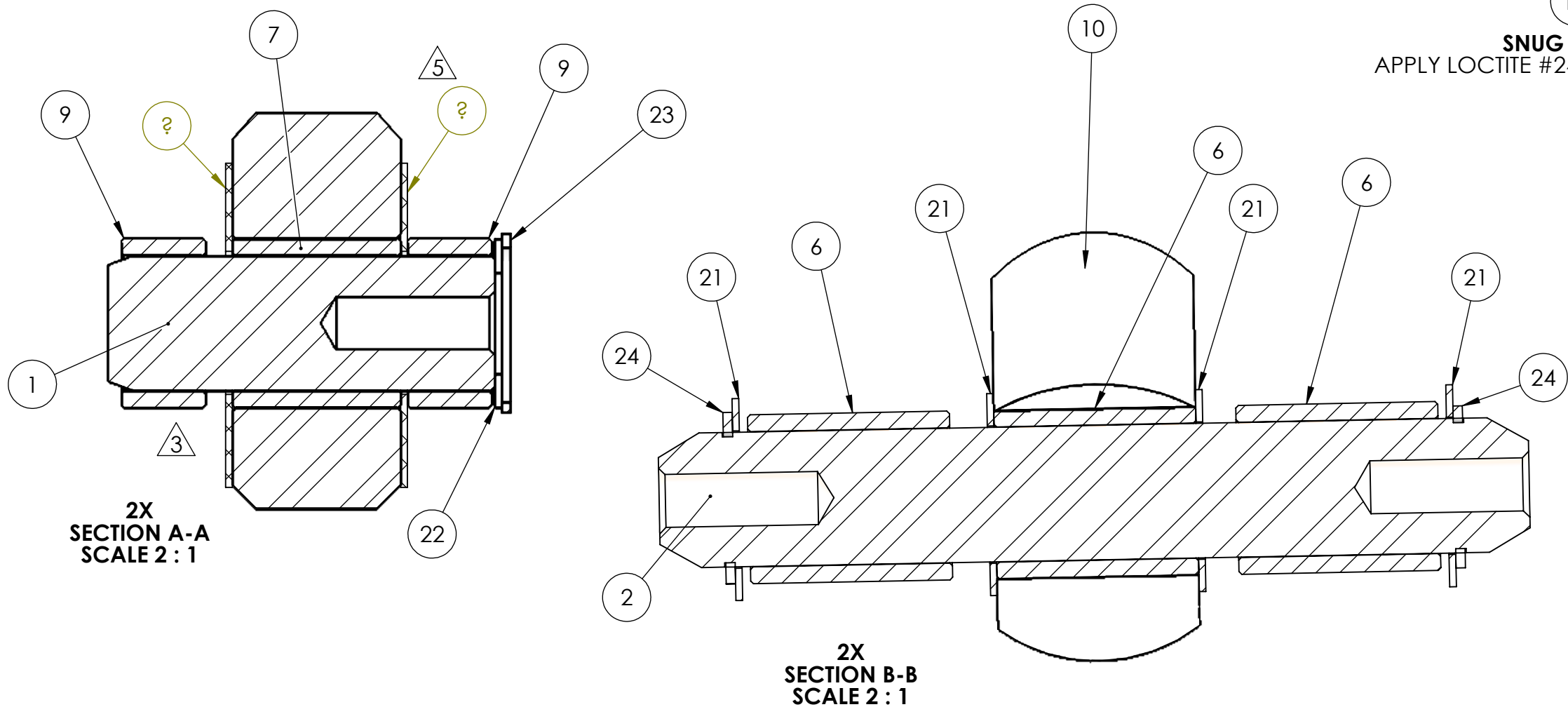


- NOTES:**
- 1) THIS DWG. REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE SK2 BRAKE SYSTEM BILL OF MATERIAL AND DOES NOT NECESSARILY REPRESENT THE ACTUAL ASSEMBLY PROCEDURE. THIS DWG DOES PROVIDE TECHNICAL INFORMATION REGARDING COMPONENT LOCATION, SUGGESTED HOSE ROUTING, AND FASTENER APPLICATION.
 - 2) WHEN FILLING MANIFOLD WITH OIL, CHARGE TO A STATIC PRESSURE OF **345 - 350 PSI**.
 - 3) BEFORE INSTALLING ITEM 7 TO CYLINDER ROD, CLEAN THREADS ON BOTH COMPONENTS, FREE OF OIL AND DEBRIS. APPLY BLUE THREADLOCKER, PART #70054, 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) THE COLOR STANDARD FOR THE CABLE TIE HOSE MARKERS ARE AS FOLLOWS;
BLUE - UPPER CYLINDERS, REAR TRUNNION END PORT - MANIFOLD PORT #1
YELLOW - UPPER CYLINDERS, FRONT ROD END PORT - MANIFOLD PORT #2
RED - LOWER CYLINDERS, REAR TRUNNION END PORT - MANIFOLD PORT #4
GREEN - LOWER CYLINDERS, FRONT ROD END PORT - MANIFOLD PORT #3
APPLY MARKERS AT BOTH ENDS OF HOSES AS SHOWN BELOW.

