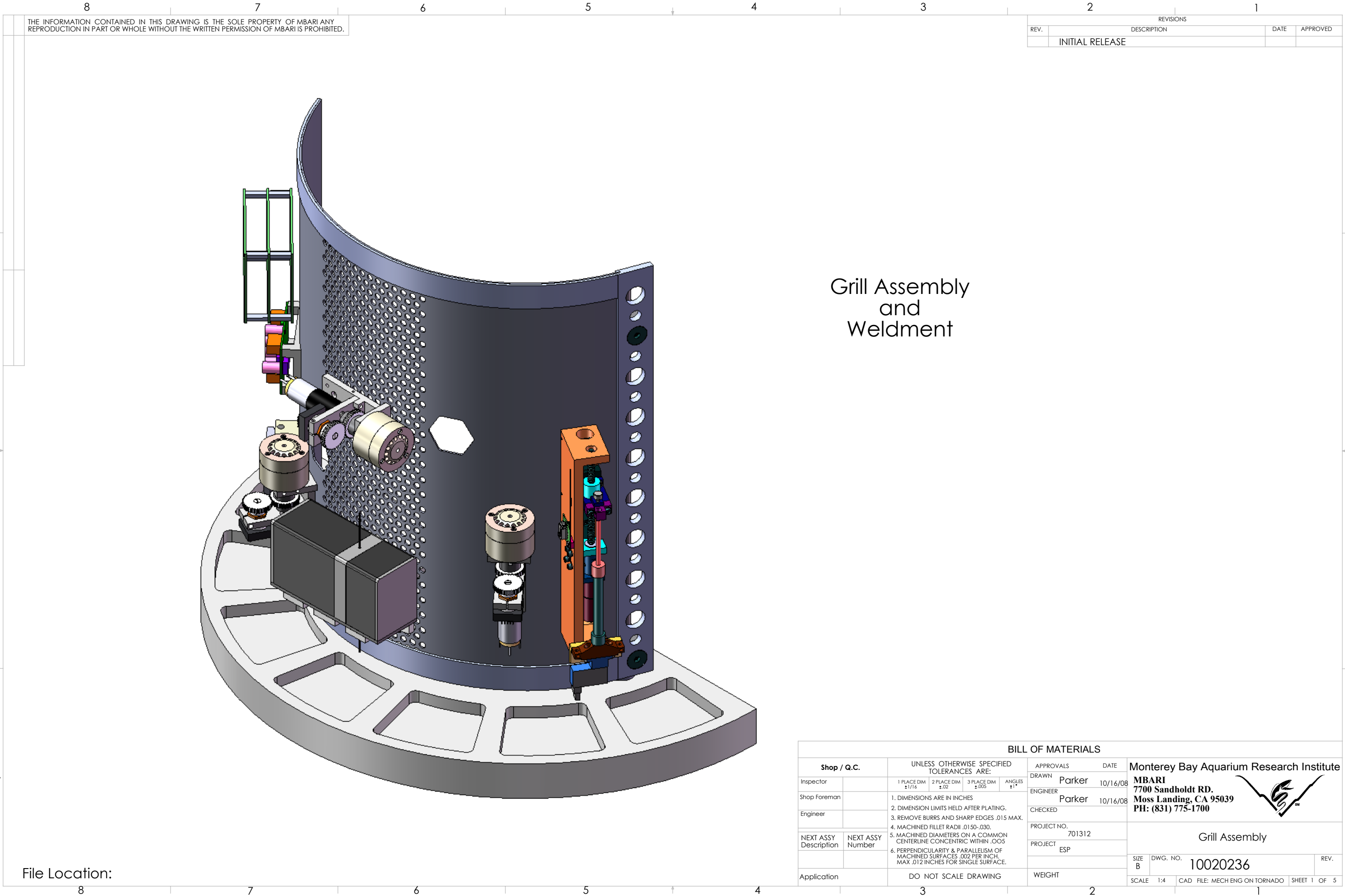


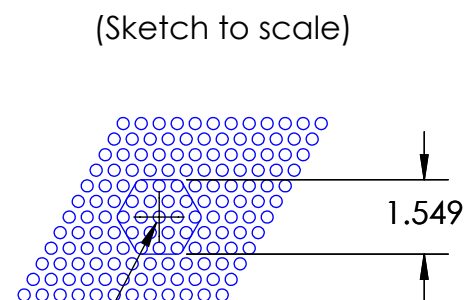


Grill Assembly
and
Weldment

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

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  Grill Assembly	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN	Parker	10/16/08			
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	Parker	10/16/08			
Engineer						CHECKED					
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	701312				
						PROJECT	ESP				
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B	DWG. NO.	10020236	REV.
							SCALE 1:4	CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 5		



Referenced x/y dims
used as center of hex

McMaster Carr Part #9232T231
(Aluminum .25 dia holes on .375 centers
.063 thk rolled to 8" radius.)

