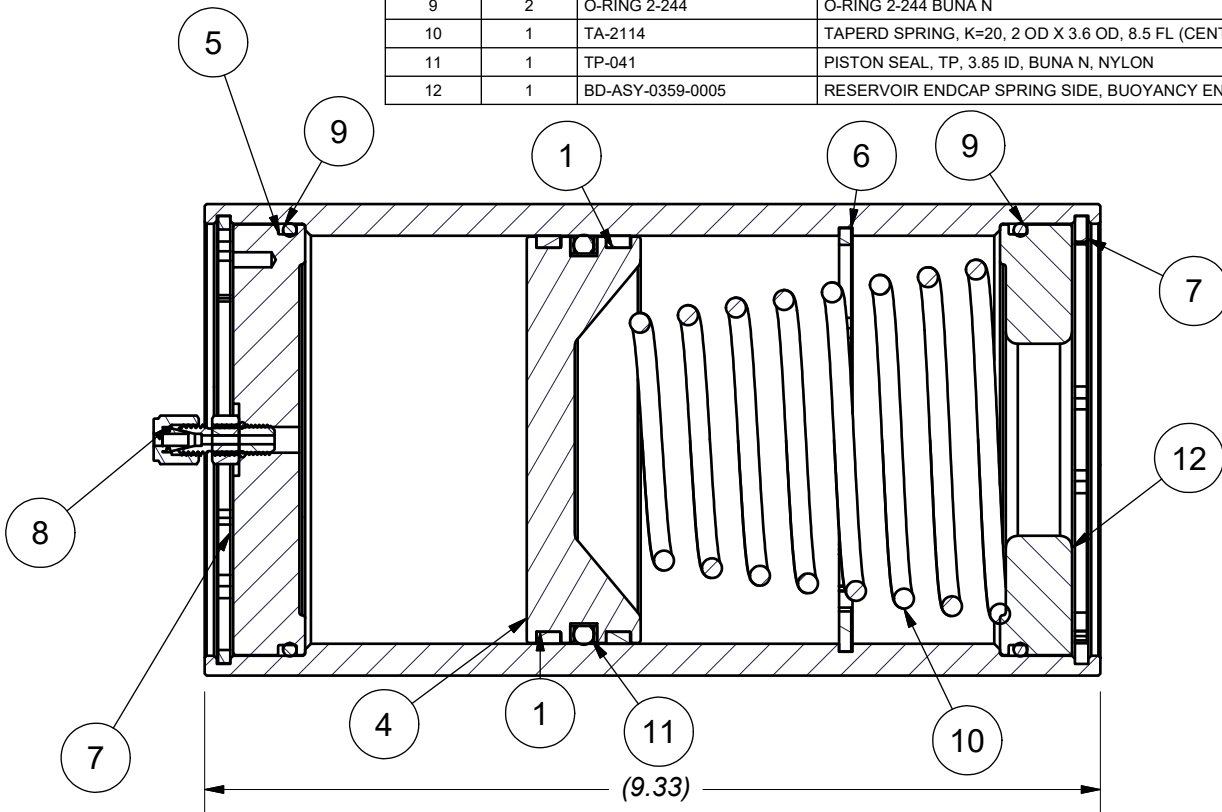
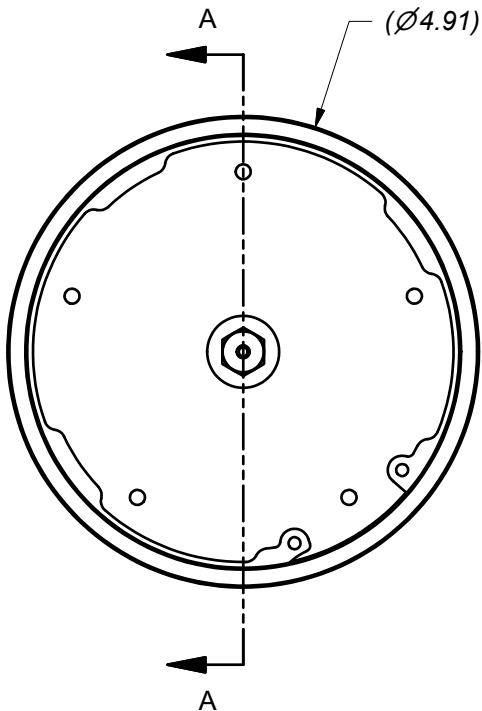


