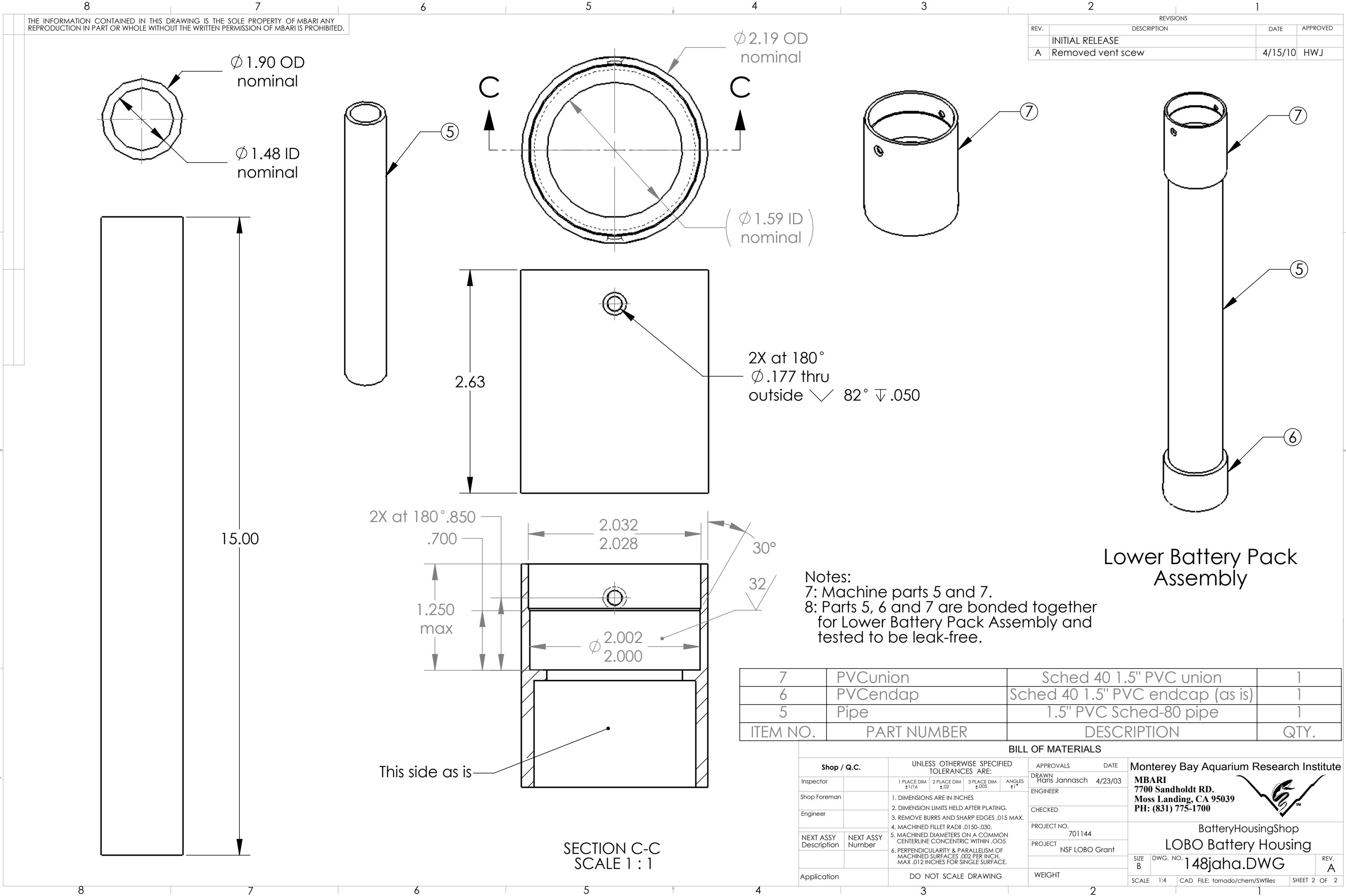
7	PVCunion	Sched 40 1.5" PVC union	1
6	PVCendap	Sched 40 1.5" PVC endcap	1
5	Pipe	1.5" PVC Sched-80 pipe	1
4	TripleDoubleDpack	Battieries supplied by MBARI	1
3	2-133	-133 O-ring	2
2	VSG-BCL-4-HP SS	Seacon Connector	1
1	ConnEnd	Gray PVC Rod	1
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.

BILL OF MATERIALS

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS	DATE	Monterey Bay Aquarium Research Institute	
Inspector		1 PLACE DIM $\pm 1/16$	2 PLACE DIM $\pm .02$	3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$	DRAWN	Hans Jannasch
Shop Foreman		1. DIMENSIONS ARE IN INCHES				ENGINEER	4/23/03
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.				CHECKED	
NEXT ASSY Description	NEXT ASSY Number	3. REMOVE BURRS AND SHARP EDGES .015 MAX.				PROJECT NO.	701144
		4. MACHINED FILLET RADII .0150-.030.				PROJECT	NSF LOBO Grant
		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005				WEIGHT	
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.				SCALE	1:4
Application		DO NOT SCALE DRAWING				CAD FILE:	tornado/chem/SWfiles
						SHEET	1 OF 2



SECTION A-A
SCALE 1 : 3



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		
A	Removed vent screw	4/15/10	HWJ

Ø 2.19 OD nominal

Ø 1.90 OD nominal

Ø 1.48 ID nominal

(Ø 1.59 ID nominal)

2X at 180°
Ø .177 thru
outside 82° .050

2X at 180°.850

1.250 max

2.032
2.028

Ø 2.002
2.000

30°

32°

Notes:
7: Machine parts 5 and 7.
8: Parts 5, 6 and 7 are bonded together for Lower Battery Pack Assembly and tested to be leak-free.

Lower Battery Pack Assembly

7	PVCunion	Sched 40 1.5" PVC union	1
6	PVCendap	Sched 40 1.5" PVC endcap (as is)	1
5	Pipe	1.5" PVC Sched-80 pipe	1
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.

BILL OF MATERIALS

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE		Monterey Bay Aquarium Research Institute			
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN Hans Jannasch	4/23/03		MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700 				
Shop Foreman		1. DIMENSIONS ARE IN INCHES				ENGINEER							
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.				CHECKED							
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.				PROJECT NO.							
		4. MACHINED FILLET RADII .0150-.030.				701144							
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005				PROJECT		NSF LOBO Grant					
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.											
Application		DO NOT SCALE DRAWING				WEIGHT							