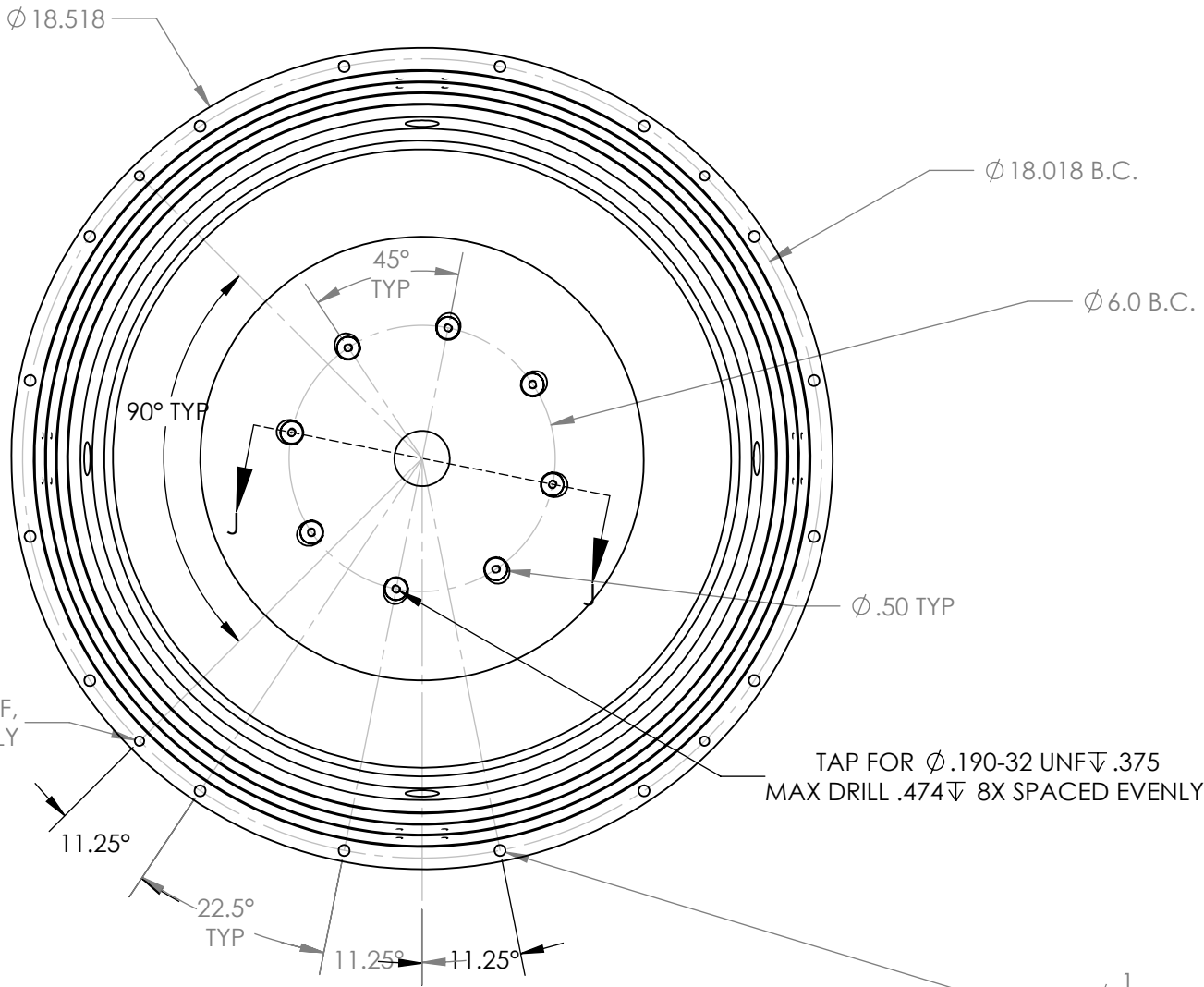


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

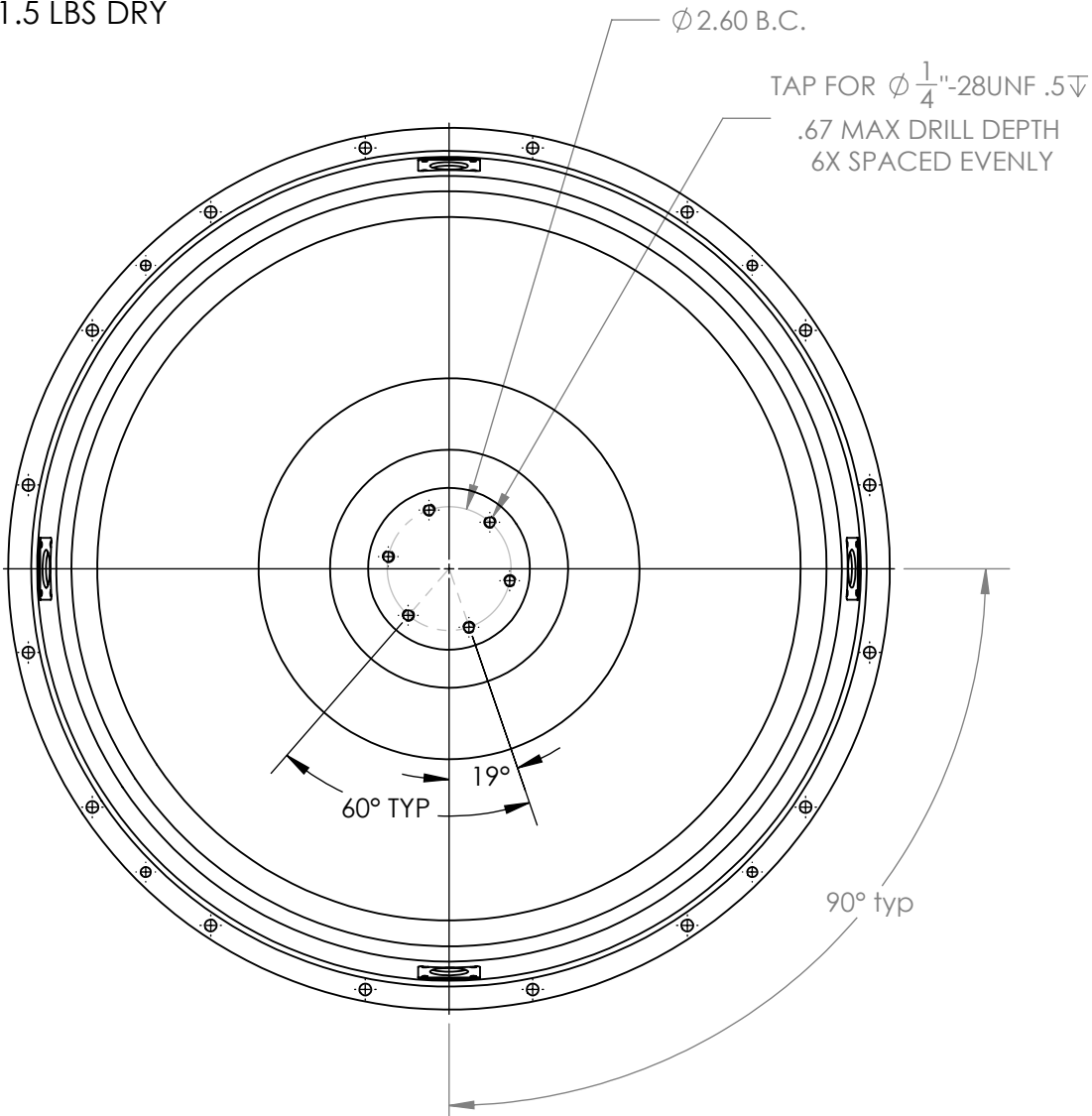
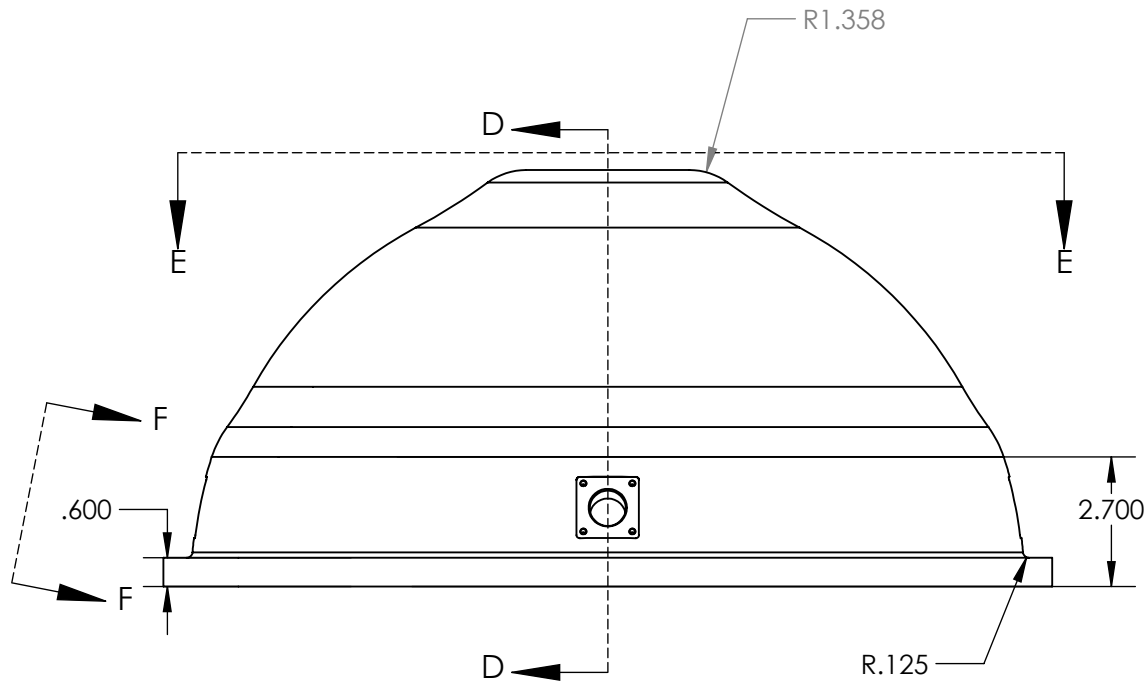
- NOTES:
1. MATERIAL IS GR 5 AS CAST TITANIUM, MIN YIELD 120 KSI
 2. BREAK ALL SHARP EDGES
 3. APPLICABLE STANDARDS/SPECIFICATIONS:
ANSI Y14.5M-1982, DIMENSIONS AND TOLERANCES
MIL-STD-12, ABBREVIATIONS.
 4. GROOVE FOR O-RING 2-385
 5. GROOVE FOR O-RING 2-386
 6. BOSS AND PENETRATION FOR SEACON MINK-FCR RECEPTACLE
 7. PART IS SYMMETRIC ABOUT CENTERLINE
 8. DEPTH RATING OF ASSEMBLY: 6000M
 9. WEIGHT: 51.5 LBS DRY



