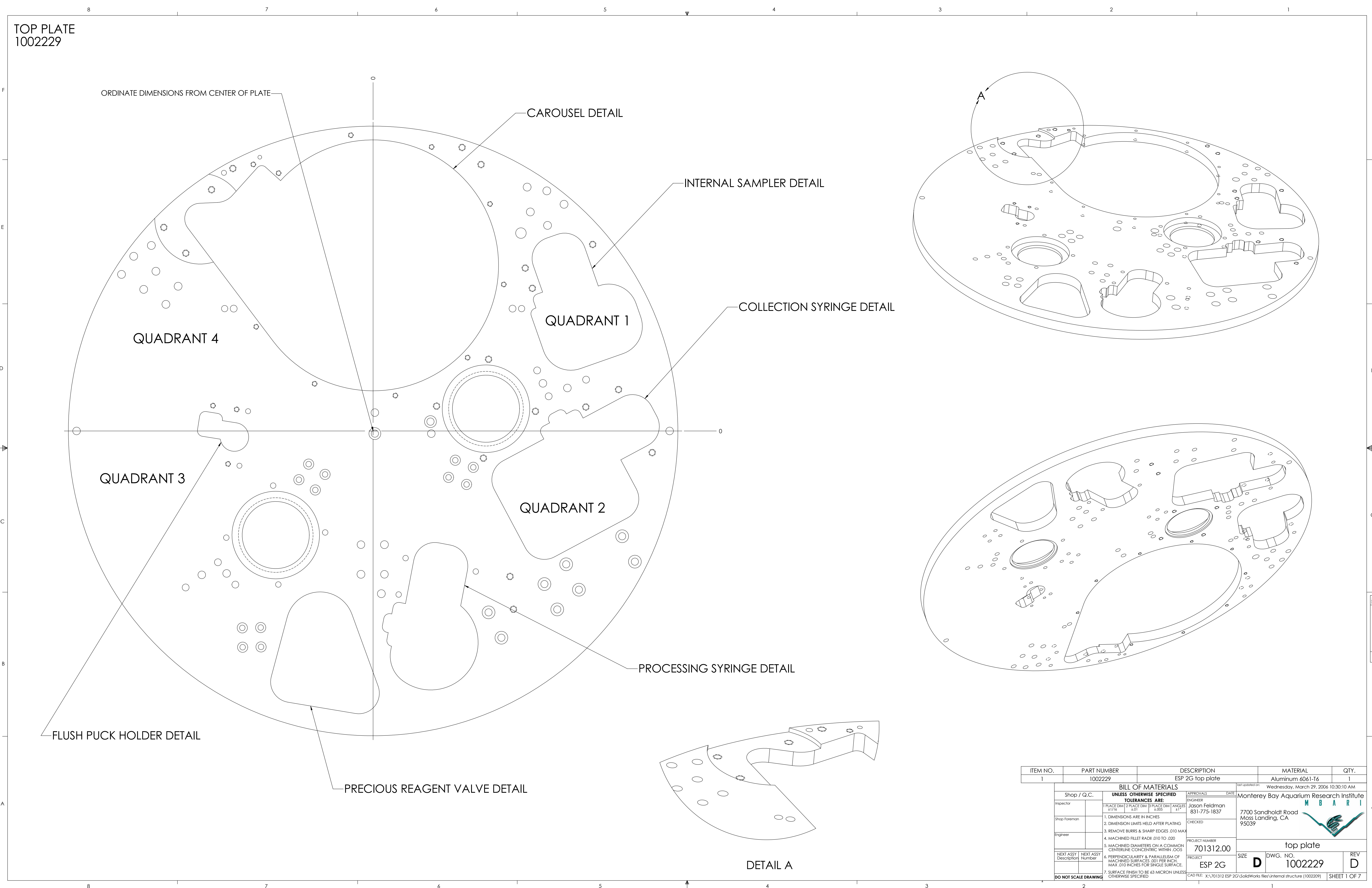
