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Microfloat Fabrication Package

Index

Page Number	Content
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9-14	External Manufcatured Parts
15-23	Internal Manufactured Parts
24	Bill of Materials

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2

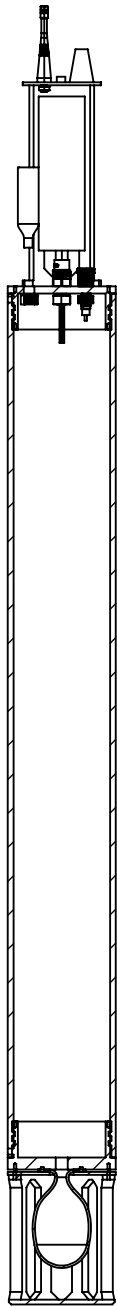
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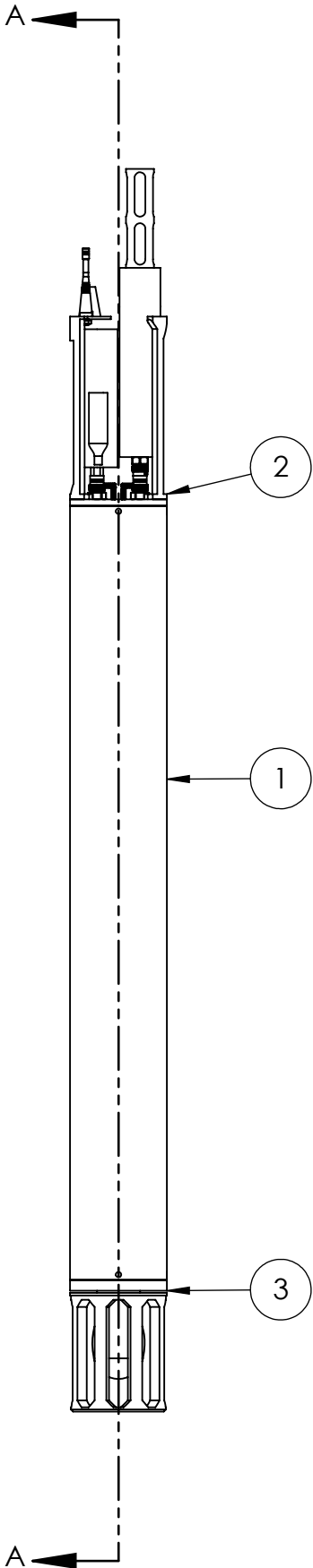
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A

A



SECTION A-A
SCALE 1 : 8



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Cylinder_Body	Main Body	1
2	Top_Cap_Assembly	Top Cap / Sensor Assembly	1
3	Bottom_Cap_Assembly	Bottom Cap / Bellows Assembly	1

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: <div>Microfloat</div>		
		DIMENSIONS ARE IN INCHES	DRAWN	DA				
		TOLERANCES: FRACTIONAL ±	CHECKED					
		ANGULAR: MACH ± BEND ±	ENG APPR.					
		TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	MFG APPR.					
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			SIZE DWG. NO. REV <div>B</div>		
		MATERIAL	COMMENTS:					
		FINISH						
NEXT ASSY	USED ON							
APPLICATION		DO NOT SCALE DRAWING						
						SCALE: 1:12	WEIGHT:	SHEET 2 OF 24

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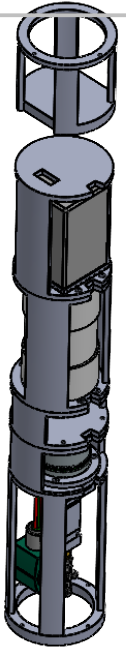
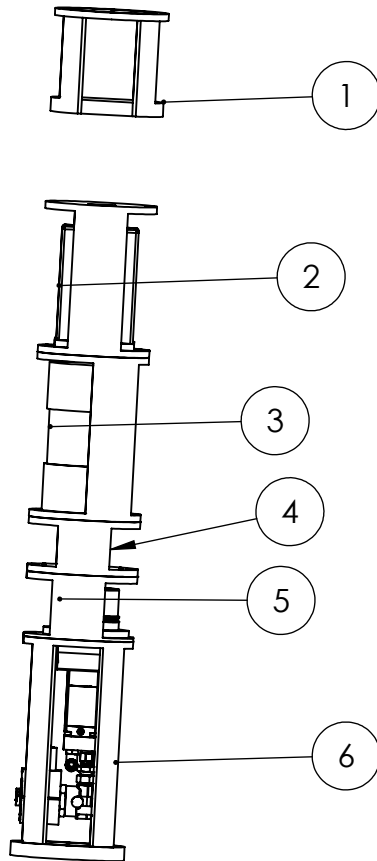
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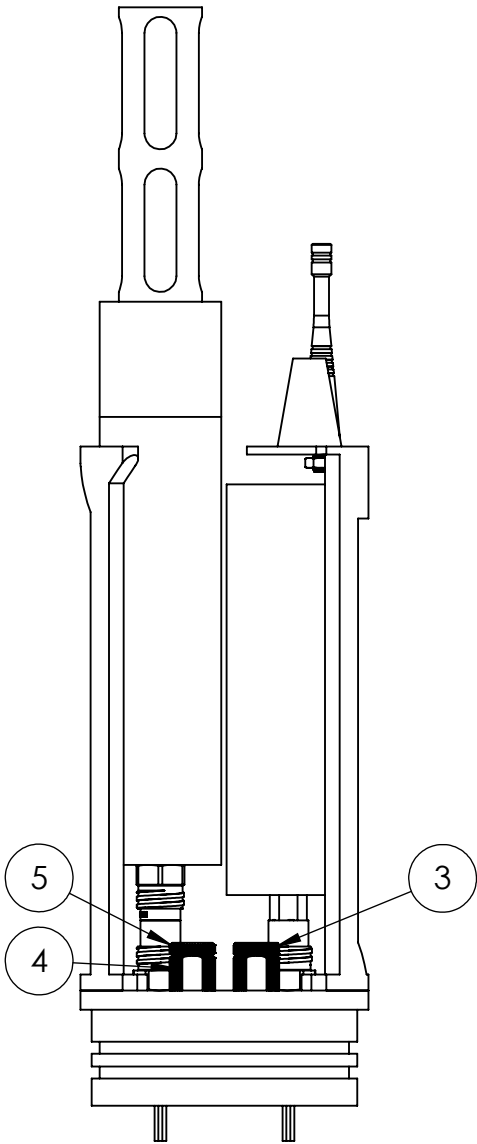
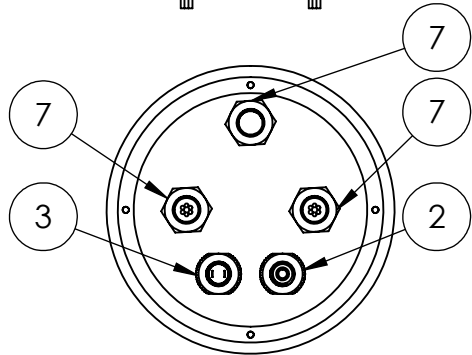
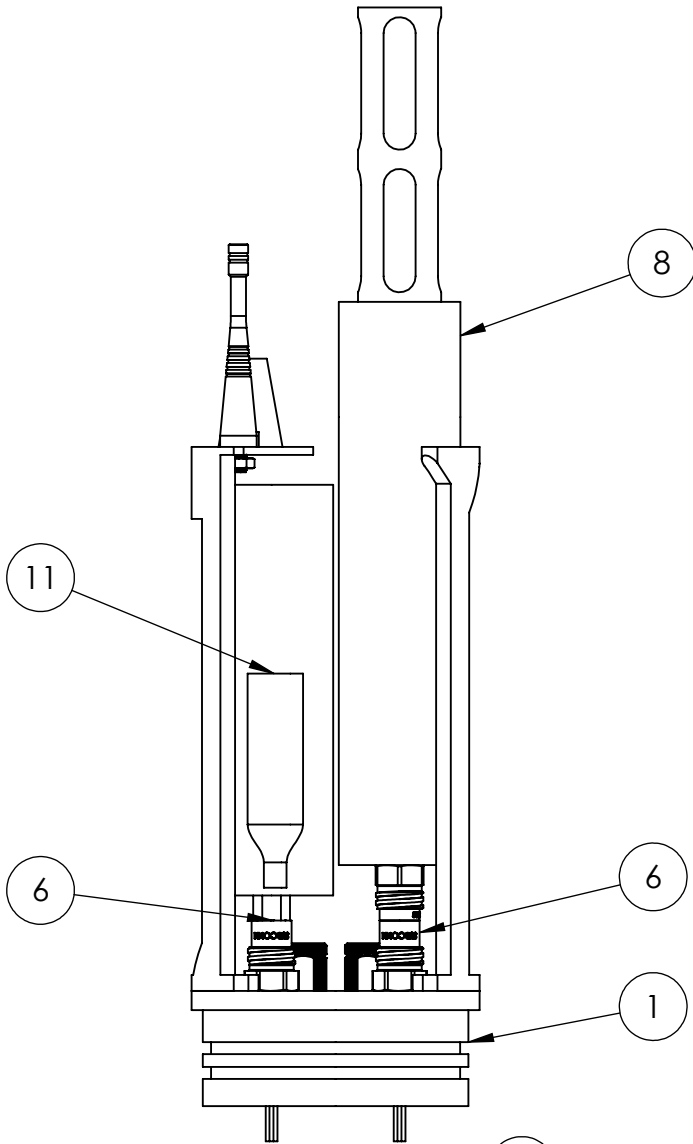
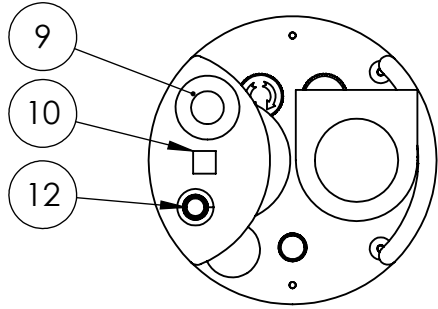
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1		Top Cap Connector	1
2		Battery Housing	1
3		Reservoir Housing	1
4		Reservoir Spacing Housing	1
5		Motor Housing	1
6		Pump Housing	

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Internal Assembly		
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL \pm ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL \pm THREE PLACE DECIMAL \pm	DRAWN					
			CHECKED					
			ENG APPR.					
			MFG APPR.					
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			SIZE	DWG. NO.	REV
		MATERIAL	COMMENTS:			A		
NEXT ASSY	USED ON	FINISH				SCALE: 1:10 WEIGHT: SHEET 3 OF 23		
APPLICATION		DO NOT SCALE DRAWING						



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Top_Cap		1
2	Blue Robotics - Nut - PENETRATOR-M-NUT-10-8-R2	Nut	1
3	Blue Robotics - Switch - SWITCH-10-5A-R1	Switch	1
4	Blue Robotics - Vent Bolt - VENT-M-BOLT-10-25-A-R4	Vent Bolt	1
5	Blue Robotics - Vent Plug - VENT-M-PLUG-10-A-R3	Vent Plug	1
6	mcbh6f.stp		2
7	95462A520	Medium-Strength Steel Hex Nut	3
8	SBE_27_PH_Sensor_Assy		1
9	Flasher_RedLed		1
10	Adafruit - GPS Antenna - 2460	GPS Antenna	1
11	Star Oddi - CTD Sensor - DST-CTD	CTD Sensor	1
12	Linx - RF Antenna - ANT-B8-PW-QW-UFL	RF Antenna	1
13	METS_Methan_Sensor		1
14	Top_Handle		1
15	Top_Handle_Left		1