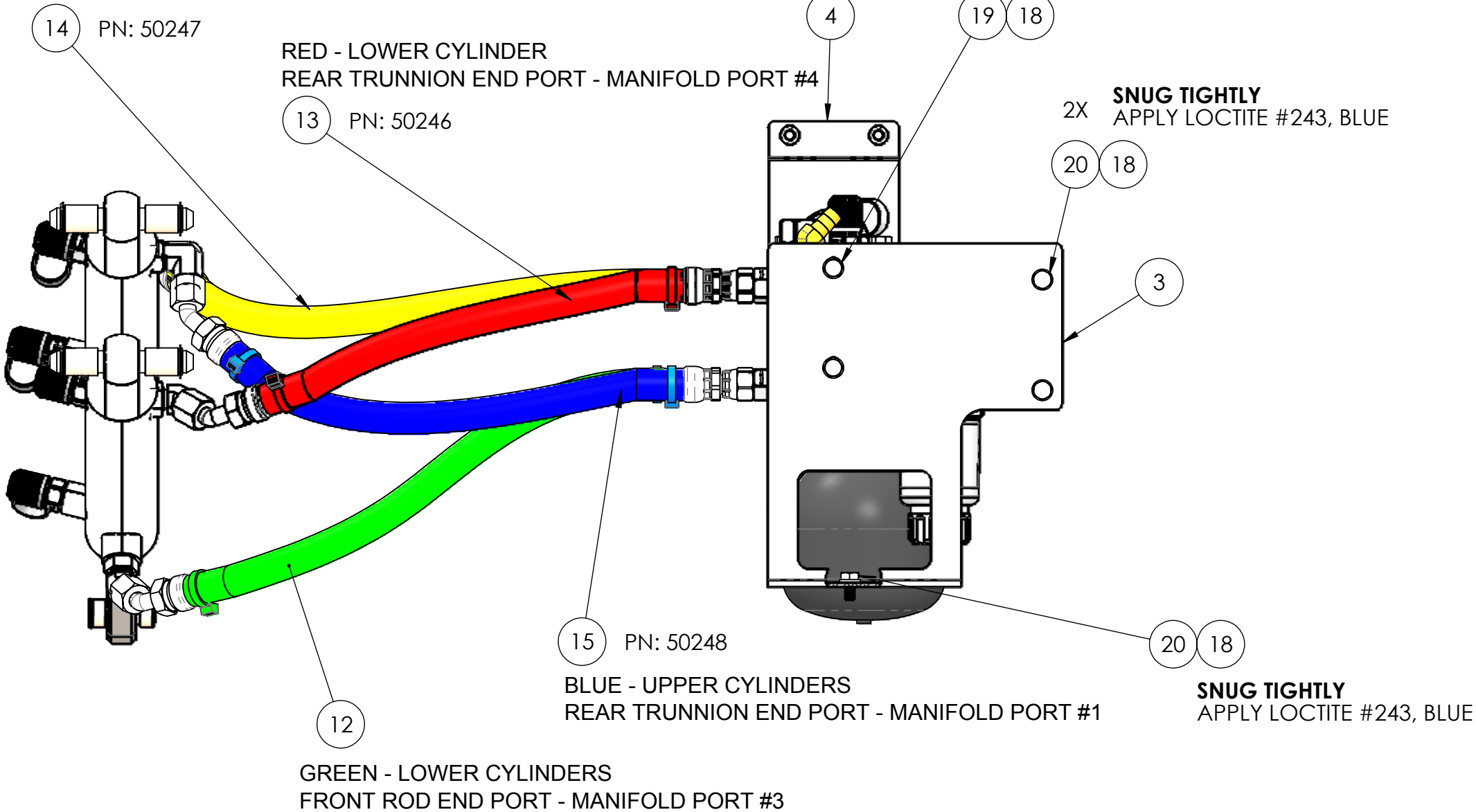


YELLOW - UPPER CYLINDER
FRONT ROD END PORT - MANIFOLD PORT #2

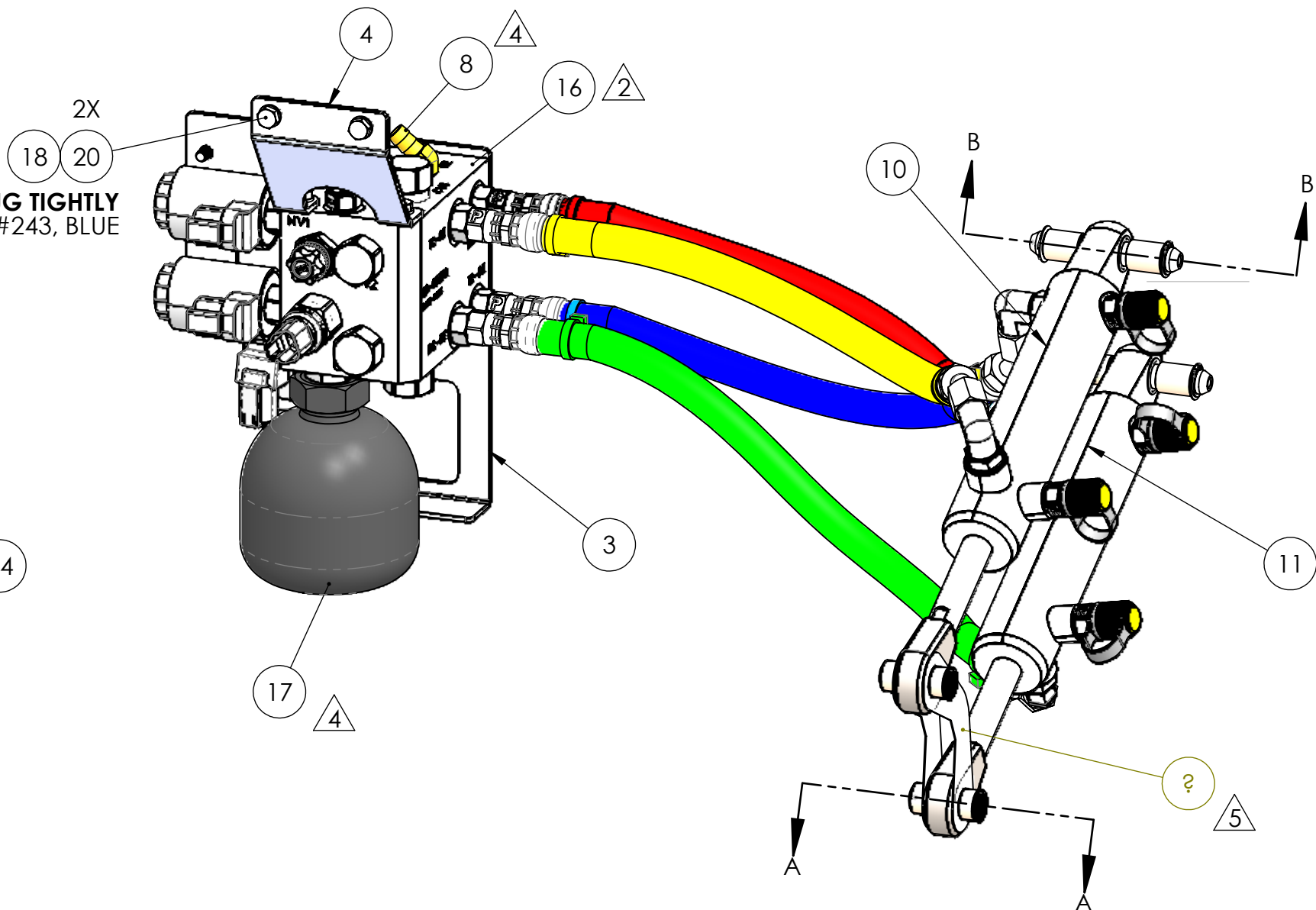
RED - LOWER CYLINDER
REAR TRUNNION END PORT - MANIFOLD PORT #4

SNUG TIGHTLY
APPLY LOCTITE #243, BLUE

2X SNUG TIGHTLY
APPLY LOCTITE #243, BLUE



REV NO.	ECN NO.	ZONE	DESCRIPTION	DATE	APPRVD.
1			RELEASED FOR PRODUCTION	3/29/2018	BEN
2	0621		BRAKE MANIFOLD ASS'Y REVISED WITH LARGER ACCUMULATOR, REVERSE FLOW CHECK BLOCKING VALVES, AND HIGHER FILL PRESSURE	6/11/2018	SAC
3	0667		STAINLESS STEEL THRUST WASHER REMOVED FROM BOTH SIDES OF BRAKE CYLINDER ROD ENDS.	9/5/2018	SAC
4	0702		ACCUMULATOR IS NOW ADDED AT ASSEMBLY, 45° COOLANT FITTING NOW ADDED AT ASSEMBLY	2/26/2019	SAC
5	713		ROD END THRUST WASHERS ADDED TO BOTH SIDES OF BRAKE CYLINDER ROD ENDS	5/24/19	BMK



25	70054	THREADLOCKER, LOCTITE #243, BLUE	1
24	60467	RETAINING RING, EXTERNAL .50 DIA. SHAFT	4
23	60466	RETAINING RING, INTERNAL .62 BORE	2
22	60465	SHIM WASHER, .62 OD X .38 ID X .025 THK	2
21	60464	SHIM WASHER, .75 OD X .50 ID X .025 THK	8
20	60294	SCREW, HEX HD CAP M6-1.0 X 12MM LG	5
19	60256	HEX HEAD CAP SCREW, M6-1.0 X 16mm LG	4
18	60223	WASHER, FLAT, M6 12MM OD	9
17	50273	ACCUMULATOR, 0.32 L, SAE-8 PORT	1
16	50249	SK2 MANIFOLD, RECTIFIED, NG6 PROP VALVE	1
15	50248	SEAKEEPER 2 HYDRAULIC HOSE ASSEMBLY, UPPER CYLINDER, CLEVIS END	1
14	50247	SEAKEEPER 2 HYDRAULIC HOSE ASSEMBLY, UPPER CYLINDER, ROD END	1
13	50246	SEAKEEPER 2 HYDRAULIC HOSE ASSEMBLY, LOWER CYLINDER, CLEVIS END	1
12	50245	SEAKEEPER 2 HYDRAULIC HOSE ASSEMBLY, LOWER CYLINDER, ROD END	1
11	50195	SK2 LOWER BRAKE CYLINDER ASSEMBLY	1
10	50194	SK2 UPPER BRAKE CYLINDER	1
9	40579	SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG	4
