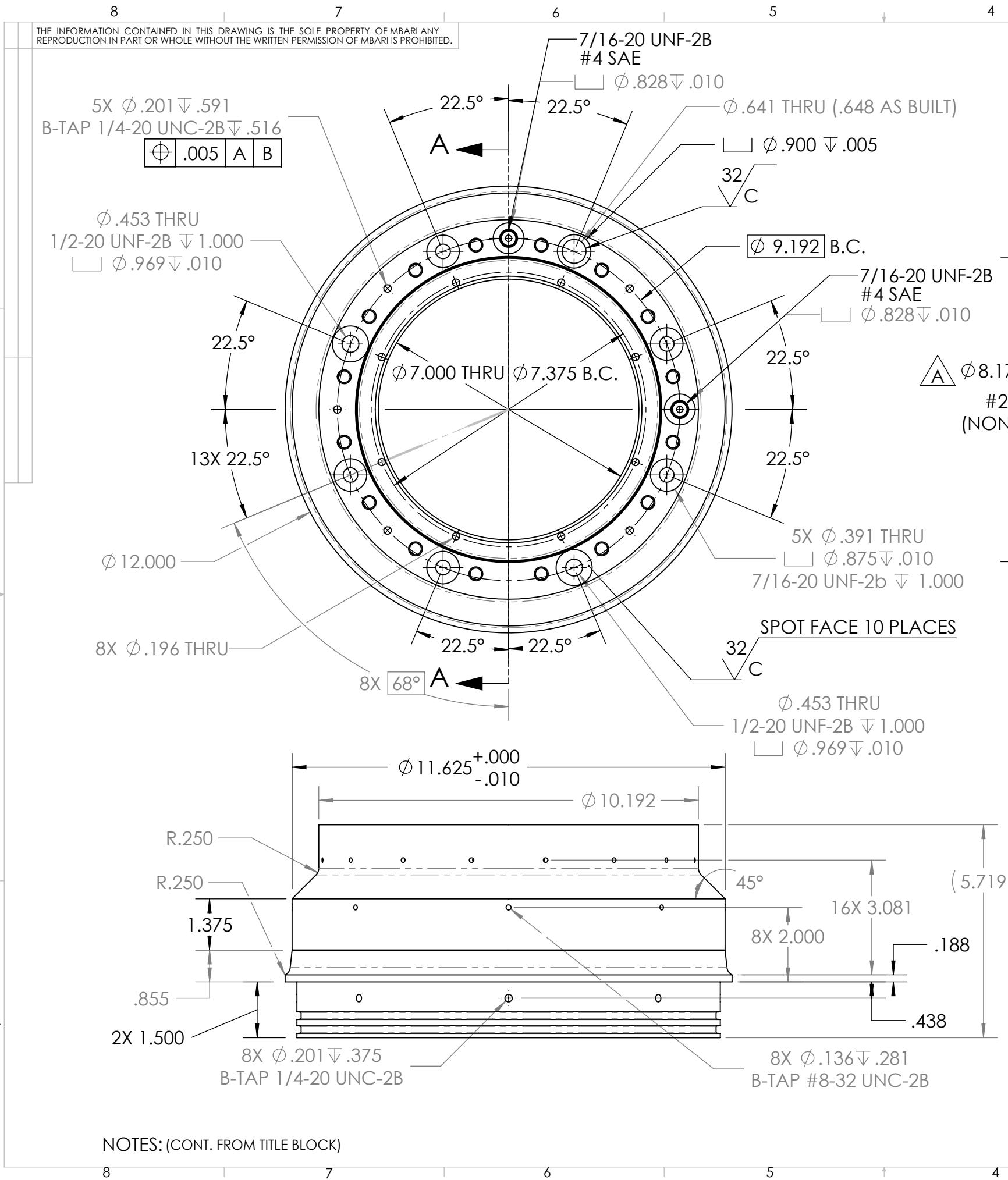




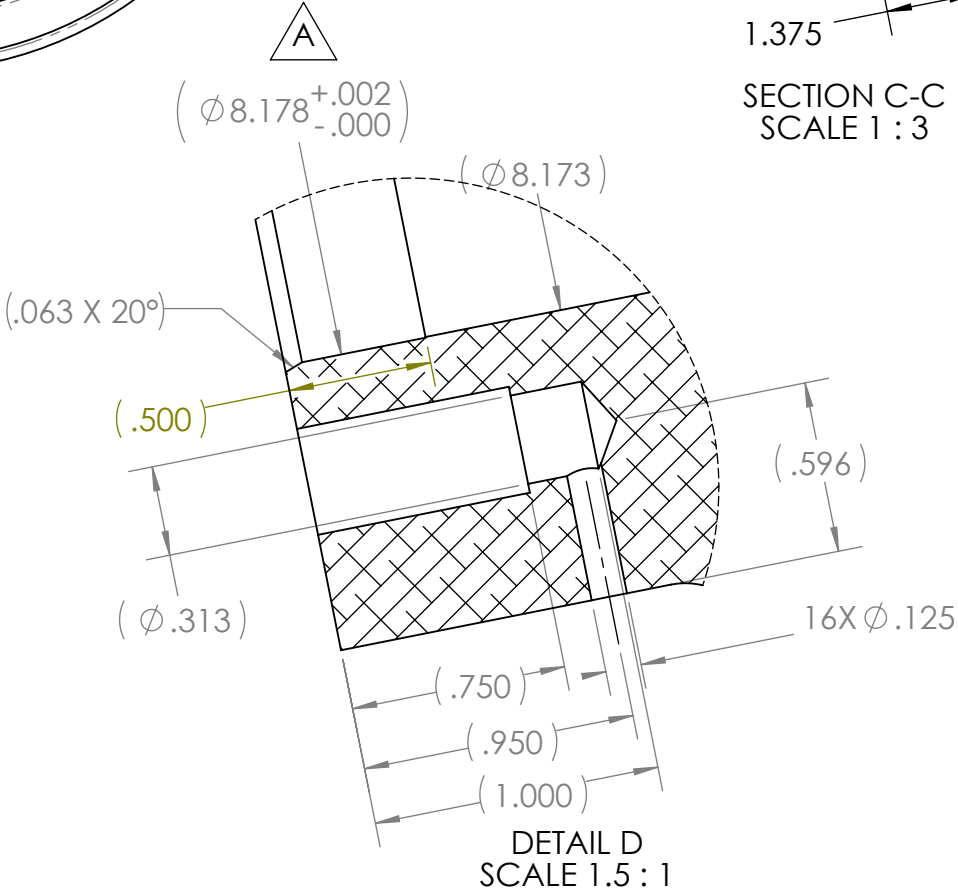
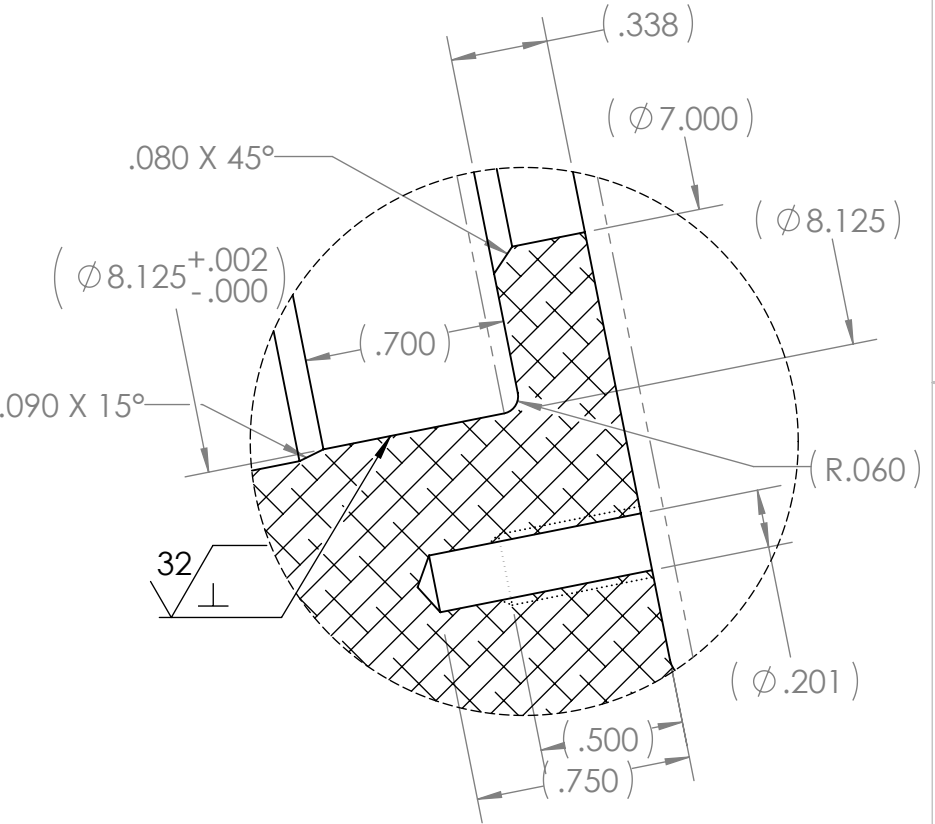