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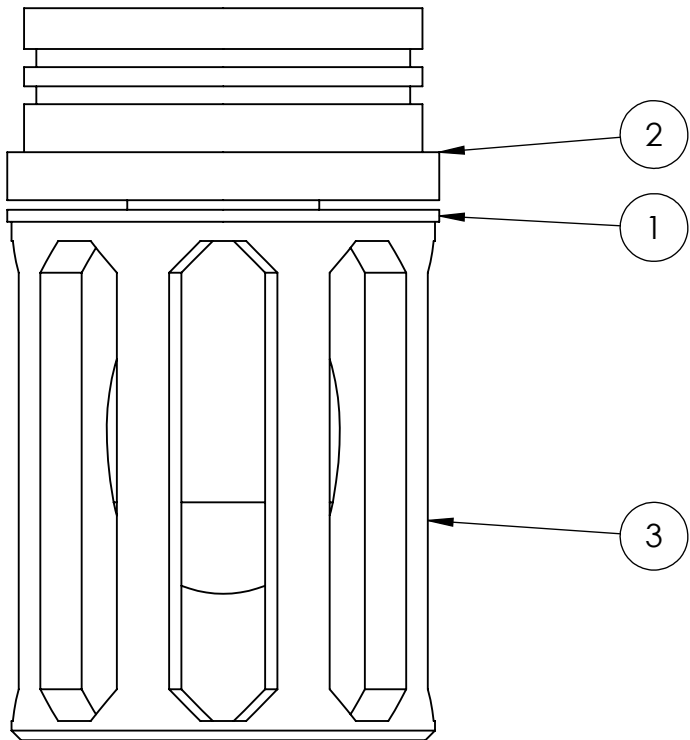
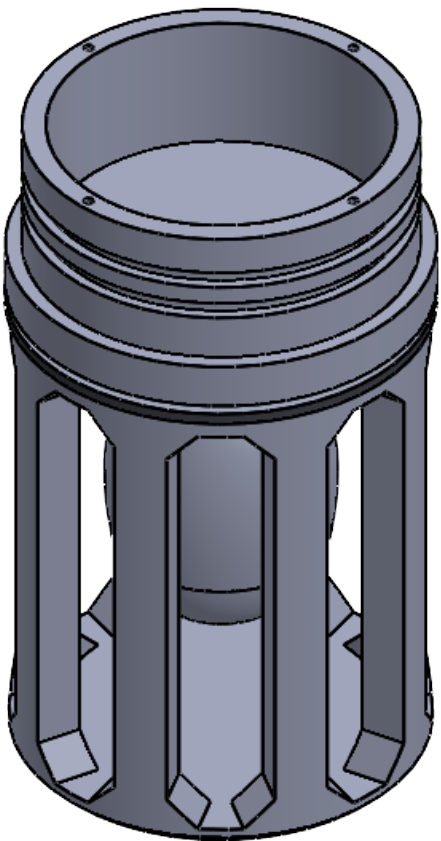
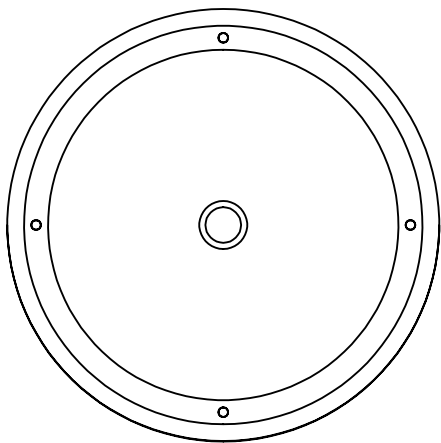
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		FRACTIONAL ±	ENG APPR.			
		ANGULAR: MACH ± BEND ±	MFG APPR.			
		TWO PLACE DECIMAL ±	Q.A.			SIZE DWG. NO. REV
		THREE PLACE DECIMAL ±	COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER:				
		MATERIAL				
NEXT ASSY	USED ON	FINISH				
APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:4 WEIGHT: SHEET 4 OF 24

4

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2

1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Cap_Plate_Lower		1
2	Lower_Cap		1
3	Bellows_Cage		1
4	Rubber_Bladder		1

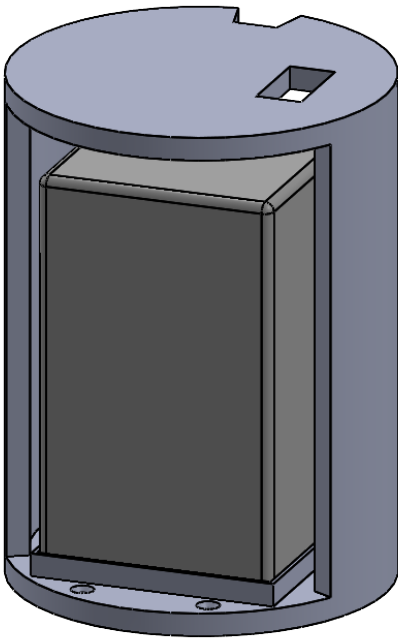
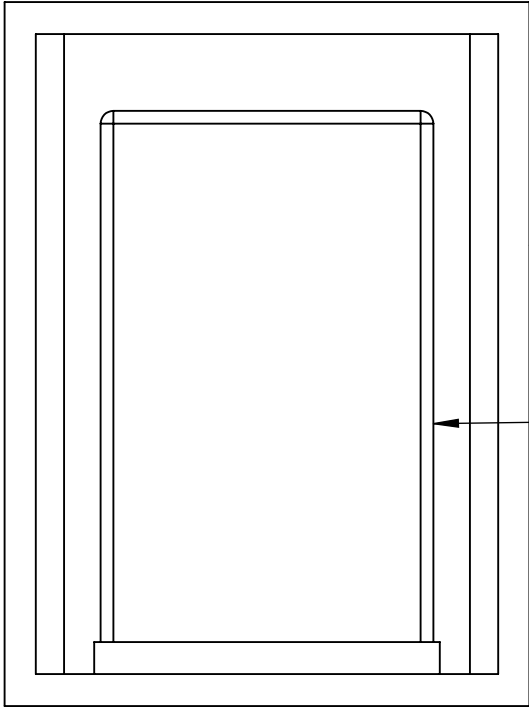
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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Bottom Cap Assembly	
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		FRACTIONAL ±	ENG APPR.				
		ANGULAR: MACH ± BEND ±	MFG APPR.				
		TWO PLACE DECIMAL ±	Q.A.			SIZE	DWG. NO.
		THREE PLACE DECIMAL ±	COMMENTS:			B	REV
NEXT ASSY	USED ON	MATERIAL				SCALE: 1:4	WEIGHT:
APPLICATION		FINISH					SHEET 5 OF 24
		DO NOT SCALE DRAWING					

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Item No.	Part Number	Part Description	Qty.
1	battery_housing_sleeve		1
2	battery_rough		1

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		UNLESS OTHERWISE SPECIFIED:
		DIMENSIONS ARE IN INCHES
		TOLERANCES:
		FRACTIONAL \pm
		ANGULAR: MACH \pm BEND \pm
		TWO PLACE DECIMAL \pm
		THREE PLACE DECIMAL \pm
		INTERPRET GEOMETRIC TOLERANCING PER:
		MATERIAL
NEXT ASSY	USED ON	FINISH
APPLICATION		DO NOT SCALE DRAWING

	NAME	DATE
DRAWN		
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

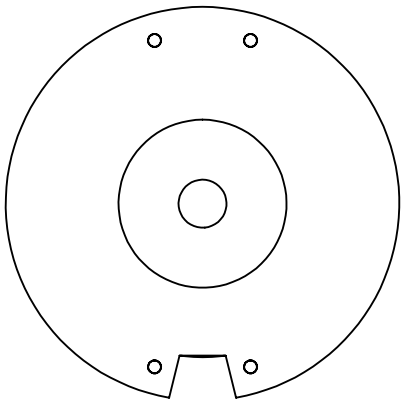
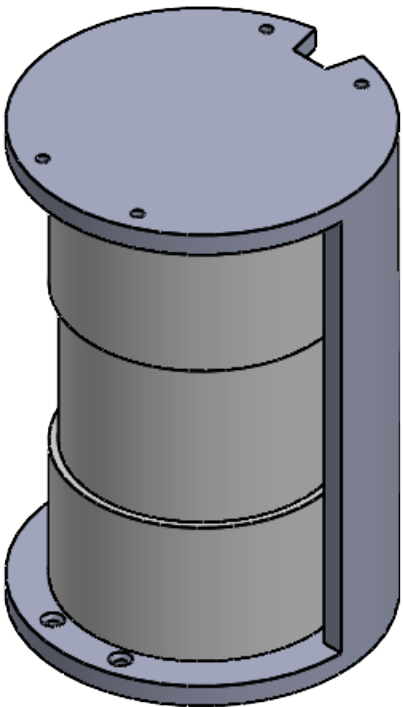
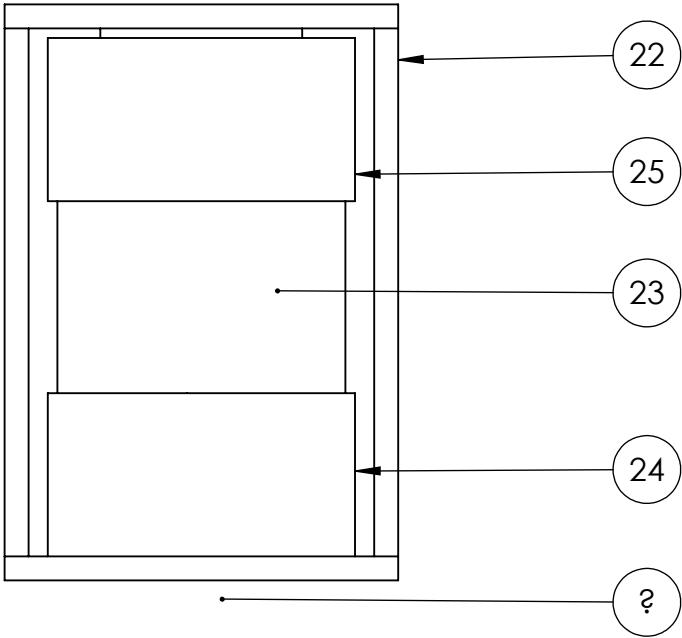
TITLE:		
Battery Assembly		
SIZE	DWG. NO.	REV
A		
SCALE: 1.5	WEIGHT:	SHEET 6 OF 23

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1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	resevoir_housing_sleeve		1
2	pvc_body		1
3	pvc_cap_bottom		1
4	pvc_cap		1

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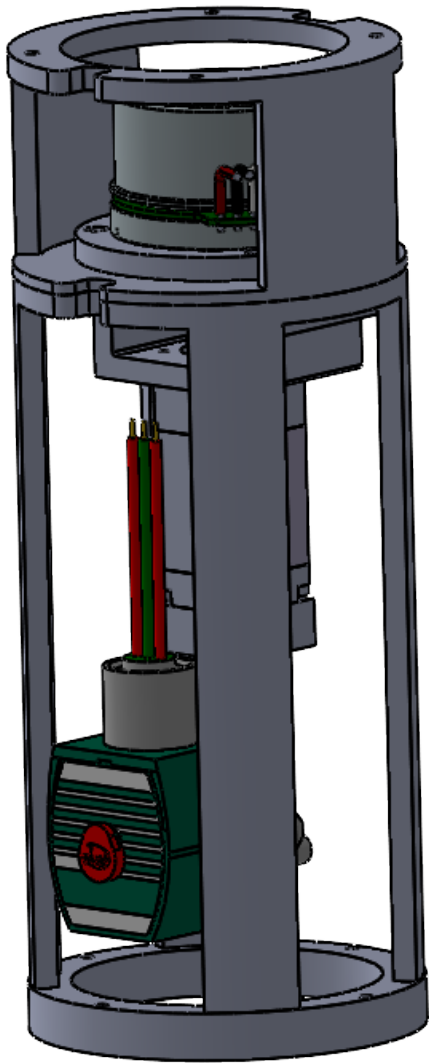
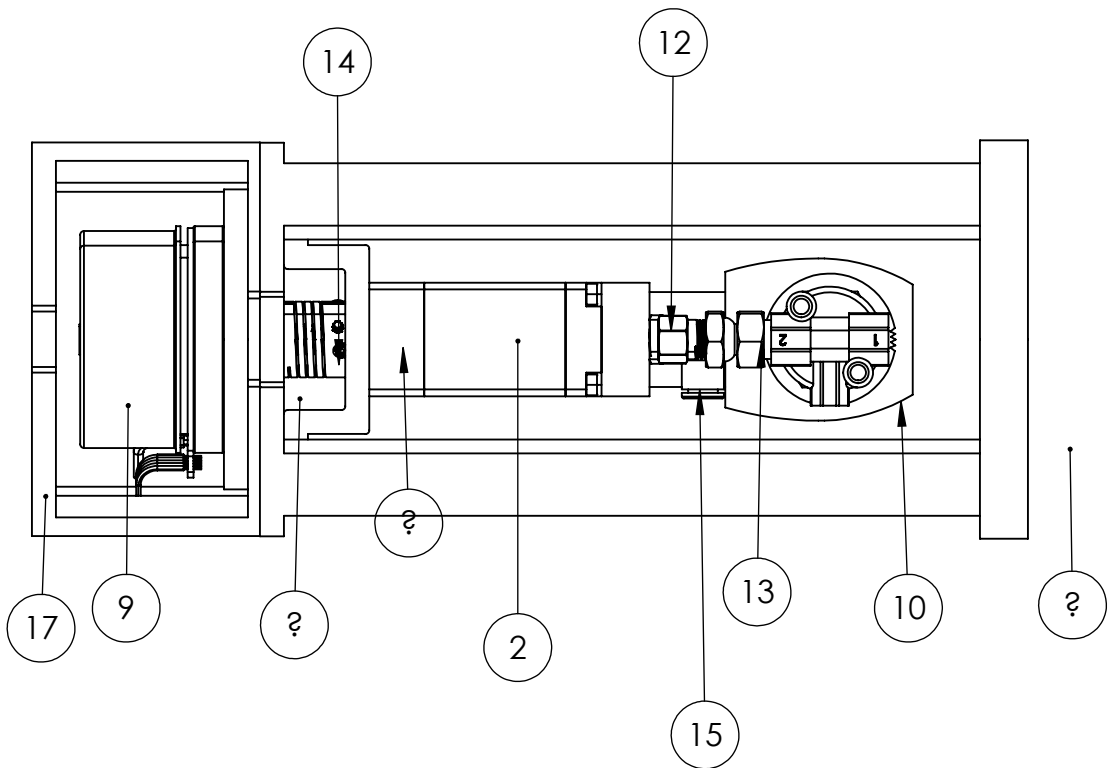
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		FRACTIONAL ±	ENG APPR.					
		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ±	Q.A.			SIZE	DWG. NO.	REV
		THREE PLACE DECIMAL ±	COMMENTS:			B		
NEXT ASSY	USED ON	MATERIAL				SCALE: 1:2	WEIGHT:	SHEET 7 OF 23
APPLICATION		FINISH						
		DO NOT SCALE DRAWING						

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B



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	Part9.IGS		1
2	Part10.IGS		1
3	Part13.IGS		1
4	Part13.1.IGS		1
5	Part13.1.2.IGS		1
6	Part16.IGS		1
7	Part20.IGS		4
8	Maxon - Motor - 625857	Motor	1
9	ASCO - Solenoid - 8262H079	Solenoid	1
10	RUR - Manifold	Manifold	1
11	Grainger - Brass Hex Nipple - 40142318	Brass Hex Nipple	1
12	McMaster - Steel Hose Fitting - 5340K11	Steel Hose Fitting	1
13	ServoCity - Coupler - 4002-0006-0008	Coupler	1
14	McMaster - 90 deg Push Fitting - 51235K127	Pump 90 deg Push Fitting	1
15	Part7		1
16	motor_housing_sleeve		1
17	motor_plate		1
18	mounting_bracket		1
19	pump_sleeve		1

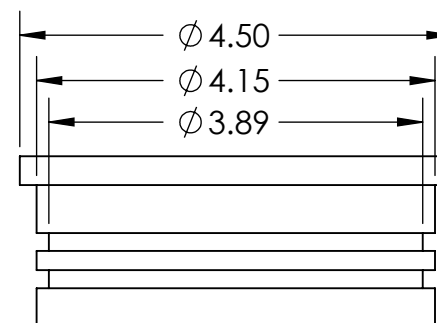
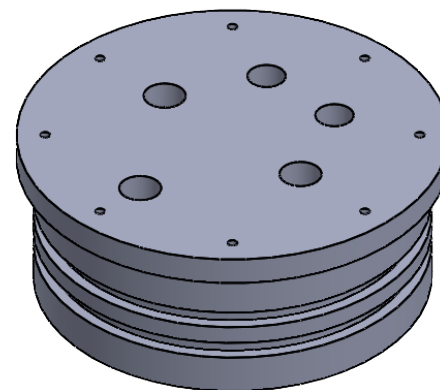
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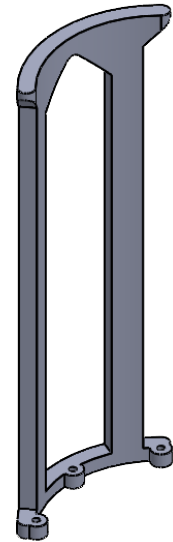
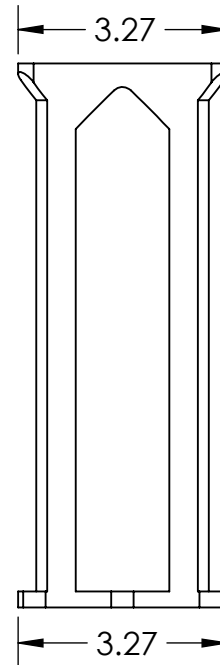
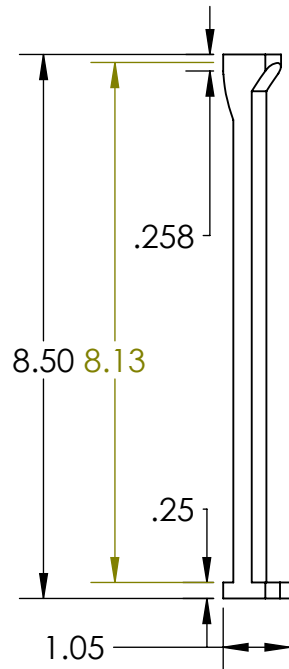
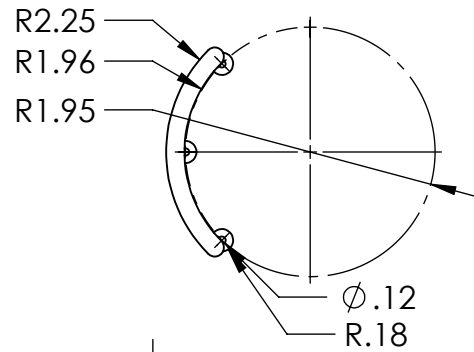
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		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ±	Q.A.				SIZE DWG. NO. REV	
		THREE PLACE DECIMAL ±	COMMENTS:					
		INTERPRET GEOMETRIC TOLERANCING PER:						
		MATERIAL						
		FINISH						
NEXT ASSY	USED ON							
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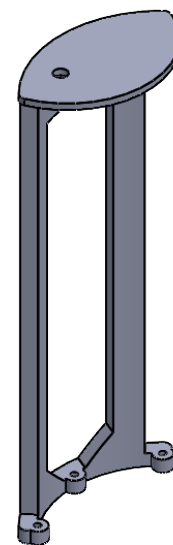
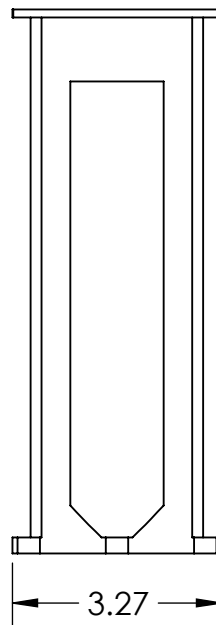
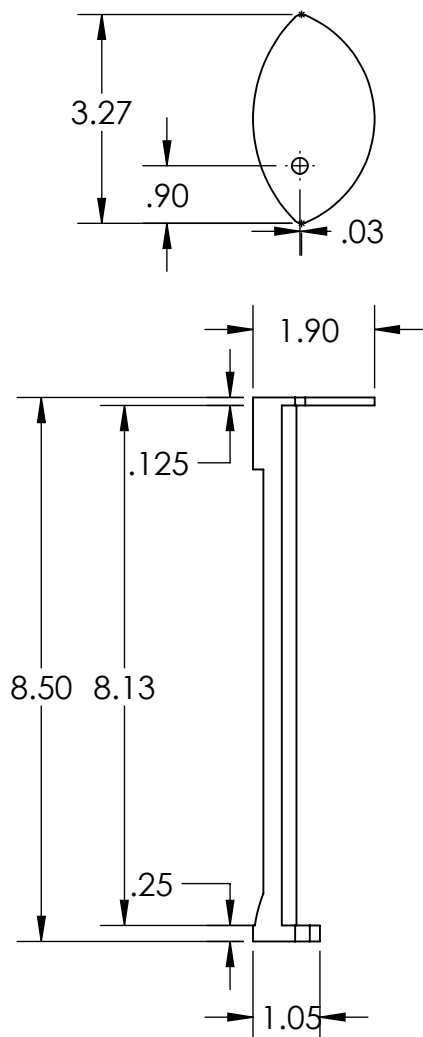
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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	Top Right Hangle		
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		ANGULAR: MACH \pm BEND \pm	MFG APPR.					
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		MATERIAL				A		
		FINISH						
NEXT ASSY	USED ON	Al 6061						
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APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:4	WEIGHT:	SHEET 10 OF 24

B

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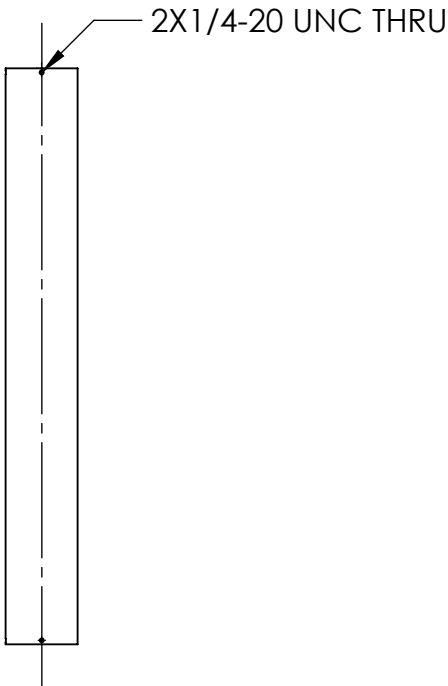
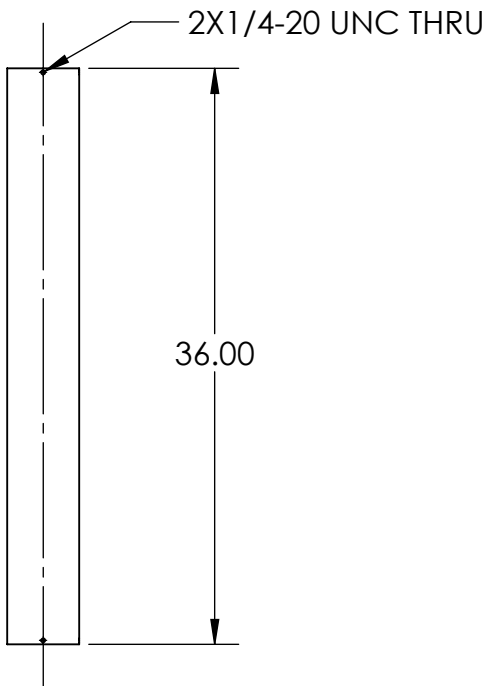
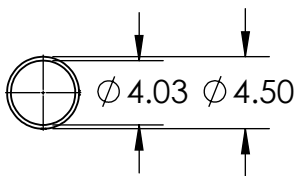


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		ANGULAR: MACH ± BEND ±	MFG APPR.						
		TWO PLACE DECIMAL ±.01				SIZE A DWG. NO. REV			
		THREE PLACE DECIMAL ±.005							
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.						
		MATERIAL	COMMENTS:						
		AI 6061							
		FINISH							
NEXT ASSY	USED ON	NA							
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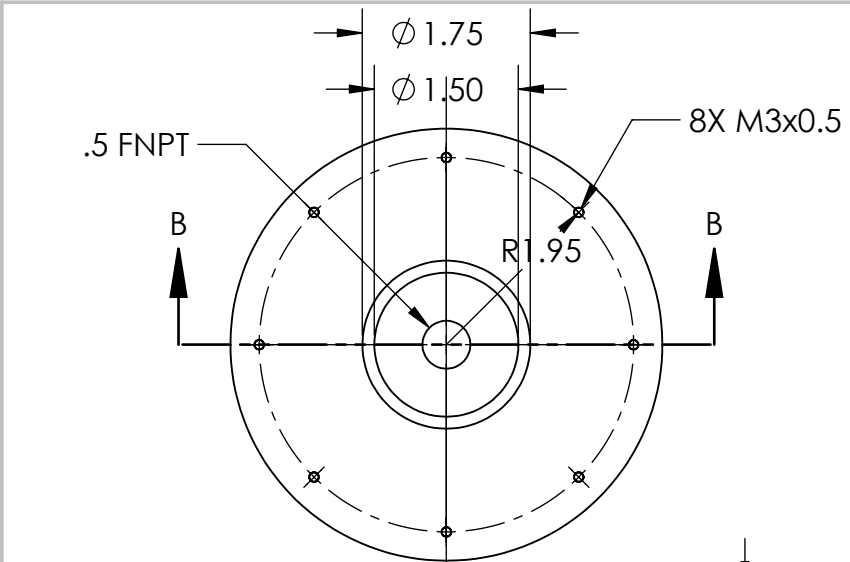


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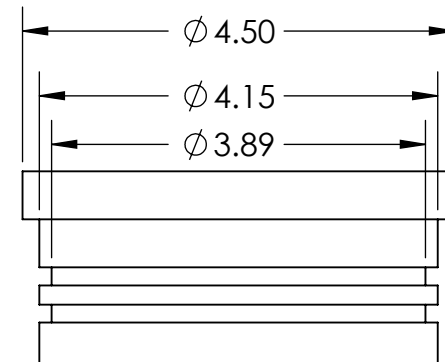
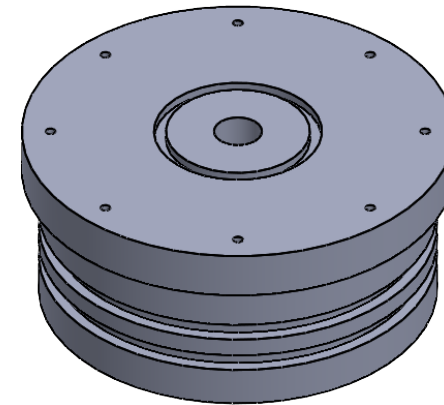
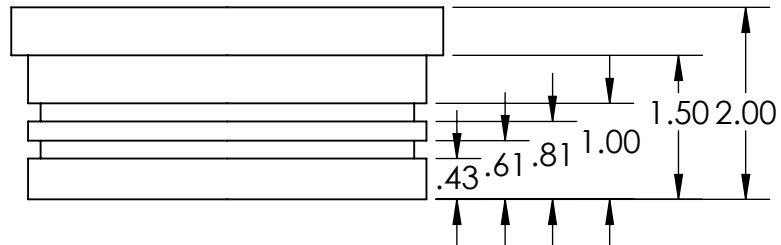
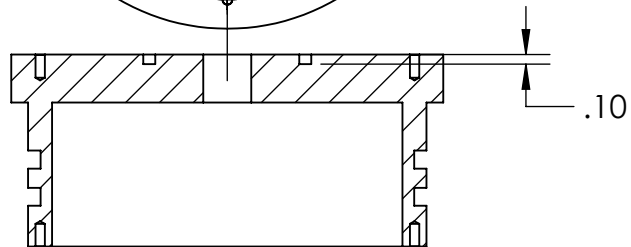
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		FRACTIONAL ±	ENG APPR.					
		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ±.01				SIZE <div>A</div>		
		THREE PLACE DECIMAL ±.005						
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.					
		MATERIAL	COMMENTS:			DWG. NO.		REV
		AI 6061						
		FINISH						
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		DO NOT SCALE DRAWING						

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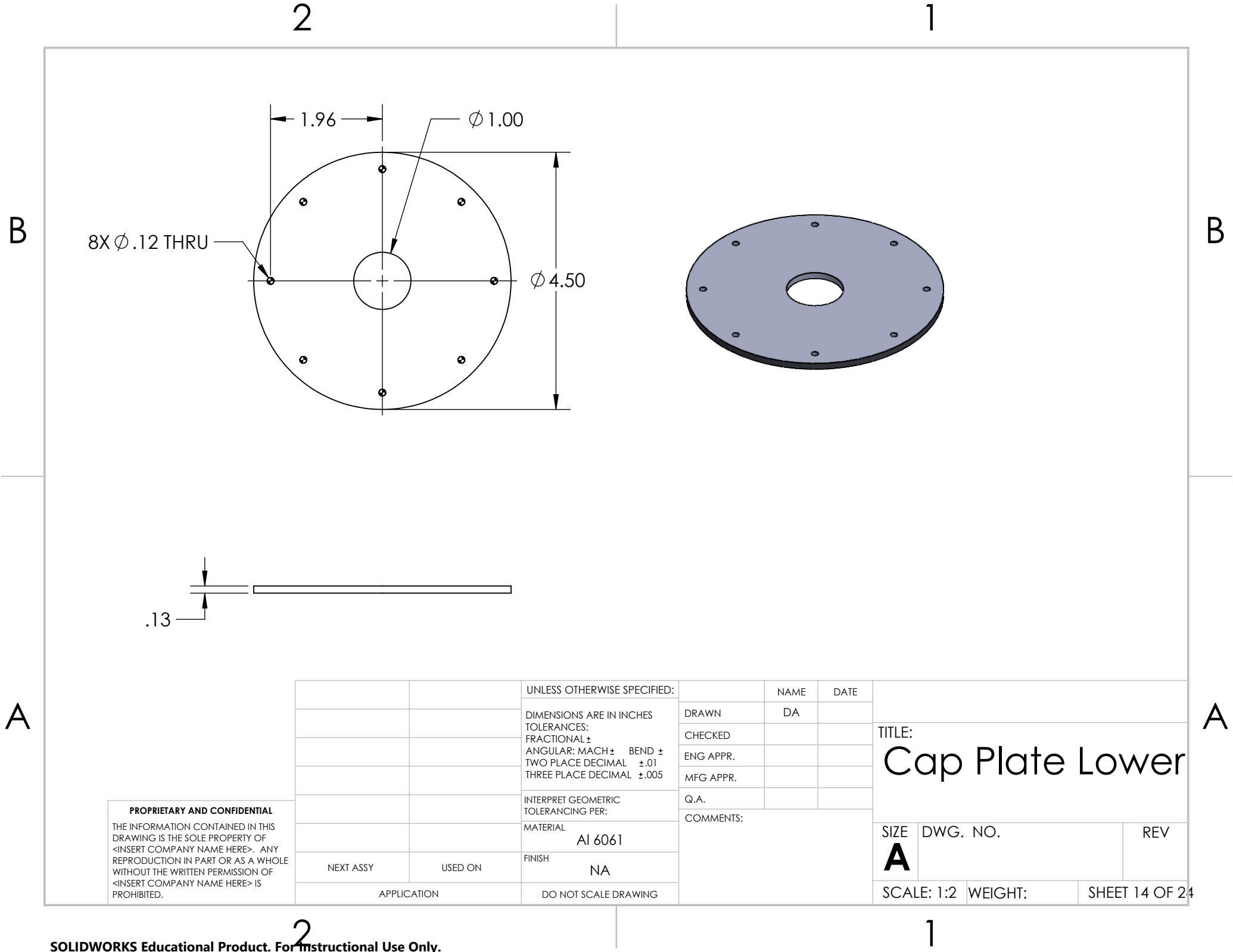
SECTION B-B

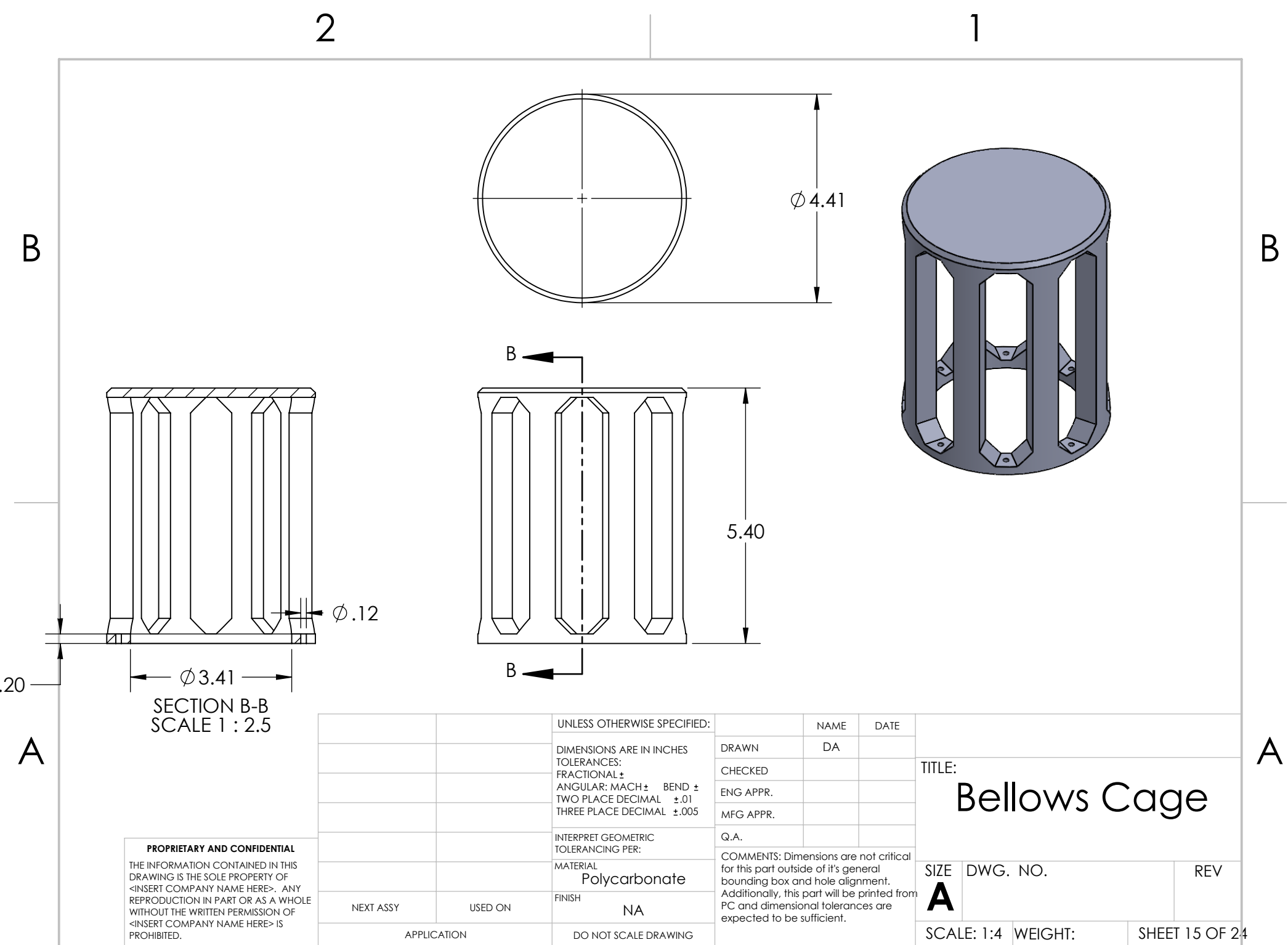


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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: <div>Lower Cap</div>			
		DIMENSIONS ARE IN INCHES		DRAWN	DA				10/20/21
		TOLERANCES:		CHECKED					
		FRACTIONAL ±		ENG APPR.					
		TWO PLACE DECIMAL ±.01		MFG APPR.					
		THREE PLACE DECIMAL ±.005		Q.A.			SIZE DWG. NO. REV <div>A Lower_Cap 1</div>		
		INTERPRET GEOMETRIC TOLERANCING PER:		COMMENTS:					
		MATERIAL	Al 6061						
		FINISH	N/A						
NEXT ASSY	USED ON					SCALE: 1:2 WEIGHT: SHEET 13 OF 24			
APPLICATION		DO NOT SCALE DRAWING							





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		DIMENSIONS ARE IN INCHES	DRAWN	DA	
		TOLERANCES:	CHECKED		
		FRACTIONAL ±	ENG APPR.		
		ANGULAR: MACH ± BEND ±	MFG APPR.		
		TWO PLACE DECIMAL ±.01			
		THREE PLACE DECIMAL ±.005			
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.		
		MATERIAL	COMMENTS: Dimensions are not critical for this part outside of it's general bounding box and hole alignment. Additionally, this part will be printed from PC and dimensional tolerances are expected to be sufficient.		
		Polycarbonate			
		FINISH			
		NA			
NEXT ASSY	USED ON				
APPLICATION		DO NOT SCALE DRAWING			

