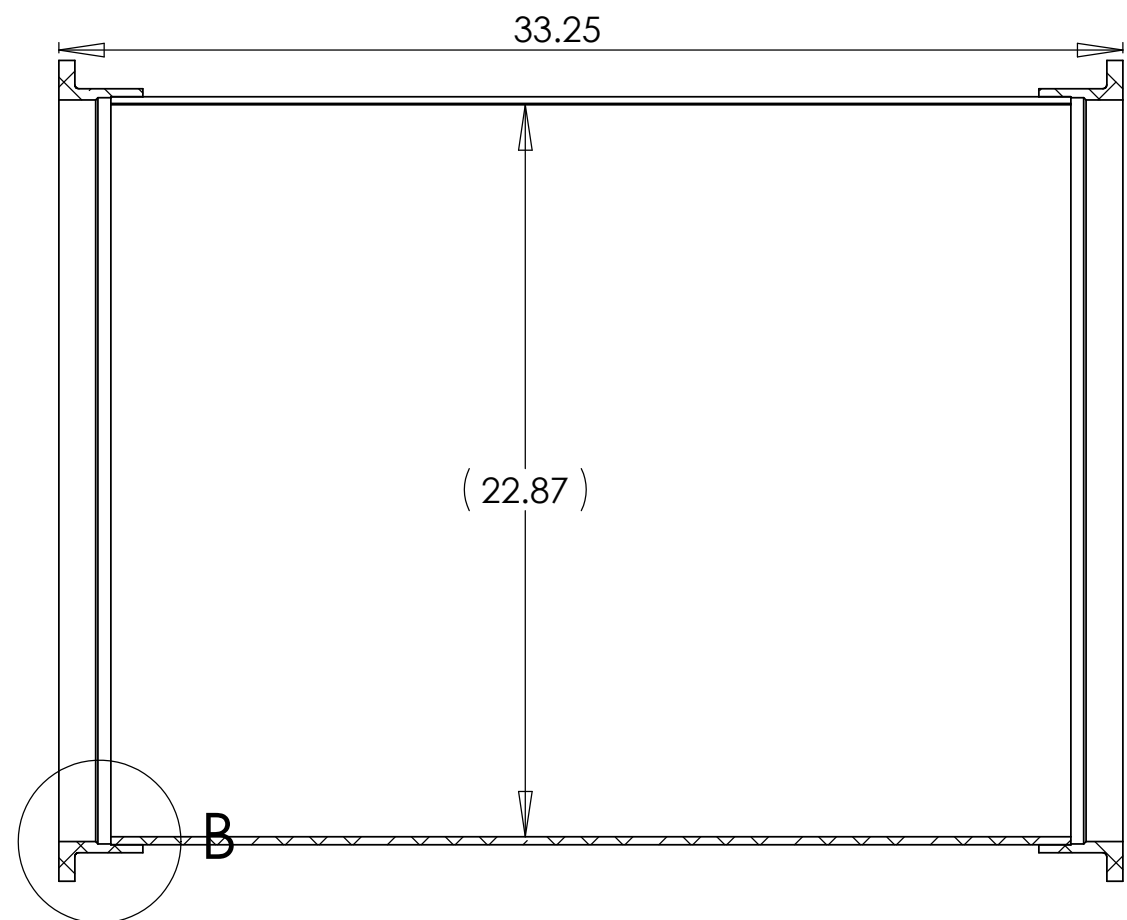




SECTION A-A
SCALE 1 : 6

1. FLANGED RINGS (DRAWING # 100323) WILL BE WELDED TO ROLLED TUBE (DRAWING# 1003025) AS SPECIFIED
2. FILLER MATERIAL WILL BE ROCKMOUNT NEPTUNE TIG
3. PARTS WILL BE THOROUGHLY CLEANED WITH ACETONE PRIOR TO WELDING
4. WELDS WILL BE CLEAN, SMOOTH, AND FREE FROM POROSITY
5. TUNGSTEN INCLUSIONS WILL BE GROUND AND REWELDED
6. WELDEMENT WILL BE INSPECTED DIMENSIONALLY AND FOR WELD QUALITY, REPORT REQUIRED
7. **WELDEMENT WILL BE STRESS RELIEVED AND SOLUTION HEAT TREATED. FLAT, PARALLEL, AND STRAIGHT +/- .062. AGE TO T-6 CONDITION. FIXTURE IF NECESSARY. DOCUMENTATION REQUIRED**
8. NEXT ASSEMBLY DRAWING # 1003024



DETAIL B
SCALE 1 : 1.5

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	L. BIRD	02/08/06			
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					
Engineer						CHECKED					
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.		900312		HOUSING WELD ASSEMBLY	
						PROJECT		ESP			
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B		DWG. NO. 1003026DWG	
								SCALE 1:10		CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 1	