

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			

- 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. DEPTH RATING OF ASSEMBLY: 6000M
 6. WEIGHT: 47.6 LBS DRY

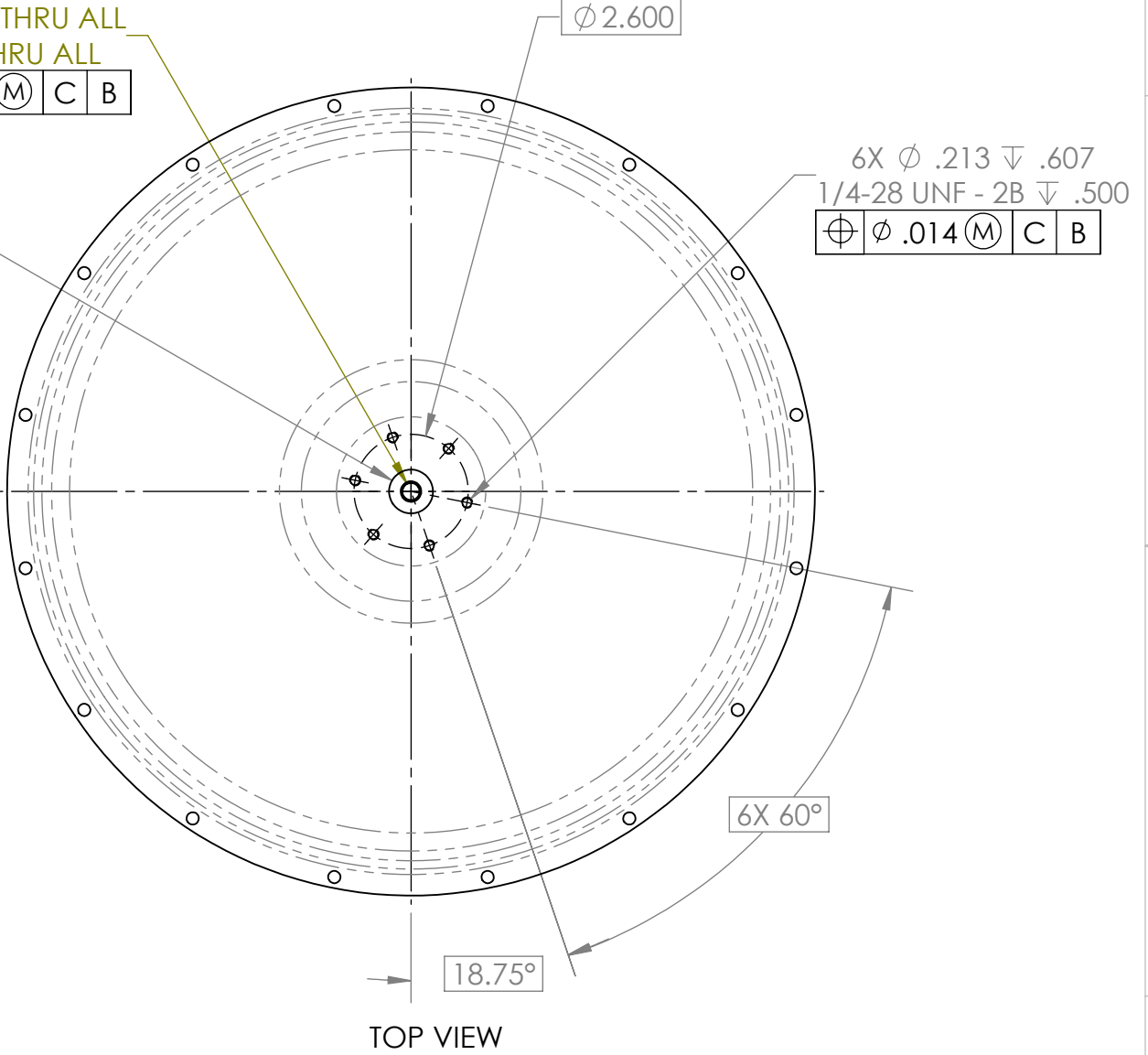
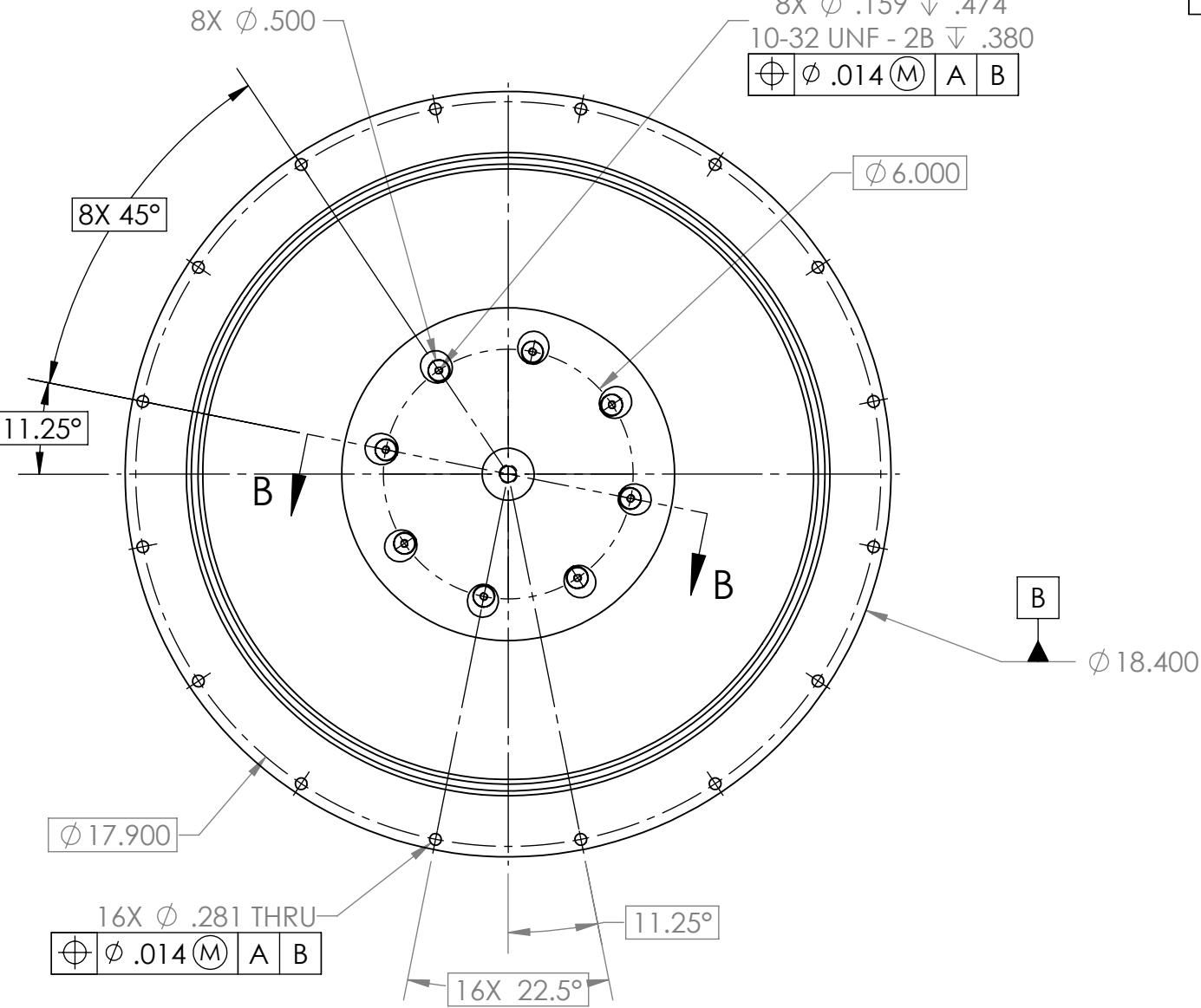
SAE #4 PORT ϕ .391 THRU ALL
7/16-20 UNF - 2B THRU ALL