✓Note: Some holes not shown

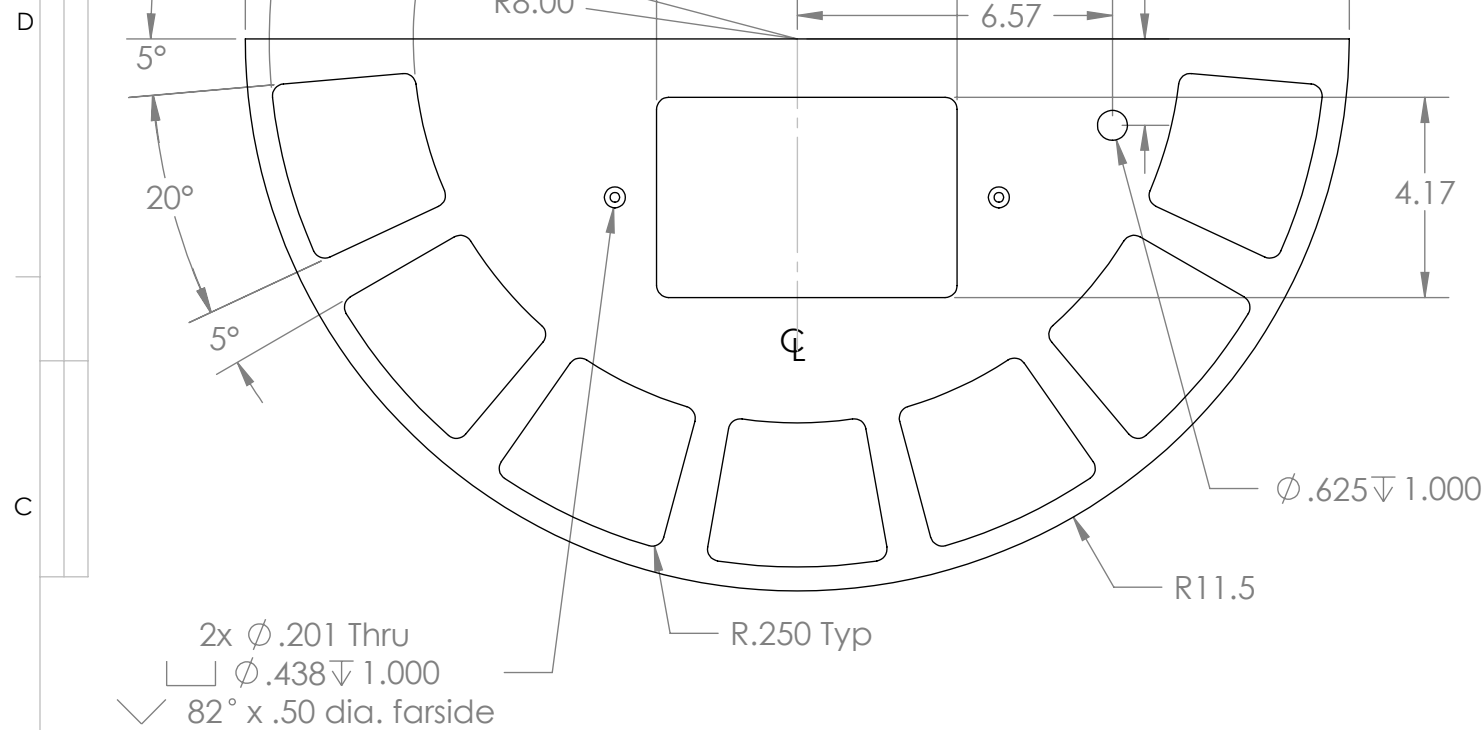
BILL OF MATERIALS											
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE		Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700 	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN	Parker	10/16/08			
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	Parker	10/16/08	Grill		
Engineer						CHECKED					
NEXT ASSY Description NEXT ASSY Number										PROJECT NO.	701312
		PROJECT	ESP								
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B	DWG. NO.	10020236	REV. A
								SCALE 1:4	CAD FILE: MECH ENG ON TORNADO	SHEET 2 OF 5	