NOTES:
1) INSPECT ALL O-RING MATING SURFACES, INCLUDING ID OF HOUSING, FOR ANY VISIBLE DAMAGE PRIOR TO ASSEMBLY
2) LUBE END CAP O-RINGS USING PARKER O-RING LUBE OR EQUIVALENT.

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	612-225-025	612 Nylon Wear Ring 1/8" Thick
2	1	BD-ASY-0359-0001	RESERVOIR HOUSING, BUOYANCY ENGINE
4	1	BD-ASY-0359-0003	RESERVOIR PISTON, BUOYANCY ENGINE
5	1	BD-ASY-0359-0004	RESERVOIR ENDCAP HYDR, BUOYANCY ENGINE
6	1	BD-PRT-0308-0000	RETAINING RING, INTERNAL, 4.25 ID, 6061-T6
7	2	BD-PRT-0307-0000	RETAINING RING, INTERNAL, 4.5 ID, 6061-T6
8	1	MMC-5182K861	YOR LOK, 1/8 TUBE X 5/16 - 24 UNF, SS
9	2	O-RING 2-244	O-RING 2-244 BUNA N
10	1	TA-2114	TAPERD SPRING, K=20, 2 OD X 3.6 OD, 8.5 FL (CENTURY)
11	1	TP-041	PISTON SEAL, TP, 3.85 ID, BUNA N, NYLON
12	1	BD-ASY-0359-0005	RESERVOIR ENDCAP SPRING SIDE, BUOYANCY ENGINE




SECTION A-A
SCALE 1 / 2

REVISION HISTORY			
REV	DATE	DESCRIPTION	APPROVED
A	9/7/2020	INITIAL RELEASE	JP
B	10/9/2020	ADDED SHEET 6, INCLUDES HOLES IN BOTTOM ENDCAP	JP
C	10/20/2020	ADDED HELICOILS TO ENDCAPS	JP
D	2/23/2020	ADDED FIXTURING NOTE FOR ANODIZNG	JP

UNLESS OTHERWISE NOTED: DIMENSIONS IN INCHES TOLERANCES:		
DECIMAL	ANGULAR	
.xx ± 0.01	± 1 deg	
.xxx ± 0.005		
BREAK ALL SHARP EDGES R0.02 MIN		
SCALE		
NOT TO SCALE		

