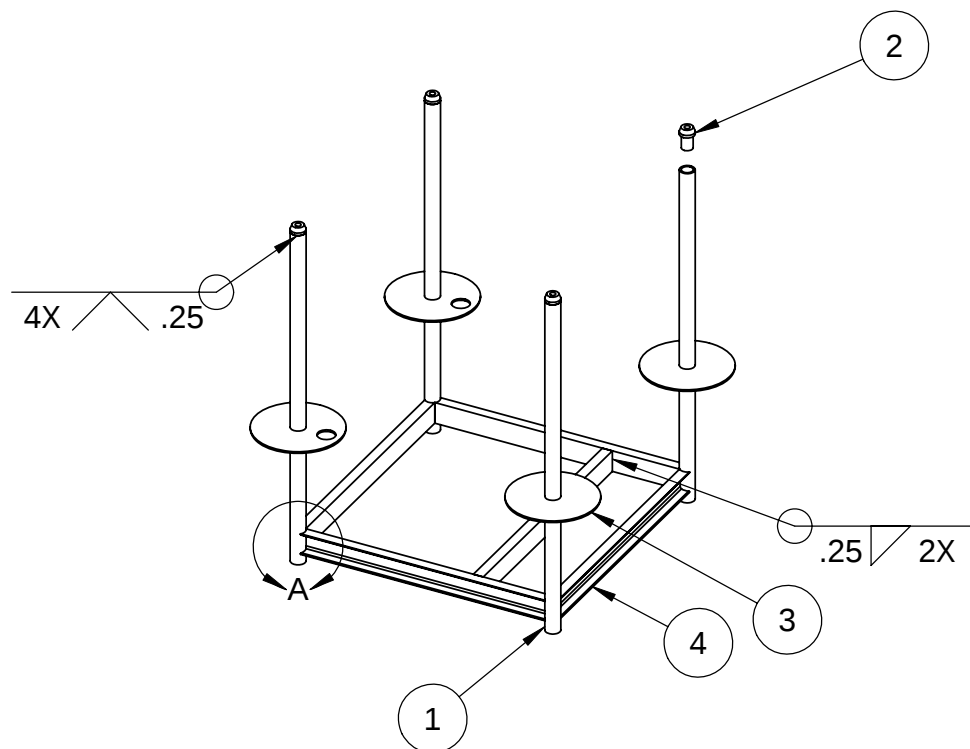
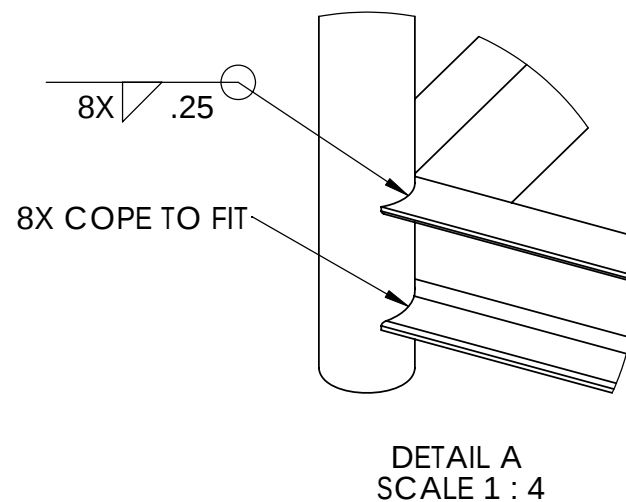
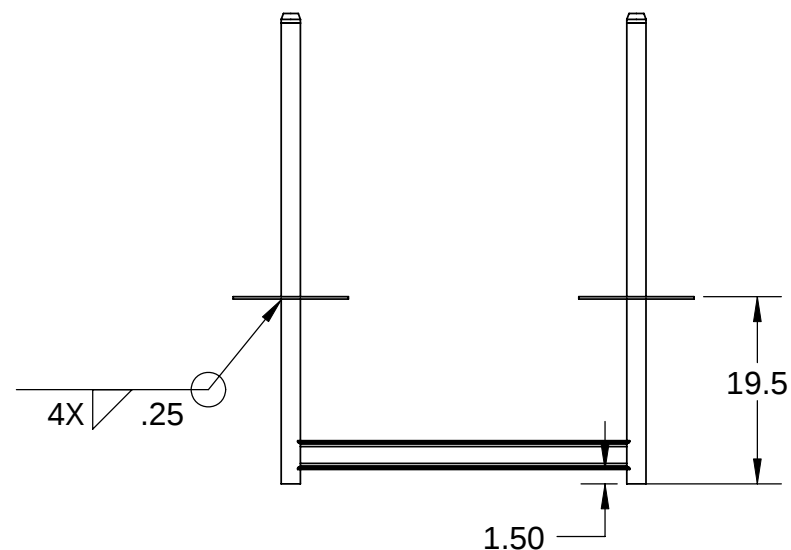