File Location:

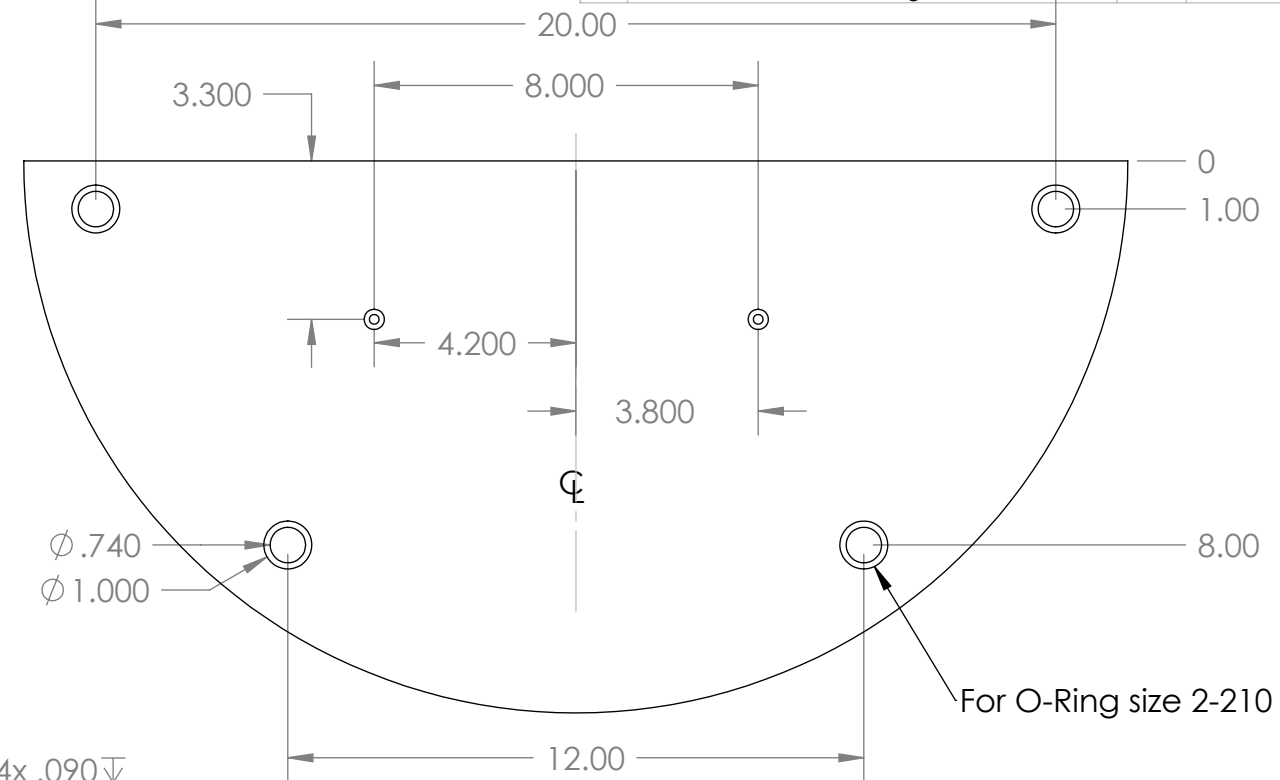
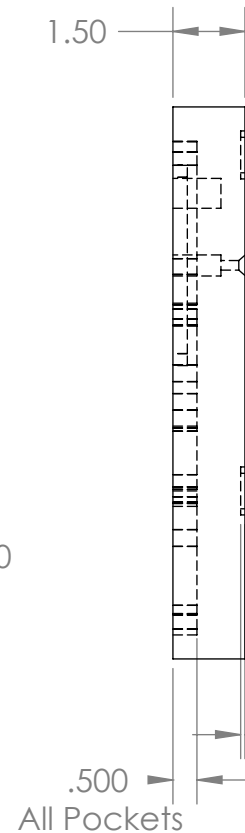
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REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		
A	Added Pockets and O-Rings	11/08	MP

