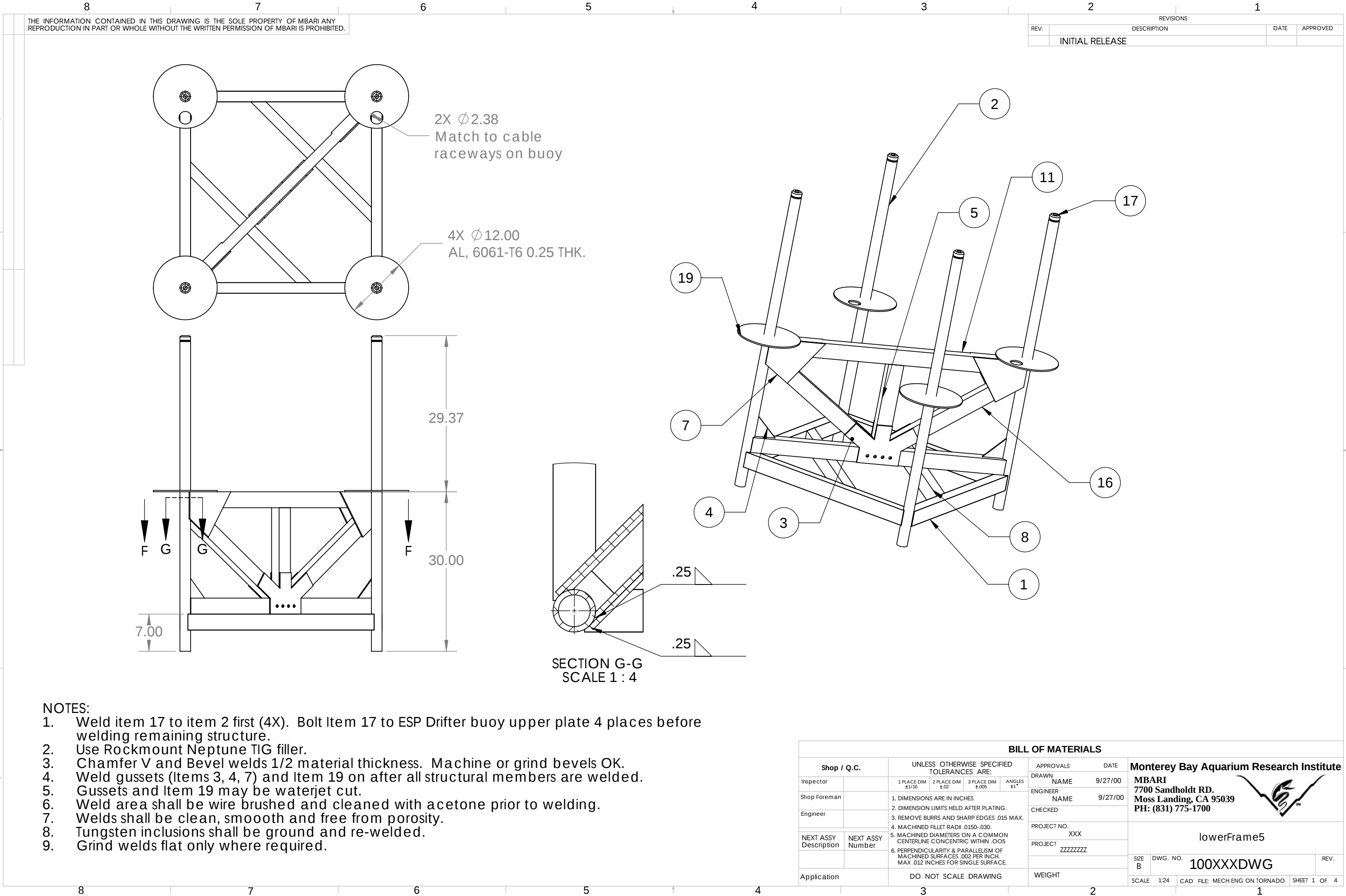




THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MBARI ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MBARI IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
INITIAL RELEASE			

NOTES:

- Weld item 17 to item 2 first (4X). Bolt Item 17 to ESP Drifter buoy upper plate 4 places before welding remaining structure.
- Use Rockmount Neptune TIG filler.
- Chamfer V and Bevel welds 1/2 material thickness. Machine or grind bevels OK.
- Weld gussets (Items 3, 4, 7) and Item 19 on after all structural members are welded.
- Gussets and Item 19 may be waterjet cut.
- Weld area shall be wire brushed and cleaned with acetone prior to welding.
- Welds shall be clean, smooth and free from porosity.
- Tungsten inclusions shall be ground and re-welded.
- Grind welds flat only where required.

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°	DRAWN	NAME	9/27/00	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.				ENGINEER	NAME	9/27/00	
Engineer						CHECKED			
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	XXX		
						PROJECT	ZZZZZZZZ		
Application		DO NOT SCALE DRAWING				WEIGHT		lowerFrame5	
						SIZE B	DWG. NO. 100XXXDWG		REV.
						SCALE 1:24	CAD FILE: MECH ENG ON TORNADO		SHEET 1 OF 4

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



lowerFrame5