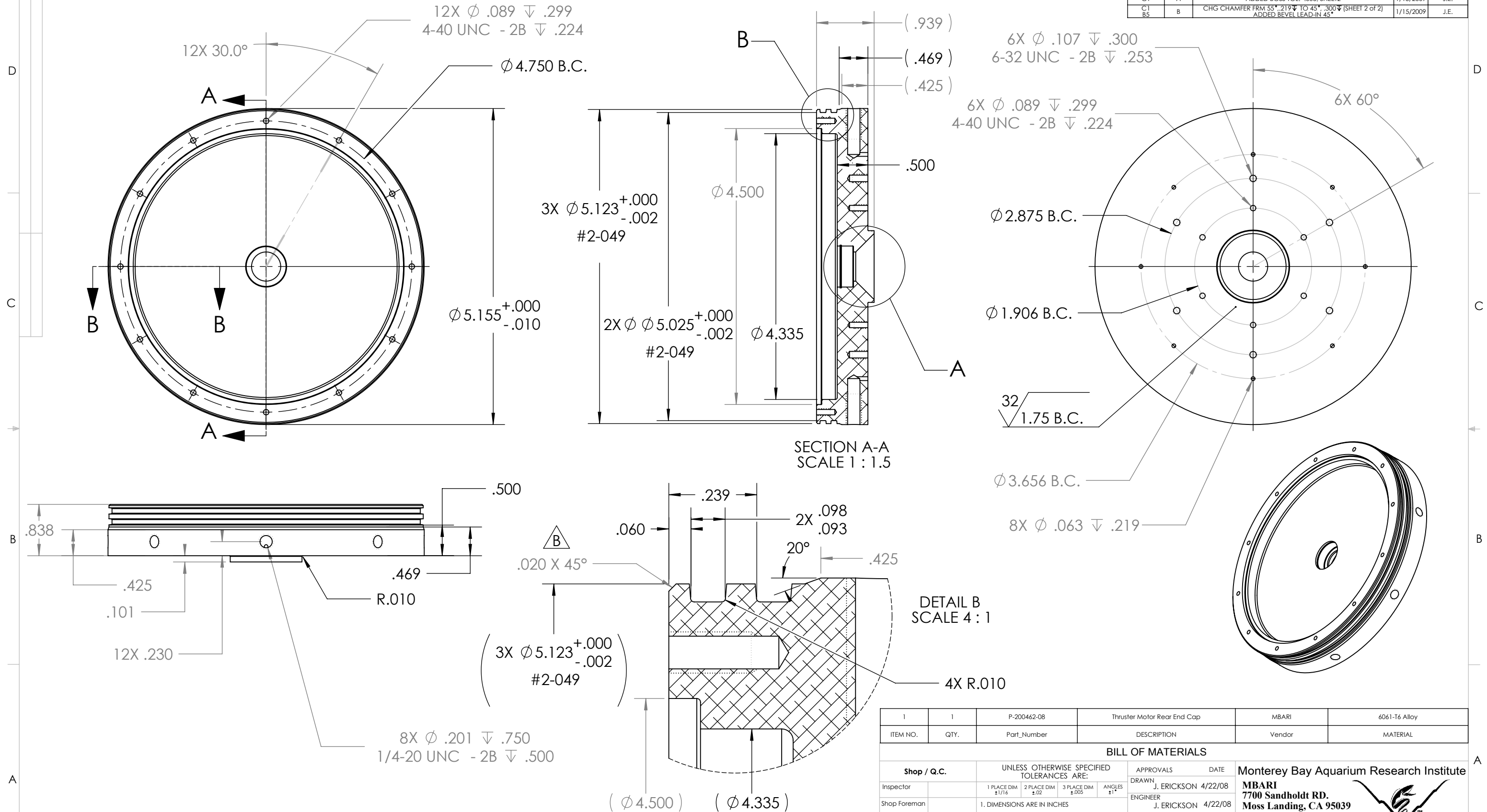


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REVISIONS					
INITIAL RELEASE				X/XX/01	J.E.
ZONE	REV.	DESCRIPTION		DATE	APPROVED
C1	A	ADDED BOSS TOL. -.005, SHEET2		1/15/2009	J.E.
C1 B5	B	CHG CHAMFER FRM 55°.219"✓ TO 45°.300"✓ (SHEET 2 of 2) ADDED BEVEL LEAD-IN 45°		1/15/2009	J.E.



