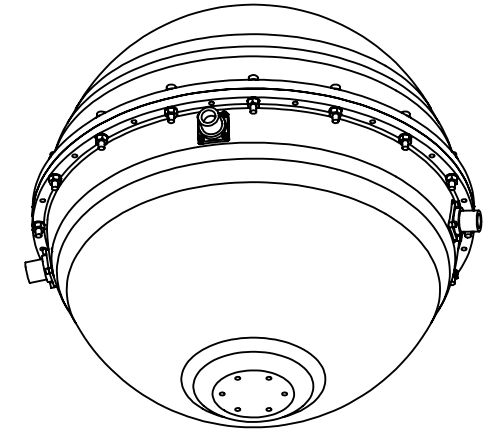
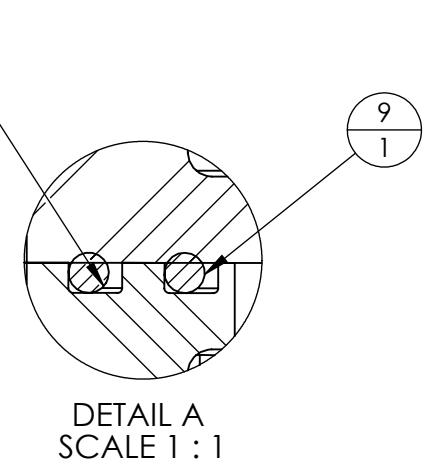
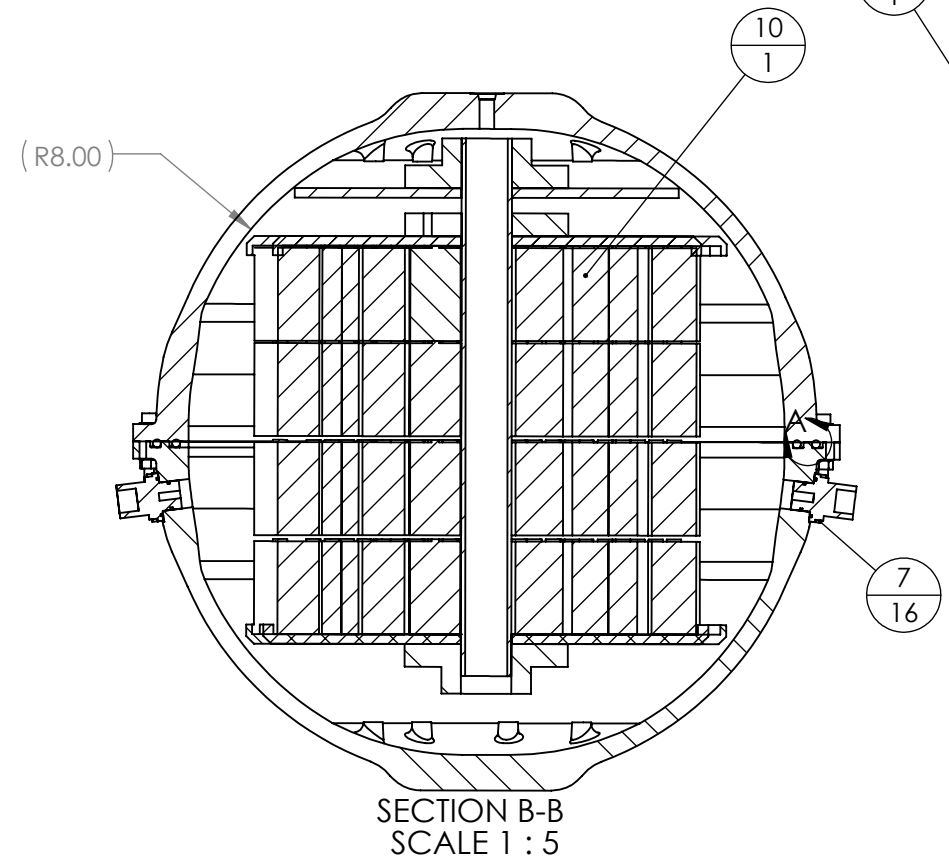
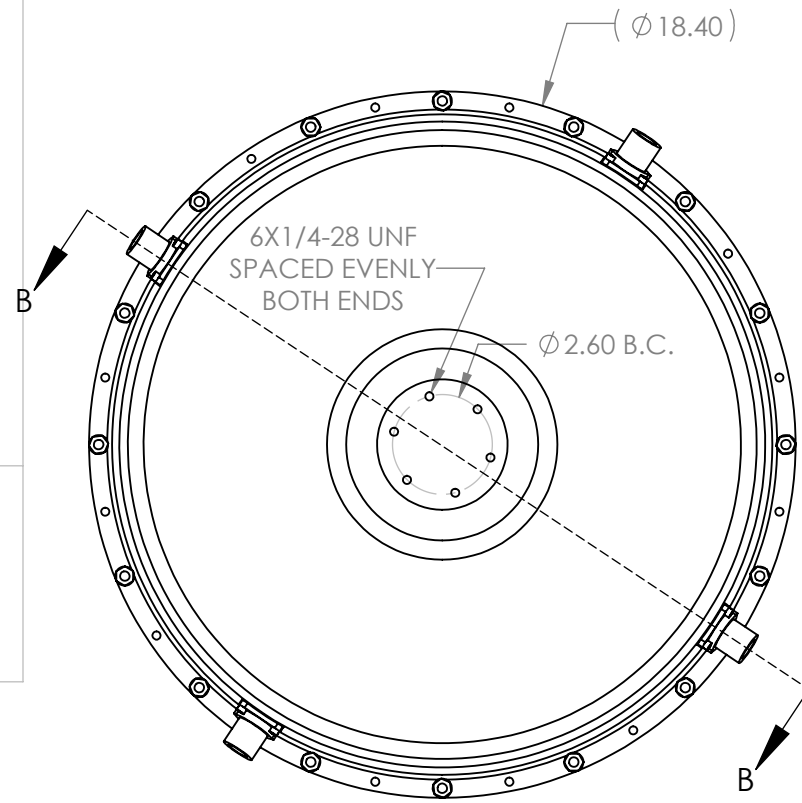