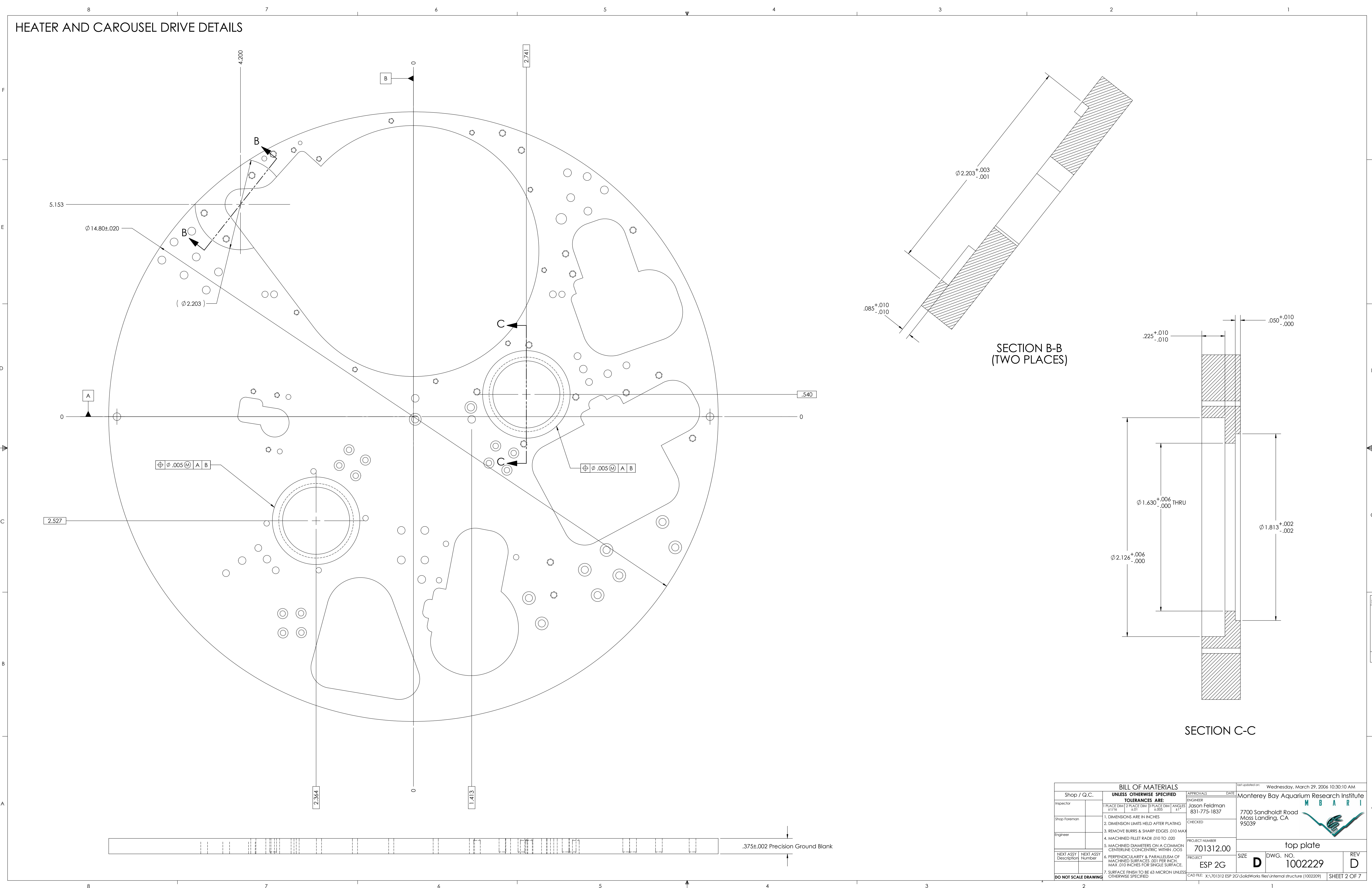




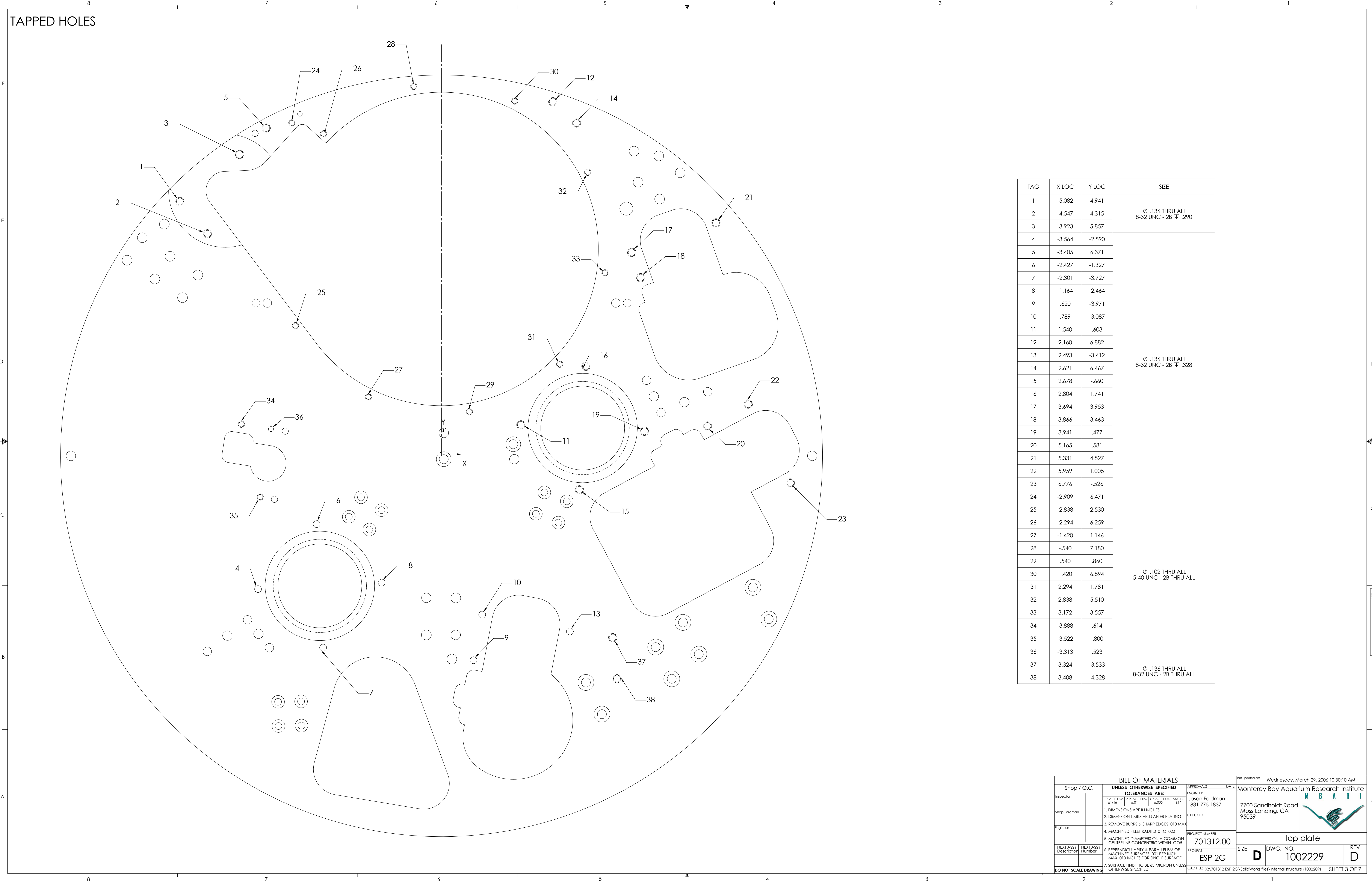
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
1	1002229	ESP 2G top plate	Aluminum 6061-T6	1