9. Q.C. (INSPECTION) REPORT REQUIRED FOR EACH PIECE.

8. Finish: HARD BLACK ANODIZE IN ACCORDANCE WITH MIL-A-8625F Type III (.001 THICK) TEFLON COAT.

7. PROJECT LIBRARY:\900739.LRAUV\Project.Drawings\Project.ME.Dwgs\LRAUV\ThrusterAssembly

NOTES: (CONT. FROM TITLE BLOCK)

1	1	P-200462-08	Thruster Motor Rear End Cap	MBARI	6061-T6 Alloy
ITEM NO.	QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL

Shop / Q.C.

Inspector

Shop Foreman

Engineer

NEXT ASSY Description

A-200503-08

Application

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:

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.

DO NOT SCALE DRAWING

APPROVALS DATE

DRAWN J. ERICKSON 4/22/08

ENGINEER J. ERICKSON 4/22/08

CHECKED

PROJECT NO. 900739

PROJECT LRAUV

WEIGHT 1.15 lb.

Monterey Bay Aquarium Research Institute

MBARI

7700 Sandholdt Rd.

Moss Landing, CA 95039

PH: (831) 775-1700



TETHYS - LRAUV

Thruster Motor Rear End Cap

SIZE B

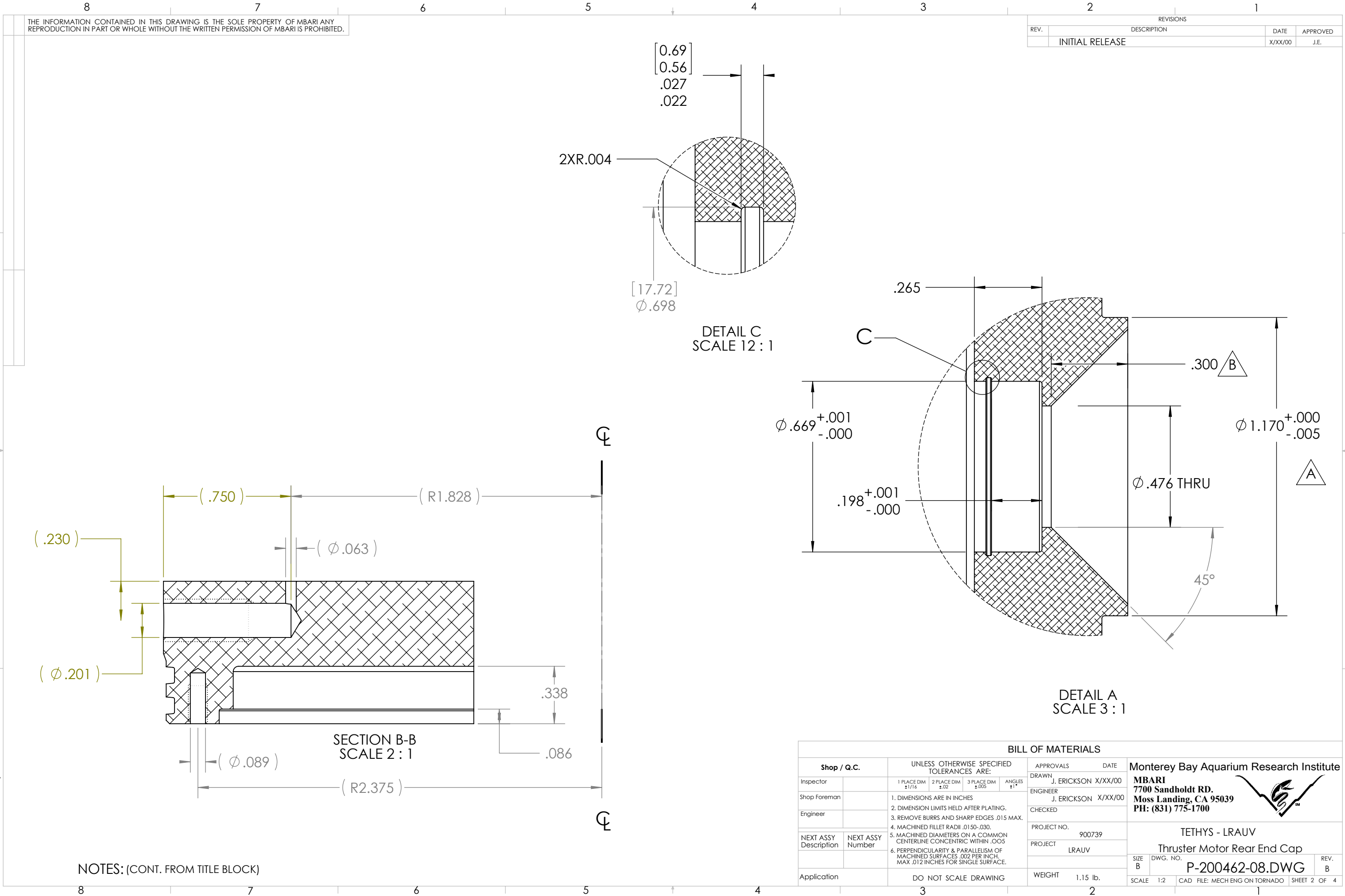
DWG. NO. P-200462-08.DWG

REV. B

SCALE 1:2

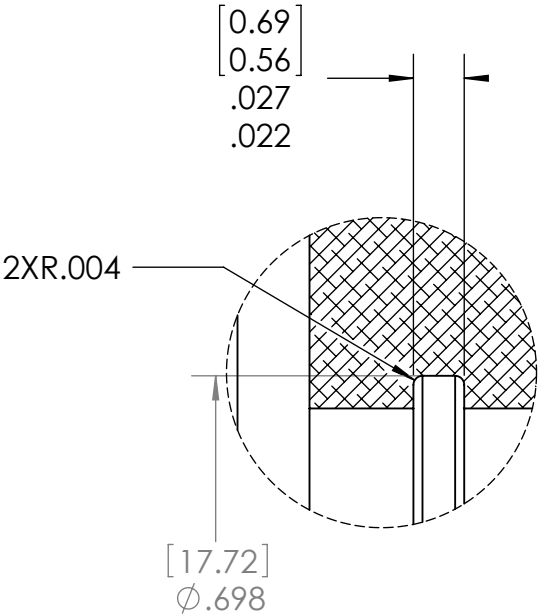
CAD FILE: MECH ENG ON TORNADO

SHEET 1 OF 4

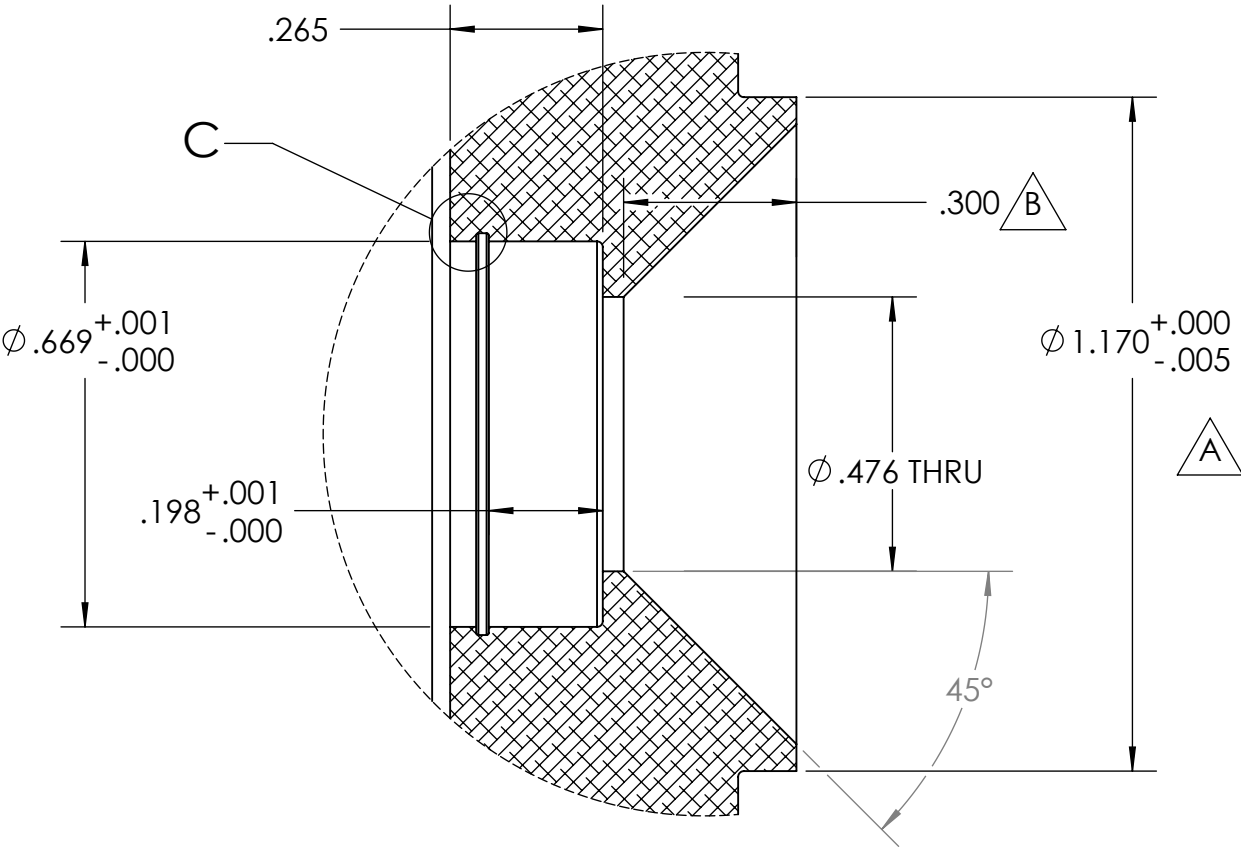


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/00	J.E.



