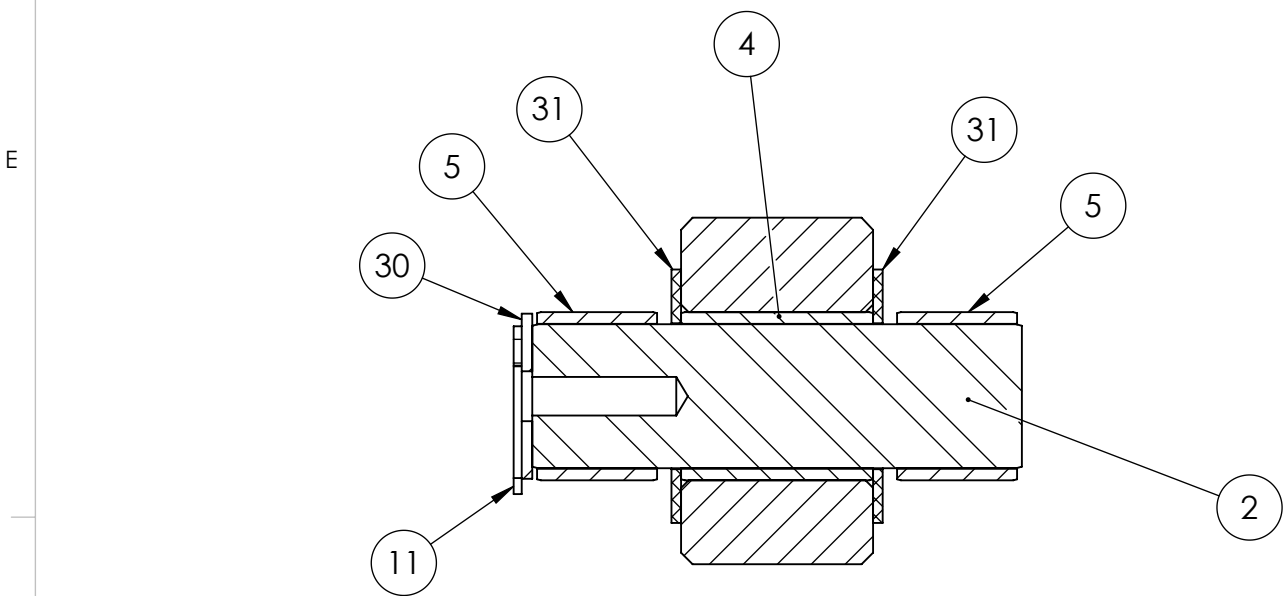


NOTES: 1) THIS DWG. REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE NG9 BRAKE SYSTEM BILL OF MATERIAL AND DOES NOT NECESSARILY REPRESENT THE ACTUAL ASSEMBLY PROCEDURE. THIS DWG DOES PROVIDE TECHNICAL INFORMATION REGARDING COMPONENT LOCATION, SUGGESTED HOSE ROUTING, AND FASTENER APPLICATION.