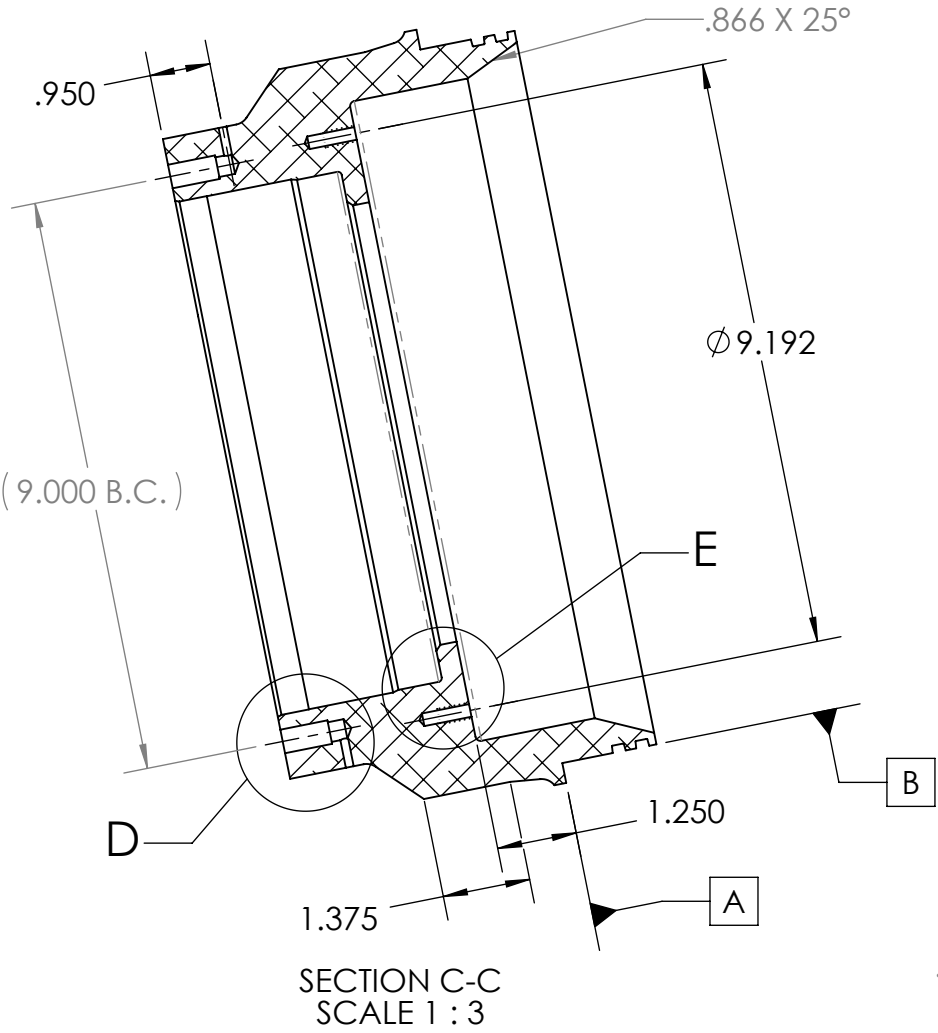
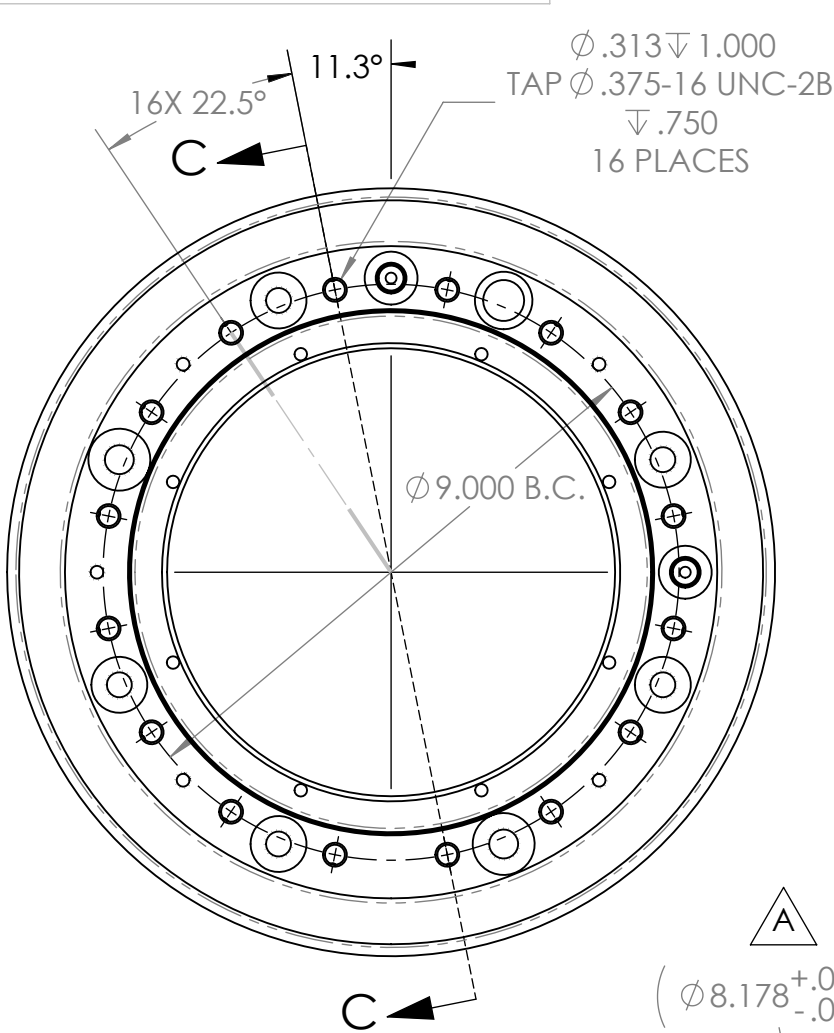
9. Q.C. (INSPECTION) REPORT REQUIRED FOR EACH PIECE.
8. Finish: HARD BLACK ANODIZE IN ACCORDANCE WITH MIL-A-8625F Type III (.001 THICK) Nickel Acetate Seal Coat, TEFLON TOP COAT. RACK AS SHOWN, (DIMENSION LIMITS HELD AFTER PLATING, see note #2)