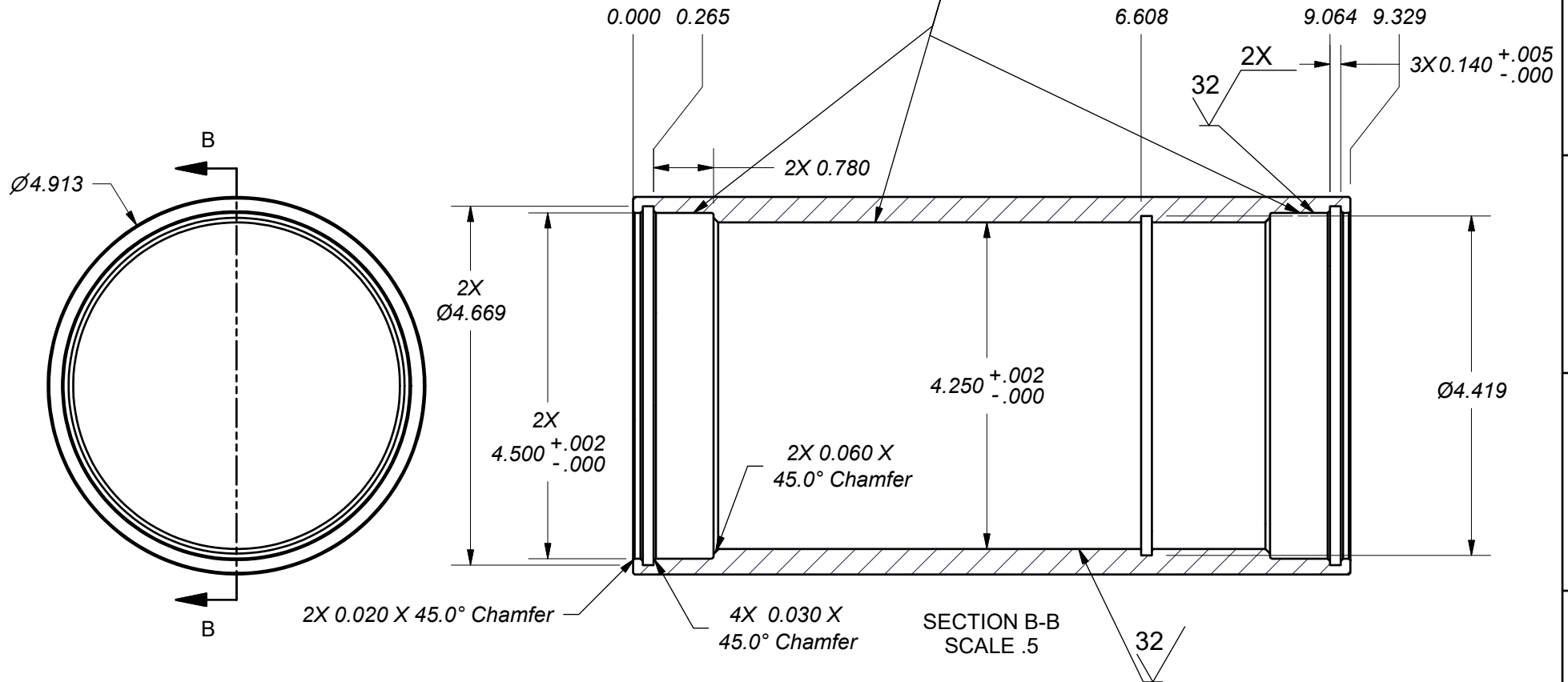
DESIGN	DATE
J PAULUS	9/7/2020
DRAFT	
J PAULUS	9/7/2020
APPROVED BY	
MATERIAL	

			
TITLE			
RESERVOIR ASSEMBLY, BUOYANCY ENGINE			
SIZE	DWG NO	REV	
A	BD-ASY-0359-0000	D	
PHONE	781-583-1984	SHEET 1 OF 6	

NOTES:

- 1) ANODIZE BLACK IAW MIL-A-8265, TYPE III, BLACK, MAX THICKNESS 0.0025
- 2) DO NOT FIXTURE FOR ANODIZING ON 32 RMS SURFACE

DO NOT FIXTURE
FOR ANODIZING ON THIS SURFACE
32 RMS FINISH REQUIRED

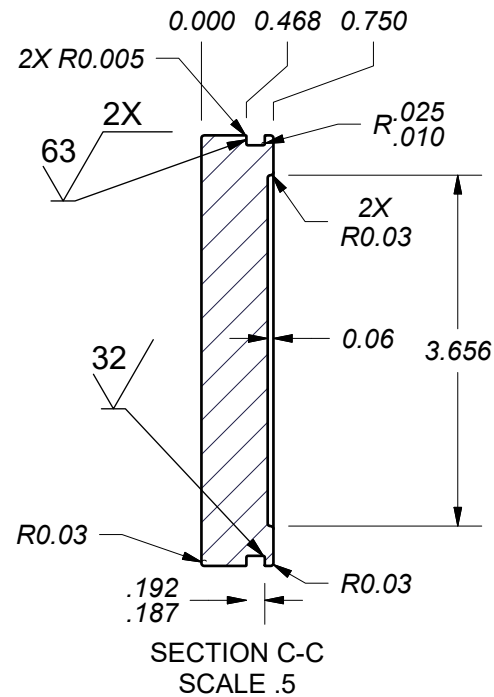
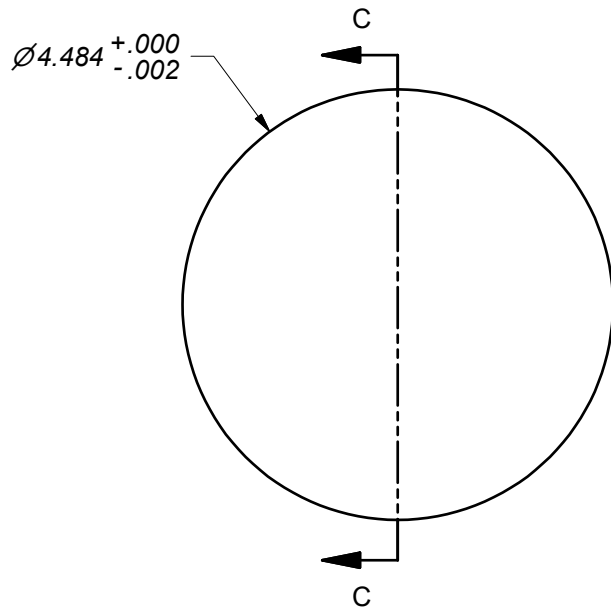


