DESCRIPTION

The following guidance is offered for instances where it is preferred to install a Seakeeper gyroscope using stainless steel fasteners. This is to be used strictly for mounting the Seakeeper to the vessel foundation only.

GENERAL NOTES

- Bolts shall comply with ISO 3506 Part 1 and have the **A4-70** designation.
- Bolts must have a minimum ultimate strength of 100 KSI.
- Bolt length shall be determined by the installer to provide a recommended minimum thread engagement of 1.5 x bolt diameter.
- It is recommended that a G-10 composite washer be placed under the flat washer to provide galvanic corrosion protection between the stainless washer and the aluminum frame.
- The installer shall apply a light coat of nickel based anti-seize to the bolt threads to avoid galling problems with stainless on stainless threads in a potentially contaminated (glass dust) environment.
- The bolt shank and washer shall be fully bedded in an appropriate marine sealant to ensure the prevention of any water intrusion.
- The below values are listed for installation into a helical threaded insert. For through-bolting using a nylock nut, add 10 ft-lbs (13.5 N-m) of torque to the listed values.

MODEL SPECIFIC NOTES

SEAKEEPER 1

- Stainless steel fasteners are not to be used when installing the Seakeeper 1.

SEAKEEPER 2

- Stainless steel fasteners are not to be used when installing the Seakeeper 2.

SEAKEEPER 3

- Stainless steel fasteners are not to be used when installing the Seakeeper 3.

SEAKEEPER 5, SEAKEEPER 6

- **M12x1.75** bolts are to be torqued to **51 ft-lbs (69 N-m)**.

SEAKEEPER 9, SEAKEEPER 16/SEAKEEPER 7HD, SEAKEEPER 12HD

- **M14x2.0** bolts are to be torqued to **78 ft-lbs (106 N-m)**.

SEAKEEPER 26, SEAKEEPER 35/SEAKEEPER 20HD, SEAKEEPER 30HD

- **M16x2.0** bolts are to be torqued to **100 ft-lbs (136 N-m)**.

REVISION	DESCRIPTION OF CHANGES	DATE	APPROVED
1	Initial Release	18APR2017	-
2	Update Format, Include Seakeeper 2	29JUL2019	DMF
3	Include Seakeeper 1 Notes	17JUN2020	JFK