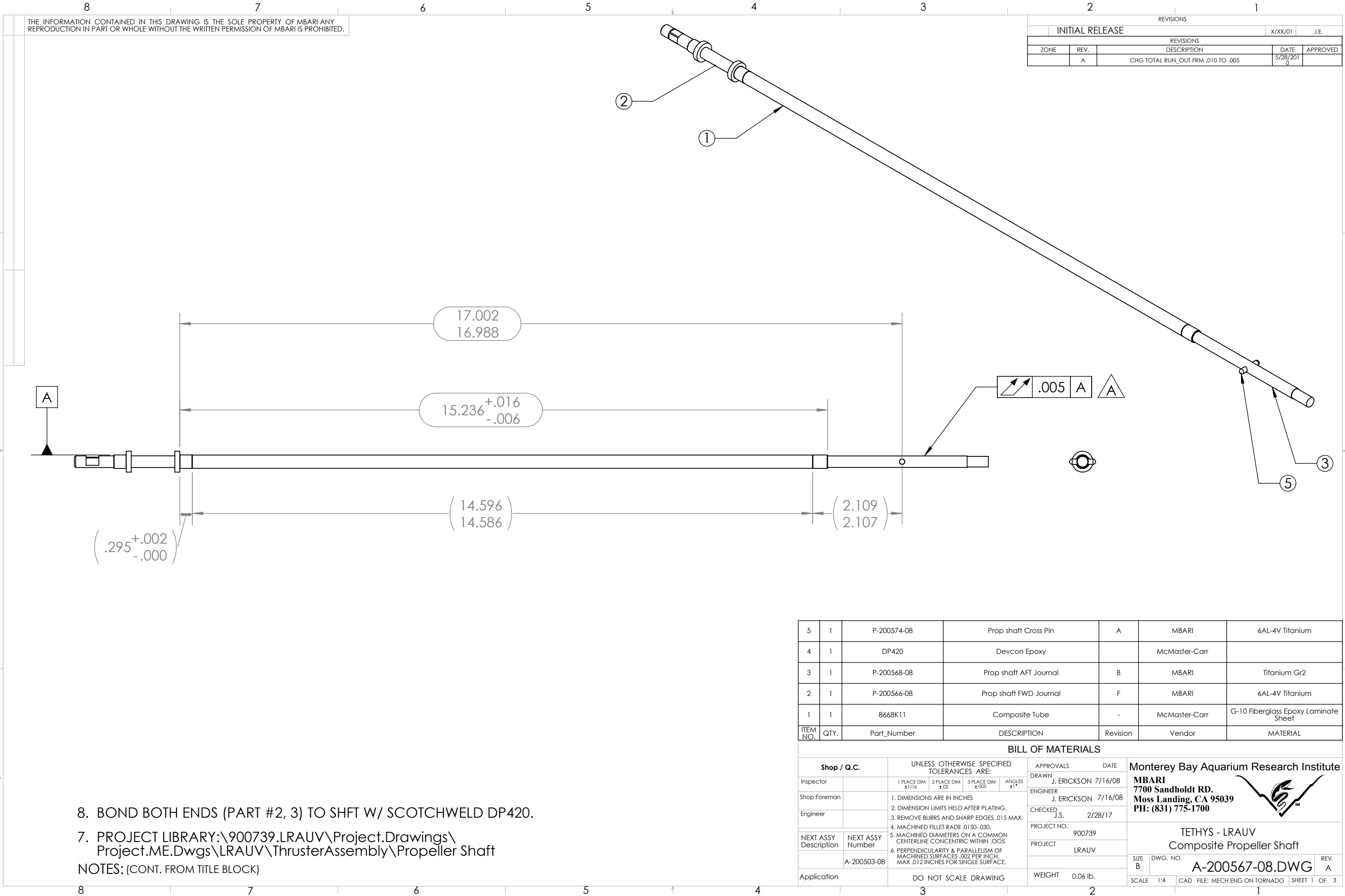
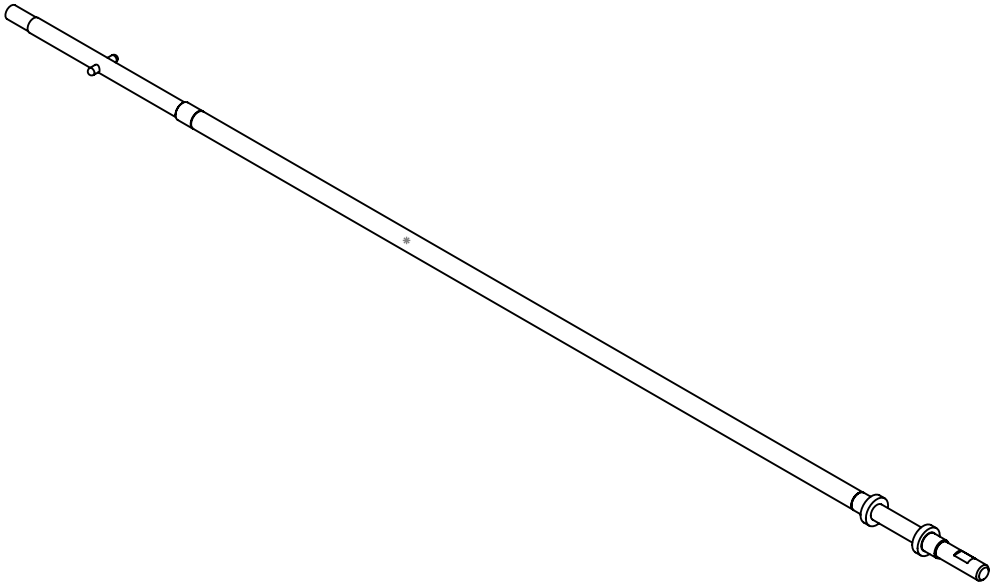






