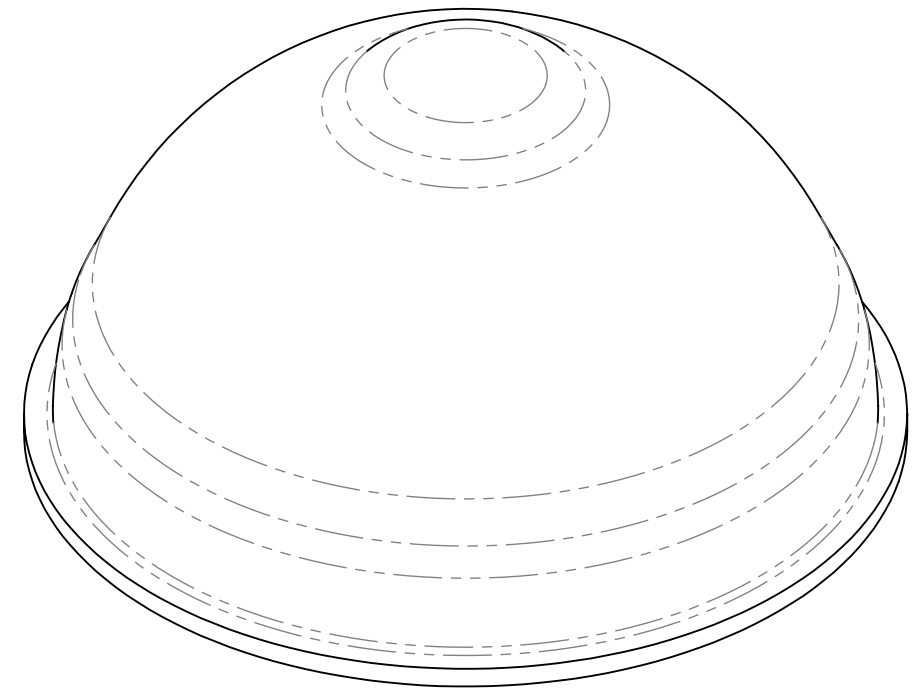
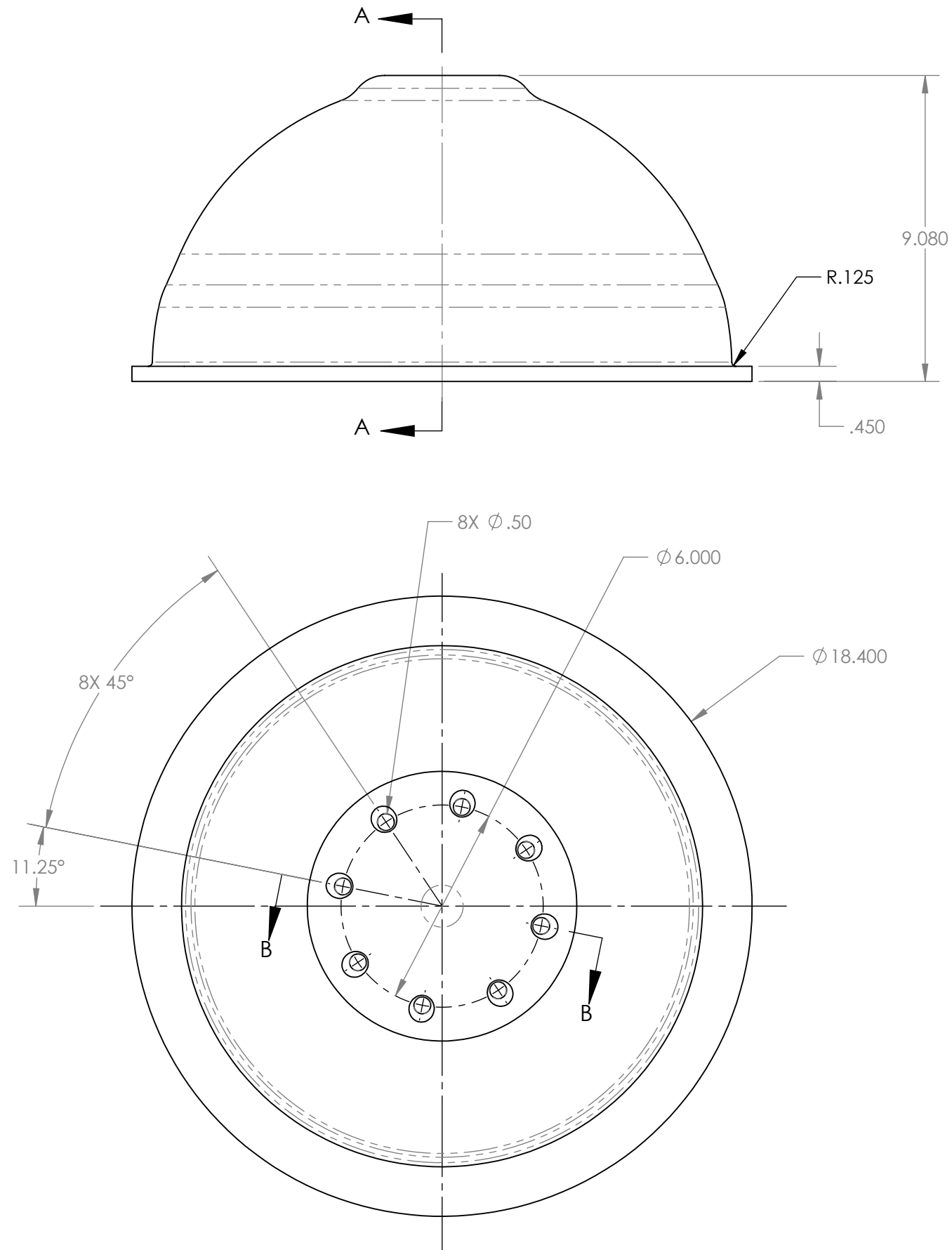