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED		APPROVALS		DATE
Inspector		TOLERANCES ARE:		ENGINEER		
Shop Foreman		1. PLACE DIM 1/16 1/32 1/64	2. PLACE DIM 1/32 1/64 1/16	Jason Feldman		831-775-1837
Engineer		1. DIMENSIONS ARE IN INCHES		CHECKED		
		2. DIMENSION LIMITS HELD AFTER PLATING		PROJECT NUMBER		701312.00
		3. REMOVE BURRS & SHARP EDGES .010 MAX		PROJECT		ESP 2G
		4. MACHINED FILLET RADII .010 TO .020		CADD FILE		X:\701312 ESP 2G\SolidWorks Files\Internal structure (1002209)
		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		SHEET 1 OF 7		
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .001 PER INCH MAX .010 INCHES FOR SINGLE SURFACE.				
		7. SURFACE FINISH TO BE 63 MICRON UNLESS OTHERWISE SPECIFIED				

last updated on: Wednesday, March 29, 2006 10:30:10 AM		Monterey Bay Aquarium Research Institute	
7700 Sandholdt Road		MBARI	
Moss Landing, CA 95039		top plate	
SIZE	D	DWG. NO.	1002229
REV	D		



Shop / Q.C.		UNLESS OTHERWISE SPECIFIED		APPROVALS		DATE		last updated on: Wednesday, March 29, 2006 10:30:10 AM	
Inspector		TOLERANCES ARE:		ENGINEER		Jason Feldman		Monterey Bay Aquarium Research Institute	
Shop Foreman		1. PLACE DIM ±1/16 2. PLACE DIM ±.01 3. PLACE DIM ±.005 4. ANGLES ±1°		CHECKED		831-775-1837		7700 Sandholdt Road Moss Landing, CA 95039	
Engineer		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING 3. REMOVE BURRS & SHARP EDGES .010 MAX 4. MACHINED FILLET RADII .010 TO .020 5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT NUMBER		701312.00		top plate	
NEXT ASSY Description	NEXT ASSY Number	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .001 PER INCH MAX .010 INCHES FOR SINGLE SURFACE. 7. SURFACE FINISH TO BE 63 MICRON UNLESS OTHERWISE SPECIFIED		PROJECT		ESP 2G		SIZE DWG. NO. REV	
DO NOT SCALE DRAWING		CAD FILE: X:\701312 ESP 2G\SolidWorks Res\Internal structure (1002209)		SHEET 2 OF 7		1002229 (top plate)		D	



TAG	X LOC	Y LOC	SIZE
1	-5.082	4.941	Ø .136 THRU ALL 8-32 UNC - 2B V .290
2	-4.547	4.315	
3	-3.923	5.857	
4	-3.564	-2.590	Ø .136 THRU ALL 8-32 UNC - 2B V .328
5	-3.405	6.371	
6	-2.427	-1.327	
7	-2.301	-3.727	
8	-1.164	-2.464	
9	.620	-3.971	
10	.789	-3.087	
11	1.540	.603	
12	2.160	6.882	
13	2.493	-3.412	
14	2.621	6.467	
15	2.678	-.660	
16	2.804	1.741	
17	3.694	3.953	
18	3.866	3.463	
19	3.941	.477	Ø .102 THRU ALL 5-40 UNC - 2B THRU ALL
20	5.165	.581	
21	5.331	4.527	
22	5.959	1.005	
23	6.776	-.526	
24	-2.909	6.471	
25	-2.838	2.530	
26	-2.294	6.259	
27	-1.420	1.146	
28	-.540	7.180	
29	.540	.860	Ø .136 THRU ALL 8-32 UNC - 2B THRU ALL
30	1.420	6.894	
31	2.294	1.781	
32	2.838	5.510	
33	3.172	3.557	
34	-3.888	.614	
35	-3.522	-.800	
36	-3.313	.523	
37	3.324	-3.533	
38	3.408	-4.328	

Shop / Q.C.