TITLE:
Bellows Cage

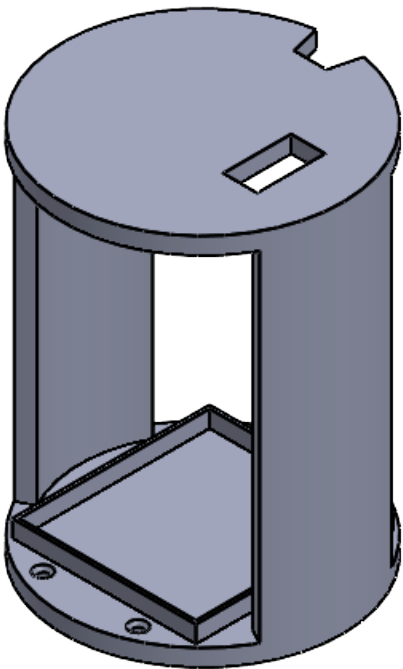
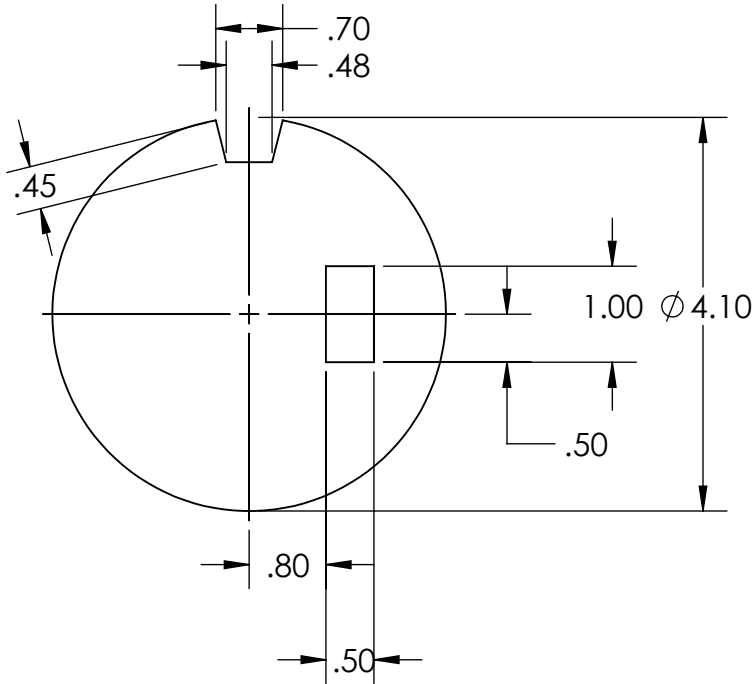
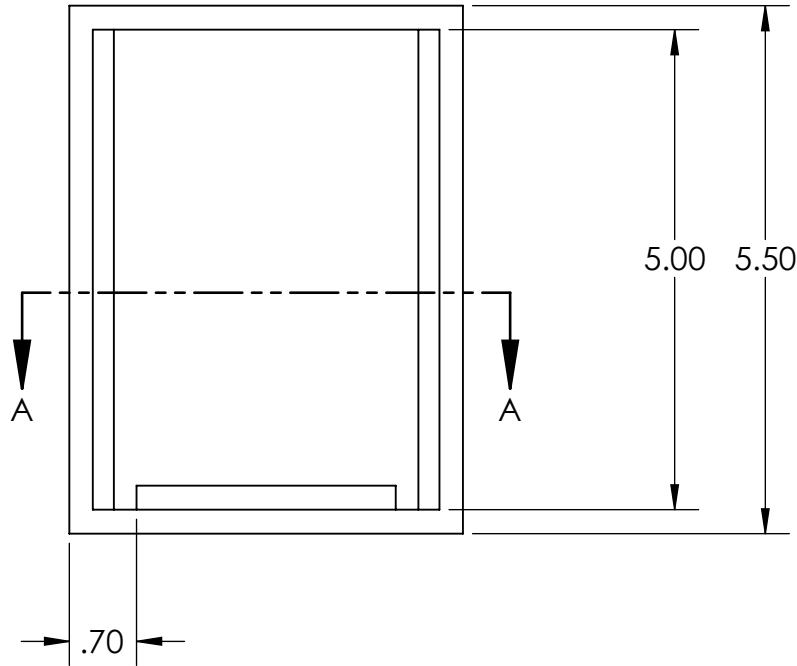
SIZE	DWG. NO.	REV
A		
SCALE: 1:4	WEIGHT:	SHEET 15 OF 24

B

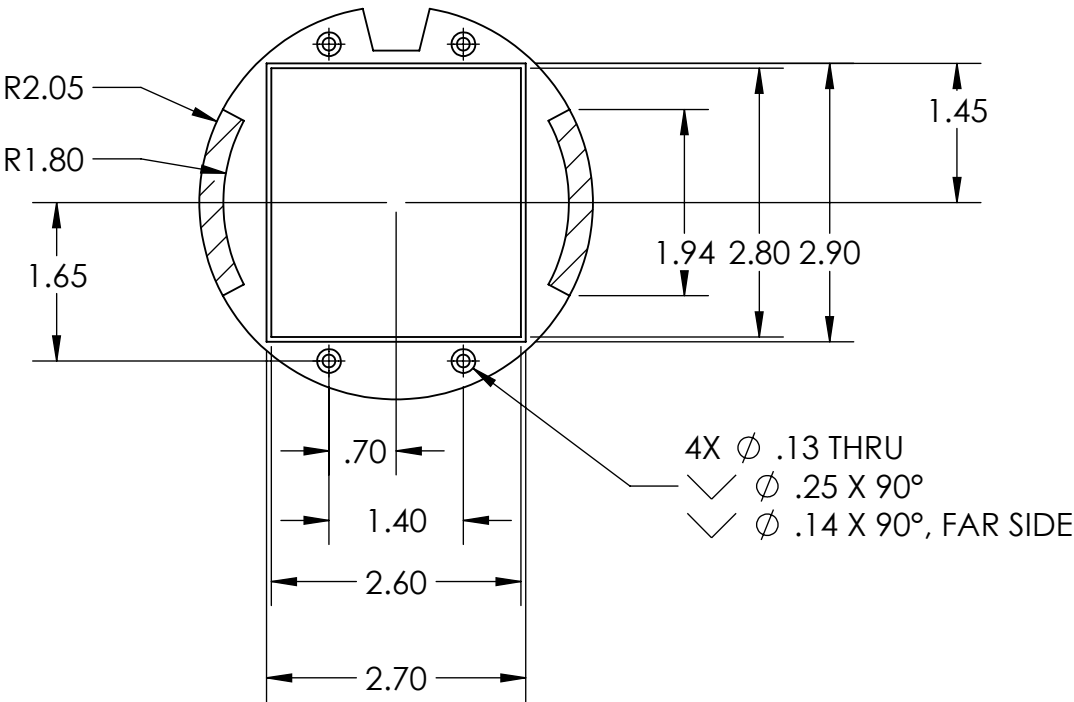
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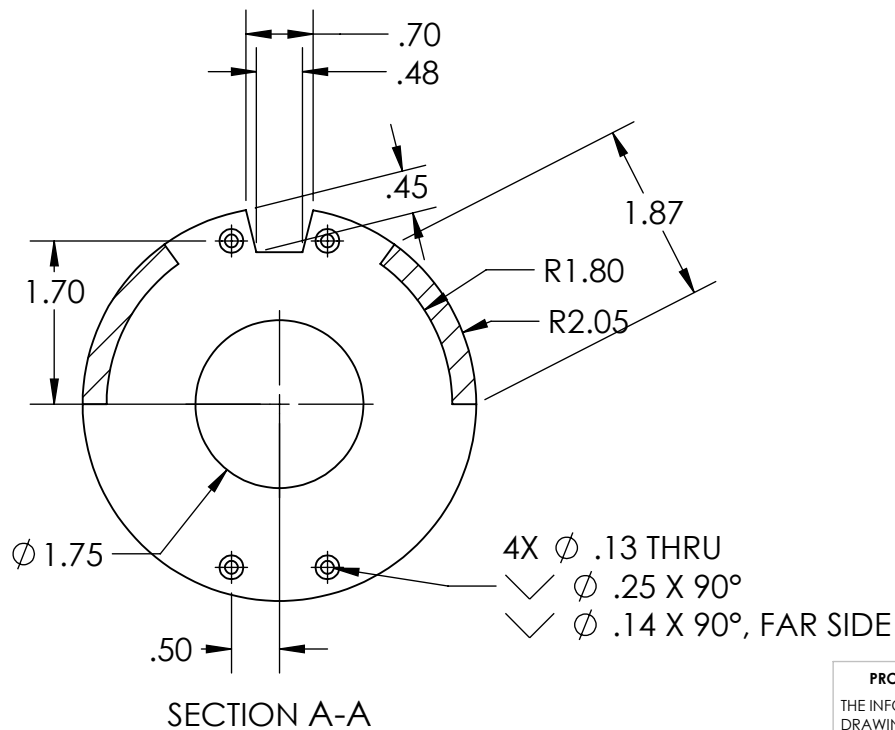
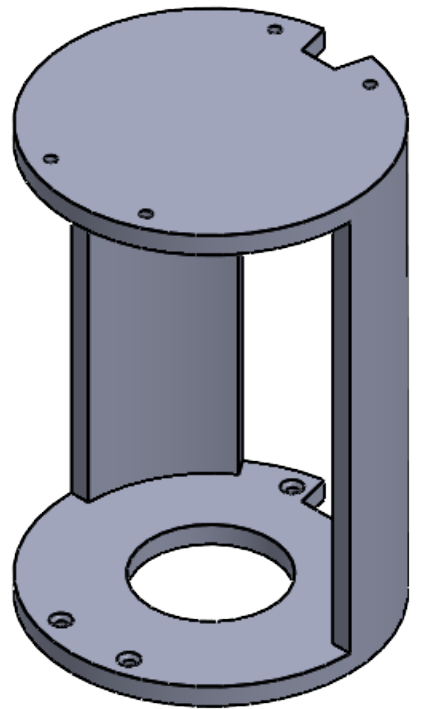
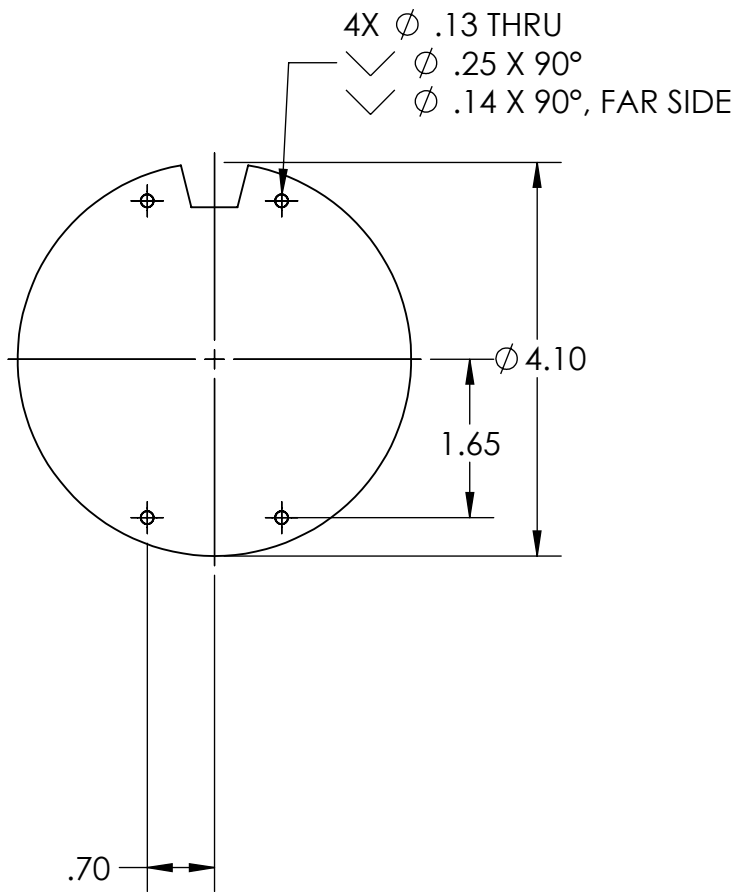
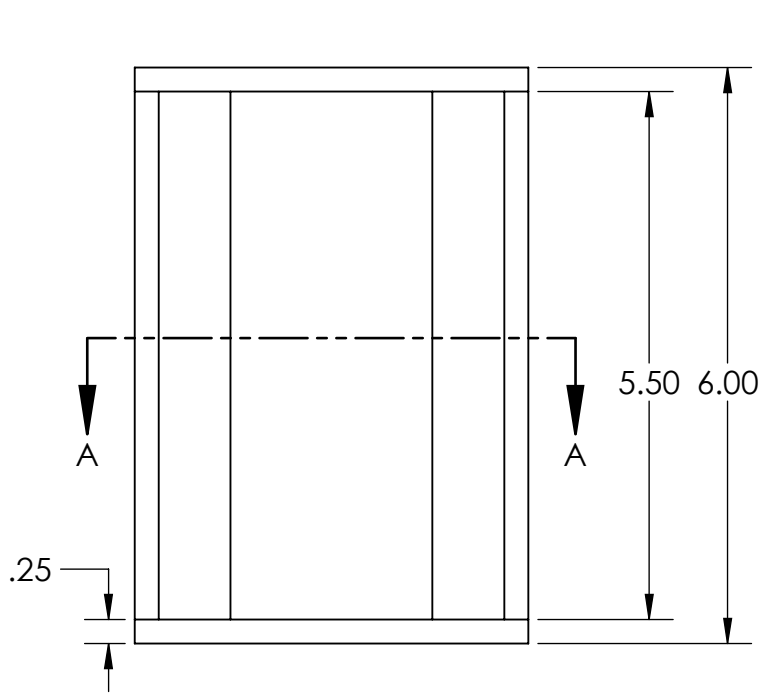


