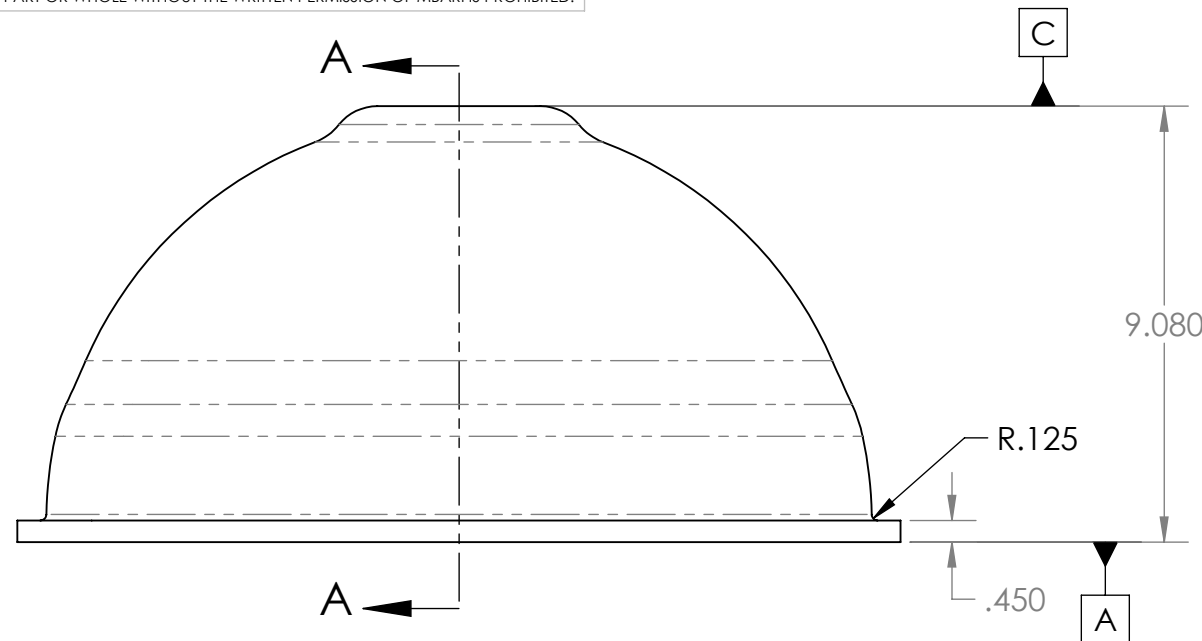


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED AS BUILT REDLINES	8OCT12	

NOTES:

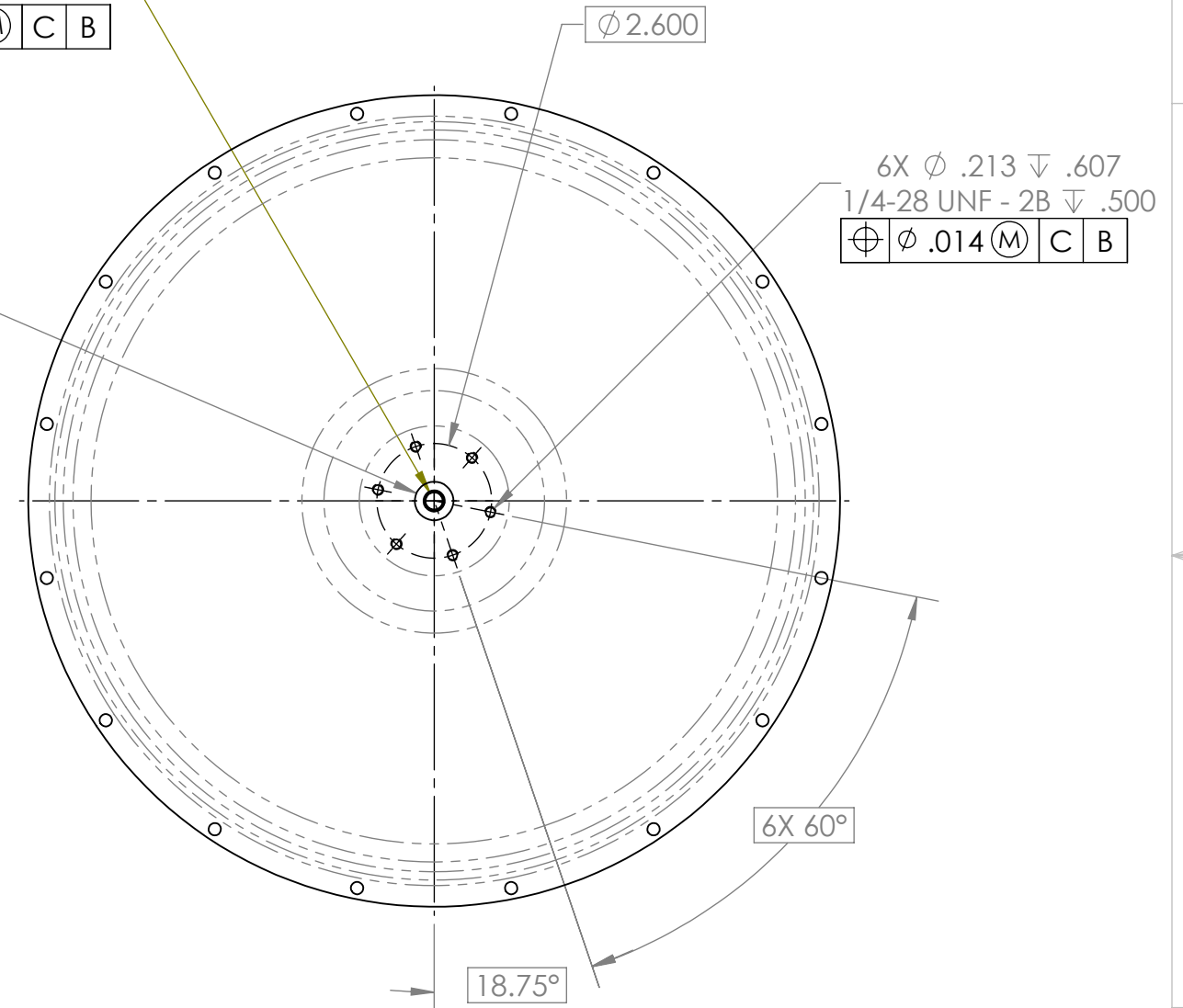
1. MATERIAL IS GR 5 AS CAST TITANIUM, MIN YIELD 120 KSI
2. BREAK ALL SHARP EDGES
3. APPLICABLE STANDARDS/SPECIFICATIONS:
ANSI Y14.5M-1994, DIMENSIONS AND TOLERANCES
MIL-STD-12, ABBREVIATIONS.
4. PART IS SYMMETRIC ABOUT CENTERLINE
5. DEPTH RATING OF ASSEMBLY: 6000M
6. WEIGHT: 47.6 LBS DRY



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

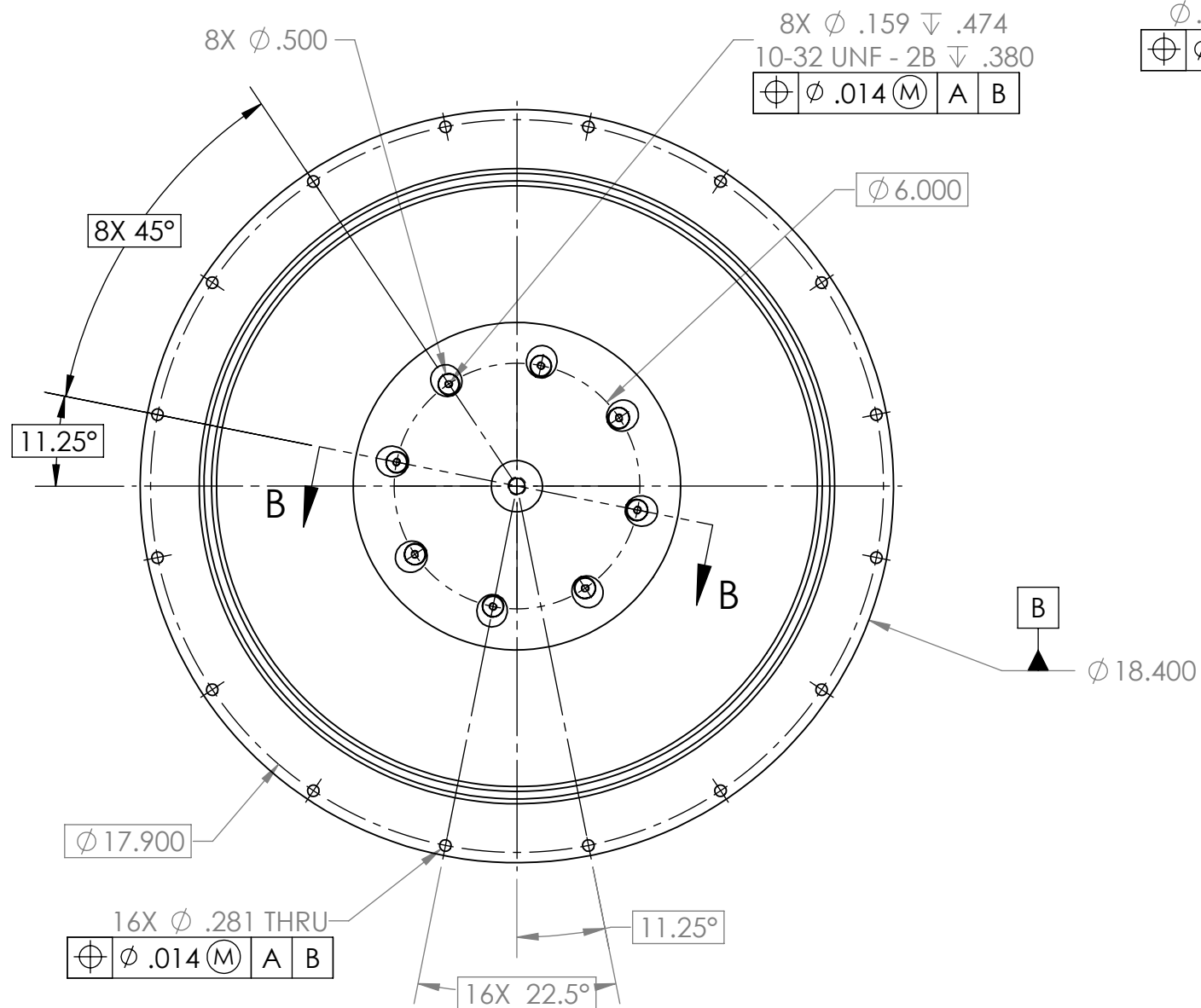
	ϕ .028 (M)	C	B
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ϕ	ϕ	.028	(M)	C	B
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TOP VIEW

DATE: 7JAN12



	ϕ .014 (M)	A	B
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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 AFTER MACHINING. 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				ENGINEER M. GREISE	11/30/11				
Engineer						CHECKED					
NEXT ASSY Description		NEXT ASSY Number		DO NOT SCALE DRAWING		PROJECT NO.		PROJECT		TOP HEMISPHERE, 6K SPHERICAL HOUSING	
								6K SPHERE			
Application						WEIGHT					
						SIZE B		DWG. NO.		REV.	
								1001102DWG		A	
						SCALE 1:5		CAD FILE: MECH ENG ON TORNADO		SHEET 1 OF 2	

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 ±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. 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	TOP HEMISPHERE 6K HOUSING		
Engineer						CHECKED					
NEXT ASSY Description						NEXT ASSY Number				PROJECT NO.	
						PROJECT		4K SPHERE			
								SIZE B	DWG. NO.		1001102DWG
										REV.	A
Application		DO NOT SCALE DRAWING				WEIGHT		SCALE 1:5		CAD FILE: MECH ENG ON TORNADO SHEET 2 OF 2	