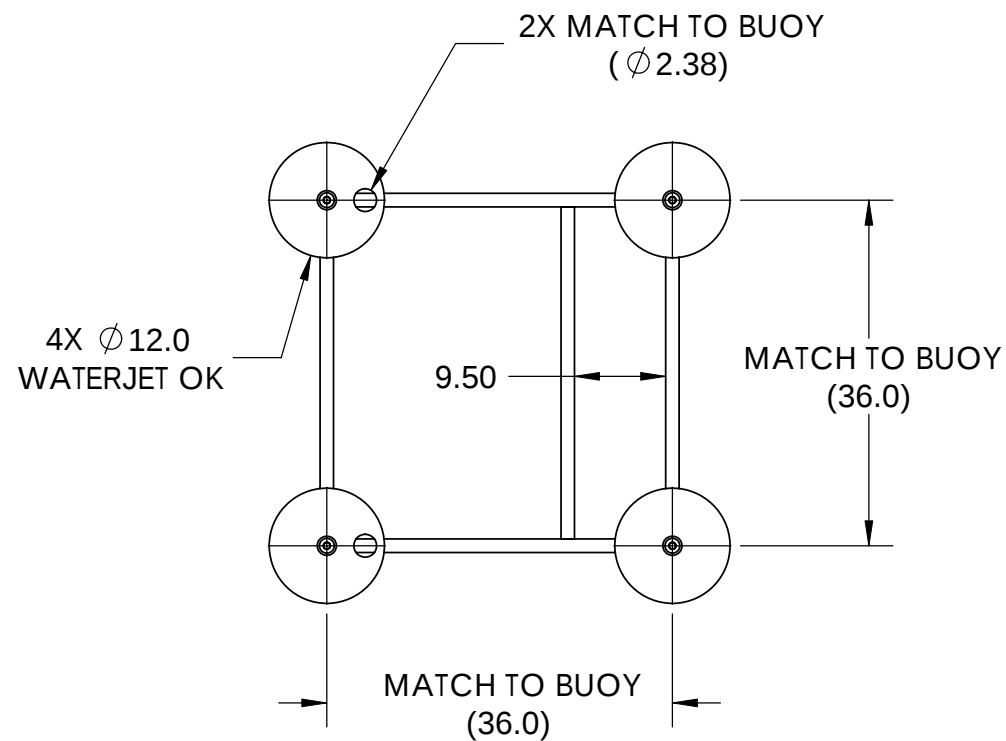
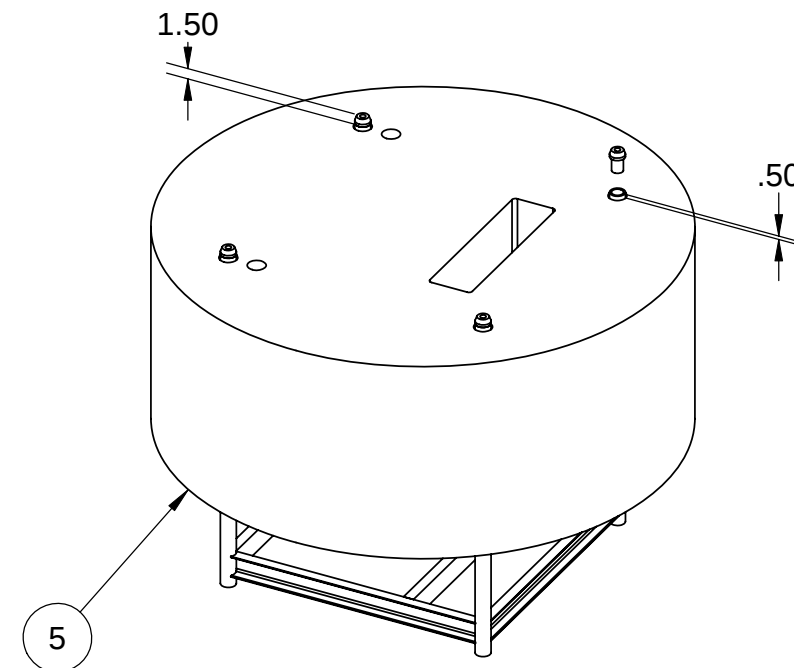