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

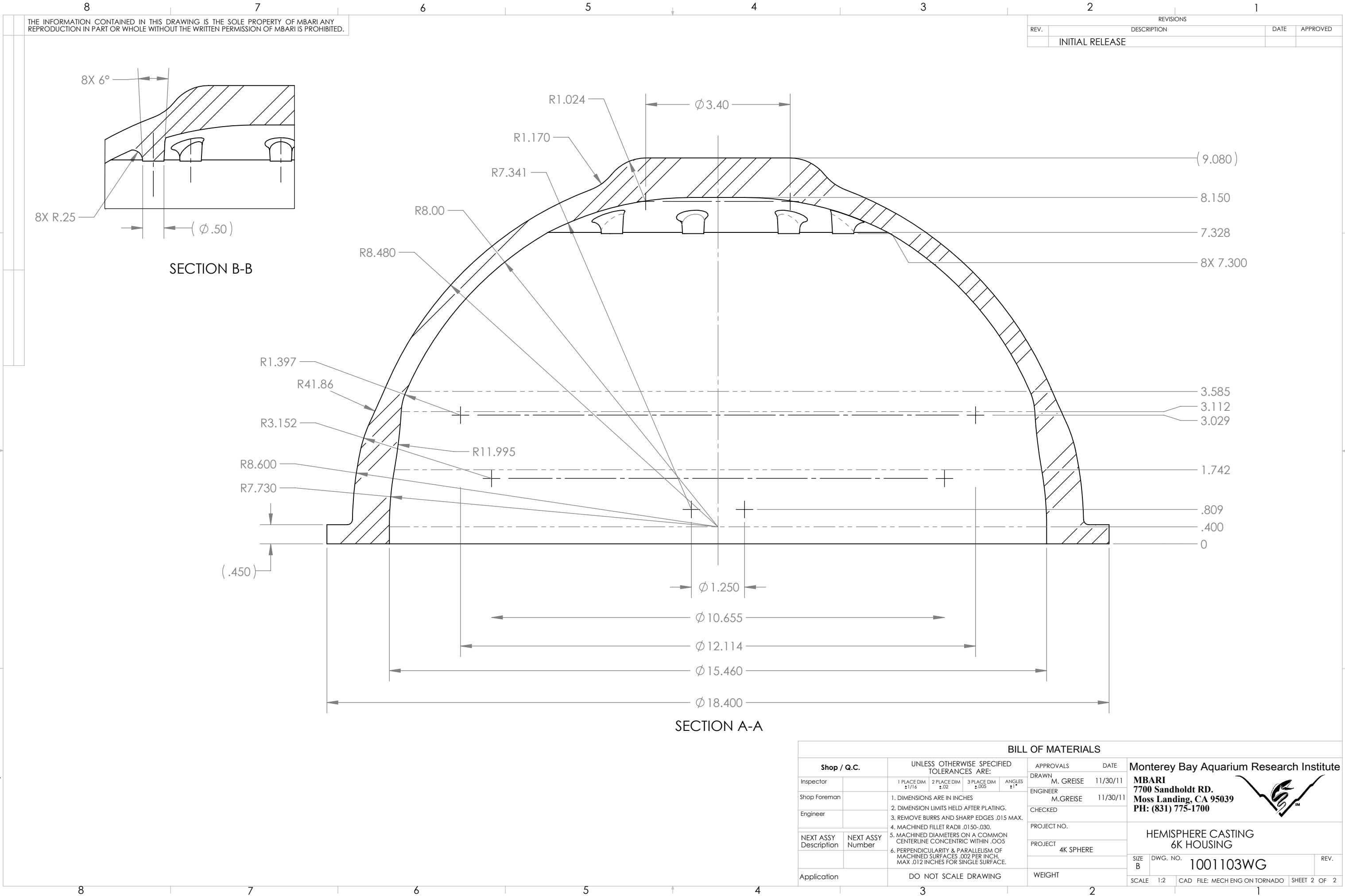
NOTES:

1. MATERIAL IS GR 5 AS CAST TITANIUM, MIN YIELD 120 KSI
2. BREAK ALL SHARP EDGES
3. APPLICABLE STANDARDS/SPECIFICATIONS:
ANSI Y14.5M-1994, DIMENSIONS AND TOLERANCES
MIL-STD-12, ABBREVIATIONS.
4. PART IS SYMMETRIC ABOUT CENTERLINE
5. WEIGHT: 47.8 LBS DRY



DATE: 1/17/12

BILL OF MATERIALS											
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE		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 ±.003	ANGLES ±1°	DRAWN	M. GREISE	11/30/11			
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	M. GREISE	11/30/11			
Engineer						CHECKED					
NEXT ASSY Description	NEXT ASSY Number	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.				PROJECT NO.		HEMISPHERE, 6K SPHERICAL HOUSING			
						PROJECT					
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B	DWG. NO.	1001103DWG	REV.
								SCALE 1:4	CAD FILE: MECH ENG ON TORNADO	SHEET 1	OF 2



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
INITIAL RELEASE			

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

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 M. GREISE 11/30/11

ENGINEER M.GREISE 11/30/11

CHECKED

PROJECT NO.

PROJECT 4K SPHERE

WEIGHT

Monterey Bay Aquarium Research Institute

MBARI

7700 Sandholdt RD.

Moss Landing, CA 95039

PH: (831) 775-1700



HEMISPHERE CASTING

6K HOUSING

SIZE B

DWG. NO. 1001103WG

REV.

SCALE 1:2

CAD FILE: MECH ENG ON TORNADO

SHEET 2 OF 2