PART NO. **BD-ASY-0359-0001**
RESERVOIR HOUSING, BUOYANCY ENGINE
 MATERIAL: 6061-T6 ALUMINUM

SIZE	DWG NO	REV
A	BD-ASY-0359-0000	D
SCALE	SHEET 2 OF 6	

NOTES:

1) ANODIZE BLACK IAW MIL-A-8265, TYPE III,
BLACK, MAX THICKNESS 0.0025

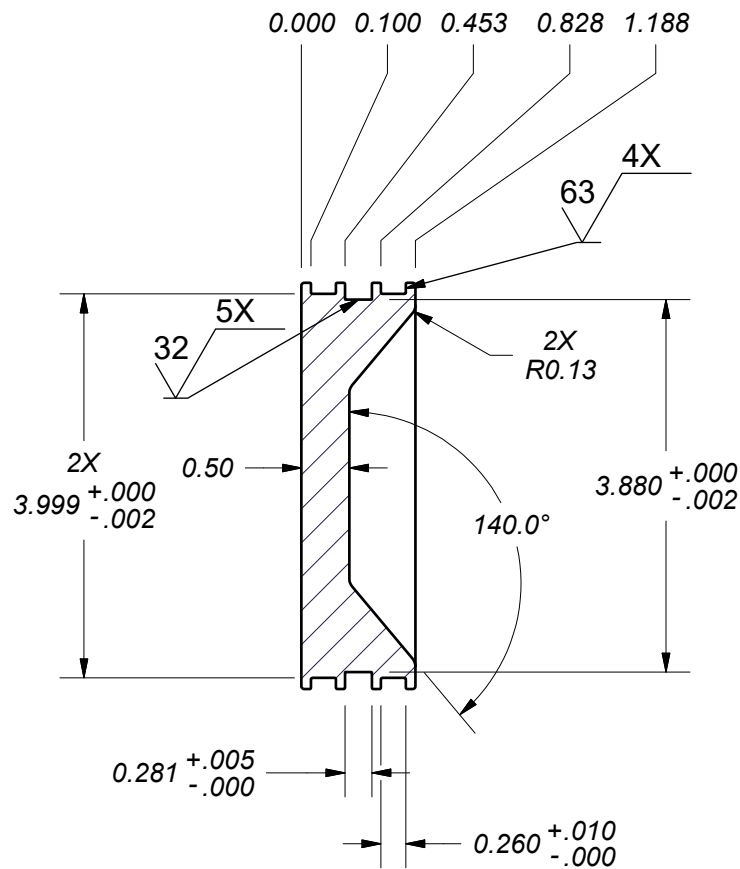
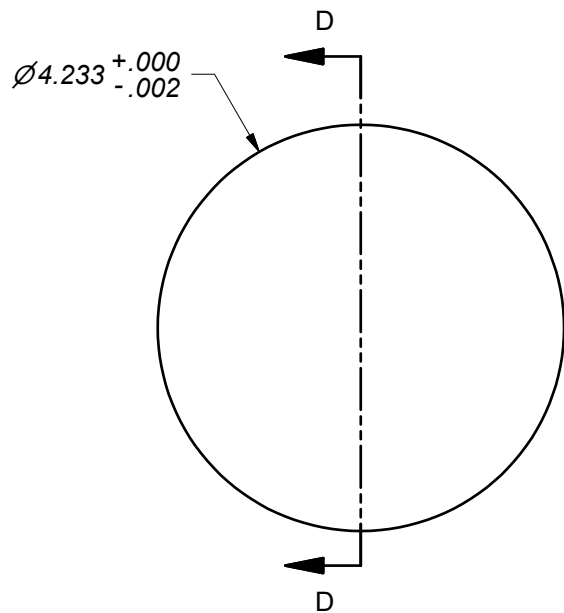