TAP FOR $\varnothing 1/4$ -28 UNF,
4X SPACED EVENLY

TAP FOR $\varnothing .190$ -32 UNF $\nabla .375$
MAX DRILL $.474 \nabla$ 8X SPACED EVENLY

$\varnothing 1/4$ "-28 UNF THRU
16X SPACED EVENLY

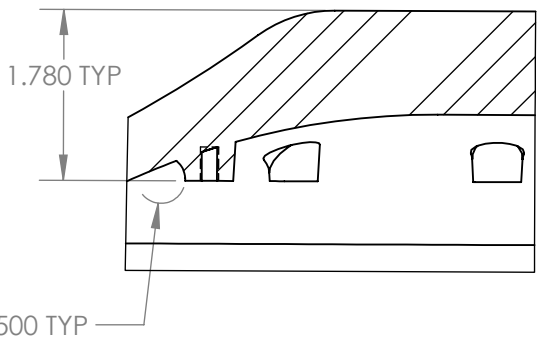


DATE: 9DEC11

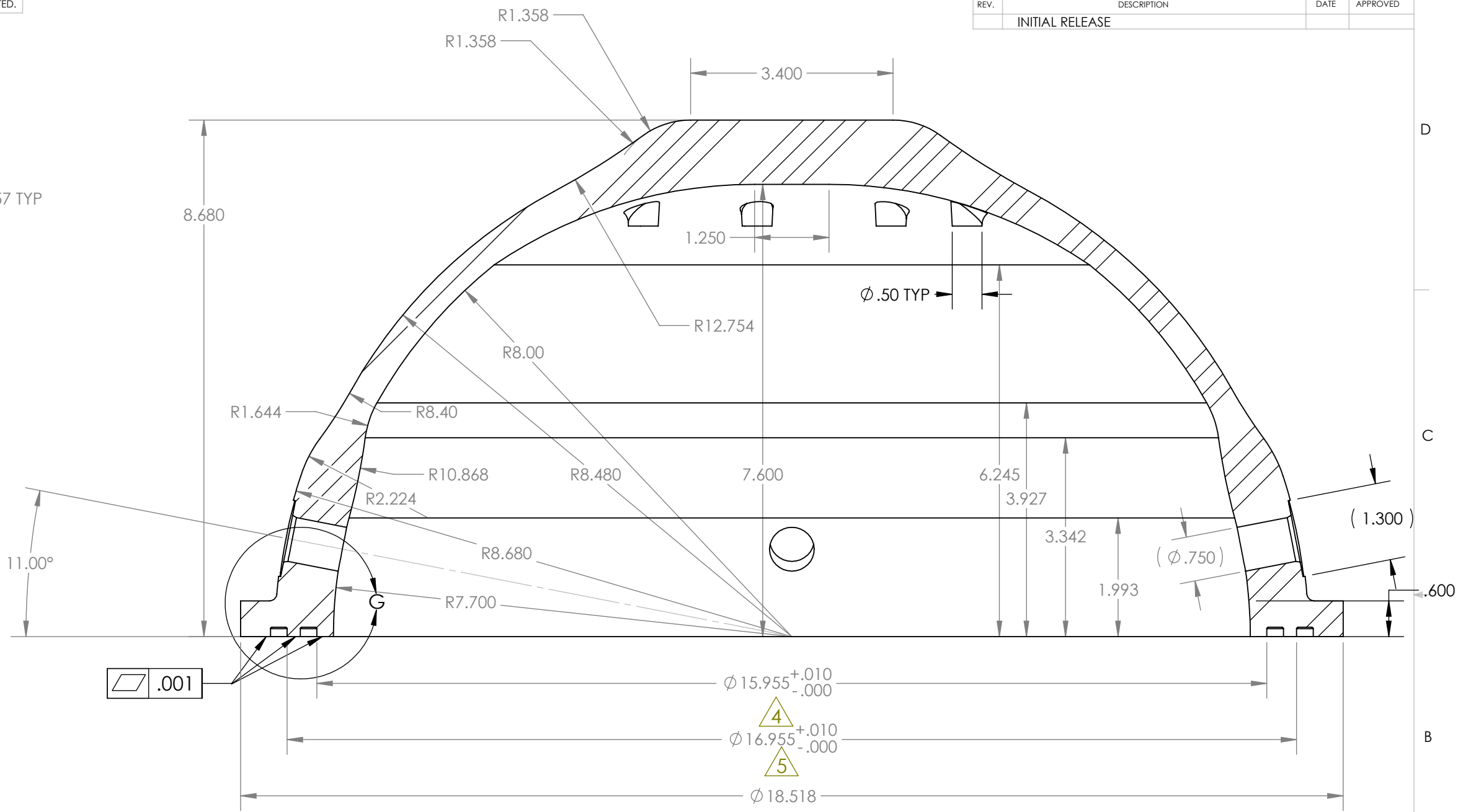
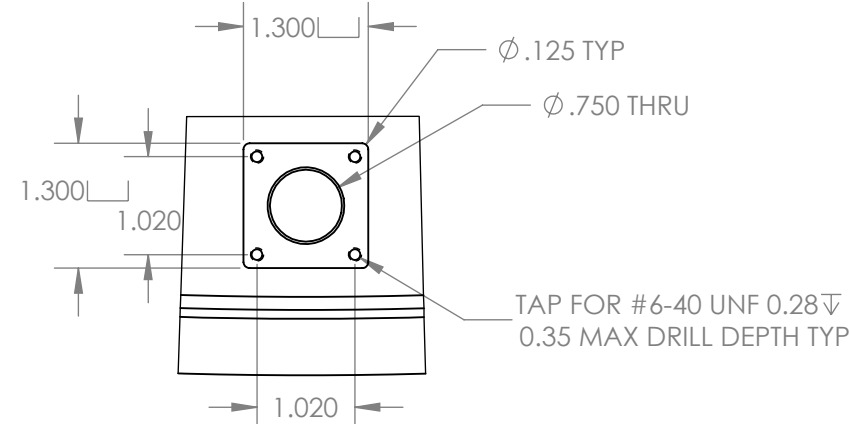
SECTION E-E
SCALE 1 : 4

BILL OF MATERIALS			
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	
Inspector		1 PLACE DIM $\pm 1/16$	2 PLACE DIM $\pm .02$
Shop Foreman		3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$
Engineer		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.	
NEXT ASSY Description	NEXT ASSY Number	APPROVALS DATE	
		DRAWN M. GREISE 11/30/11	Monterey Bay Aquarium Research Institute
		ENGINEER M. GREISE 11/30/11	MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700
		CHECKED	
		PROJECT NO.	
		PROJECT 4K SPHERE	
		WEIGHT	
		DO NOT SCALE DRAWING	
		SCALE 1:5	
		CAD FILE: MECH ENG ON TORNADO	
		SHEET 1 OF 2	

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		



MINK-FCR BORE DETAIL, 4X
SPACED EVENLY 
SECTION F-F
SCALE 1 : 2



SECTION D-D
SCALE 1 : 2

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 ±.005	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.							
								PROJECT				4K SPHERE			
Application		DO NOT SCALE DRAWING				WEIGHT				SIZE B		DWG. NO. 1001101DWG		REV.	
										SCALE 1:5		CAD FILE: MECH ENG ON TORNADO		SHEET 2 OF 2	