Inspector

Shop Foreman

Engineer

Next Assy Description

Next Assy Number

UNLESS OTHERWISE SPECIFIED

TOLERANCES ARE:

1. PLACE DIM ±.1/.6

2. PLACE DIM ±.01

3. PLACE DIM ±.005

4. ANGLES ±1°

1. DIMENSIONS ARE IN INCHES

2. DIMENSION LIMITS HELD AFTER PLATING

3. REMOVE BURRS & SHARP EDGES .010 MAX

4. MACHINED FILLET RADII .010 TO .020

5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005

6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .001 PER INCH MAX .010 INCHES FOR SINGLE SURFACE.

7. SURFACE FINISH TO BE 63 MICRON UNLESS OTHERWISE SPECIFIED

APPROVALS

DATE

ENGINEER

CHECKED

PROJECT NUMBER

PROJECT

last updated on: Wednesday, March 29, 2006 10:30:10 AM

Monterey Bay Aquarium Research Institute

7700 Sandholdt Road
Moss Landing, CA 95039

top plate

SIZE D

DWG. NO. 1002229

REV D

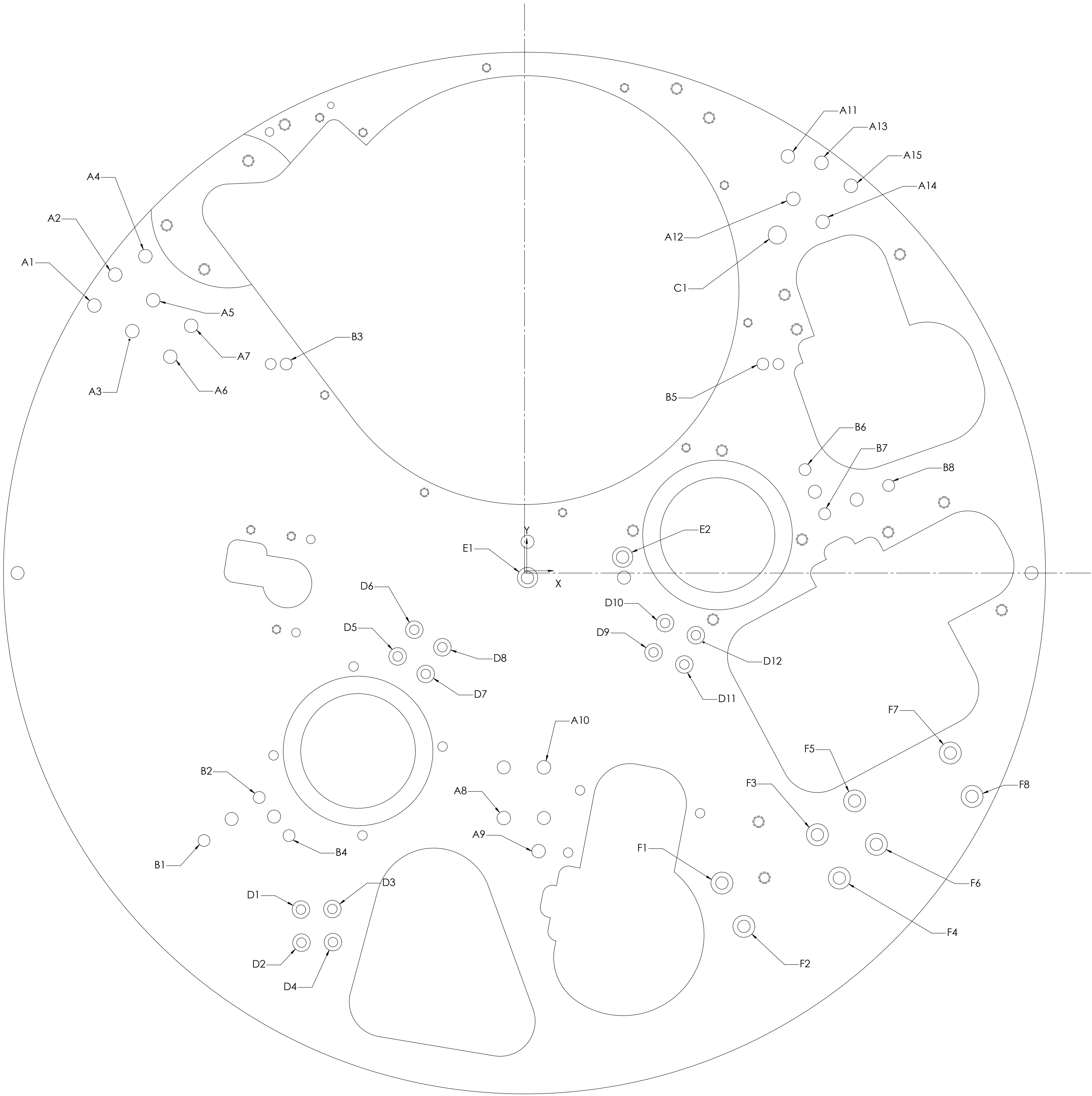
DO NOT SCALE DRAWING

CAD FILE: X:\701312 ESP 2G\SolidWorks Res\Internal structure (1002209)

SHEET 3 OF 7

REV
D 1002229 (top plate)

CLEARANCE and COUNTERBORE HOLES



TAG	X LOC	Y LOC	SIZE
A1	-6.109	3.801	Ø .194 THRU ALL
A2	-5.813	4.240	
A3	-5.570	3.437	
A4	-5.385	4.503	
A5	-5.274	3.877	
A6	-5.031	3.074	
A7	-4.735	3.513	
A8	-.295	-3.480	
A9	.200	-3.950	
A10	.275	-2.760	
A11	3.740	5.920	
A12	3.818	5.317	
A13	4.218	5.829	
A14	4.235	4.990	
A15	4.635	5.503	
B1	-4.552	-3.799	Ø .170 THRU ALL
B2	-3.768	-3.188	
B3	-3.385	2.970	
B4	-3.345	-3.730	
B5	3.385	2.970	
B6	3.983	1.470	
B7	4.263	.841	
B8	5.171	1.246	
C1	3.589	4.804	Ø .257 THRU ALL
D1	-3.176	-4.780	Ø .136 THRU ALL └─┐ Ø .250 ▾ .200
D2	-3.168	-5.250	
D3	-2.729	-4.772	
D4	-2.721	-5.242	
D5	-1.802	-1.184	
D6	-1.565	-.805	
D7	-1.403	-1.433	
D8	-1.167	-1.054	
D9	1.832	-1.126	
D10	1.996	-.710	
D11	2.269	-1.298	
D12	2.433	-.883	
E1	.043	-.064	Ø .178 THRU ALL └─┐ Ø .290 ▾ .200
E2	1.393	.227	
F1	2.803	-4.404	Ø .177 THRU ALL └─┐ Ø .313 ▾ .230
F2	3.115	-5.019	
F3	4.159	-3.717	
F4	4.471	-4.332	
F5	4.688	-3.237	
F6	4.997	-3.854	
F7	6.047	-2.556	
F8	6.356	-3.173	

Shop / Q.C.

Inspector

Shop Foreman

Engineer

Next Assy Description

Next Assy Number

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:

1. PLACE DIM ±.016

2. DIMENSIONS ARE IN INCHES

3. REMOVE BURRS & SHARP EDGES .010 MAX

4. MACHINED FILLET RADII .010 TO .020

5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005

6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .001 PER INCH MAX .010 INCHES FOR SINGLE SURFACE.

