

NOTES:

- 1) THIS DWG. REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE SK6 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) 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.
- 3) FIXED COOLING COLLARS **MUST** BE INSTALLED DURING THE FLYWHEEL SUB-SYSTEM BUILD, PRIOR TO FLYWHEEL BEARING INSTALLATION.

APPLY MARINE SEALANT UNDER FACE OF WASHERS WHERE CONTACT TO ENCLOSURE. ALWAYS USE NEW NYLOCK NUTS. TORQUE BOLTS TO 200 IN-LBS.

APPLY VACUUM GREASE TO O-RING.

APPLY MARINE SEALANT UNDER HEAD OF BOLTS. APPLY THREADLOCKER TO BOLT THREADS. TORQUE BOLTS TO 50 FT-LBS. BOTH SIDES

APPLY MARINE SEALANT UNDER FLAT WASHERS. TORQUE BOLTS TO 72 IN-LBS. BOTH SIDES

APPLY O-RING TO ENCLOSURE BEFORE ATTACHING GIMBAL SHAFT, REPEAT ON RIGHT SIDE

JUST BEFORE PUMP DOWN, INSERT ITEMS 25 AND 26, AND INSTALL PORT PLUG WITHIN 5 MINUTES.

DETAIL E
SECTION THROUGH
GIMBAL SHAFT
SCALE 1 : 1

REV NO.	ECN NO.	ZONE	DESCRIPTION	DATE	APPRVD.
1			RELEASED FOR PRODUCTION		
2	619		ADDED GIMBAL SHAFT O-RING SEAL, SHT 1 DETAIL E	24JUL2018	EMS

43	70054	THREADLOCKER, LOCTITE #243, BLUE	1
42	70001	VACUUM GREASE	1
41	60498	WASHER, WEDGE LOCK, M6, .256 ID X .43 OD	24
40	60494	SCREW, HEX HD FLANGE, 10-32 X .375	2
39	60486	STANDOFF, .38 HEX, 10-32 MALE X 10-32 FEMALE X 1.75 LG	2
38	60473	SCREW, HX HD CAP, M8-1.25 X 30MM LG	10
37	60471	SCREW, SKT HD CAP, M6-1.0 X 60MM LG	12
36	60470	SCREW, SKT HD CAP, M6-1.0 X 50MM LG	12
35	60468	SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9	26
34	60404	EYEBOLT, M10-1.5 X 20MM LG	2
33	60339	SCREW, SOCKET HD CAP M6-1.0 X 15MM GRD 10.9	12
32	60330	WASHER, FLAT DIN125 M8	20
31	60329	WASHER, HI COLLAR LOC DIN7980 M6	12
30	60328	WASHER, SPLIT LOC DIN127B M6	16
29	60267	HEX NUT, NYLOK M8-1.2 SS	10
28	60262	SCREW, HEX HD CAP, M6-1.0 X 30mm LG	16
27	60223	WASHER, FLAT, M6 12MM OD	16
26	40574	FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG	1
25	40518	DESICCANT, 10G PACKET	5
24	40516	O-RING, SIZE 025 .070 X 1.176 ID	2
23	40499	SK6 EQUATOR O-RING, OUTSIDE GROOVE	1
22	40498	SK6 EQUATOR O-RING, INSIDE GROOVE	1
21	40497	SK6 WATERJACKET O-RING	2
20	40496	SK6 COVER O-RING, OUTSIDE GROOVE	2
19	40495	SK6 COVER O-RING, INSIDE GROOVE	2
18	40491	SK6 LOWER WAVE SPRING	1
17	40490	SK6 UPPER WAVE SPRING	1
16	40448	O-RING, SIZE 2-263, VITON	2
15	40250	SILI-THANE 803 MARINE SEALANT	1
14	40004	VALVE, VACUUM PORT	1
13	30016	LARGE CLICK BOND WIRE TIE ANCHOR	11
12	30015	SMALL CLICK BOND WIRE TIE ANCHOR	10
11	11722	SK6 DESICCANT CONTAINMENT GUARD	1
10	11714	DESICCANT PORT PLUG	1
9	11709	SK6 GIMBAL SHAFT, NON-BRAKE SIDE SUB-ASSEMBLY	1
8	11708	SK6 BRAKE SIDE GIMBAL SHAFT SUB-ASSEMBLY	1
7	11647	SK6 UPPER FIXED COOLING COLLAR MACHINED	1
6	11643	SK6 LOWER FIXED COOLING COLLAR MACHINED	1
5	11634	SK6 WATER JACKET	2
4	11631	SK6 EXTERIOR BEARING RETAINER	2
3	11630	SK6 ENCLOSURE ASSEMBLY MACHINED, FINAL GRIND	1
2	11625	SK6 COVER FINISHED MACHINED	2
1	10961	SK5 WATER JACKET GASKET	2
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.


WEIGHT - LBS :
MATERIAL:

DATE: 14JULY2016
WHK
DATE:

DATE: 14JULY2016
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.

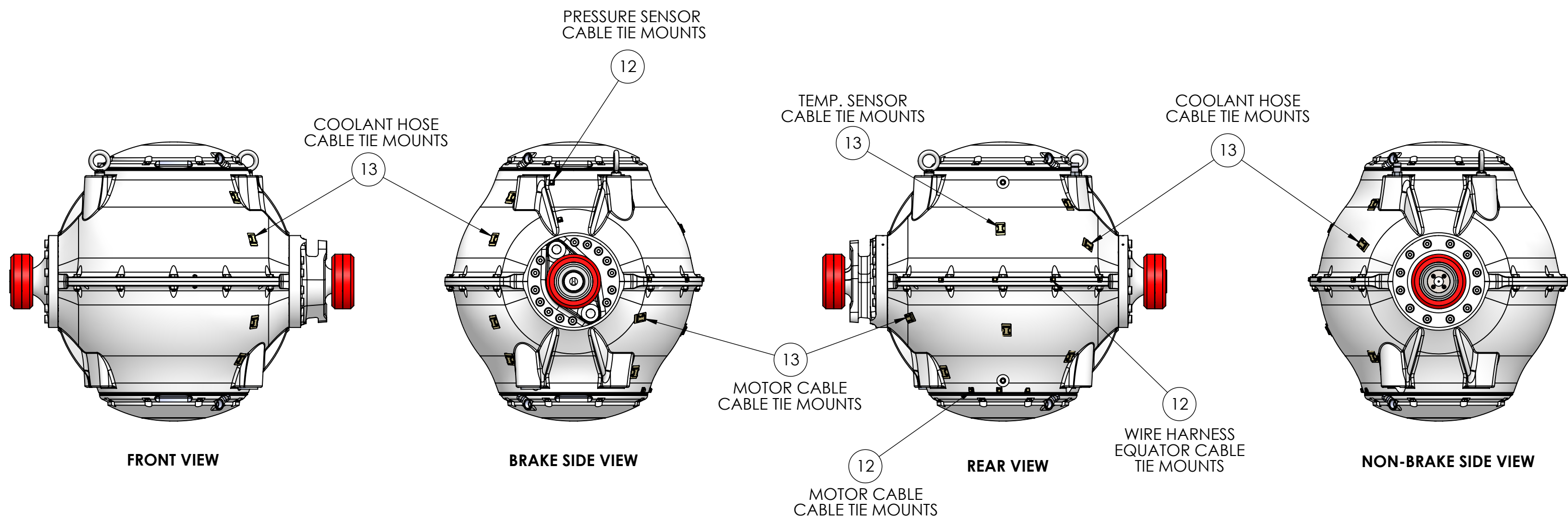


Seakeeper Inc. 44425 Pecan Court, Suite 151 California, MD 20619

NAME: SK6 / 5HD ENCLOSURE AND GIMBAL SHAFT SUB-SYSTEM SERVICE REFERENCE

DWG NUMBER 11681-SP

REV. NO. SHEET NO. 2 1 OF 2



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

WEIGHT - LBS : ---
MATERIAL:

DRAWN: WHK
ENG APPR: DATE: 14 JULY 2016
PROD APPR: DATE:

NAME: SK6 / 5HD ENCLOSURE AND GIMBAL SHAFT SUB-SYSTEM SERVICE REFERENCE

DWG NUMBER 11681-SP
REV. NO. SHEET NO. 2 2 OF 2