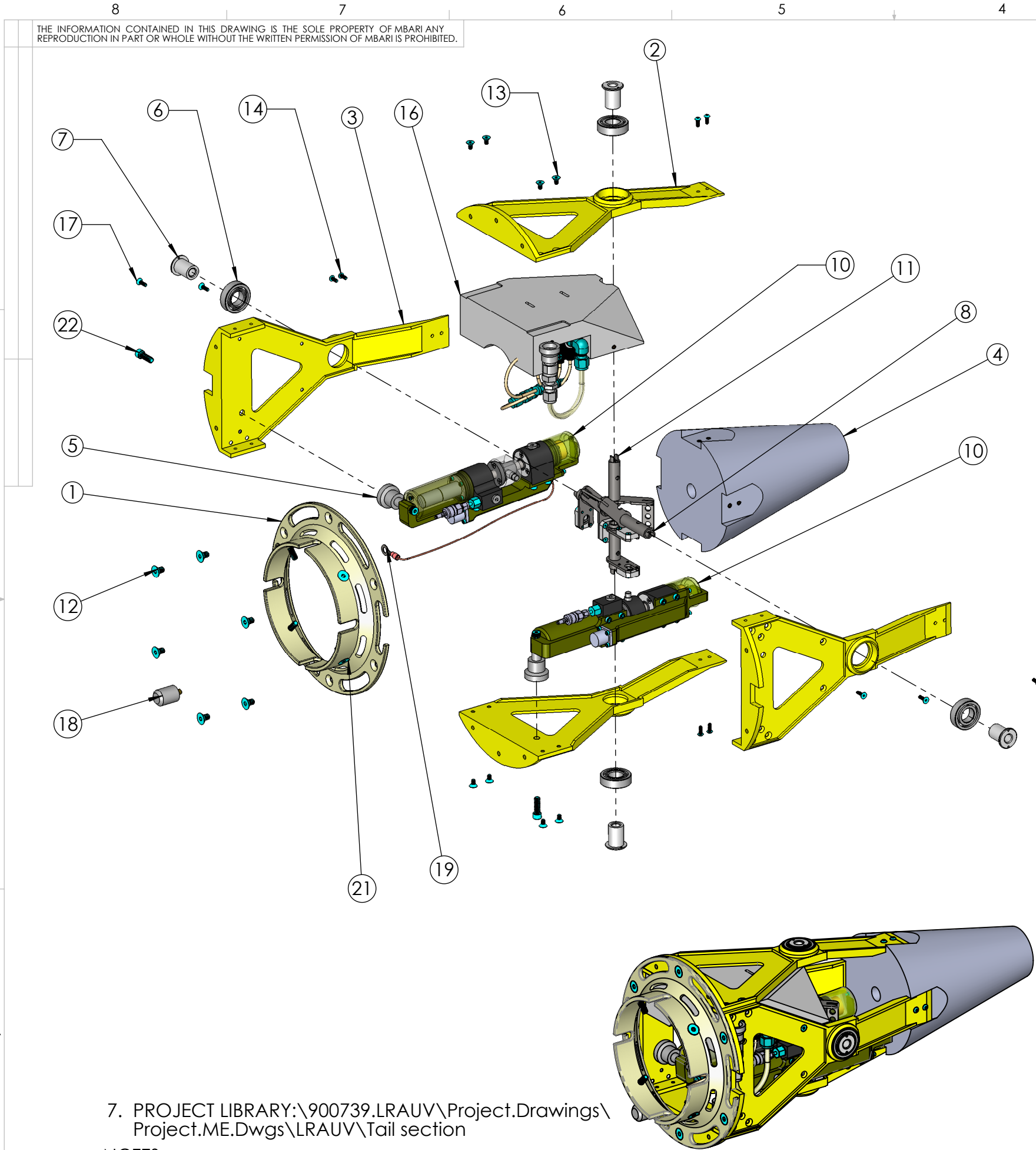




22	2	92185A540	1/4-20 x 3/4 Soc Hd Cap		McMaster-Carr	AISI 316
21	4	90585A540	1/4-20 x 3/4L Flt Hd Sckt Screw		McMaster-Carr	AISI 316
20	2	97345A540	1/4 x 3/4 x #10-24 Soc Hd Shldr Screw		McMaster-Carr	AISI 316
19	1	P-201xxx-12	Buss Wire - Grounding Wire Assem.		MBARI	
18	1	A-201xxx-13	Zinc Anode - O-Ring Assembly		MBARI	
17	4	90585A214	#6-32 x 1/2 Flt Hd Soc Screw		McMaster-Carr	AISI 316
16	1	A-201176-11	Tecnadyne PC1X Compensator Assembly	A	MBARI	
15	12	632B6-8B	Yardley #6-32 Brass Insert		Yardley	Brass, C230 (Red brass)
14	8	98164A107	#6-32 x 3/8 Button Hd Screw		McMaster-Carr	AISI 316
13	8	90585A225	#8-32 x 5/16 Flt Hd Soc Screw		McMaster-Carr	AISI 316
12	6	90585A038	1/4-20 x 7/16 Flt Hd Soc Screw		McMaster-Carr	AISI 316
11	1	A-200732-09	Rudder Crank FINISH MACHINING	B	MBARI	
10	2	A-200711-09	CS LDA AssemblyI		MBARI	
9	4	A-200xxx-09	Pivot Bearing Assembly		MBARI	
8	1	A-200731-09	Elevator CRANK FINISH MACHINING	B	MBARI	
7	4	P-200700-09	CS Centering Sleeve	A	MBARI	Black DELRIN
6	4	06003	Jilson Plastic Bearing		Jilson Group	ACETAL
5	2	P-200702-09	CS Fin Actuator Mount		MBARI	Black DELRIN
4	1	P-200497-08	Tail Cone Foam Flotation _V4 (Daphne)		Ideal Instrument	TG-28A Syntactic Foam
3	2	P-200950-10	Fin Bearing Mount	C	MBARI	Aluminum 6061-T6
2	2	P-200950-10	Fin Bearing Mount	C	MBARI	Aluminum 6061-T6
1	1	P-200627-08	Foam Mount Plate	A	MBARI	Aluminum 6061-T6
ITEM NO.	CS Actuator Assembly/QTY.	Part_Number	DESCRIPTION	Revision	Vendor	MATERIAL