8	40482	HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW	1
7	40479	SK2 ROD END BUSHING, .63 X .50 X .63LG	2
6	40478	SK2 CLEVIS PIN BUSHING, .63 X .50 X .75 LG	6
5	12117	SEAKEEPER 2 ROD END THRUST SHIM	2
4	11555	SEAKEEPER 2 MANIFOLD SUPPORT BRACKET	1
3	11553	SEAKEEPER 2 REAR MANIFOLD PANEL	1
2	11548	SEAKEEPER 2 BRAKE CYLINDER PIN, REAR PIVOT	2
1	11547	SEAKEEPER 2 BRAKE CYLINDER ROD CLEVIS PIN	2
ITEM NO.	PART NO.	DESCRIPTION	QTY.

WEIGHT - LBS : ---		MATERIAL: ---		DRAWN: BEN		DATE: 10JAN2018		ENG APPR: DATE:		PROD APPR: DATE:		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SEAKEEPER INCORPORATED. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SEAKEEPER IS PROHIBITED.		SEAKEEPER Seakeeper Inc. 44425 Pecan Court, Suite 151 California, MD 20619		NAME: SEAKEEPER 2 BRAKE SUB-SYSTEM		DWG NUMBER 11863-SP		REV. NO. 5		SHEET NO. 1 OF 1	
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