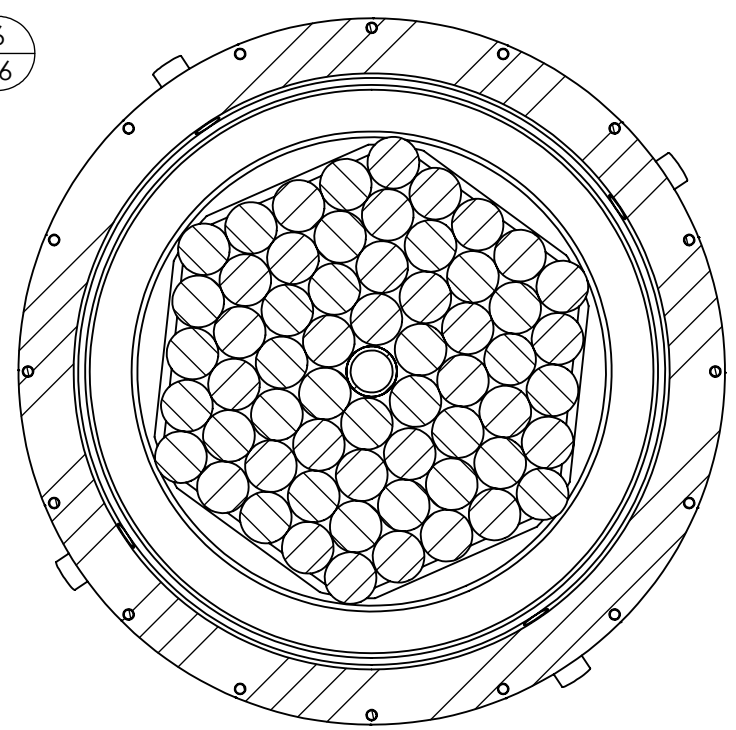
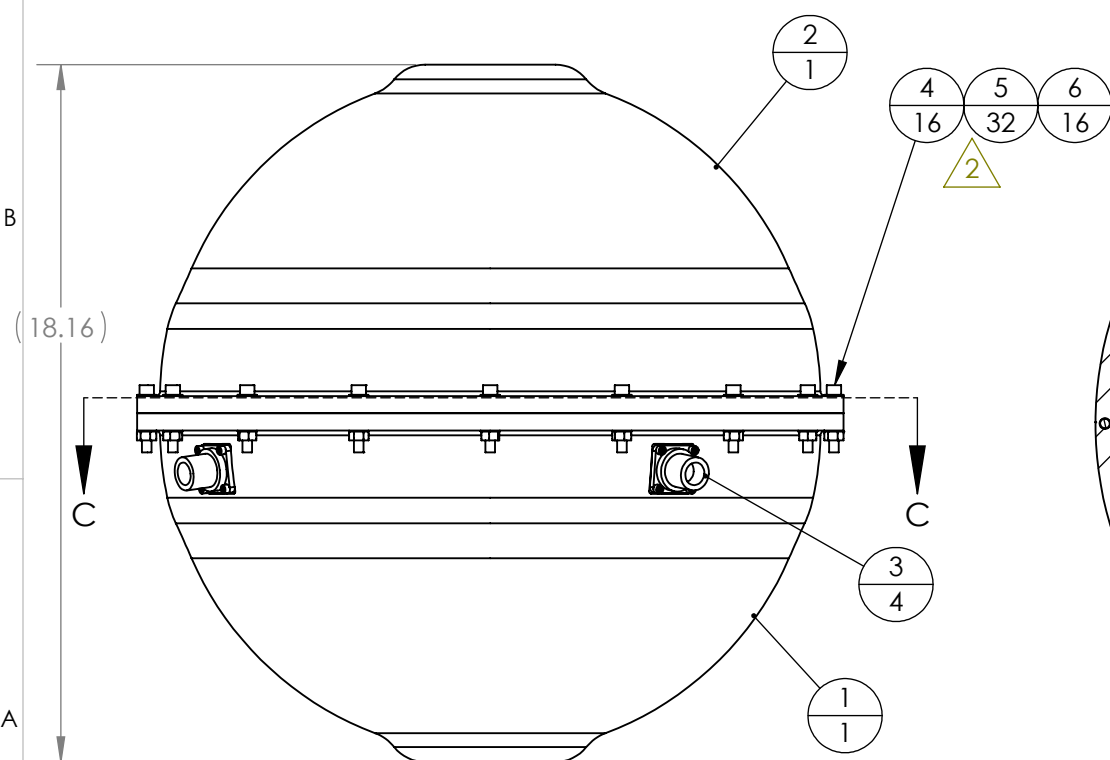
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		