ϕ .028 (M) C B

ϕ 1.000 ∇ .040
 ϕ .028 (M) C B

6X ϕ .213 ∇ .607
1/4-28 UNF - 2B ∇ .500
 ϕ .014 (M) C B

8X ϕ .159 ∇ .474
10-32 UNF - 2B ∇ .380
 ϕ .014 (M) A B



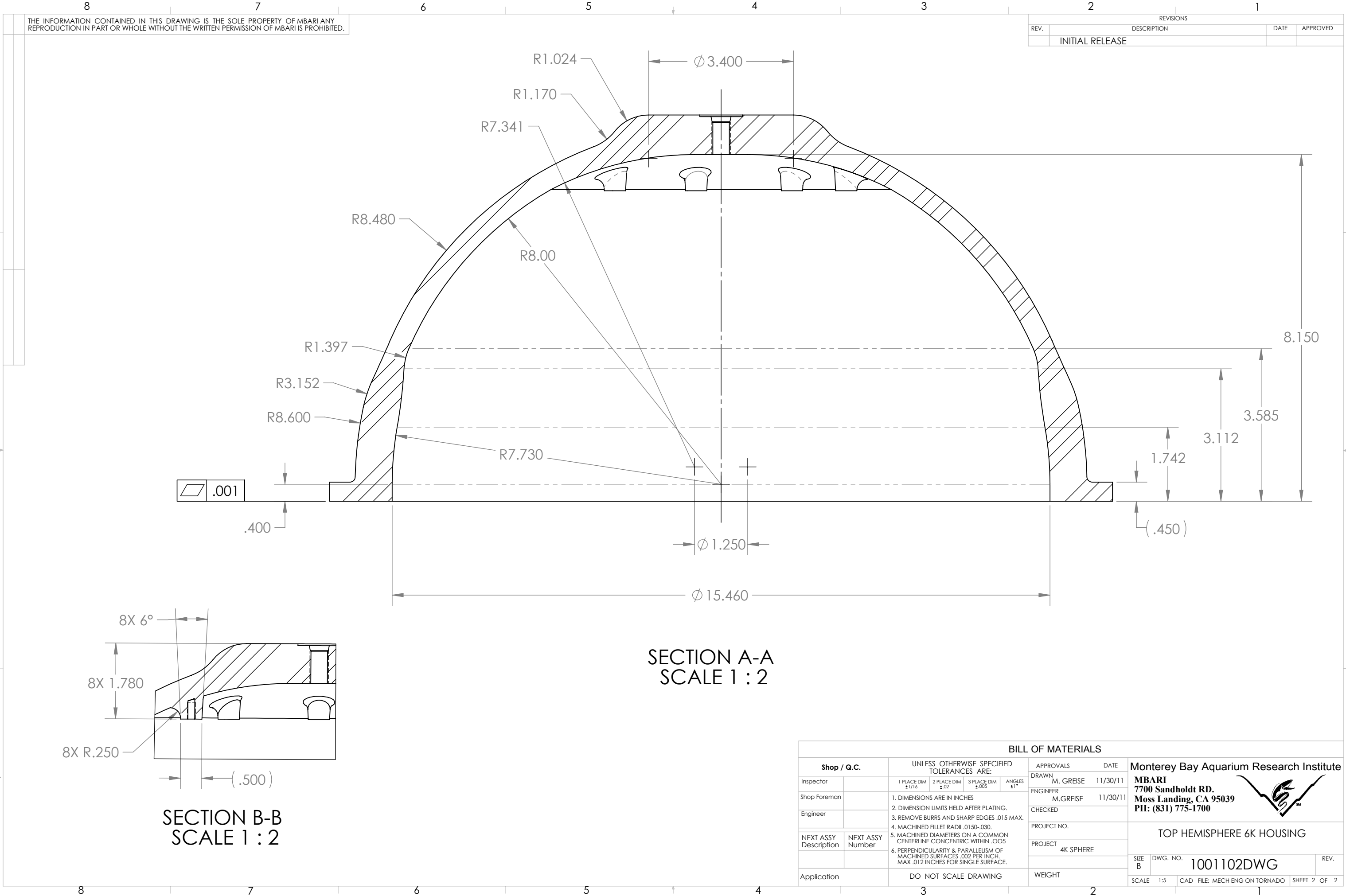
DATE: 7JAN12

BILL OF MATERIALS			
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	APPROVALS
Inspector		1 PLACE DIM $\pm$ 1/16	DATE
Shop Foreman		2 PLACE DIM $\pm$.02	DRAWN M. GREISE 11/30/11
Engineer		3 PLACE DIM $\pm$.005	ENGINEER M. GREISE 11/30/11
		ANGLES $\pm$ 1°	CHECKED
NEXT ASSY Description	NEXT ASSY Number	1. DIMENSIONS ARE IN INCHES	PROJECT NO.
		2. DIMENSION LIMITS HELD AFTER PLATING.	PROJECT 6K SPHERE
		3. REMOVE BURRS AND SHARP EDGES .015 MAX AFTER MACHINING.	WEIGHT
		4. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005 UNLESS SPECIFIED OTHER.	
		5. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX .012 IN FOR SINGLE SURFACE UNLESS SPECIFIED OTHER	
Application		DO NOT SCALE DRAWING	

Monterey Bay Aquarium Research Institute
MBARI
7700 Sandholdt RD.
Moss Landing, CA 95039
PH: (831) 775-1700

TOP HEMISPHERE,
6K SPHERICAL HOUSING

SIZE B	DWG. NO. 1001102DWG	REV.
SCALE 1:5	CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 2



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			

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 $\pm 1/16$	2 PLACE DIM $\pm .02$	3 PLACE DIM $\pm .005$	ANGLES $\pm 1^\circ$	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. 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 M.GREISE	11/30/11		
Engineer						CHECKED			
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.		TOP HEMISPHERE 6K HOUSING	
						PROJECT 4K SPHERE			
Application		DO NOT SCALE DRAWING				WEIGHT		SIZE B	DWG. NO. 1001102DWG
								SCALE 1:5	CAD FILE: MECH ENG ON TORNADO
								SHEET 2 OF 2	