BONDING SET-UP (EACH END).

ITEM NO.	QTY.	PART NO.	DESCRIPTION			VENDOR	MATERIAL SPECIFICATION
BILL OF MATERIALS							
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			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°	APPROVALS DATE DRAWN J. ERICKSON X/XX/00 ENGINEER J. ERICKSON X/XX/00 CHECKED PROJECT NO. 900739 PROJECT LRAUV WEIGHT 0.06 lb. TETHYS - LRAUV Composite Propeller Shaft SIZE B SCALE 1:4 DWG. NO. A-200567-08.DWG REV. SHEET 2 OF 3	
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		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005 6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX. .012 INCHES FOR SPLIT SURFACE.					
NEXT ASSY Description	NEXT ASSY Number						
Application		DO NOT SCALE DRAWING					

NOTES: (CONT. FROM TITLE BLOCK)

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THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MBARI ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MBARI IS PROHIBITED.

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

SEE MS WORD--LRAUV PROPELLER SHAFT ASSEMBLY DOC FOR DETAILS

ASS'Y RUNOUT--TO ATTAIN DESIRED RUNOUT 0.005", THE G-10 SHAFTING ID NEEDS TO BE CIRCULARIZED AS MUCH AS POSSIBLE WITH A VERY SMALL BORING TOOL IN A LATHE, BRING ID TO 0.188", THIS WILL ALLOW A SMALL BONDING CLEARANCE. SOME SHAFTING JUST MAY BE UNSUITABLE, CHECK PIECES

JOURNAL ENDS--ABRAID AND CLEAN, USE A LATHE TO HOLD AND ALIGN ALL PARTS, A FLAT TABLE TOP IS NOT SUFFICIENT TO HOLD RUNOUT SPECS.

DP420--SLIDE PARTS TOGETHER SEVERAL TIMES TO GET ADHESIVE DISTRIBUTED UNIFORMLY, THE AIR TRAPPED INSIDE THE SHAFT MAY PUSH THE JOURNALS OUT, SO USING A LATHE BOTH ALIGNS AND ACTS AS A JIG TILL THE EPOXY SETS

BEARING SURFACES--THE AREAS ON THE JOURNALS MAY NEED TO BE CAREFULLY CLEANED, AFTER BONDING, TO ALLOW PROPER BEARING INSTALLATION

NOTES: (CONT. FROM TITLE BLOCK)

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			
		PROJECT	LRAUV					TETHYS - LRAUV		
Application		DO NOT SCALE DRAWING				WEIGHT	lb.	COMPOSITE PROP SHAFT ASSEMBLY NOTES		
								SIZE B	DWG. NO. .DWG	REV.
								SCALE 1:4	CAD FILE: MECH ENG ON TORNADO	SHEET 3 OF 3

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