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	-	Initial Release	March 15, 2009	Gene M.
	A	Add threaded tube top and remove thread on tube	March 16, 2009	Gene M.



ITEM NO.	DESCRIPTION	QTY.
1	2.0 DIA X .25 WALL ALUM, 6061-T6	4
2	TUBE TOP (SEE SHEET 2)	4
3	.25 THK PLATE, ALUM 6061-T6 (WATERJET OK)	4
4	3 WIDE x 1.42 HIGH x 2.42 LB/FT AMER. STD. CHANNEL, ALUM 6061-T6	5
5	ESP PROFILER BUOY	1

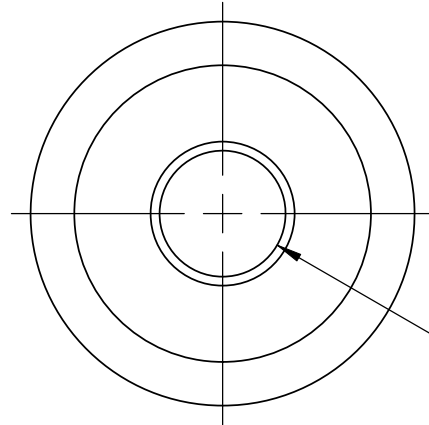
NOTES:

1. Entire frame shall be fit to mounting holes in ESP Profiler buoy. Reference dimensions (xx.x) are provided for material ordering purposes only.
2. Use Rockmount Neptune TIG filler.
3. Chamfer V and Bevel welds 1/2 material thickness.
4. Weld area shall be wire brushed and cleaned with acetone prior to welding.
5. Welds shall be clean, smooth and free from porosity.
6. Tungsten inclusions shall be ground and re-welded.
7. Grind welds flat only where required.

