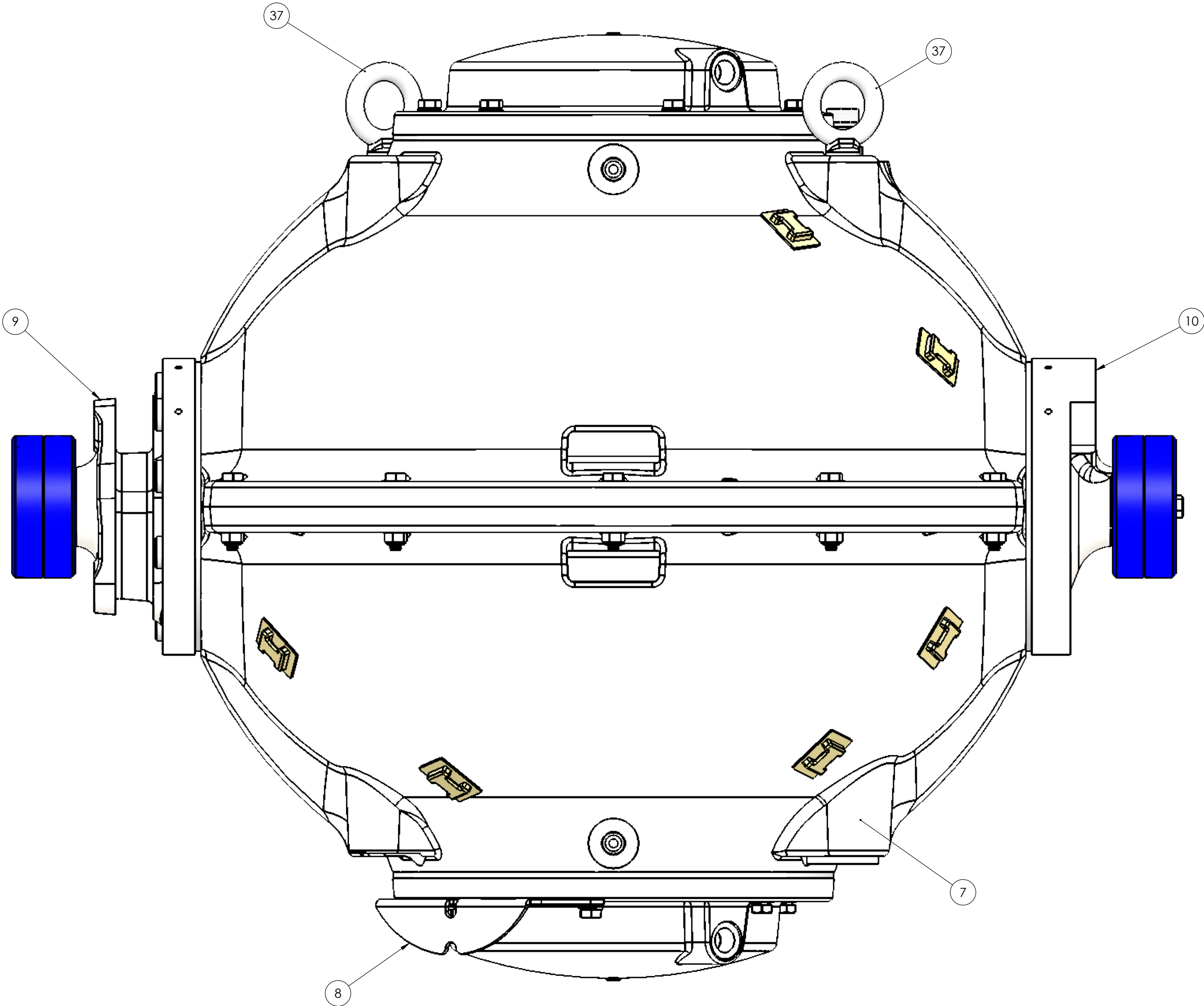


8 7 6 5 4 3 2 1

NOTES: 1) THIS DWG. REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE SEAKEEPER 3 GYRO ENCLOSURE BILL OF MATERIAL AND DOES NOT NECESSARILY REPRESENT THE ACTUAL ASSEMBLY PROCEDURE. THIS DWG DOES PROVIDE TECHNICAL INFORMATION REGARDING COMPONENT LOCATION AND FASTENER APPLICATION.
2) MOST ALL INTERNAL ASSEMBLY WILL BE SIMILAR TO CURRENT SK3 PROTOCOL.
3) BE SURE TO CLEAN ALL COMPONENTS OF METAL CHIPS AND OIL OR GREASE. CLEAN AND BLOW OUT ALL THREADED HOLES. CLEAN ANY GREASE OR OIL FROM BLACK FINISHED ALLOY BOLTS USED FOR GIMBAL SHAFT ASSEMBLY.
4) APPLY THREADLOCKER ACCORDING TO SEAKEEPER WORK INSTRUCTION WI-085.
5) APPLY VACUUM GREASE SPARINGLY TO O-RING OPENING PRIOR TO INSTALLING THE VACUUM SERVICE VALVE, ITEM 13. EXCESSIVE GREASE WILL CAUSE THE O-RING TO PROTUDE OUTSIDE THE OPENING AND BE PINCHED.



PRELIMINARY
NOT RELEASED FOR PRODUCTION
07MAY2018

REV.	ECN NO.	ZONE	DESCRIPTION	DATE	APPROVED
1			RELEASED FOR PRODUCTION	15JAN2018	BEN
2		SHT2: F5, C5, A5	CHANGED TORQUE VALUE ON GIMBAL SHAFT BOLTS FROM 35 FT-LBS TO 25 FT-LBS	11APR2018	DDG
3		SHT2: F5, C5, A5	CHANGED GIMBAL SHAFT BOLT SIZE FROM M8 TO M10; CHANGED BOLT TORQUE FROM 25 FT-LBS TO 60 FT-LBS	25APR2018	DDG
4		SHT2: F5, C5, A5	REDUCE GIMBAL SHAFT BOLT TORQUE TO 30 FT-LBS	07MAY2018	DDG

43	70054	THREADLOCKER, LOCTITE #243, BLUE	1	
42	70001	VACUUM GREASE	1	
41	60576	SCREW, SKT HD CAP, M10-1.5 X 16MM LG	14	
40	60552	SCREW, SOCKET HD CAP, M4-0.7 X 12MM LG, FULL TD, BLK OXIDE CLASS 12.9	12	
39	60550	WASHER, WEDGE LOCK M4, 17ID X .30 OD, ALUM ZINC PLTD STEEL	24	
38	60468	SCREW, SOCKET HD CAP, M10-1.5 X 25MM LG, CLASS 12.9	2	
37	60463	LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH	2	
36	60462	SCREW, SOCKET HD CAP, M4-0.7 X 45MM LG, CLASS 12.9	12	
35	60459	SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9	16	
34	60411	WASHER, HI COLLAR SPLIT LOC, M4 10.9	16	
33	60410	WASHER, FLAT M4, 10.9	16	
32	60338	SCREW, SKT HD CAP, M4-7 X 10mm LG	12	
31	60328	WASHER, SPLIT LOC DIN127B M6	2	
30	60262	SCREW, HEX HD CAP, M6-1.0 X 30mm LG	12	
29	60255	HEX NUT, NYLOK M6-1.0	10	
28	60223	WASHER, FLAT, M6 12MM OD	32	
27	60222	HHCS M6-1.0 X 35mm LG FULL THREAD	10	
26	60035	WASHER, SPLIT LOC DIN7980, M4	2	
25	40589	O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK	2	
24	40587	O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK	2	
23	40574	FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG	1	
22	40518	DESICCANT, 10G PACKET, TYVEK	4	
21	40476	SEAKEEPER 2 LOWER WAVE SPRING	1	
20	40475	SEAKEEPER 2 UPPER WAVE SPRING	1	
19	40473	O-RING, SIZE SAE-164, VITON	2	
18	40472	O-RING, WATER JACKET BOLT SEAL	2	
17	40471	O-RING, SIZE SAE-164, VITON	4	
16	40470	O-RING, SK2 OUTSIDE EQUATOR CUSTOM, VITON	1	
15	40250	SIL-THANE 803 MARINE SEALANT	1	
14	40189	O-RING, .139 DIA X 15.955 ID	1	
13	40142	O-RING, SIZE 024 A75 DUROMETER	2	
12	40004	VALVE, VACUUM PORT	1	
11	30016	LARGE CLICK BOND WIRE TIE ANCHOR	10	
10	11877	SK2 NON-BRAKE SIDE GIMBAL SHAFT SUBASSEMBLY	1	
9	11876	SK2 BRAKE SIDE GIMBAL SHAFT SUBASSEMBLY	1	
8	11839	SEAKEEPER 2 MOTOR CABLE GUARD	1	
7	11801	SEAKEEPER 2 ENCLOSURE, FINAL GRIND	1	
6	11762	DESICCANT PORT PLUG, 1.25 PORT SIZE	1	
5	11538	SEAKEEPER 2 WATER JACKET, FINISH MACHINED	2	
4	11536	SEAKEEPER 2 COOLING COVER, FINISH MACHINED	2	
3	11524	SEAKEEPER 2 UPPER & LOWER EXTERIOR BEARING RETAINER	2	
2	11507	SEAKEEPER 2 UPPER FIXED COOLING COLLAR, FINISH MACHINED	1	
1	11505	SEAKEEPER 2 LOWER FIXED COOLING COLLAR, FINISH MACHINED	1	
ITEM NO.	PART NO.	DESCRIPTION	QTY.	NOTE

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NAME:		SEAKEEPER 2 ENCLOSURE AND GIMBAL SHAFT SUB-SYSTEM SERVICE REFERENCE	
WEIGHT - LBS : ---	DRAWN: BEN	DATE: 10JAN2018	REV. NO. / SHEET NO. 4 / 2
MATERIAL: ---	ENG APPR:	DATE:	DWG NUMBER 11860-SP
PROD APPR:		DATE:	1 OF 2