7. PROJECT LIBRARY:\ESP\G3-ESP\Solidworks files\Turbine\NewFMldrive

1	1	P-201531-13	ESP Press Hull-DOME-A1		MBARI	6061-T6 Alloy
ITEM NO.	UNIT QTY.	Part_Number	DESCRIPTION		Vendor	MATERIAL
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°	Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700 
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 J. ERICKSON 7/9/13	
Engineer					ENGINEER J. ERICKSON 7/9/13	
					CHECKED	
					PROJECT NO. 901228.99	
NEXT ASSY Description	NEXT ASSY Number				PROJECT ESP	MAKAI - LRAUV ESP Press Hull-DOME-A1 SIZE B DWG. NO. P-201531-13.DWG REV. A SCALE 1:4 CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 3
Application		DO NOT SCALE DRAWING			WEIGHT 16.904	
		3			2	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/00	J.E.



7. PROJECT LIBRARY:\ESP\G3-ESP\Solidworks files\Turbine\NewFMldrive

NOTES: (CONT. FROM TITLE BLOCK)

1	1	P-201531-13	ESP Press Hull-DOME-A1	MBARI	6061-T6 Alloy
ITEM NO.	UNIT QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL
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		DRAWN J. ERICKSON 7/9/13	
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.		ENGINEER J. ERICKSON 7/9/13	
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED	
		4. MACHINED FILLET RADII .0150-.030.		PROJECT NO. 901228.99	
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT ESP	
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.		WEIGHT 16.904 lb.	
Application		DO NOT SCALE DRAWING		SIZE B DWG. NO. P-201531-13.DWG	
				SCALE 1:4 CAD FILE: MECH ENG ON TORNADO SHEET 2 OF 3	

DETAIL E
SCALE 1.5:1

DETAIL D
SCALE 1.5:1

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



MAKAI - LRAUV
ESP Press Hull-DOME-A1

REV. A

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/00	J.E.

INSIDE VIEW

7/16-20 UNF-2B
#4 SAE

$\phi .828 \nabla .010$

11.3°

16X 22.5°

16X $\phi .201 \nabla .750$
TAP 1/4-20 UNC-2 $\nabla .500$

2X $\surd \phi .613 \times 90^\circ$

7/16-20 UNF-2B
#4 SAE

$\phi .828 \nabla .010$

$\phi 9.192$

$\phi .50 \nabla .005$

(R.250)

6°

($\phi 12.000$)

(.188)

(.470)

DETAIL H
SCALE 2 : 1

2X $\phi 11.140^{+.000}_{-.002}$

#2-276
(non-standard
o-ring groove)

2X .192
.187

32 $\perp$

2X R.010

.188

32 $\perp$

2X R.010

2X 10°

(.814)

DETAIL G
SCALE 3 : 1

(3X $\phi 11.367^{+.000}_{-.002}$)

2X $\phi 11.140^{+.000}_{-.002}$
#2-276
(non-standard
o-ring groove)

G

(.125)

2X 1.500

(.814)

.470

A

H

7. PROJECT LIBRARY:\ESP\G3-ESP\Solidworks files\Turbine\NewFMIdrive

NOTES: (CONT. FROM TITLE BLOCK)

1	1	P-201531-13	ESP Press Hull-DOME-A1	MBARI	6061-T6 Alloy
ITEM NO.	UNIT QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL
BILL OF MATERIALS					
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS DATE	
Inspector		1 PLACE DIM $\pm 1/16$	2 PLACE DIM $\pm .02$	3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$
Shop Foreman		1. DIMENSIONS ARE IN INCHES		DRAWN J. ERICKSON 7/9/13	
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.		ENGINEER J. ERICKSON 7/9/13	
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED	
		4. MACHINED FILLET RADII .0150-.030.		PROJECT NO. 901228.99	
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT ESP	
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.		WEIGHT 16.904 lb.	
Application		DO NOT SCALE DRAWING		SIZE B DWG. NO. P-201531-13.DWG	
				SCALE 1:4 CAD FILE: MECH ENG ON TORNADO SHEET 3 OF 3	

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Moss Landing, CA 95039
PH: (831) 775-1700



MAKAI - LRAUV
ESP Press Hull-DOME-A1

REV. A