NOTES:

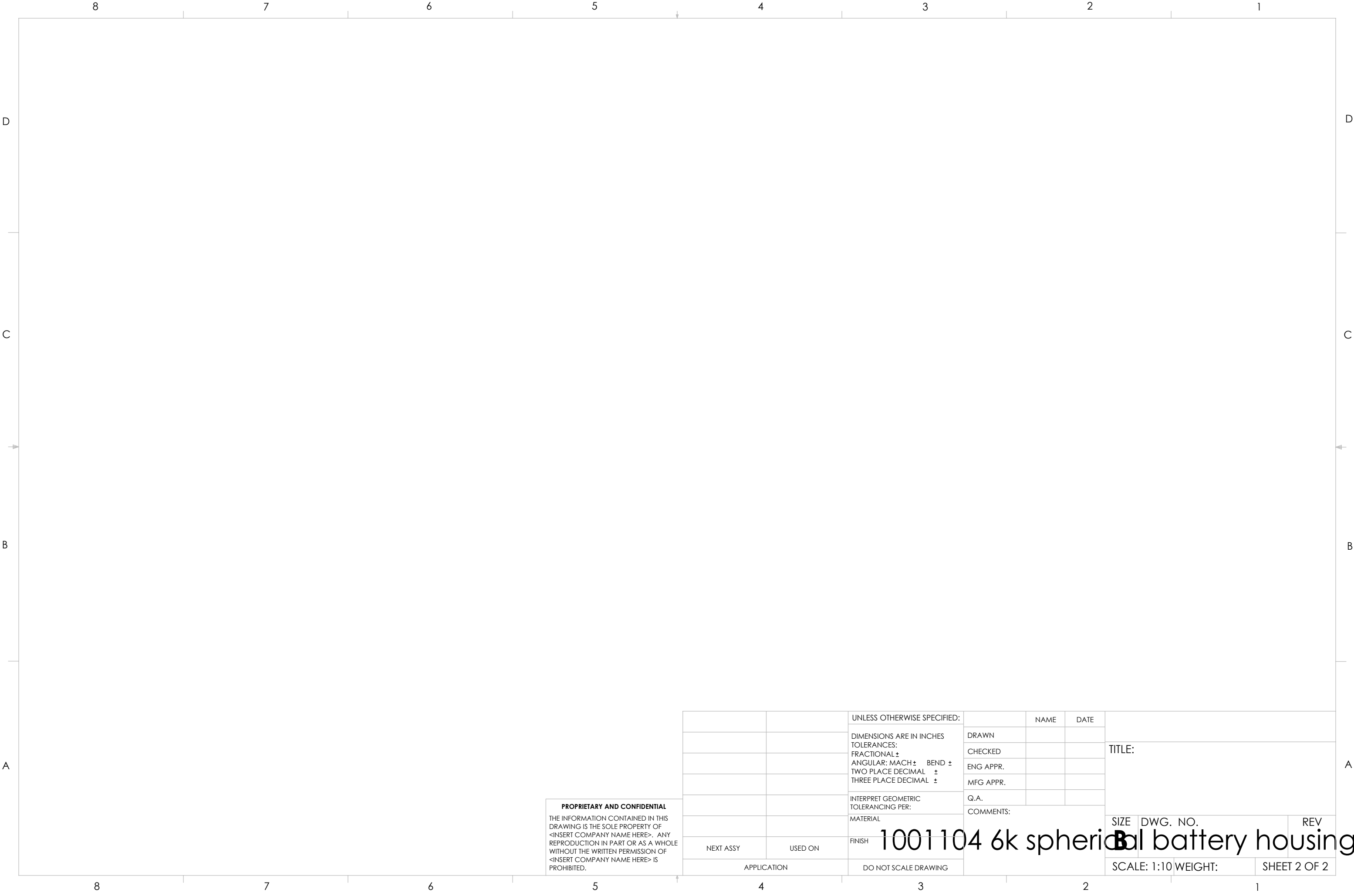
1. APPLY NEVERSIEZE TO ALL THREAD PRIOR TO ASSEMBLY
2. TORQUE FASTENERS TO 60 IN-LBS
3. INSPECT AND LUBRICATE ALL O-RINGS PRIOR TO ASSEMBLY
4. APPROXIMATE WEIGHT: 100 LBS DRY, -12 LBS WET (NOT INCLUDING BATTERY PACK)