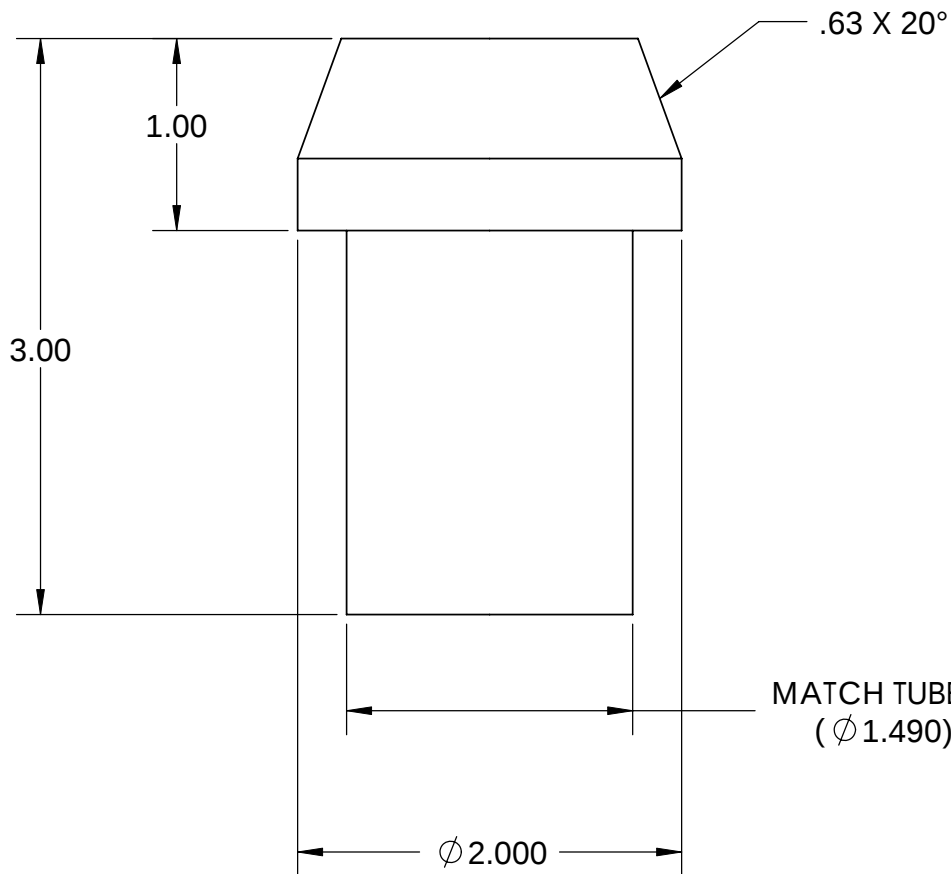
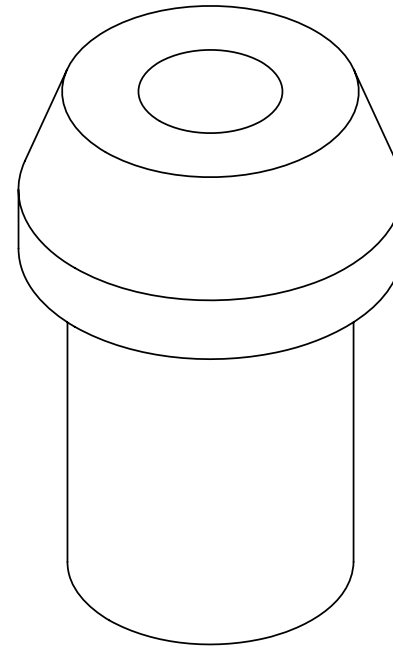
Status:

BILL OF MATERIALS									
NEXT ASSY Description	NEXT ASSY Number	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS	DATE	Monterey Bay Aquarium Research Institute M B A R I  7700 Sandholdt Rd. Moss Landing, CA 95039 831 775-1922	
		1 PLACE DIM ±.1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN Gene M.			
THIRD ANGLE PROJECTION	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 SLOPED SURFACE.				ENGINEER Gene M.				
					CHECKED				
					PROJECT NO.	708602			
					PROJECT	ESP Profiler			
	DO NOT SCALE DRAWING				MAT'L		SIZE B	DWG. NO.	REV. A
							SCALE 1:20	CAD FILE:	SHEET 1 OF 2

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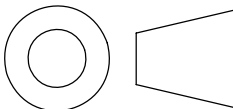


Ø .656 THRU ALL
3/4-10 UNC ∇ 1.50



MATCH TUBE ID
(ϕ 1.490)

Ø 2.000

ITEM NO.	DESCRIPTION				MATERIAL		QTY.	
1	TUBE TOP				ALUM, 6061-T6		4	
BILL OF MATERIALS								
NEXT ASSY Description	NEXT ASSY Number	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			APPROVALS	DATE	Monterey Bay Aquarium Research Institute 7700 Sandholdt Rd. Moss Landing, CA 95039 831 775-1922	
		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN Gene M.		
THIRD ANGLE PROJECTION		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 Gene M.			
					CHECKED			
		DO NOT SCALE DRAWING			PROJECT NO. 708602			
					PROJECT ESP Profiler			
					SIZE B	DWG. NO.		REV REV
					SCALE 1:1	CAD FILE:		SHEET 2 OF 2

Status: