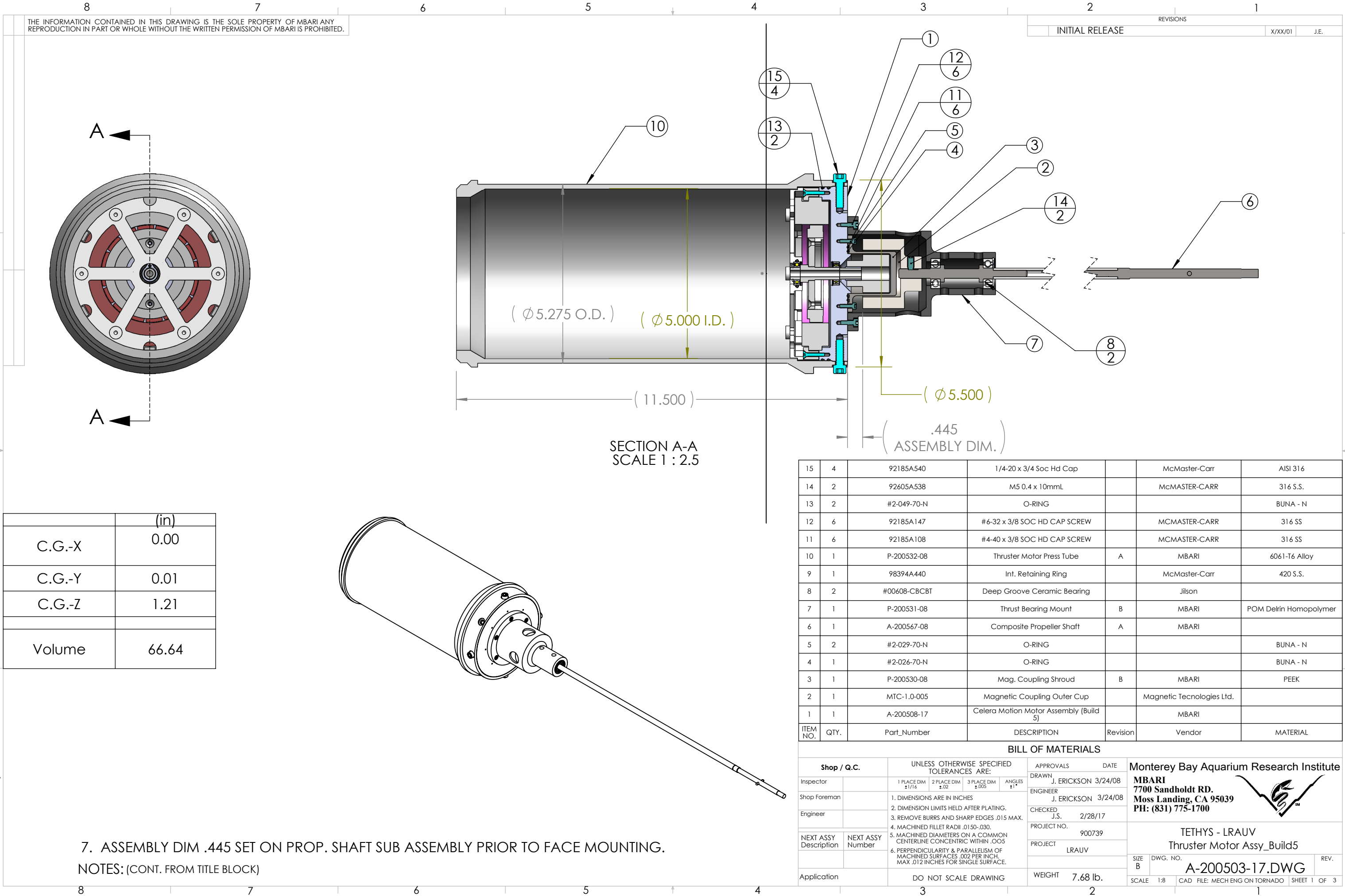
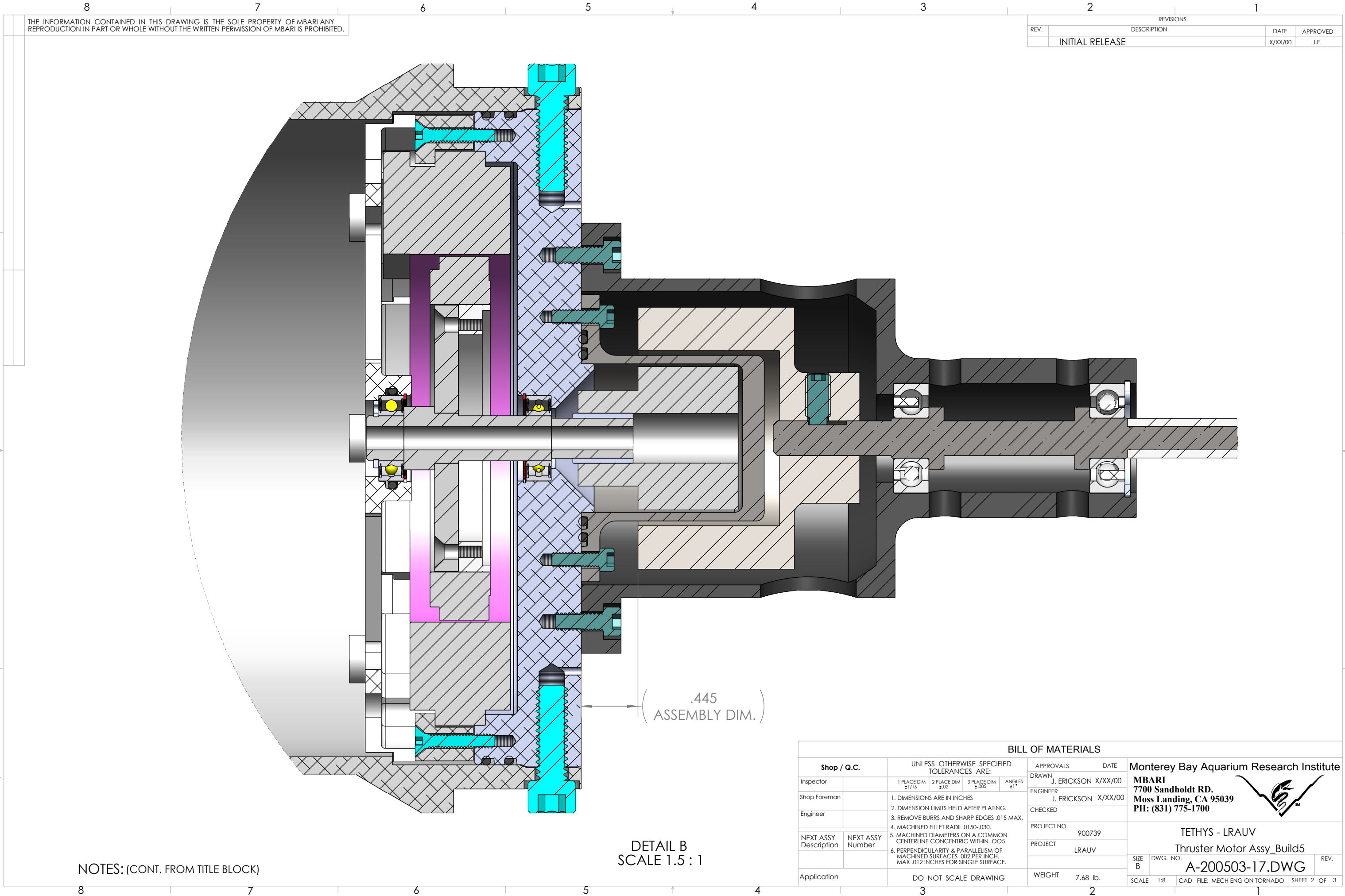