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL/ MANUFACTURER	QTY
1	1001101	BOTTOM HEMISPHERE, 6K SPHERICAL HOUSING	6AL/4V GR 5 Ti CAST ALLOY	1
2	1001102	TOP HEMISPHERE, 6K SPHERICAL HOUSING	6AL-4V GR 5 Ti CAST ALLOY	1
3	MINK- FCR	FLANGED CONNECTOR RECEPTACLE	TITANIUM/ SEACON	4
4	93435A773	1/4-20 UNC X 1.5L SHCS	TITANIUM/ McMASTER-CARR	16
5	95647A125	FLAT WASHER, 0.26 ID X 0.5 OD	ACETAL/ McMASTER CARR	32
6	90545A029	1/4-20 UNC HEX NUT	TITANIUM/ McMASTER CARR	16
7		SHCS 6-40 X0.25L	TITANIUM	16
8	2-385	O-RING	BUNA/ PARKER	1
9	2-386	O-RING	BUNA/ PARKER	1
10	MX 1300	ROVER BATTERY PACK	VARIES	1

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	10/14/12			
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	10/14/12			
Engineer						CHECKED					
						PROJECT NO.	XXX				
NEXT ASSY Description	NEXT ASSY Number					PROJECT	ZZZZZZZZ		6K SPHERICAL BATTERY HOUSINGASSEMBLY		
Application		DO NOT SCALE DRAWING				WEIGHT					
						SIZE B	DWG. NO.		1001104DWG		REV.
						SCALE	1:10		CAD FILE: MECH ENG ON TORNADO		SHEET 1 OF 2

DATE: 14OCT12



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PROHIBITED.

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE:		
		DIMENSIONS ARE IN INCHES	DRAWN					
		TOLERANCES:	CHECKED					
		FRACTIONAL ±	ENG APPR.					
		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ±	Q.A.			SIZE DWG. NO. REV		
		THREE PLACE DECIMAL ±	COMMENTS:					
		INTERPRET GEOMETRIC TOLERANCING PER:						
		MATERIAL						
NEXT ASSY	USED ON	FINISH				1001104 6k spherical battery housing		
APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:10 WEIGHT: SHEET 2 OF 2		

1001104 6k spherical battery housing assy