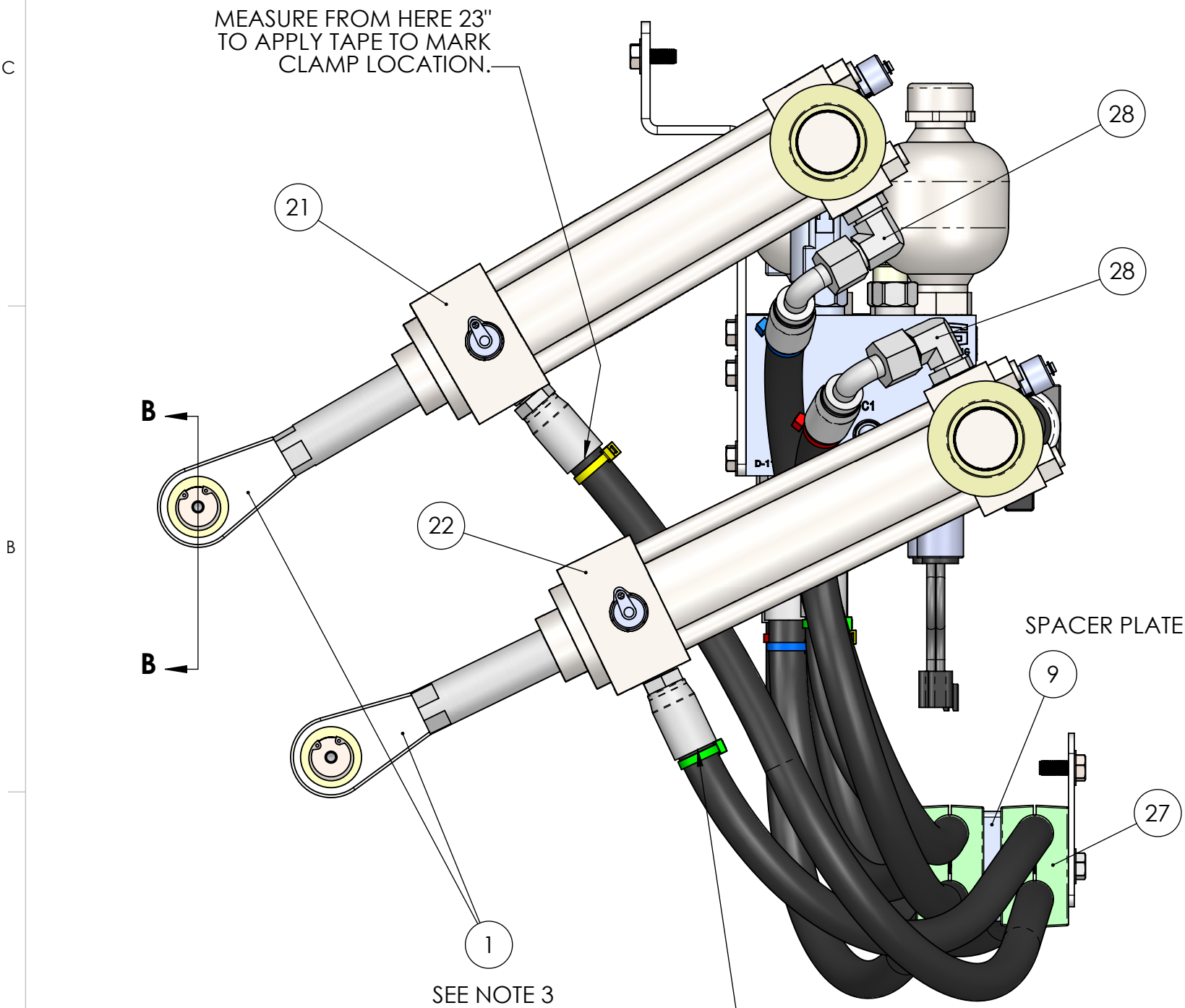
- 2) WHEN FILLING MANIFOLD WITH OIL, CHARGE TO A STATIC PRESSURE OF 235 - 245 PSI.
- 3) BEFORE INSTALLING ITEM 1 TO CYLINDER ROD, CLEAN THREADS ON BOTH COMPONENTS, FREE OF OIL AND DEBRIS. APPLY BLUE THREADLOCKER, ITEM 39 DURING ASSEMBLY OF THREADS.
- 4) HOSE CONNECTION PORTS ARE STAMPED NUMERICALLY 1 THRU 4 ON BOTTOM SIDE OF MANIFOLD. ACTUAL HOSE ROUTING MAY DIFFER FROM DRAWING.
- 5) APPLY THREADLOCKER ACCORDING TO SEAKEEPER WORK INSTRUCTION WI-085.

- 6) THE COLOR STANDARD FOR THE CABLE TIE HOSE MARKERS ARE AS FOLLOWS;
BLUE - UPPER CYLINDER, REAR TRUNNION END PORT - PORT #2 ON MANIFOLD
YELLOW - UPPER CYLINDER, FRONT ROD END PORT - PORT #1 ON MANIFOLD
RED - LOWER CYLINDER, REAR TRUNNION END PORT - PORT #3 ON MANIFOLD
GREEN - LOWER CYLINDER, FRONT ROD END PORT - PORT #4 ON MANIFOLD
APPLY MARKERS AT BOTH ENDS OF HOSE AS SHOWN BELOW.