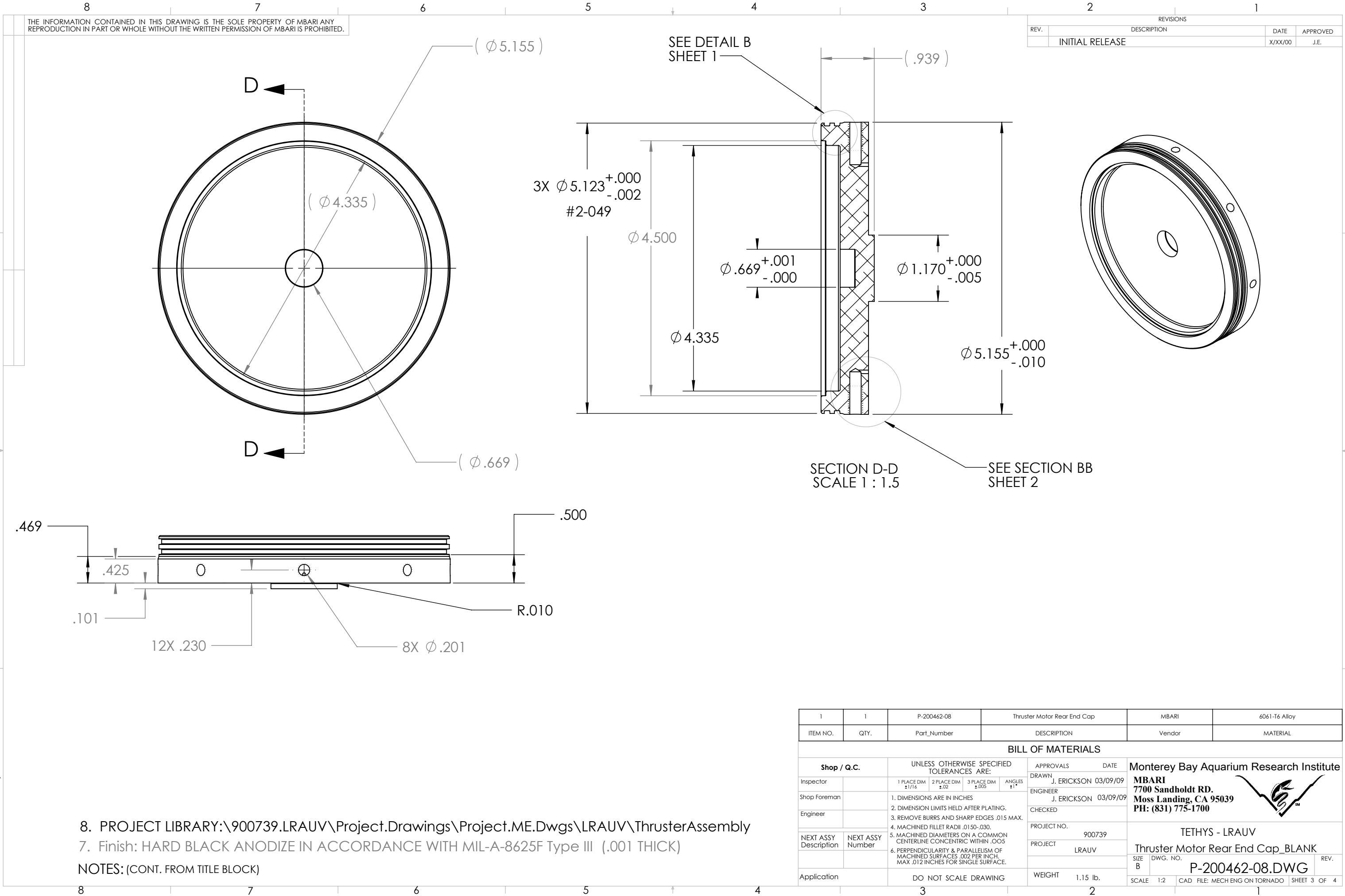
DETAIL C
SCALE 12 : 1



DETAIL A
SCALE 3 : 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
Shop Foreman		1. DIMENSIONS ARE IN INCHES	ENGINEER J. ERICKSON X/XX/00
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.	CHECKED
NEXT ASSY Description	NEXT ASSY Number	3. REMOVE BURRS AND SHARP EDGES .015 MAX.	PROJECT NO. 900739
		4. MACHINED FILLET RADII .0150-.030.	PROJECT LRAUV
		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005	WEIGHT 1.15 lb.
		6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.	
Application		DO NOT SCALE DRAWING	

Monterey Bay Aquarium Research Institute			
MBARI			
7700 Sandholdt RD.			
Moss Landing, CA 95039			
PH: (831) 775-1700			
TETHYS - LRAUV			
Thruster Motor Rear End Cap			
SIZE B	DWG. NO. P-200462-08.DWG	REV. B	
SCALE 1:2	CAD FILE: MECH ENG ON TORNADO	SHEET 2 OF 4	



1	1	P-200462-08	Thruster Motor Rear End Cap	MBARI	6061-T6 Alloy
ITEM NO.	QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL
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°
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.		DRAWN J. ERICKSON 03/09/09	
Engineer				ENGINEER J. ERICKSON 03/09/09	
				CHECKED	
NEXT ASSY Description	NEXT ASSY Number			PROJECT NO.	
				900739	
				PROJECT	LRAUV
