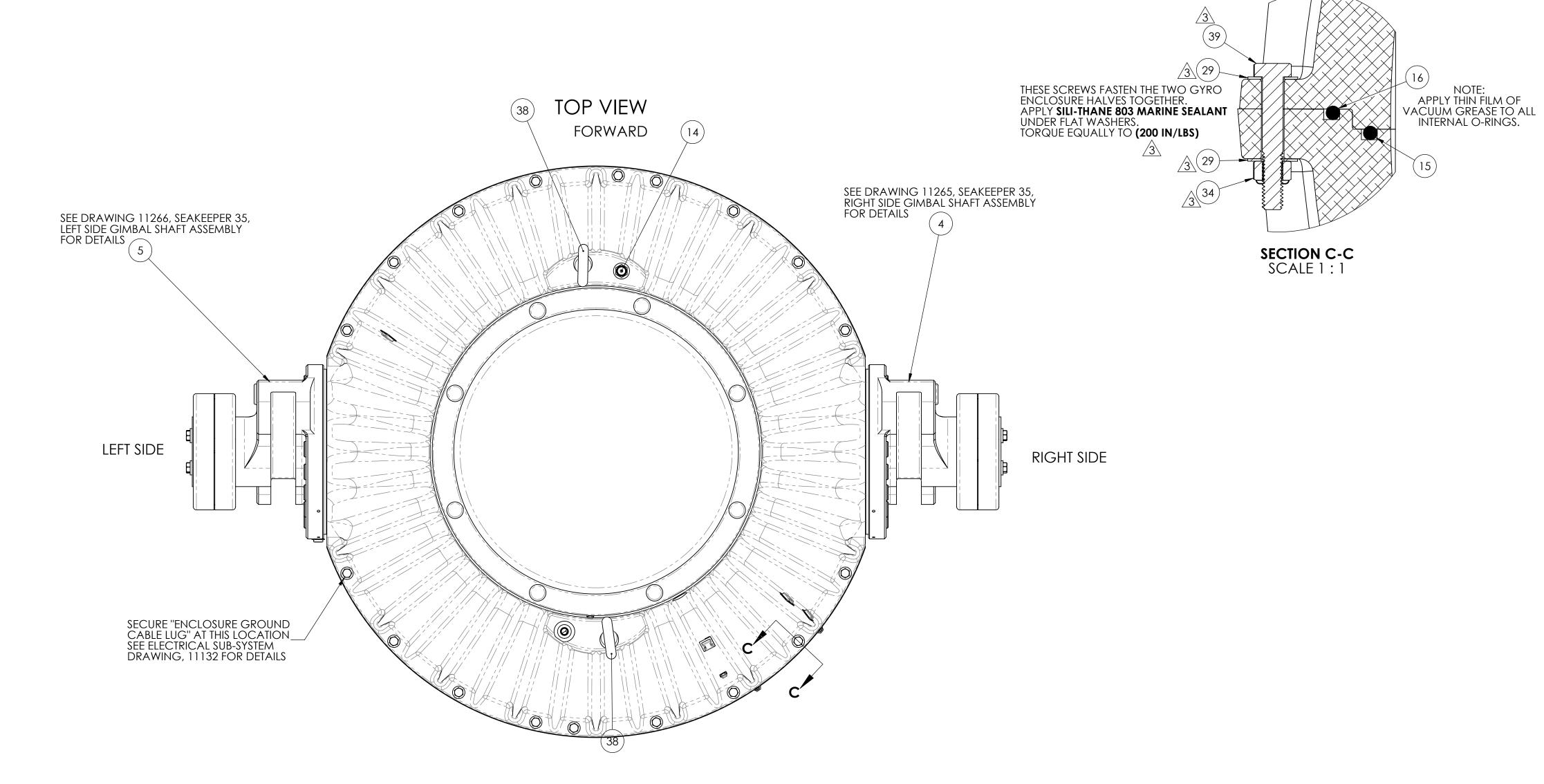
NOTES:
(1) THIS DWG REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE SEAKEEPER 35 GYRO ENCLOSURE BILL OF MATERIAL AND DOES NOT NECESSARILY REPRESENT THE ACTUAL ASSEMBLY PROCEDURE. THIS DWG DOES PROVIDE TECHNICAL INFORMATION.
(2) BE SURE TO CLEAN ALL COMPONENTS OF METAL CHIPS AND OIL OR GREASE, CLEAN AND BLOW OUT ALL THREADED HOLES.