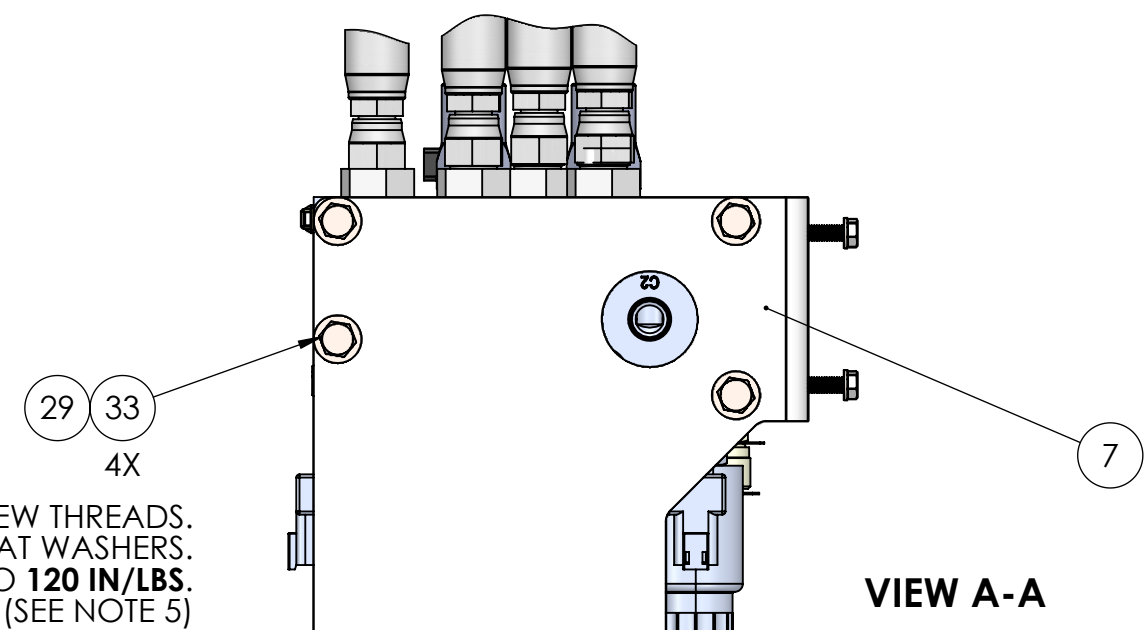


SECTION B-B
SCALE 1 : 1

APPLY THIN FILM OF BLUE ASSEMBLY GREASE, ITEM 38, TO OUTSIDE SURFACE OF ALL 4 BUSHINGS, WHEN FITTING BUSHINGS INTO CYLINDER BRACES. **DO NOT** APPLY GREASE TO INSIDE SURFACE OF BUSHINGS, OR TO SURFACE OF CYLINDER TRUNNION SHAFT.