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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/00	J.E.

NOTES: (CONT. FROM TITLE BLOCK)

DETAIL B
SCALE 1.5 : 1

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 J. ERICKSON X/XX/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.				ENGINEER J. ERICKSON X/XX/00		
Engineer		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005				CHECKED		
NEXT ASSY Description	NEXT ASSY Number	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.				PROJECT NO. 900739		
						PROJECT LRAUV	TETHYS - LRAUV Thruster Motor Assy_Build5	
Application		DO NOT SCALE DRAWING				WEIGHT 7.68 lb.		
						SIZE B	DWG. NO. A-200503-17.DWG	REV.
						SCALE 1:8	CAD FILE: MECH ENG ON TORNADO	SHEET 2 OF 3

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

ASSEM/DISASSEMBLY TOOL--A ROUND PVC TOOL IS PROVIDED TO MAKE DISASS. POSSIBLE, IT MAY HELP AS WELL FOR ASSEMBLY.
GREASE AND CONSIDERABLE PRESSURE ARE REQUIRED TO COMPRESS DUAL ORINGS(13) INTO HOUSING

WIRES-CARE MUST BE TAKEN TO AVOID PINCHING, A PROTECTIVE SLEEVE IS ADVISABLE

MAGNETIC COUPLING--IS VERY STRONG, CARE MUST BE TAKEN NOT TO DAMAGE SHROUDS, SEALS OR PROPELLER SHAFT

WET BEARINGS--#8, AND ON PROP END, ARE CURRENTLY DELRIN/GLASS. THEY SHOULD BE CHANGED OUT ON A REGULAR BASIS, TBD.
A LONGER LIFE MAY BE GAINED BY USING CERAMIC BEARINGS, 0608-CBCBT, HOWEVER, THESE HAVE NOT BEEN EVALUATED YET.

NOTES: (CONT. FROM TITLE BLOCK)

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	J. ERICKSON	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	J. ERICKSON		
Engineer						CHECKED			
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	900739		
		PROJECT	LRAUV					TETHYS - LRAUV THRUSTER MOTOR ASSY_V3 NOTES	
Application		DO NOT SCALE DRAWING	WEIGHT	lb.			SIZE B		
						SCALE	1:8	CAD FILE: MECH ENG ON TORNADO	SHEET 3 OF 3

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