PART NO. **BD-ASY-0359-0002**
RESERVOIR ENDCAP, BUOYANCY ENGINE
MATERIAL: 6061-T6 ALUMINUM

SIZE	DWG NO	REV
A	BD-ASY-0359-0000	D
SCALE	SHEET 3 OF 6	

NOTES:

1) ANODIZE BLACK IAW MIL-A-8265, TYPE III,
BLACK, MAX THICKNESS 0.0025



SECTION D-D
SCALE .5

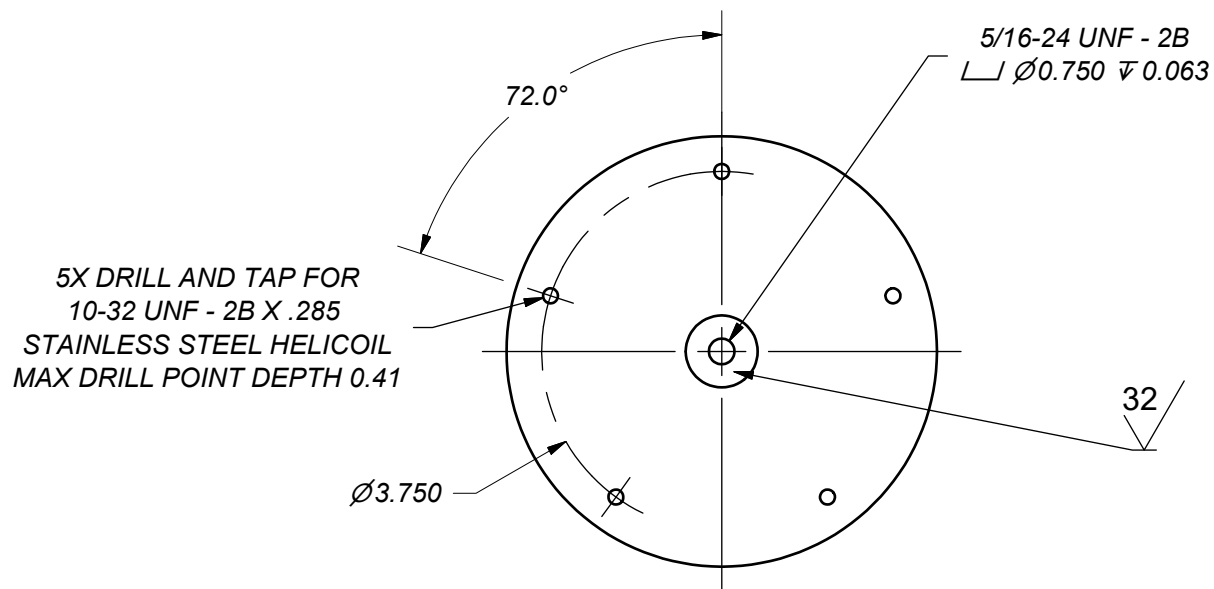
PART NO. **BD-ASY-0359-0003**
RESERVOIR PISTON, BUOYANCY ENGINE
MATERIAL: 6061-T6 ALUMINUM

SIZE	DWG NO	REV
A	BD-ASY-0359-0000	D
SCALE	SHEET 4 OF 6	

8 7 6 5 4 3 2 1

NOTES:

- 1) ALL DIMENSIONS OCCORDING TO BD-ASY-0059-0002, SEE SHEET 3.
2) OVERSIZE TAPPED HOLES FOR ANODIZING
2) ANODIZE BLACK IAW MIL-A-8265, TYPE III, BLACK, MAX THICKNESS 0.0025



PART NO. **BD-ASY-0359-0004**
RESERVOIR ENDCAP HYDR, BUOYANCY ENGINE

SIZE	DWG NO	REV
A	BD-ASY-0359-0000	D
SCALE	SHEET 5 OF 6	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

F

NOTES:

- 1) ALL DIMENSIONS OCCORDING TO BD-ASY-0059-0002, SEE SHEET 3.
- 2) OVERSIZE TAPPED HOLES FOR ANODIZING
- 3) ANODIZE BLACK IAW MIL-A-8265, TYPE III, BLACK, MAX THICKNESS 0.0025
- 4) INSTALL HELICOILS AFTER ANODIZING

F

E

E

D

D

C

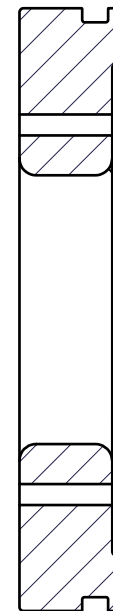
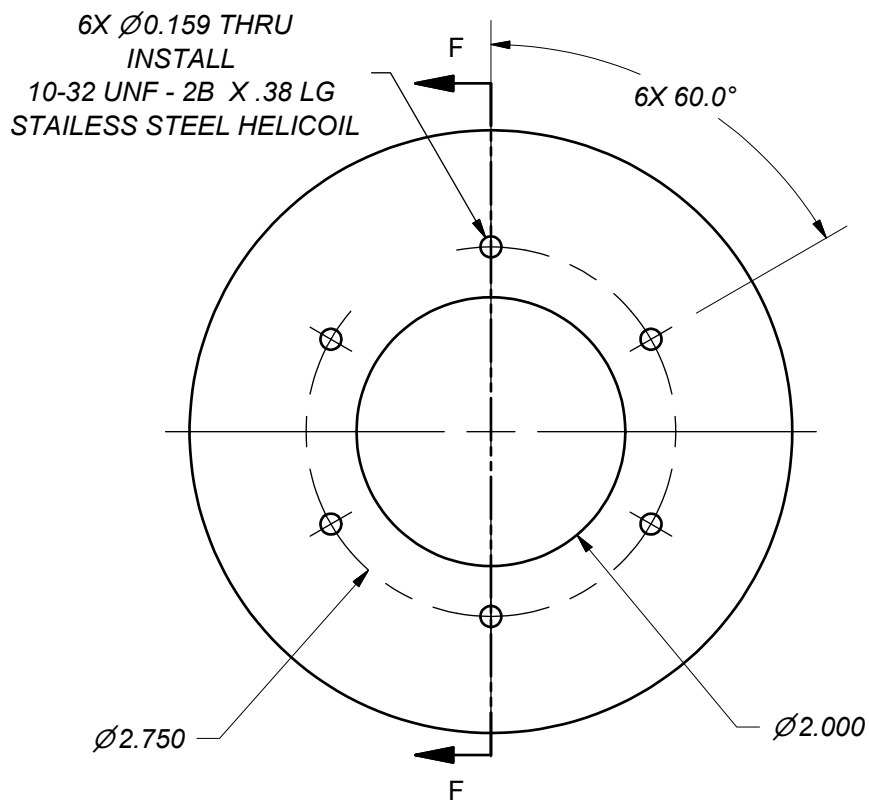
C

B

B

A

A



2XR0.13

SECTION F-F
SCALE .7

PART NO. **BD-ASY-0359-0005**
RESERVOIR ENDCAP SPRING SIDE, BUOYANCY ENGINE

SIZE	DWG NO	REV
A	BD-ASY-0359-0000	D
SCALE	SHEET 6 OF 6	

8 7 6 5 4 3 2 1