BILL OF MATERIALS

Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE		Monterey Bay Aquarium Research Institute			
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN	J. ERICKSON			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	J. ERICKSON						
Engineer						CHECKED							
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	900739			TETHYS - LRAUV			
						PROJECT	LRAUV			Tail Control Assem. V7 - CS ACTUATOR ASSY			
Application		DO NOT SCALE DRAWING				WEIGHT	9.00			SIZE B	DWG. NO. A-201xxx-15	REV.	
						SCALE	1:12	CAD	FILE: MECH ENG ON TORNADO	SHEET 1 OF 2			

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

D

C

B

A

8

7

6

5

4

3

2

1

Shop / Q.C.

Inspector

Shop Foreman

Engineer

NEXT ASSY Description

NEXT ASSY Number

Application

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:

1 PLACE DIM ±1/16

2 PLACE DIM ±.02

3 PLACE DIM ±.005

ANGLES ±1°

1. DIMENSIONS ARE IN INCHES

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6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.

DO NOT SCALE DRAWING

APPROVALS

DATE

DRAWN J. ERICKSON

ENGINEER J. ERICKSON

CHECKED

PROJECT NO. 900739

PROJECT LRAUV

WEIGHT lb.

Monterey Bay Aquarium Research Institute

MBARI

7700 Sandholdt RD.

Moss Landing, CA 95039

PH: (831) 775-1700



TETHYS - LRAUV

TAIL CONTROL ASSEM.V7-CS ACTUATOR ASSY

SIZE B

DWG. NO. .DWG

REV.

SCALE 1:12

CAD FILE: MECH ENG ON TORNADO

SHEET 2 OF 2

NOTES: (CONT. FROM TITLE BLOCK)