SECTION A-A



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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Battery Housing		
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005	DRAWN					
		INTERPRET GEOMETRIC TOLERANCING PER:	CHECKED					
		MATERIAL ABS	ENG APPR.					
NEXT ASSY	USED ON	FINISH N/a	MFG APPR.			SIZE B	DWG. NO.	REV
APPLICATION		DO NOT SCALE DRAWING	COMMENTS:			SCALE: 1:2	WEIGHT:	SHEET 16 OF 23



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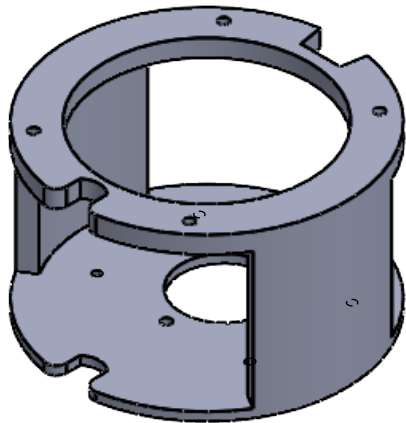
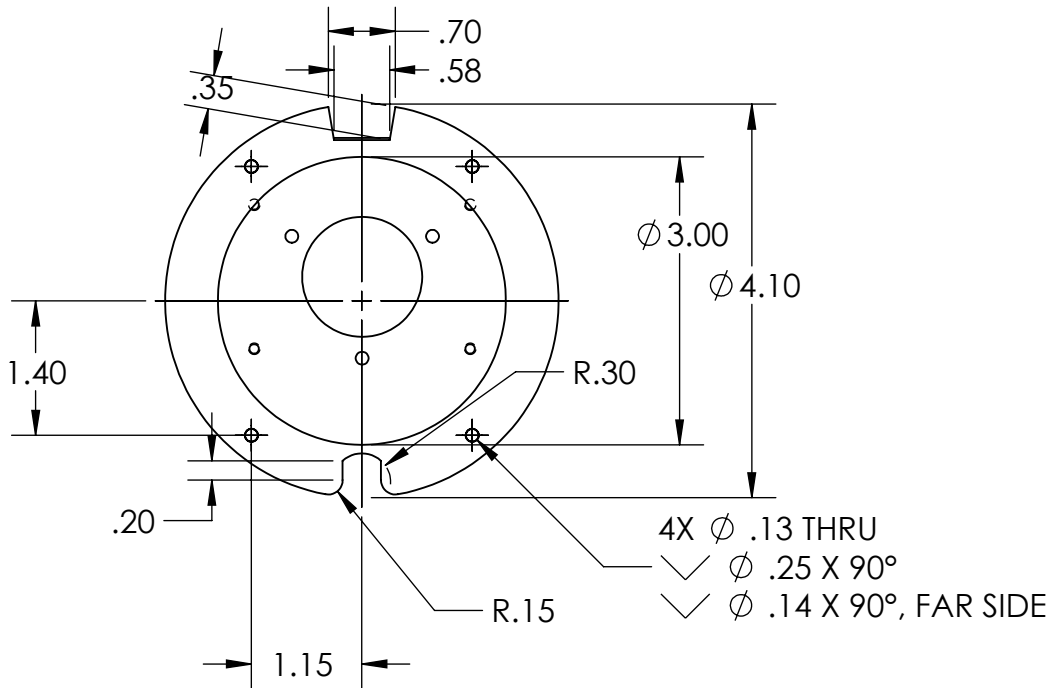
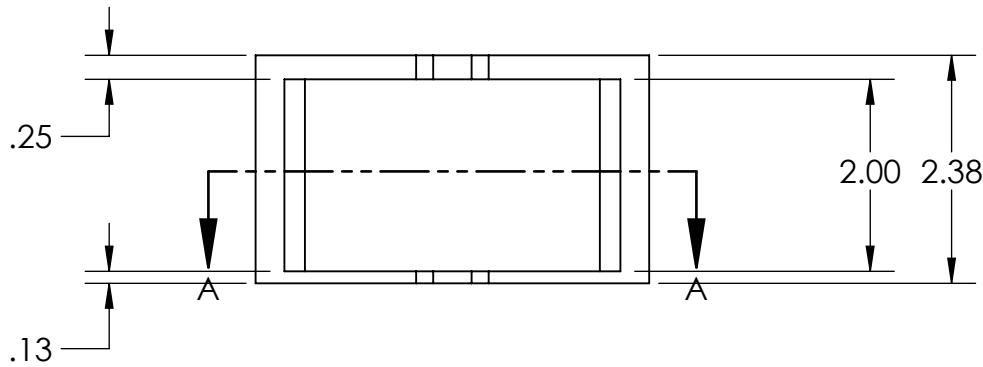
		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Reservoir Housing		
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005	DRAWN					
			CHECKED					
			ENG APPR.					
			MFG APPR.			SIZE DWG. NO. REV B		
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.					
		MATERIAL ABS	COMMENTS:					
		FINISH N/a						
NEXT ASSY		USED ON						
APPLICATION		DO NOT SCALE DRAWING						

4

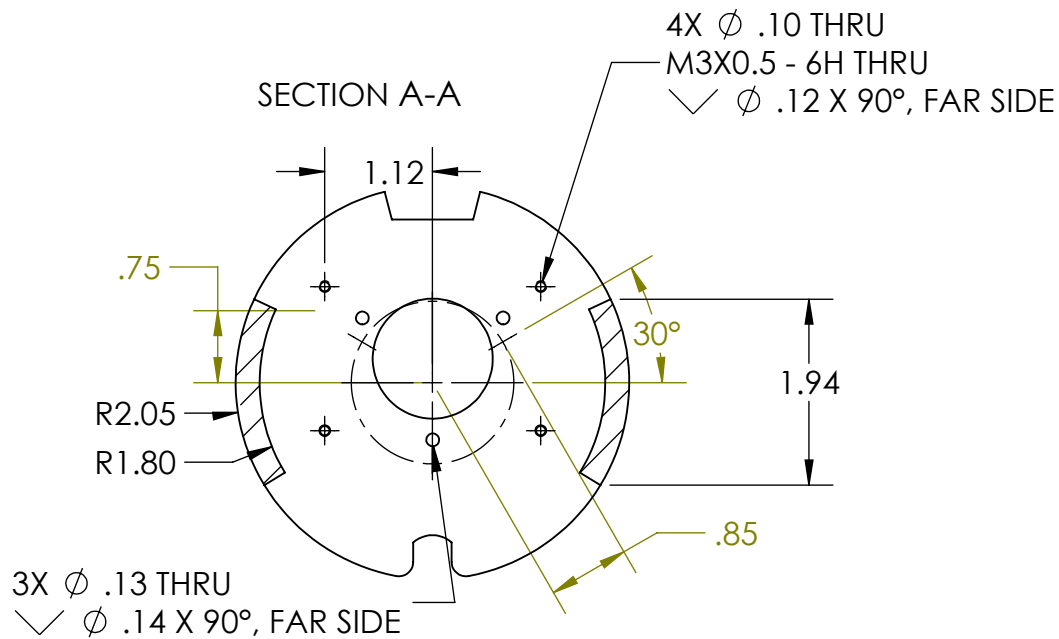
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2

1



SECTION A-A



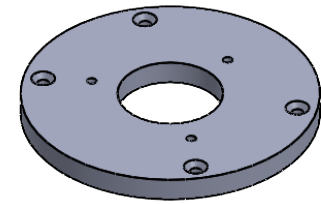
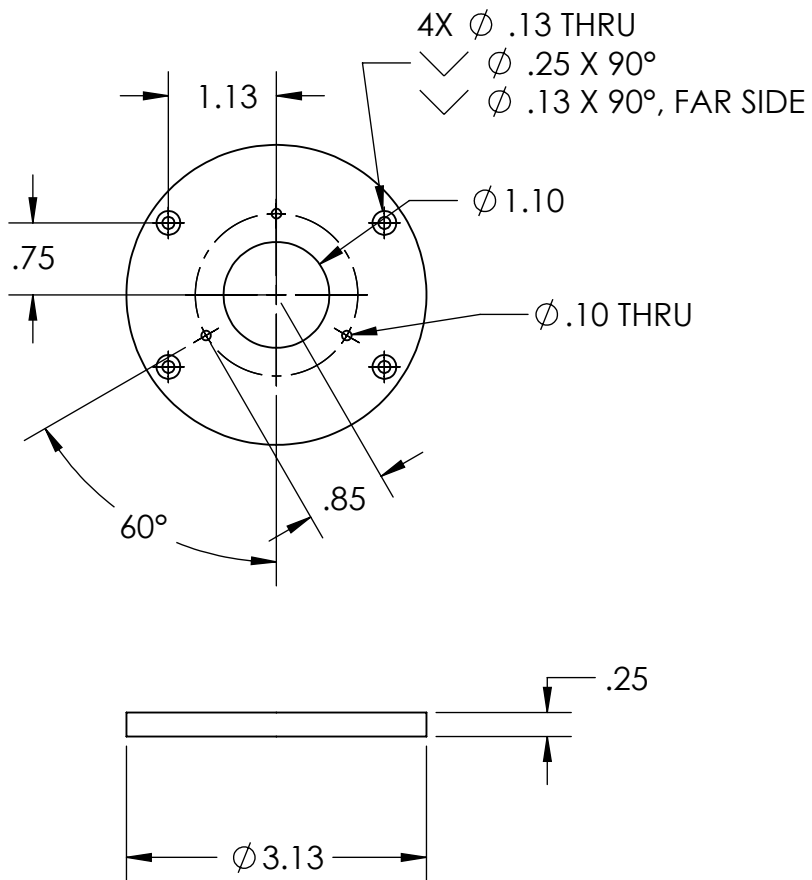
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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Motor Housing Sleeve	
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005	DRAWN				
		INTERPRET GEOMETRIC TOLERANCING PER:	CHECKED				
		MATERIAL ABS	ENG APPR.				
		FINISH N/a	MFG APPR.			SIZE B	DWG. NO.
			Q.A.			REV	
			COMMENTS:			SCALE: 1:2	WEIGHT:
						SHEET 18 OF 23	