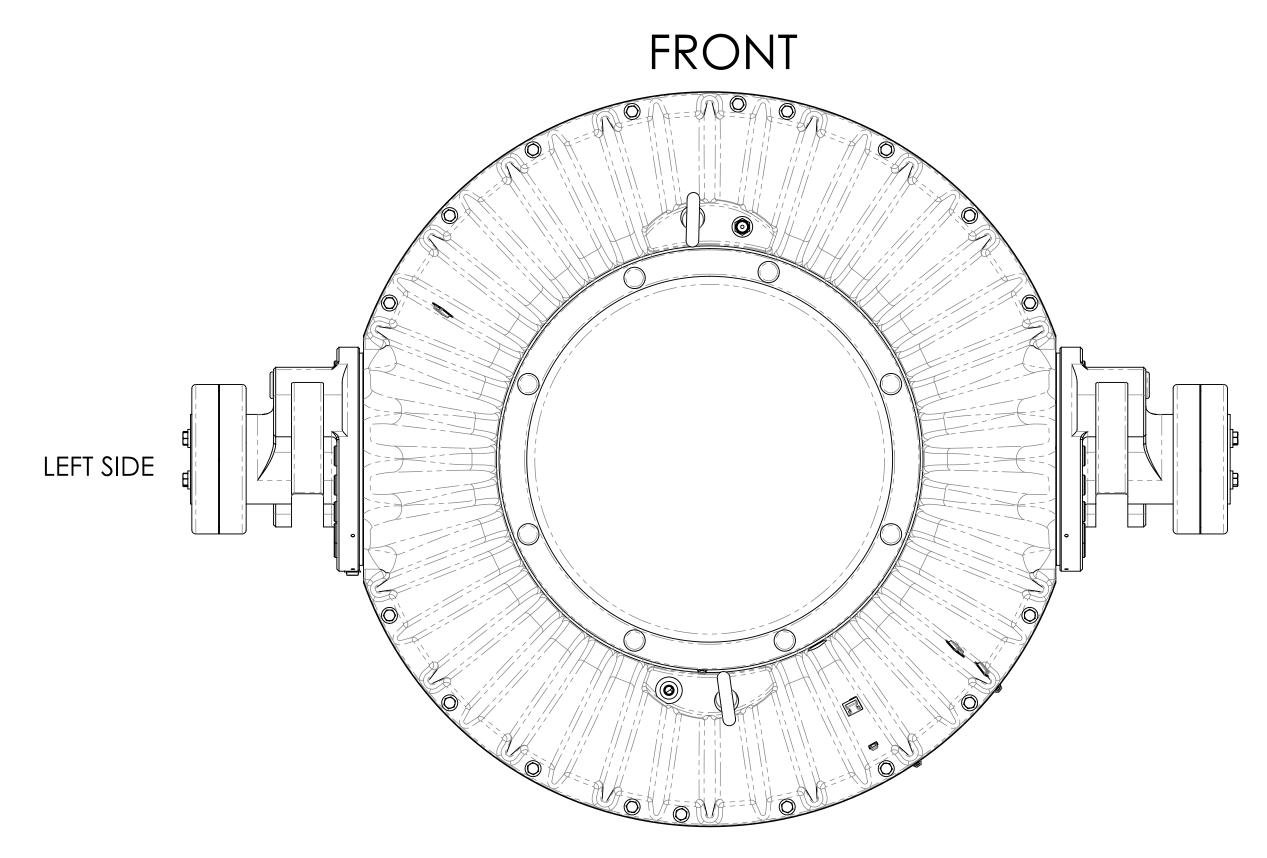


2					
REV NO.	ECN NO.	ZONE	DESCRIPTION	DATE	APPRVD.