Application		DO NOT SCALE DRAWING		WEIGHT	1.15 lb.
				TETHYS - LRAUV	
				Monterey Bay Aquarium Research Institute	
				MBARI	
				7700 Sandholdt RD.	
				Moss Landing, CA 95039	
				PH: (831) 775-1700	
				Thruster Motor Rear End Cap_BLANK	
				SIZE B	DWG. NO. P-200462-08.DWG
				SCALE 1:2	REV.
				CAD FILE: MECH ENG ON TORNADO	SHEET 3 OF 4

87654321

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

D

C

B

A

87654321

NOTES: (CONT. FROM TITLE BLOCK)

ITEM NO.	QTY.	PART NO.	DESCRIPTION	VENDOR	MATERIAL SPECIFICATION
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°
Shop Foreman		1. DIMENSIONS ARE IN INCHES		DRAWN J. ERICKSON	
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.		ENGINEER J. ERICKSON	
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED	
		4. MACHINED FILLET RADII .0150-.030.		PROJECT NO. 900739	
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT LRAUV	
	A-200503-08	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.			
Application		DO NOT SCALE DRAWING		WEIGHT 1.15 lb.	

87654321

Monterey Bay Aquarium Research Institute

MBARI

7700 Sandholdt RD.

Moss Landing, CA 95039

PH: (831) 775-1700



TETHYS - LRAUV

Thruster Motor Rear End Cap

SIZE B

DWG. NO. P-200462-08.DWG

REV.

SCALE 1:2

CAD FILE: MECH ENG ON TORNADO

SHEET 4 OF 4