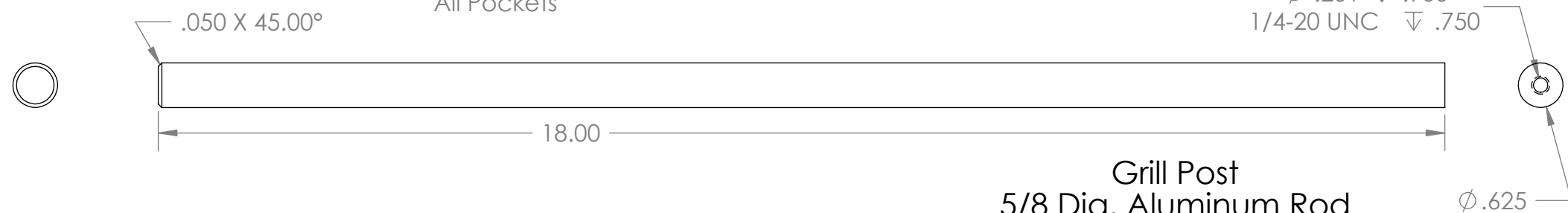
Grill Base
1 1/2" thk UHMW Sheet



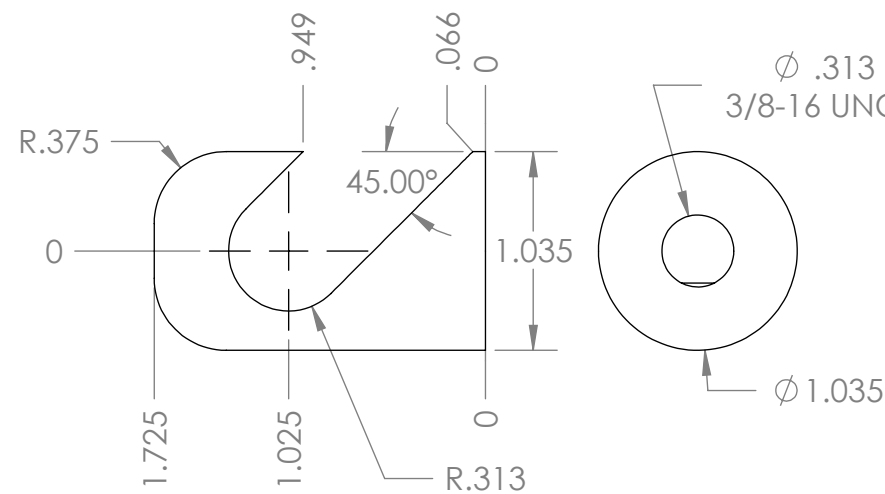
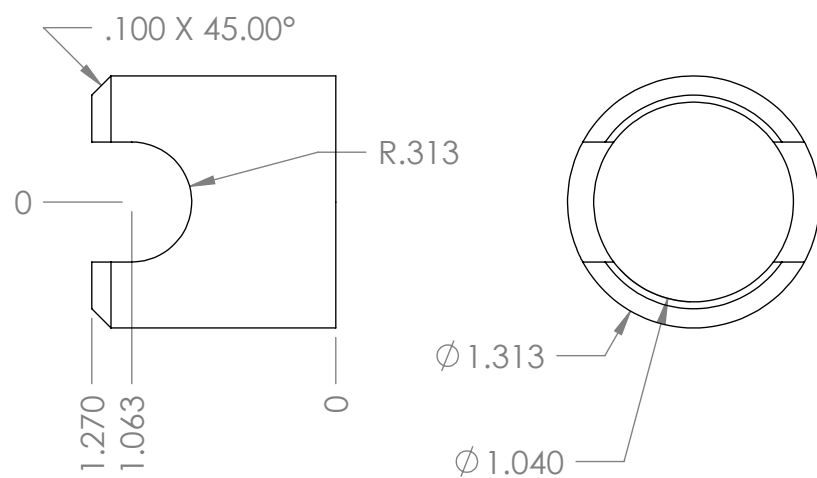
Barrel - Qty. 2
1" Sch 40
Aluminum