3

2

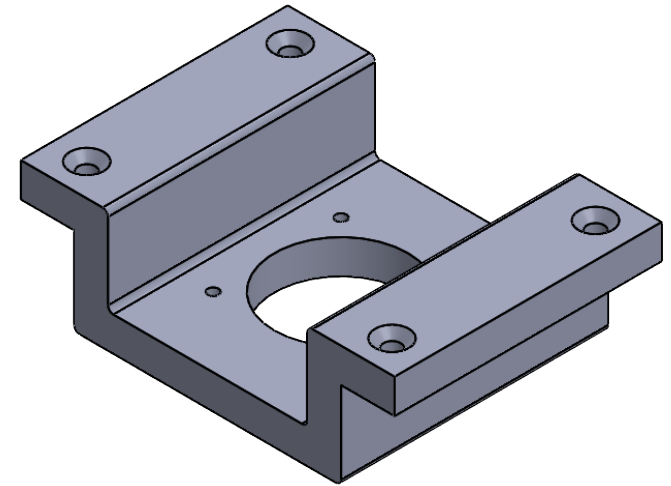
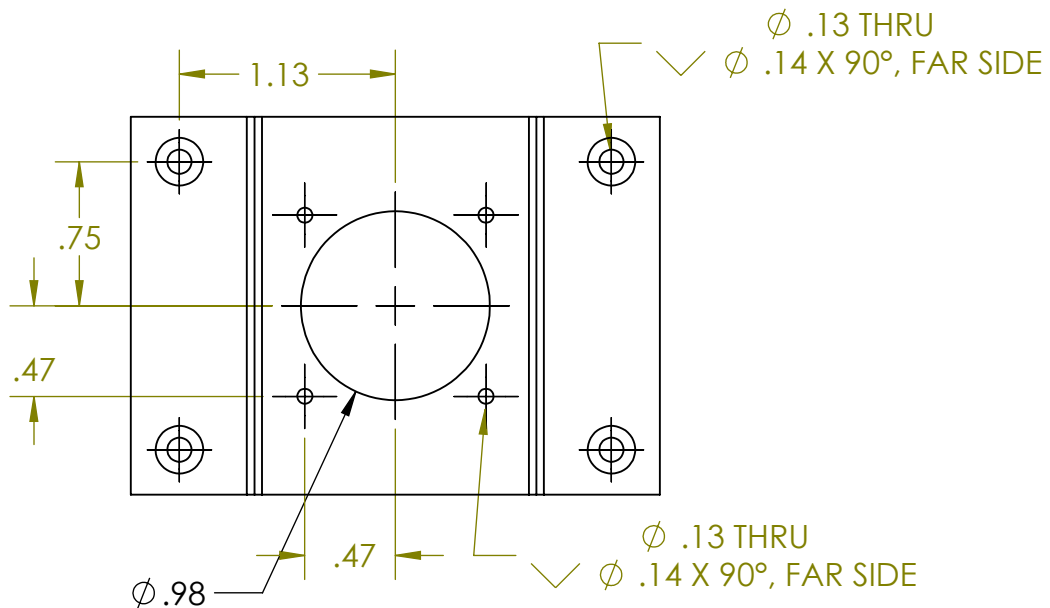
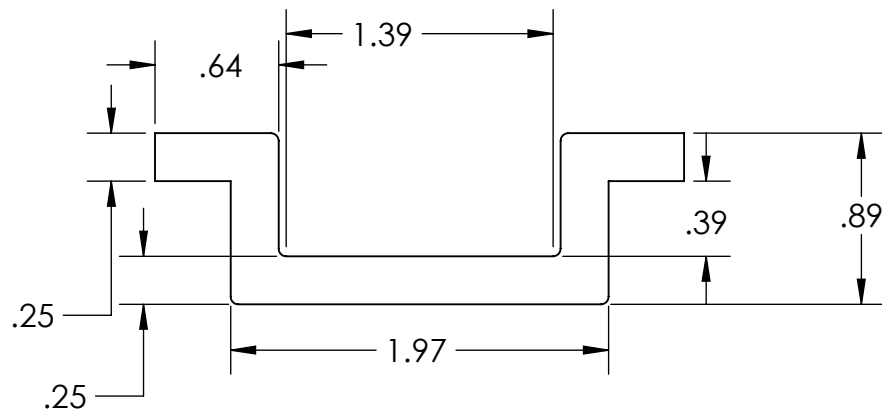
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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Motor Plate		
		DIMENSIONS ARE IN INCHES		DRAWN				
		TOLERANCES:		CHECKED				
		FRACTIONAL \pm		ENG APPR.				
		ANGULAR: MACH \pm BEND \pm		MFG APPR.				
		TWO PLACE DECIMAL $\pm .01$		Q.A.		SIZE A DWG. NO. REV		
		THREE PLACE DECIMAL $\pm .005$		COMMENTS:				
		INTERPRET GEOMETRIC TOLERANCING PER:						
		MATERIAL	AL 6061					
	NEXT ASSY	USED ON	FINISH			SCALE: 1:2 WEIGHT: SHEET 19 OF 23		
			N/a					
	APPLICATION		DO NOT SCALE DRAWING					

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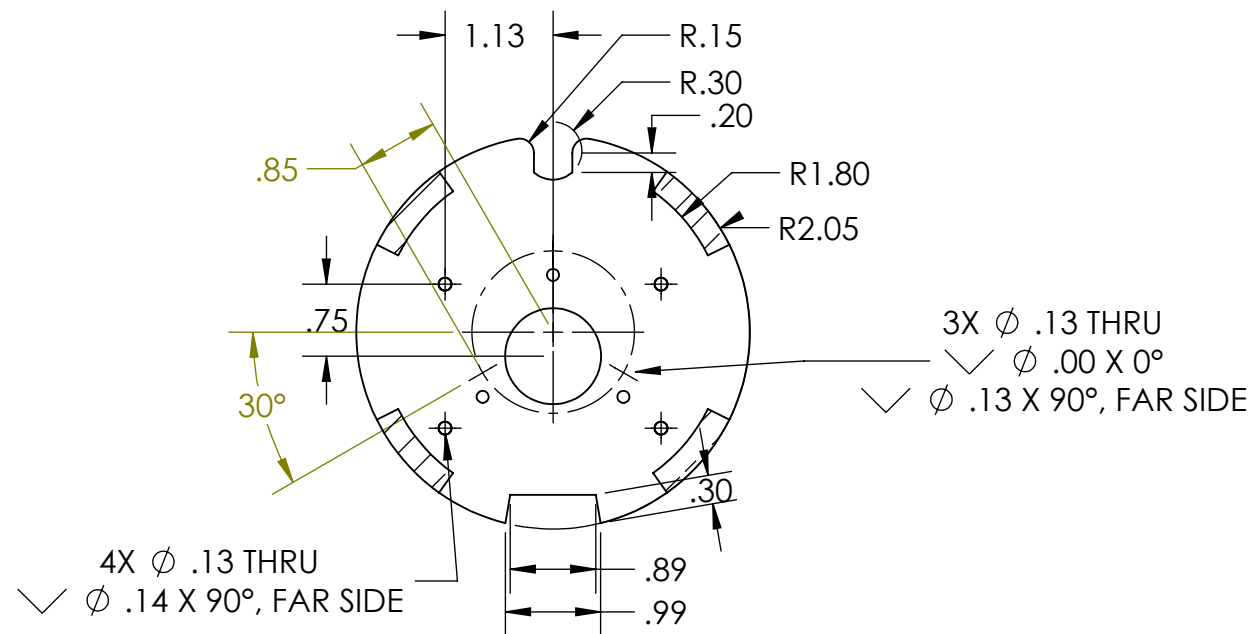
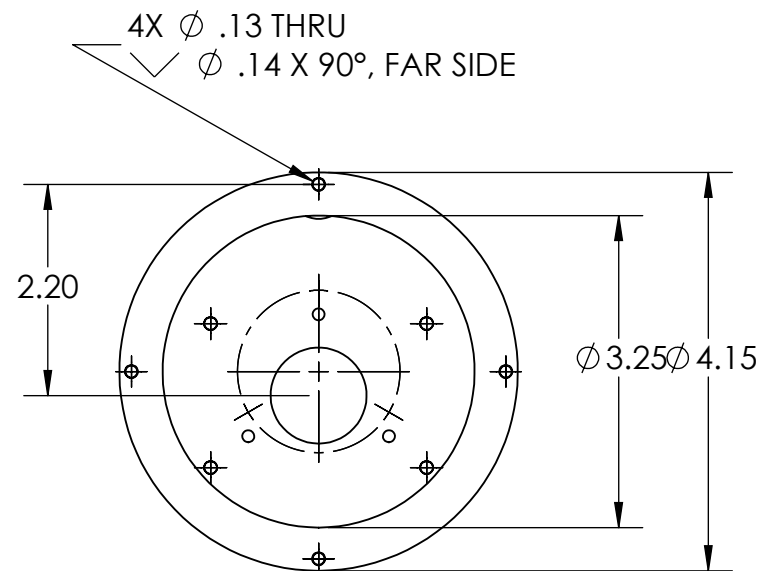
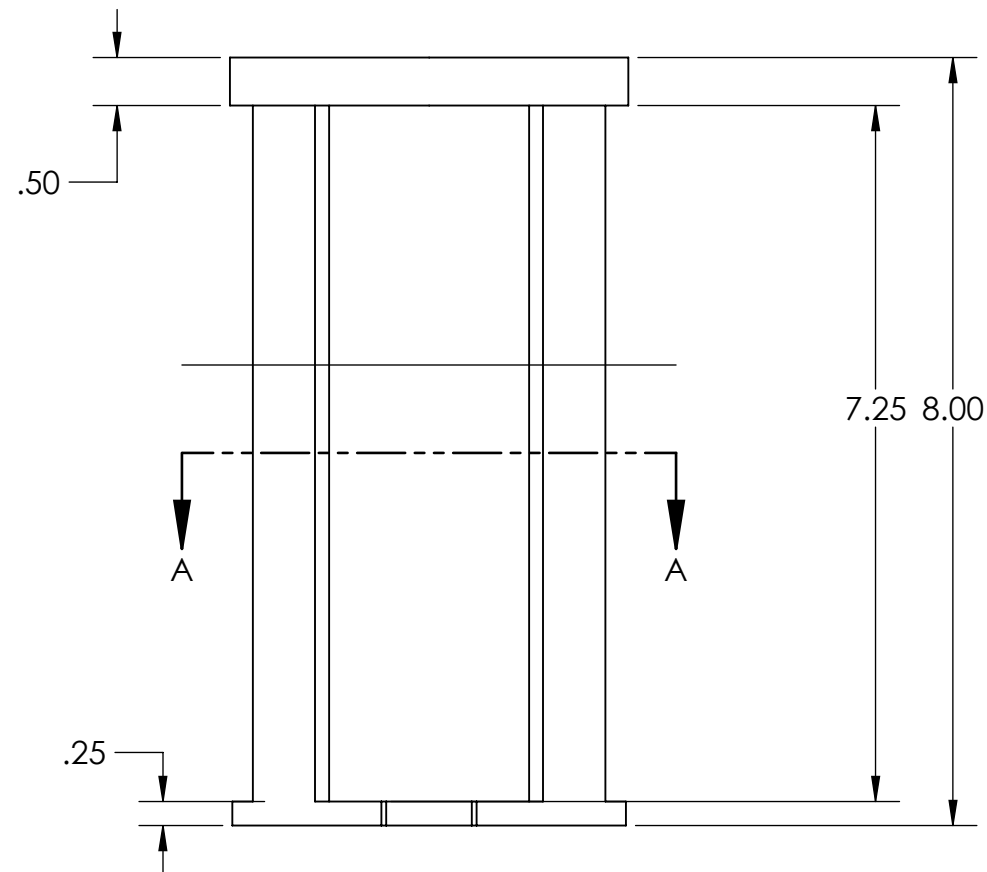
		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: <h1>Mounting Bracket</h1>		
		DIMENSIONS ARE IN INCHES	DRAWN					
		TOLERANCES:	CHECKED					
		FRACTIONAL ±	ENG APPR.					
		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ± .01	Q.A.			SIZE DWG. NO. REV		
		THREE PLACE DECIMAL ± .005	COMMENTS:					
		INTERPRET GEOMETRIC TOLERANCING PER:						
		MATERIAL				A SCALE: 1:1 WEIGHT: SHEET 20 OF 23		
		AL 6061						
		FINISH						
		N/a						
NEXT ASSY	USED ON	DO NOT SCALE DRAWING						
APPLICATION								

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SECTION A-A
SCALE 1 : 2

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Pump Sleeve		
		DIMENSIONS ARE IN INCHES	DRAWN					
		TOLERANCES:	CHECKED					
		FRACTIONAL \pm	ENG APPR.					
		ANGULAR: MACH \pm	MFG APPR.			SIZE DWG. NO. REV		
		TWO PLACE DECIMAL \pm .01	Q.A.					
		THREE PLACE DECIMAL \pm .005	COMMENTS:			SCALE: 1:5 WEIGHT: SHEET 21 OF 23		
		INTERPRET GEOMETRIC TOLERANCING PER:						
		MATERIAL						
		ABS						
NEXT ASSY	USED ON	FINISH						
		N/a						
APPLICATION		DO NOT SCALE DRAWING						

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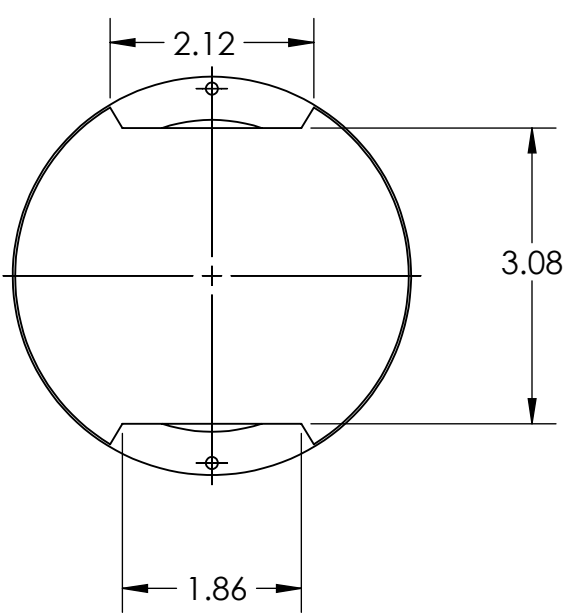
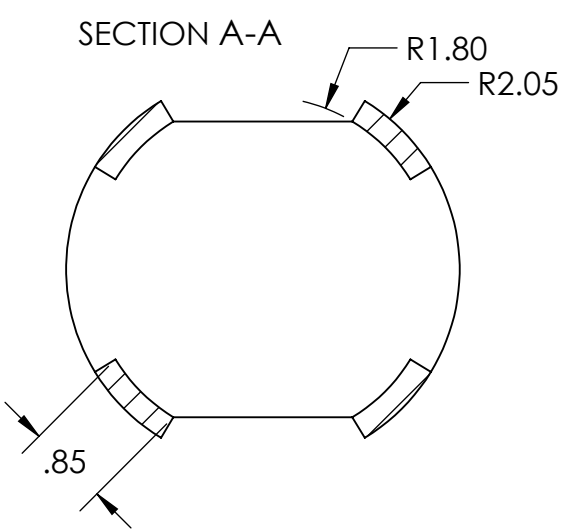
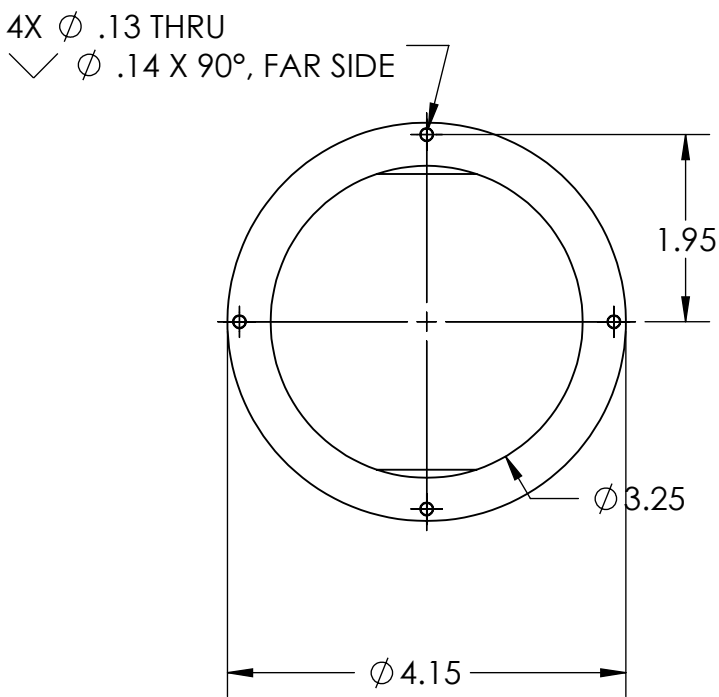
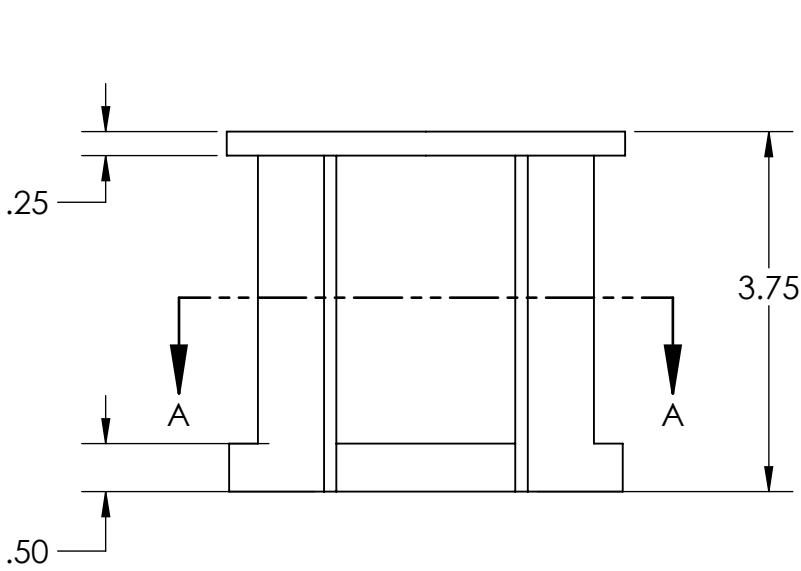
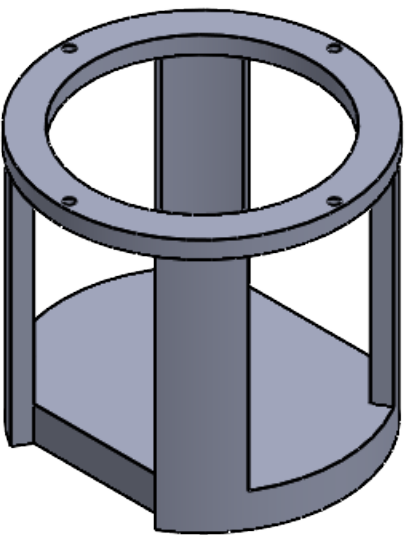
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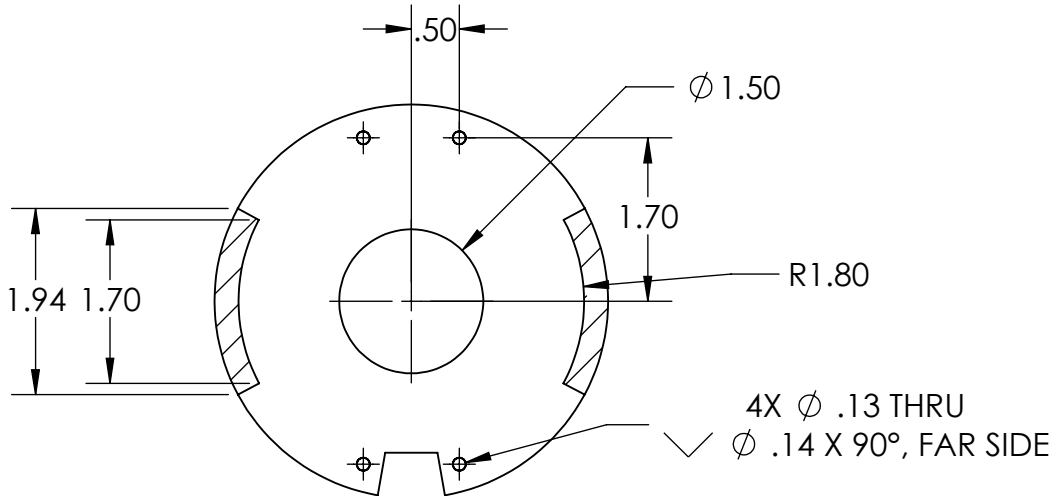
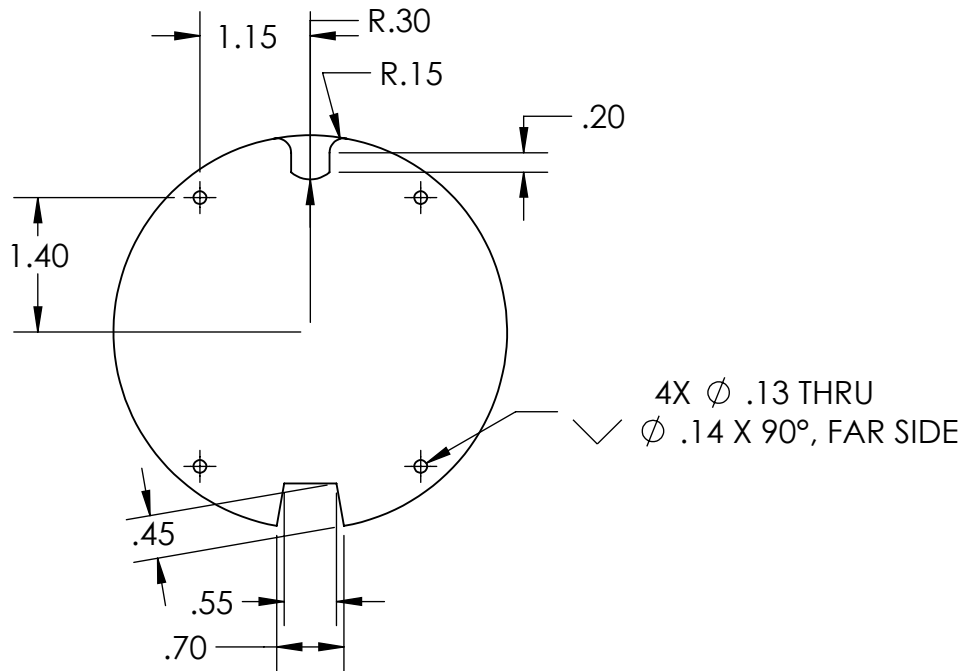
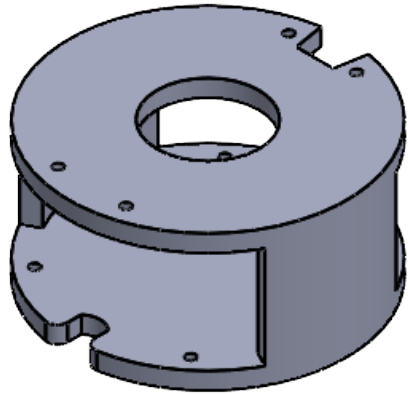
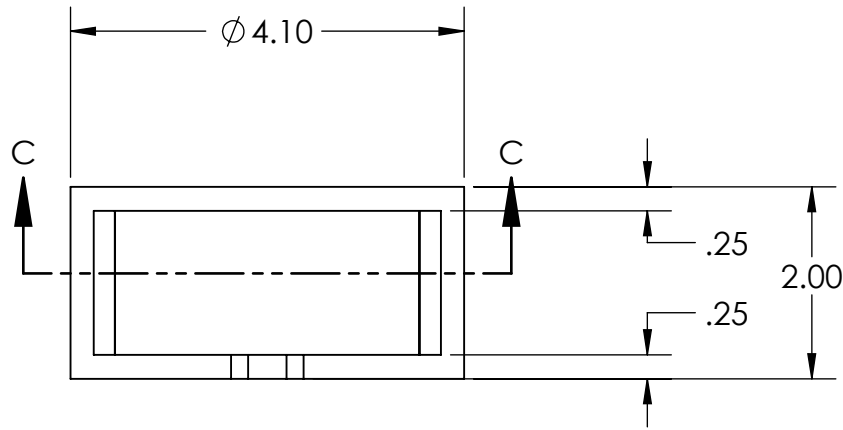
		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: PCB Sleeve		
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005	DRAWN					
			CHECKED					
			ENG APPR.					
			MFG APPR.					
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			SIZE B DWG. NO. 		

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SECTION C-C

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Reservoir Spacing Housing	
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	DRAWN				
		INTERPRET GEOMETRIC TOLERANCING PER:	CHECKED				
		MATERIAL	ENG APPR.				
		FINISH	MFG APPR.			REV	
			Q.A.				
			COMMENTS:			SCALE: 1:2 WEIGHT:	
NEXT ASSY		USED ON				SHEET 23 OF 24	
APPLICATION		DO NOT SCALE DRAWING					

Bill of Materials

Vendor	Part Number	Description	Unit Cost	Quantity	Total Cost
2-4	Assembly Drawings				
5-14	External Manufactured Parts				
15-23	Internal Manufactured Parts				
24	Bill of Materials				

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