1	177		INITIAL RELEASE	2/18/2015	BRD
2	228		11265 AND 11266 GIMBAL SHAFT ASSEMBLIES CHANGED URETHANE BUSHING FROM 10993 (ORANGE) TO 11221 (GRAY).	14OCT2014	BRD
3	366	C4, D4	1. ADDED FLANGE TO ENCLOSURE. 2. REPLACE D 60067 (18) WITH 60449 (18). 3. REMOVED 60002 (17). 4. ADDED 60243 (18). 5. CHANGED QTY OF 60003 FROM 32 TO 52. 6. CHANGED QTY OF 30015 FROM 4 TO 5. 7. CHANGED QTY OF 30016 FROM 12 TO 11. 8. CHANGED TORQUE FROM 120 TO 200 IN-LBS.	17MAY2016	BRD
4	328, 485, 482		1. FIXED COOLING COLLARS - MADE FROM CASTINGS. 2. RETAINER/ENCLOSURE MACHINING CHANGES. 3. RETAINERS CHANGED TO PILOT USING OD AND HAVE CLEARANCE TO BEARING. 4. RETAINER HOLE DIAMETERS INCREASED FOR HEICOLOCK WASHERS. 5. REPLACED 3/8" BOLT WITH 5/16" BOLT. 6. REPLACED HI-COLLAR LOCK WASHERS WITH HEICO LOCK WASHERS. 7. REDUCED RETAINER TORQUE, WAS 300 IN-LBS. 8. COOLING COLLAR FIN TOLERANCE INCREASE.	06JUL2018	EMS
5	491, 546		1. PRE-GRIND AND FINAL GRIND ENCLOSURE WITH DESICCANT PLUG. 2. DESICCANT IMPLEMENTATION INCLUDES DESICCANT GUARD, HARDWARE, DESICCANT PACKS, FOAM AND MOTOR WITH ADDED MOUNTING HOLES FOR GUARD.	06JUL2018	EMS
6	633	2-B2	REPLACED GIMBAL BOLT HARDWARE 60005 & 60006 WITH 60578 (BOLT WITH O-RING) AND CHANGED TORQUE TO 100 FT-LBS, WAS 150 FT-LBS.	22JAN2018	BRD

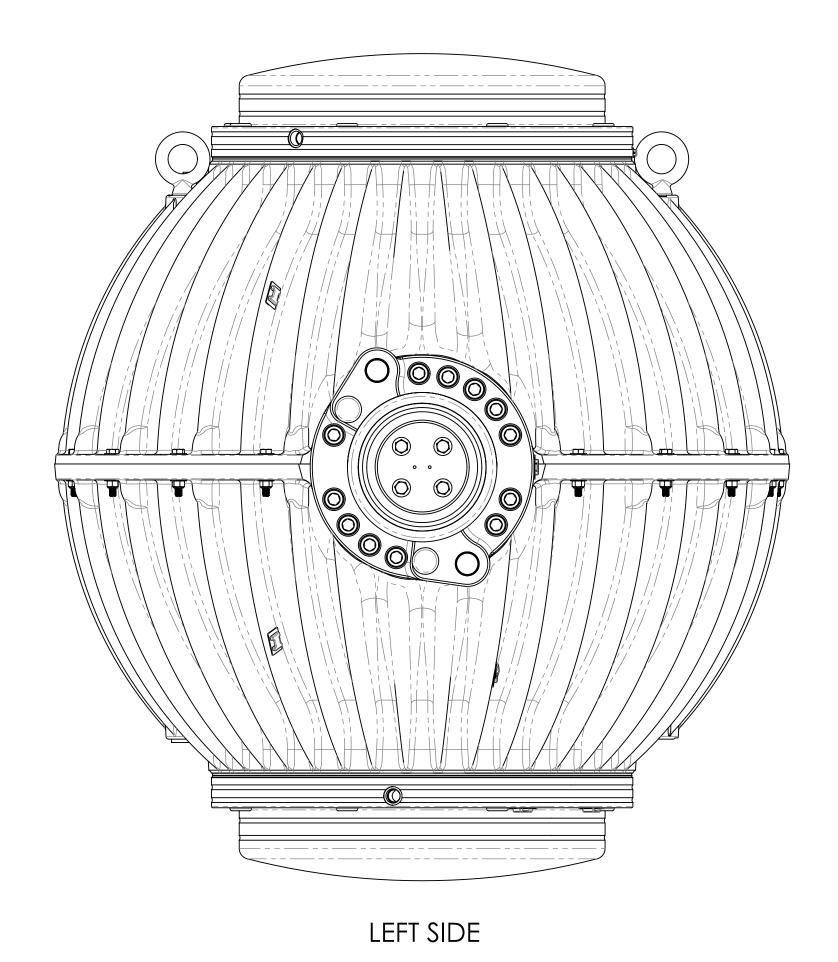
44	70054	THREADLOCKER, LOCTITE #243, BLUE		AR
43	60578	SCREW, SOCKET HD CAP WITH O-RING, .62-18 X 1.75 FULL TD	ALLOY STEEL, ALUM ZINC PLTD	28
42	60495	STANDOFF, .38 HEX, 10-32 MALE X 10-32 FEMALE X 1.25 LG	18-8\$\$	3
41	60494	SCREW, HEX HD FLANGE, 10-32 X .375	GRD 5 STL	3
40	60491	HEICO-LOCK WASHER, .313 SCREW SIZE	ZINC PLT STL	40
39	60449	HEX HD CAP SCREW, .31-18 X 2" LG	316 SS	18
38	60275	EYEBOLT, M14 X 2 X 28 LNG	ALLOY STEEL	2
37	60274	SCREW, SOCKET HD CAP .25-28 X 2.25 FULL TD	ALLOY STEEL	16
36	60273	SCREW, SOCKET HD CAP .31-24 X 4 PART TD	ALLOY STEEL	20
35	60272	SCREW, SOCKET HD CAP .31-24 X 1.75 FULL TD	ALLOY STEEL	16
34	60243	NUT, NYLOCK HEX .31-18	316SS	18
33	60133	WASHER, SPRING LOCK, HI-COLLAR, 5/16	ALLOY STEEL	16
32	60131	SCREW, SOCKET HD CAP .31-24 X 1 FULL TD	ALLOY STEEL	20
31	60069	NUT, NYLOCK HEX, 10-24	18-8 SS	2
30	60020	WASHER, SPRING LOCK, HI-COLLAR, 1/4	STEEL	16
29	60003	WASHER, FLAT TYPE B NARROW 0.31	316 SS	52
28	40574	FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG	OPEN CELL URETHANE	2
27	40523	RUBBER BUMPER, 1" DIA X .50 HIGH, 10-24 MALE STUD	RUBBER, BLACK	2
26	40518	DESICCANT, 10G PACKET	TYVEK	14
25	40516	O-RING, SIZE 025 .070 X 1.176 ID	75A VITON, BROWN	2
24	40352	SEAKEEPER 35, SEAL, WATER JACKET, .203 SQUARE X 19.350 INCH ID	VITON 75	2
23	40351	BLACK PLASTIC CAP PLUG, 1 INCH	PLASTIC	16
22	40348	O-RING, .139 DIA X 16.955 DIA ID	VITON 75	4
21	40347	SEAKEEPER 35, LOWER BEARING WAVE SPRING	CARBON STEEL	1
20	40346	SEAKEEPER 35, UPPER BEARING WAVE SPRING	CARBON STEEL	1
19	40250	SILI-THANE 803 MARINE SEALANT	POLYURETHANE	AR
18	40233	BLACK PLASTIC PLUG CAP	PLASTIC	4
17	40189	O-RING, .139 DIA X 15.955 ID	VITON 75	2
16	40162	O-RING, .210 x 30.760"	VITON 75	1
15	40161	O-RING, .210 x 29.640"	VITON 75	1
14	40004	VALVE, VACUUM PORT	302SS	1
13	30016	LARGE CLICK BOND WIRE TIE ANCHOR	COMPOSITE	11
12	30015	SMALL CLICK BOND WIRE TIE ANCHOR	COMPOSITE	5
11	11733	SEAKEEPER 35 DESICCANT CONTAINMENT GUARD	ALUM 5052	1
10	11727	SEAKEEPER 35, LOWER BEARING EXTERIOR RETAINER	1018 STEEL	1
9	11724	SEAKEEPER 35, UPPER BEARING EXTERIOR RETAINER	1018 STEEL	1
8	11714	DESICCANT PORT PLUG	6061 ALUM.	1
7	11291	SEAKEEPER 35, LOWER FIXED COOLING COLLAR, FINISH MACHINED	A319F ALLOY ALUMINUM	1
6	11290	SEAKEEPER 35, UPPER FIXED COOLING COLLAR, FINISH MACHINED		
5	11266	SEAKEEPER 35, LEFT SIDE GIMBAL SHAFT ASSEMBLY	SEE BOM	1
4	11265	SEAKEEPER 35, RIGHT SIDE GIMBAL SHAFT ASSEMBLY	SEE BOM	1
3	10881	SEAKEEPER 35, COVER	6061 ALUMINUM	2
2	10880	SEAKEEPER 35, WATER JACKET	6061 ALUMINUM	2
1	10879	SEAKEEPER 35, ENCLOSURE	A356-T6 ALUM	1
TEM NO.	PART NO.	DESCRIPTION		QTY

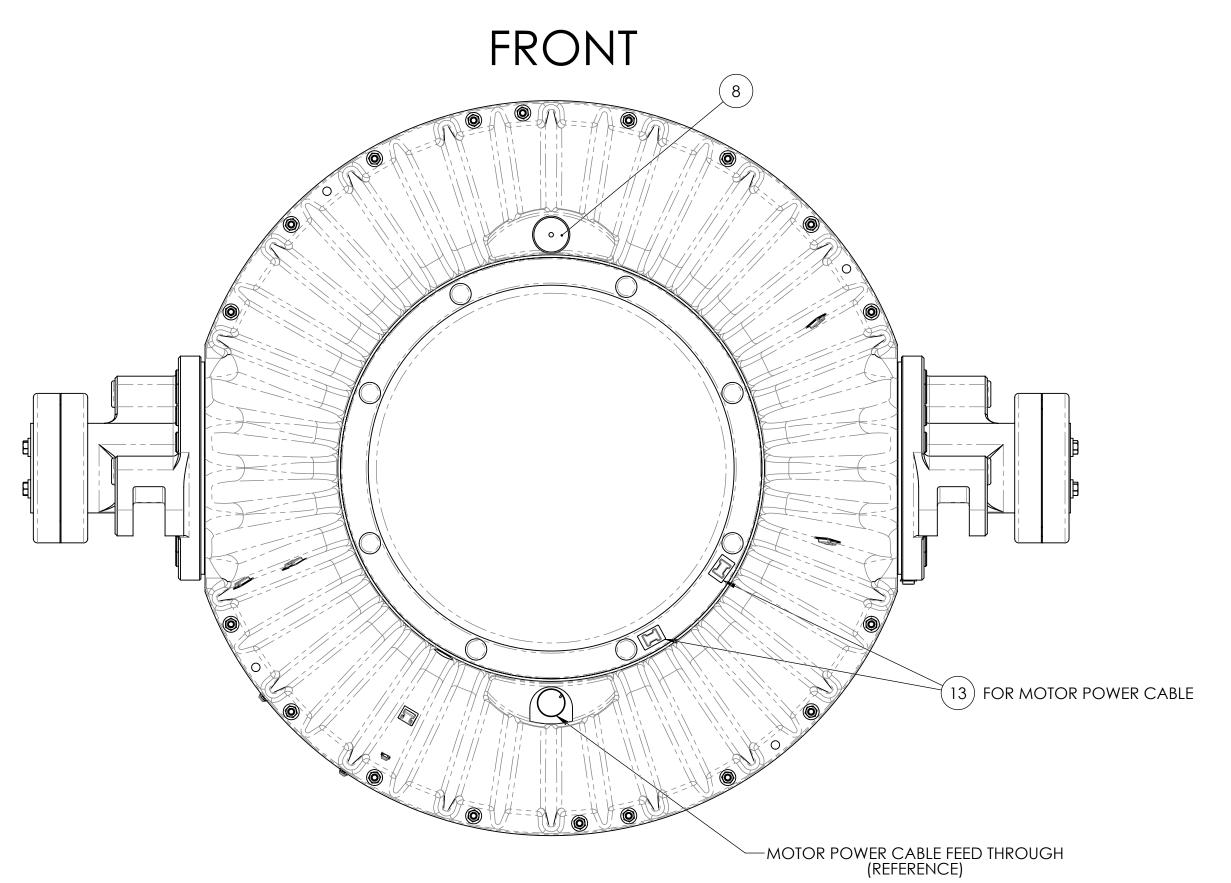
		PROPRIETARY A	AND CONFIDENTIAL		SEAKEE		D ®
			N CONTAINED IN THIS SOLE PROPERTY OF		SEAREE		K
			CORPORATED. ANY	Seakeeper Inc.	44425 Pecan Court, Suite 151 0	California,	MD 2061
_			I PART OR AS A WHOLE	NAME:			
	WEIGHT - LBS : 828	WITHOUT THE WRITTEN PERMISSION OF SEAKEEPER IS PROHIBITED.		SEAKEEPER 35 ENCLOSURE SUBSYSTEM			
	MATERIAL:	DRAWN: PRA	DATE: 29JUL2014		SERVICE REFERENCE	CE	
	SEE BOM	ENG APPR:	DATE:	DWG NUMBER		REV. NO.	SHEET N
		BRD PROD APPR:	29JUL2014 DATE:	11	127-SP	6	1 OF

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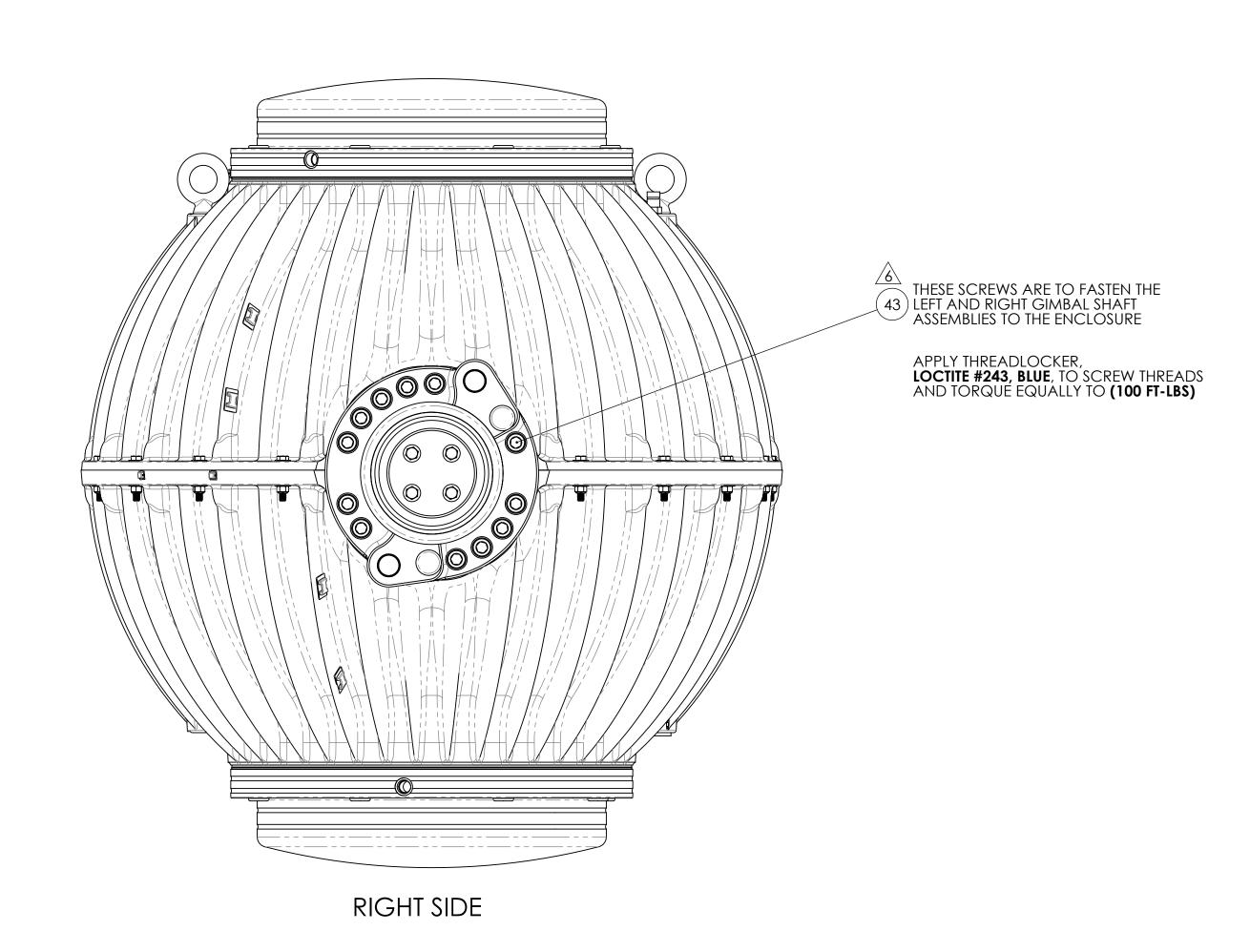


TOP VIEW OF ENCLOSURE





BOTTOM VIEW OF ENCLOSURE

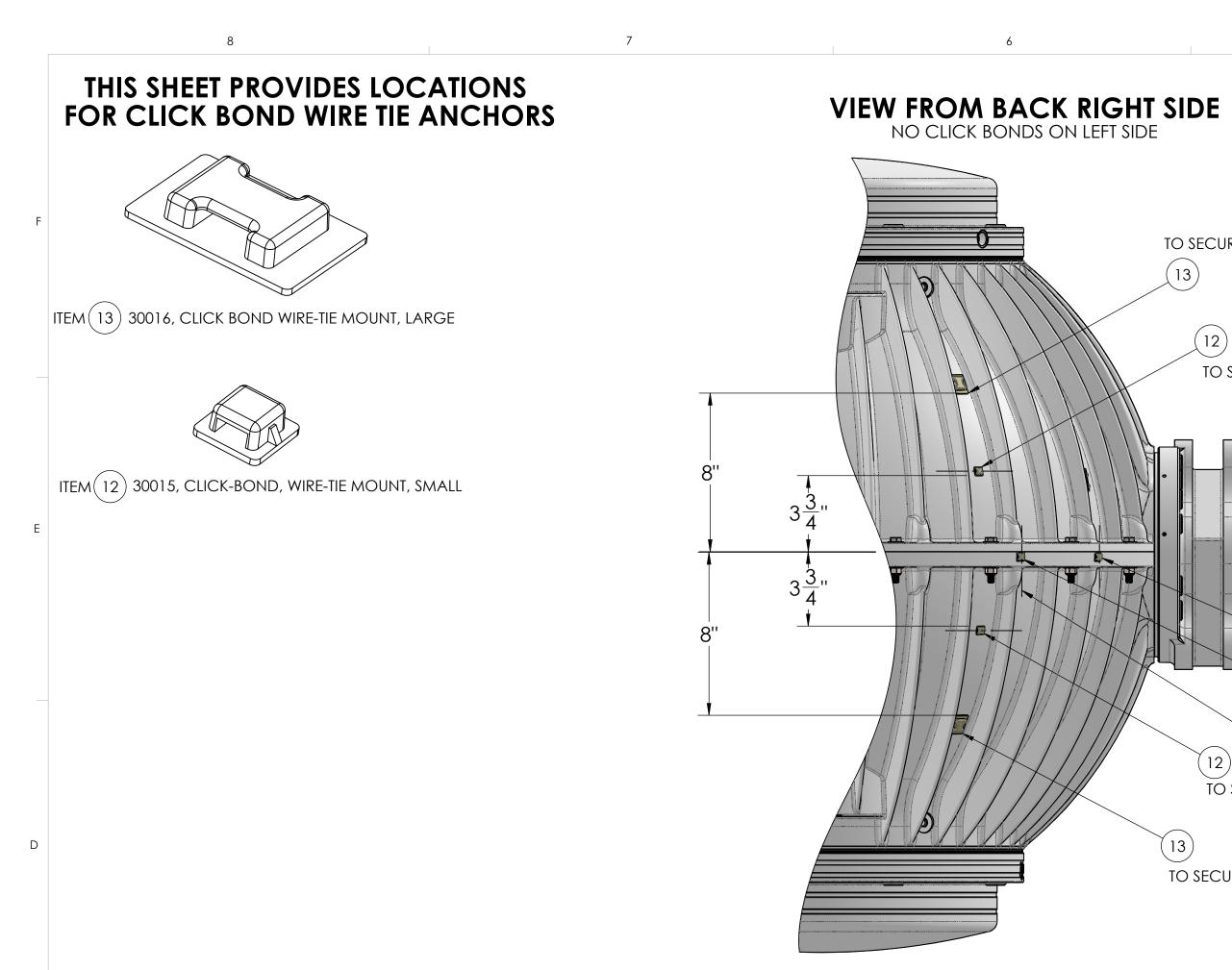


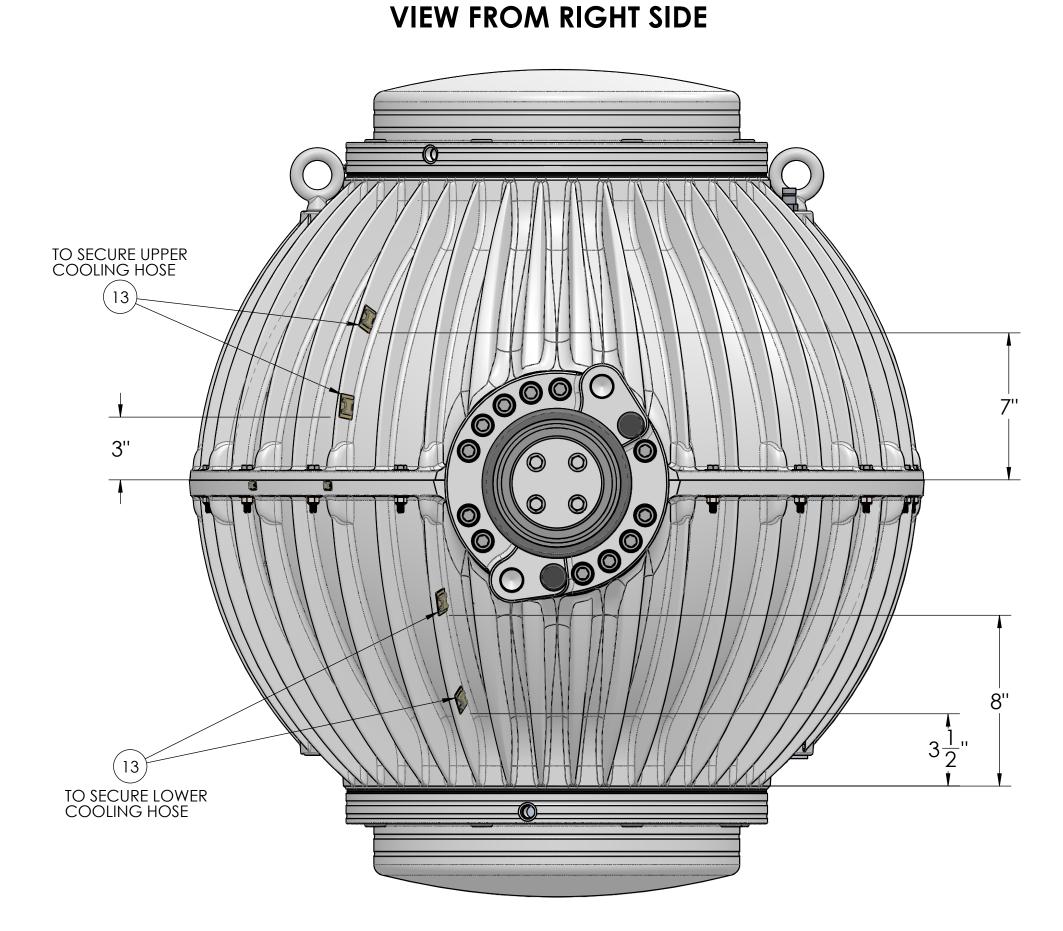
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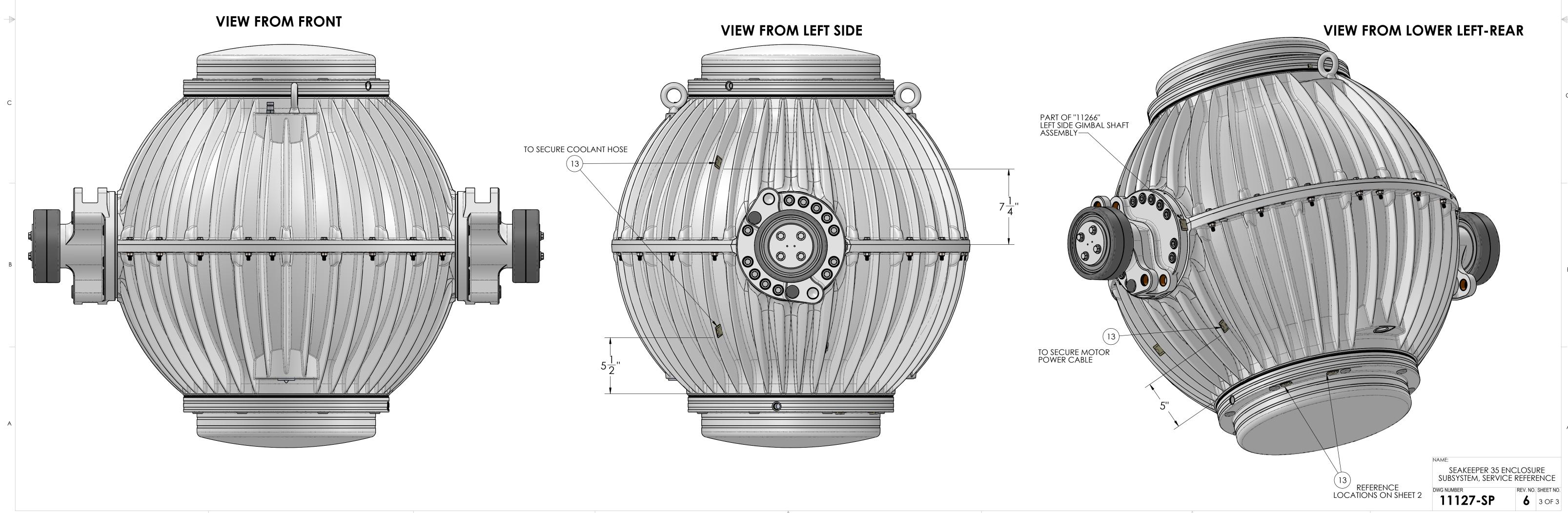
SEAKEEPER 35 ENCLOSURE
SUBSYSTEM, SERVICE REFERENCE

11127-SP

27-SP 6 2 OF 3







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—CABLE TIE ORIENTATION

TO SECURE WIRE HARNESS

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