Grill Post
5/8 Dia. Aluminum Rod

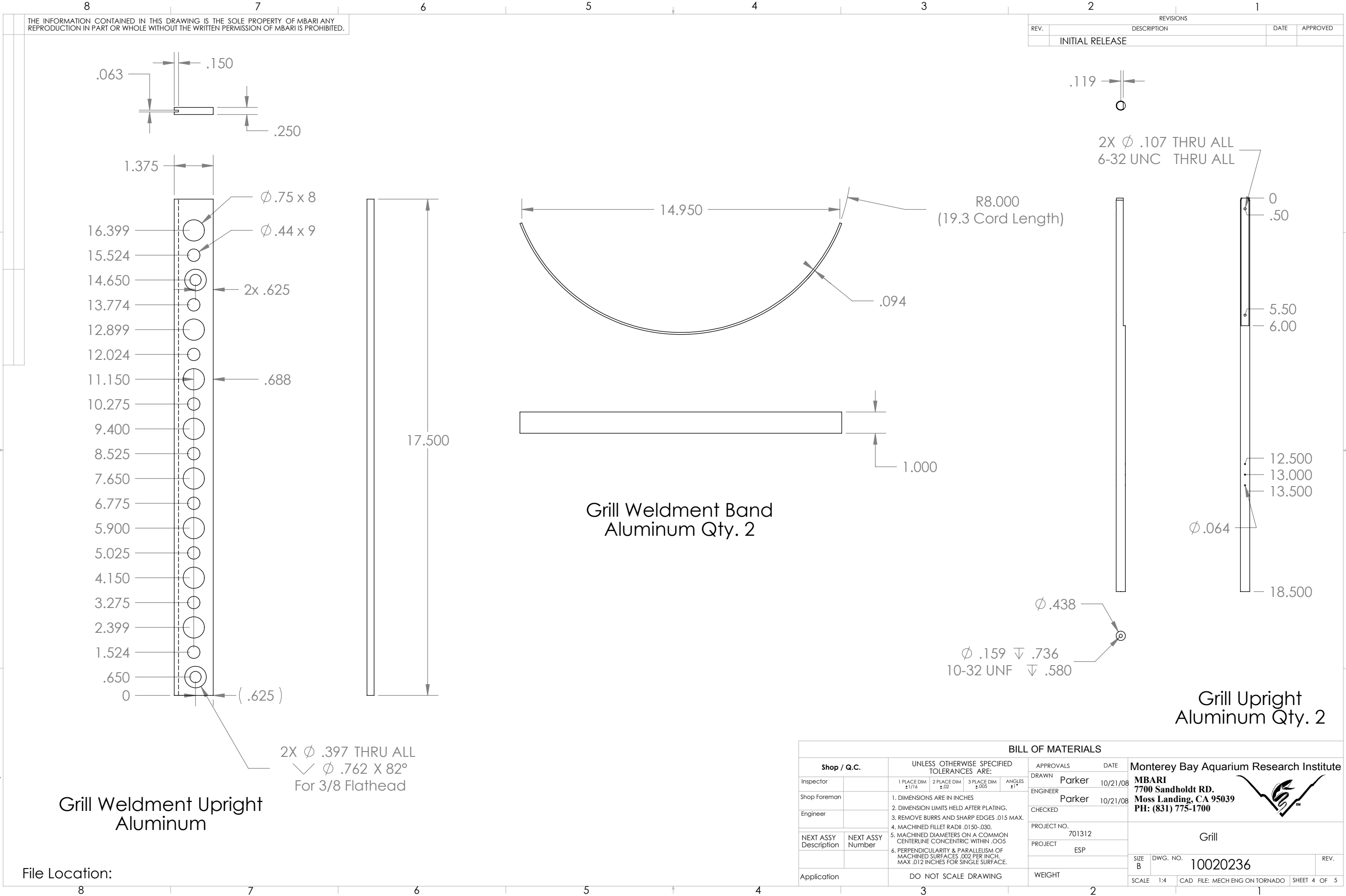


Barrel Nut - Qty. 2
Aluminum



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Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ± 1°	DRAWN	Parker	10/21/08					
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	Parker	10/21/08					
Engineer						CHECKED							
NEXT ASSY Description		NEXT ASSY Number				PROJECT NO.		701312		Grill Base, Post & Barre Nut			
						PROJECT		ESP					
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B		DWG. NO.		10020236	REV.
								SCALE 1:4		CAD FILE: MECH ENG ON TORNADO		SHEET 3 OF 3	

File Location:



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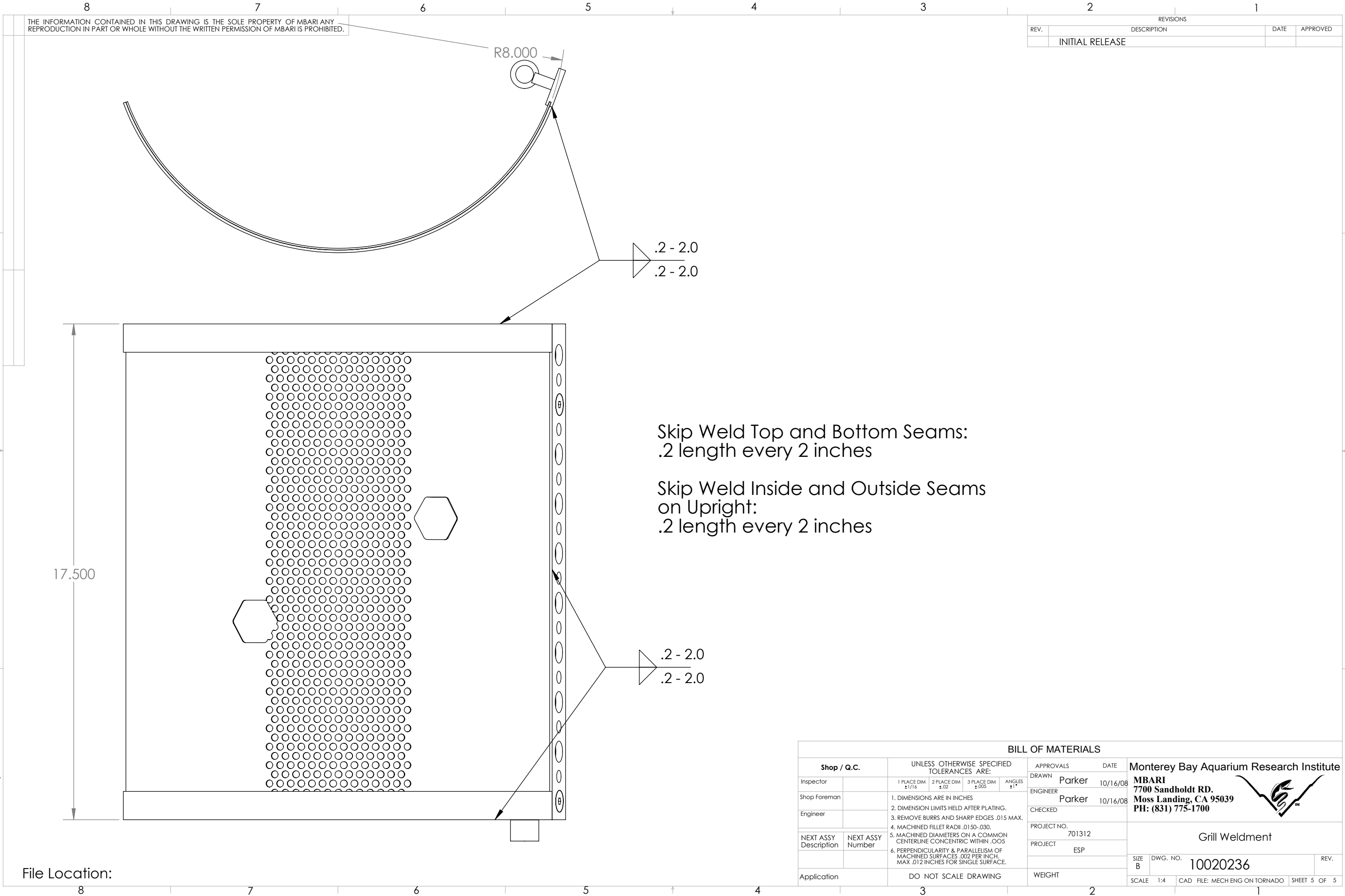
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

Grill Weldment Upright
Aluminum

Grill Weldment Band
Aluminum Qty. 2

Grill Upright
Aluminum Qty. 2

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	Parker	10/21/08			
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	Parker	10/21/08			
Engineer						CHECKED					
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.		701312		Grill	
						PROJECT		ESP			
Application						DO NOT SCALE DRAWING				WEIGHT	
						SIZE B		DWG. NO.		10020236	
						SCALE 1:4		CAD FILE: MECH ENG ON TORNADO		REV.	
								SHEET 4 OF 5			



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Skip Weld Top and Bottom Seams:
.2 length every 2 inches

Skip Weld Inside and Outside Seams
on Upright:
.2 length every 2 inches

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 Grill Weldment	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN	Parker 10/16/08		
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	Parker 10/16/08		
Engineer						CHECKED			
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	701312	Grill Weldment	
						PROJECT	ESP		
Application		DO NOT SCALE DRAWING				WEIGHT			
						SIZE B	DWG. NO. 10020236	REV.	
						SCALE 1:4	CAD FILE: MECH ENG ON TORNADO	SHEET 5 OF 5	

File Location: