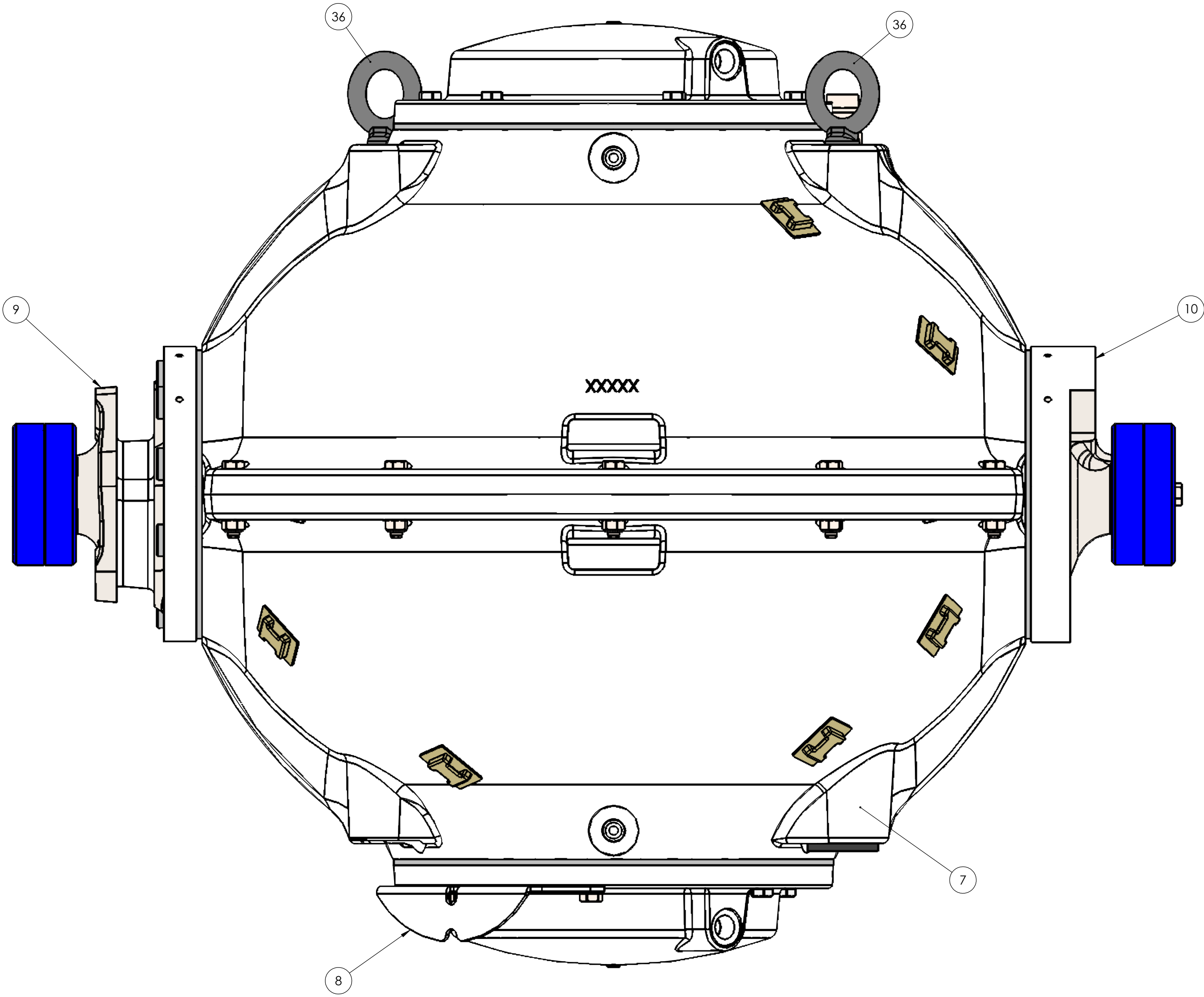



NOTES: 1) THIS DWG. REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE SEAKEEPER 2 GYRO ENCLOSURE BILL OF MATERIAL AND DOES NOT NECESSARILY REPRESENT THE ACTUAL ASSEMBLY PROCEDURE. THIS DWG DOES PROVIDE TECHNICAL INFORMATION REGARDING COMPONENT LOCATION AND FASTENER APPLICATION.  
2) BE SURE TO CLEAN ALL 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) APPLY THREADLOCKER ACCORDING TO SEAKEEPER WORK INSTRUCTION WI-085.



REV.	ECN NO.	ZONE	DESCRIPTION	DATE	APPROVED
1	---	---	RELEASED FOR PRODUCTION	15JAN2018	BEN
2	---	SH12: F5, C5, A5	CHANGED TORQUE VALUE ON GIMBAL SHAFT BOLTS FROM 35 FT-LBS TO 25 FT-LBS	11APR2018	DDG
3	---	SH12: F5, C5, A5	CHANGED GIMBAL SHAFT BOLT SIZE FROM M8 TO M10; CHANGED BOLT TORQUE FROM 25 FT-LBS TO 60 FT-LBS	25APR2018	DDG
4	---	SH12: F5, C5, A5	REDUCE GIMBAL SHAFT BOLT TORQUE TO 30 FT-LBS	07MAY2018	DDG
5	0872	SH12: A1, C1, F1	ADDED WATER JACKET SEALING WASHERS. INCREASED WATER JACKET BOLT TORQUE TO 90 IN-LBS. ADJUSTED WATER JACKET BOLT LENGTHS FOR DEPTH CLEARANCE.	05FEB2021	DDG
6	0912	---	REVISED EQUATOR HARDWARE AND ASSEMBLY PROCESS	28APR2022	GRR

43	70054	THREADLOCKER, LOCTITE #243, BLUE	1
42	70001	DOW CORNING, HIGH VACUUM GREASE	1
41	60631	WASHER, FLAT SEALING M6 SS	32
40	60576	SCREW, SKT HD CAP, M10-1.5 X 16MM LG	14
39	60552	SCREW, SOCKET HD CAP, M4-.7 X 12MM LG, FULL TD BLK OXIDE CLASS 12.9	12
38	60550	WASHER, WEDGE LOCK M4, .171D X .30 OD, ALUM ZNC PLTD STEEL	24
37	60468	SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9	2
36	60463	LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH	2
35	60462	SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9	12
34	60459	SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9	16
33	60411	WASHER, HI COLLAR SPLIT LOC, M4 10.9	16
32	60410	WASHER, FLAT M4, 10.9	16
31	60338	SCREW, SKT HD CAP, M4-.7 X 10mm LG	2
30	60321	SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD	10
29	60262	SCREW, HEX HD CAP, M6-1.0 X 30mm LG	2
28	60255	HEX NUT, NYLOK M6-1.0	10
27	60222	SCREW, HEX HD CAP M6-1.0 X 35MM 316SS	10
26	60035	WASHER, SPLIT LOC DIN7980, M4	2
25	40588	O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK	2
24	40587	O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK	2
23	40574	FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG	1
22	40518	DESICCANT, 10G PACKET	4
21	40476	SEAKEEPER 2 LOWER WAVE SPRING	1
20	40475	SEAKEEPER 2 UPPER WAVE SPRING	1
19	40473	O-RING, SIZE SAE-164, VITON	2
18	40472	O-RING, SAE-017	2
17	40471	O-RING, SIZE SAE-166, VITON	4
16	40470	O-RING, SK2 OUTSIDE EQUATOR CUSTOM, VITON	1
15	40250	SILI-THANE 803 MARINE SEALANT	1
14	40189	O-RING, .139 DIA X 15.955 ID	1
13	40142	O-RING, SIZE 024 A75 DUROMETER	2
12	40004	VALVE, VACUUM PORT	1
11	30016	LARGE CLICK BOND WIRE TIE ANCHOR	10
10	11877	SK2 NON-BRAKE SIDE GIMBAL SHAFT SUBASSEMBLY	1
9	11876	SK2 BRAKE SIDE GIMBAL SHAFT SUBASSEMBLY	1
8	11839	SEAKEEPER 2 MOTOR CABLE GUARD	1
7	11801	SEAKEEPER 2 ENCLOSURE, FINAL GRIND	1
6	11762	DESICCANT PORT PLUG, 1.25 PORT SIZE	1
5	11538	SEAKEEPER 2 WATER JACKET, FINISH MACHINED	2
4	11536	SEAKEEPER 2 COOLING COVER, FINISH MACHINED	2
3	11524	SEAKEEPER 2 UPPER & LOWER EXTERIOR BEARING RETAINER	2
2	11507	SEAKEEPER 2 UPPER FIXED COOLING COLLAR, FINISH MACHINED	1
1	11505	SEAKEEPER 2 LOWER FIXED COOLING COLLAR, FINISH MACHINED	1
ITEM NO.	PART NO.	DESCRIPTION	QTY.

		<b><u>PROPRIETARY AND CONFIDENTIAL</u></b>		 <b>SEAKEEPER®</b>	
		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	
WEIGHT - LBS : ---				NAME:	SEAKEEPER 2 ENCLOSURE AND GIMBAL SHAFT SUB-SYSTEM SERVICE REFERENCE
MATERIAL: ---	DRAWN: BEN	DATE: 10JAN2018		DWG NUMBER	
	ENG APPR: ---	DATE: ---		<b>11860-SP</b>	REV. NO.   SHEET NO. <b>6</b>   1 OF 2
	PROD APPR: ---	DATE: ---			