7. SURFACE FINISH TO BE 63 MICRON UNLESS OTHERWISE SPECIFIED

APPROVALS

DATE

ENGINEER

CHECKED

PROJECT NUMBER

PROJECT

last updated on: Wednesday, March 29, 2006 10:30:10 AM

Monterey Bay Aquarium Research Institute

7700 Sandholdt Road
Moss Landing, CA 95039

top plate

SIZE D

DWG. NO. 1002229

REV D

DO NOT SCALE DRAWING

CAD FILE: X:\701312 ESP 2G\SolidWorks Res\Internal structure (1002209)

SHEET 4 OF 7

REV
D 1002229 (top plate)

F



REV
D1002229 (top plate)

^

F

E

D

B

A

11

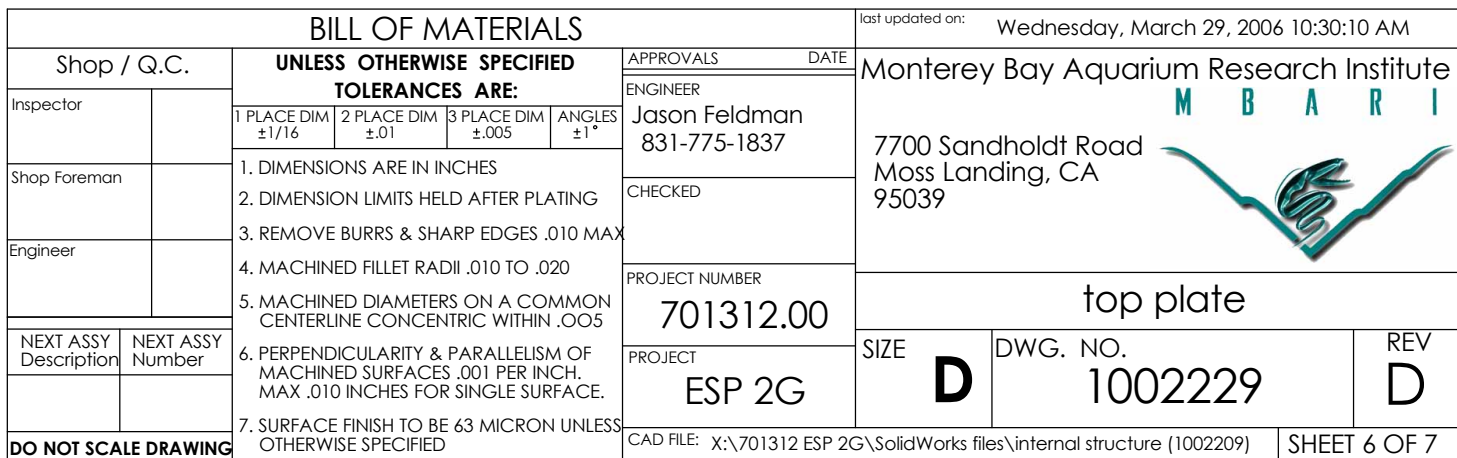
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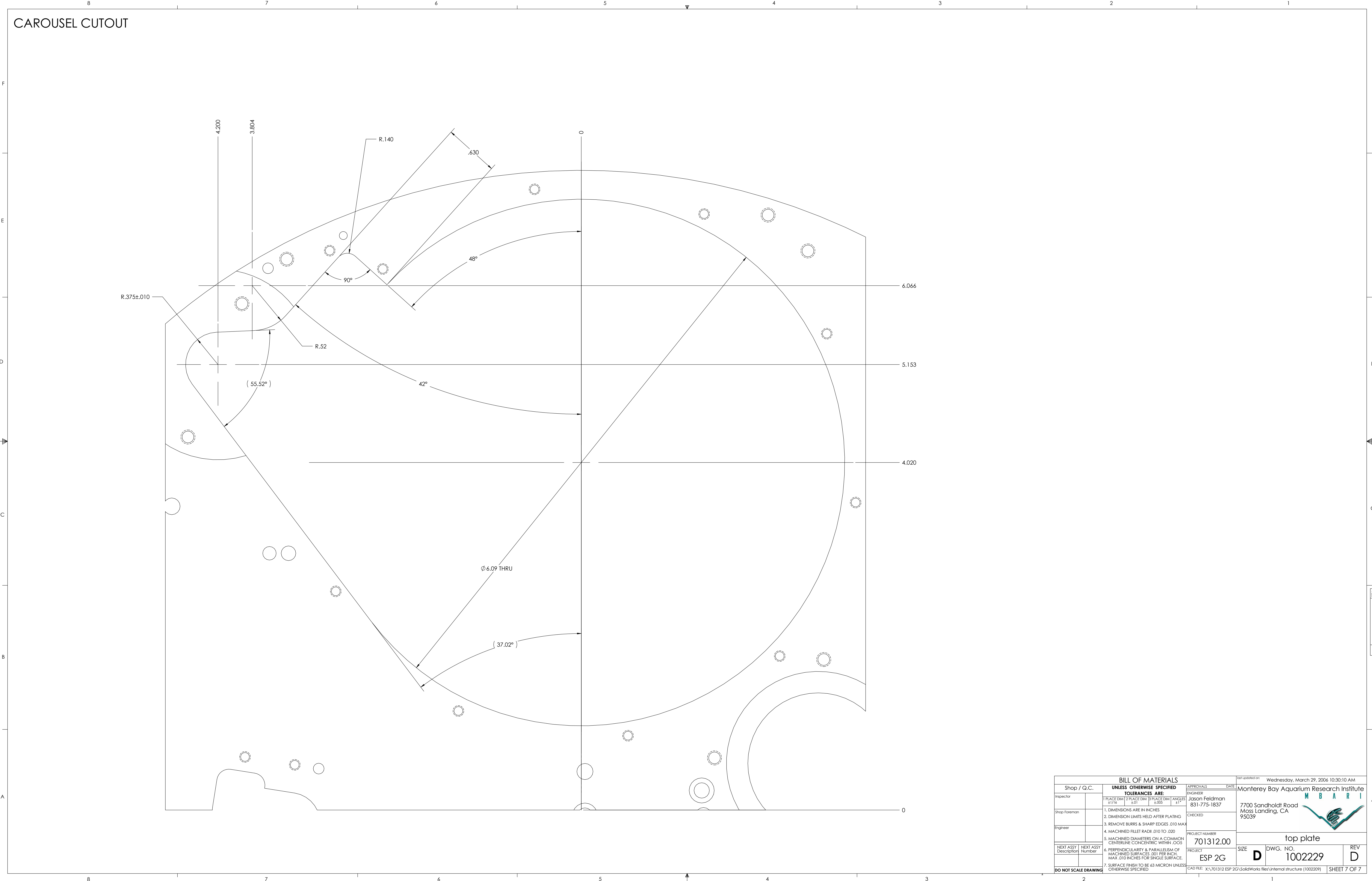
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5





BILL OF MATERIALS										last updated on: Wednesday, March 29, 2006 10:30:10 AM		
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:						APPROVALS		DATE		
Inspector		1. PLACE DIM ±1/16		2. PLACE DIM ±.01		3. PLACE DIM ±.005		4. ANGLES ±1°		ENGINEER		
								Jason Feldman 831-775-1837		Monterey Bay Aquarium Research Institute		
Shop Foreman		1. DIMENSIONS ARE IN INCHES						CHECKED		7700 Sandholdt Road Moss Landing, CA 95039		
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING										
		3. REMOVE BURRS & SHARP EDGES .010 MAX						PROJECT NUMBER				
		4. MACHINED FILLET RADII .010 TO .020						701312.00				
		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005								top plate		
NEXT ASSY Description	NEXT ASSY Number	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .001 PER INCH MAX .010 INCHES FOR SINGLE SURFACE.						PROJECT		SIZE	DWG. NO.	REV
		7. SURFACE FINISH TO BE 63 MICRON UNLESS OTHERWISE SPECIFIED						ESP 2G		D	1002229	D
DO NOT SCALE DRAWING								CAD FILE: X:\701312 ESP 2G\SolidWorks Files\Internal structure (1002209)		SHEET 7 OF 7		