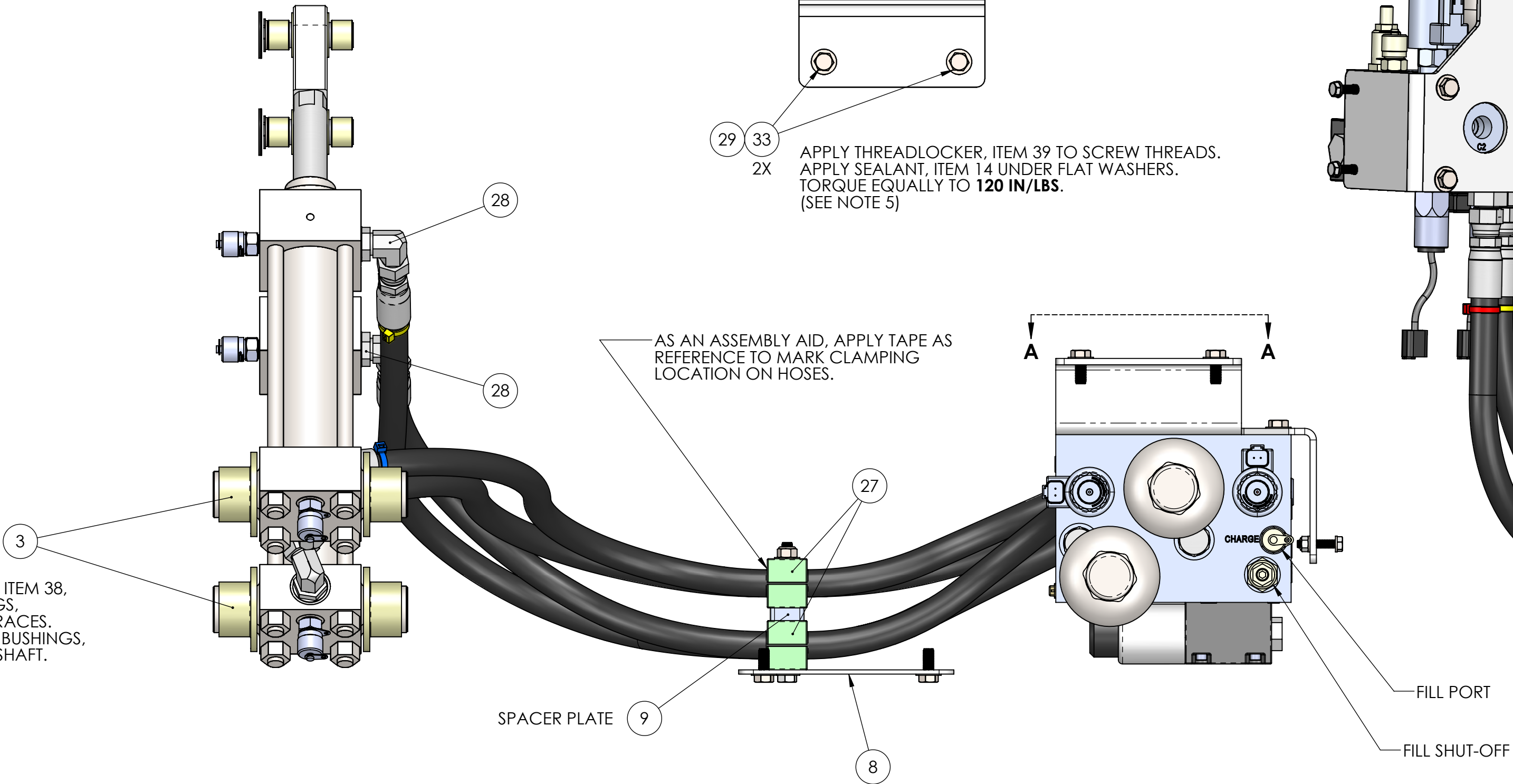


MEASURE FROM HERE 16-3/4" TO APPLY TAPE TO MARK CLAMP LOCATION.



APPLY THREADLOCKER, ITEM 39 TO SCREW THREADS. APPLY SEALANT, ITEM 14 UNDER FLAT WASHERS. TORQUE EQUALLY TO **120 IN/LBS.** (SEE NOTE 5)

APPLY THREADLOCKER, ITEM 39 TO SCREW THREADS. APPLY SEALANT, ITEM 14 UNDER FLAT WASHERS. TORQUE EQUALLY TO **120 IN/LBS.** (SEE NOTE 5)



AS AN ASSEMBLY AID, APPLY TAPE AS REFERENCE TO MARK CLAMPING LOCATION ON HOSES.

APPLY CLICKBOND ANCHOR FOR WIRE HARNESS

MEASURE FROM HERE 18" TO APPLY TAPE TO MARK CLAMP LOCATION ON TOP REAR HOSE, ITEM 20. MEASURE 17-1/2" FOR CLAMP LOCATION ON THE BOTTOM REAR HOSE, ITEM 21.

HOSE 50099 CONNECTS TO PORT #2 ON MANIFOLD

HOSE 50100 CONNECTS TO PORT #3 ON MANIFOLD

HOSE 50097 CONNECTS TO PORT #1 ON MANIFOLD

HOSE 50098 CONNECTS TO PORT #4 ON MANIFOLD

TORQUE TO **120 IN/LBS.**

APPLY THREADLOCKER, ITEM 39 TO BOLT THREADS. APPLY SEALANT, ITEM 14 UNDER FLAT WASHERS. TORQUE EQUALLY TO **120 IN/LBS.** (SEE NOTE 5)

USE STICK-ON VINYL COVERS AND DOUBLE SIDED STICK TAPE APPLIED TO CYLINDER BRACES TO COVER OPEN TRUNNION BUSHINGS.

USE STICK-ON COVER OVER GIMBAL SHAFT HOLE TO PROTECT SNAP-RING FROM CORROSION.

REV.	ECN NO.	ZONE	DESCRIPTION	DATE	APPROVED
1	0174		RELEASED FOR PRODUCTION	3/11/2014	RSK
2	0288	A3	ADDED COLORED HOSE MARKERS TO BOM	2/17/2015	RSK
3	0232	F1	REPLACED WHITE PLASTIC CAPS WITH STICK-ON VINYL COVERS	5/12/2015	SAC

39	70054	THREAD LOCKER, LOCTITE #243, BLUE	---	AR	NOTE 5
38	70021	GREASE, BLUE ASSEMBLY	---	AR	
37	60280	HEX HD CAP SCREW, M8-1.25 X 100mm LG. SS	316 SS	1	
36	60267	HEX NUT, NYLOK M8-1.2 SS	316 SS	1	
35	60262	HHCS M6-1.0 X 30mm LG	316 SS	2	
34	60255	HEX NUT, NYLOK M6-1.0	316 SS	2	
33	60246	HEX HD CAP SCREW M8-1.25 X 20mm LG. 316SS	316SS	8	
32	60223	FLAT WASHER M6 SCREW SIZE	316 SS	4	
31	60156	FLAT WASHER, 3/4", DELRIN	ACETAL PLASTIC	4	
30	60121	FLAT WASHER, .86 X .26 X .06	18-8 SS	2	
29	60003	WASHER, FLAT TYPE B NARROW 0.31	316 SS	10	
28	50106	ADAPTOR, -8 SAEORB TO -8 JIC M, 90 DEG	ZINC PLTD STEEL	4	
27	50101	PLASTIC HOSE CLAMP BODY	BLK POLYAMIDE	2	2
26	50100	SEAKEEPER 9 BRAKE HOSE ASSY, LOWER TRUNNION END	---	1	
25	50099	SEAKEEPER 9 HYDRAULIC HOSE ASSY, UPPER TRUNNION END	---	1	
24	50098	SEAKEEPER 9 HYDRAULIC HOSE ASSY, LOWER ROD END	---	1	
23	50097	SEAKEEPER 9 HYDRAULIC HOSE ASSY, UPPER ROD END	---	1	
22	50095	SEAKEEPER 9 LOWER BRAKE CYLINDER	---	1	
21	50093	SEAKEEPER 9 UPPER BRAKE CYLINDER	---	1	
20	40439	CABLE TIE, 50# X 7" LG, BLUE	NYLON	2	
19	40438	CABLE TIE, 50# X 7" LG, RED	NYLON	2	
18	40437	CABLE TIE, 50# X 7" LG, YELLOW	NYLON	2	
17	40436	CABLE TIE, 50# X 7" LG, GREEN	NYLON	2	
16	40413	VHB TAPE, 2" OD X 1-3/8" ID X .025 THK.	ARCRYLIC FOAM	4	
15	40412	COVER, 2" OD X .025 THK, BLACK	POLYETHYLENE	4	
14	40250	SILI-THANE 803 MARINE SEALANT	---	AR	
13	40244	VHB TAPE, 1.38" DIA., .025 THK	ADHESIVE FILM	2	
12	40243	COVER, 1-3/8" DIA. X .06 THK, BLACK	POLYETHYLENE	2	
11	40101	RETAINING RING, INTERNAL, .875	SS	2	
10	30015	SMALL CLICK BOND WIRE TIE ANCHOR	COMPOSITE	1	
9	11062	SEAKEEPER 9 HOSE CLAMP SPACER	ALUMINUM	1	
8	10876	SEAKEEPER 9 HYDRAULIC HOSE CLAMP BRACKET	5052 ALUM. SHT.	1	
7	10875	SEAKEEPER 9 BRAKE MANIFOLD BRACKET	5052 ALUM SHT	1	
6	10841	SEAKEEPER 9 HYDRAULIC BRAKE MANIFOLD	---	1	
5	10657	PTFE BUSHING .875 OD X .750 ID X .63 LG	COMPOSITE	4	
4	10656	PTFE BUSHING .875 OD X .750 ID X 1.00 LG	COMPOSITE	2	
3	10308	FLANGED TRUNNION BUSHING	N/A	4	
2	10306	BRAKE CRANK PIN	17-4PH	2	
1	10297	BRAKE CYLINDER ROD-END	1018 STEEL	2	

ITEM NO.	PART NO.	DESCRIPTION	MATERIAL	QTY	NOTE
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MATERIAL:	---	DATE:	24JUN13
ENG APPR:	RSK	DATE:	11MAR14
PROD APPR:	---	DATE:	---
WEIGHT - LBS :	---	DATE:	---

PROPRIETARY AND CONFIDENTIAL	PART TOLERANCE UNLESS OTHERWISE NOTED:	SEAKEEPER Inc.
THE INFORMATION CONTAINED IN THIS	FRACTIONAL: ±.015	44425 Pecan Court
DRAWING IS THE SOLE PROPERTY OF	DECIMAL XXX±.01"	Suite 151
SEAKEEPER INCORPORATED. ANY	ANGULAR X±.1°	California, MD 20619
REPRODUCTION IN PART OR AS A WHOLE	UNSPECIFIED THREADS ARE CLASS 2	
WITHOUT THE WRITTEN PERMISSION OF	UNSPECIFIED MACHINE SURFACE FINISH	
SEAKEEPER IS PROHIBITED.		
DRAWN:	DATE:	NAME:
SAC	24JUN13	SEAKEEPER 9 BRAKE SUB-
ENG APPR:	DATE:	SYSTEM SERVICE REFERENCE
RSK	11MAR14	
PROD APPR:	DATE:	DWG NUMBER:
---	---	10846-SP
		REV. NO. 3
		SHEET NO. 1 OF 1