NOTES: 1) THIS DWG PROVIDES 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.

4) APPLY VACUUM GREASE SPARINGLY TO O-RING OPENING PRIOR TO INSTALLING THE VACUUM SERVICE VALVE. EXCESSIVE GREASE WILL CAUSE THE O-RING TO PROTRUDE OUTSIDE THE OPENING AND BE PINCHED.

5) USE HYDRAULIC PRESS TO INSTALL GIMBAL BEARING ONTO SHAFT. PRESS ONLY ON INSIDE BEARING RACE UNTIL SEATED AGAINST JOURNAL SHOULDER.

			2X 48	APPLY SILI-THANE MARINE SEALANT UNDER ALL FLAT WASHERS. DO NOT RE-USE NYLOCK HEX NUTS, ALWAYS USE NEW. TORQUE ALL BOLTS EQUALLY TO 72 IN-LBS.
				NO VACUUM GREASE IS REQUIRED
		XXXXX		
NO VACUUM GREASE IS REQUIRED				
	12	8		

54       7         53       6         52       6         51       6         50       6         49       6         48       6         47       6         46       6         43       6         41       6         40       6         39       6         38       6         37       6         36       6         35       2         34       2         31       2         32       2         31       2         29       2         28       2         27       2         24       2         24       2         24       2         24       2         24       2	40574 40518 40482 40476	LOCTITE, THREAD SEALANT 564, 50ml TUBE  DOW CORNING, HIGH VACUUM GREASE  WASHER, FLAT SEALING M6 SS  SCREW, SKT HD CAP, M10-1.5 X 16MM LG  SCREW, SOCKET HD CAP, M47 X 12MM LG, FULL TD BLK OXIDE CLASS 12.9  WASHER, WEDGE LOCK M4, .17ID X .30 OD, ALUM ZNC PLTD STEEL  SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9  LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH  SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9  SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9  WASHER, HI COLLAR SPLIT LOC, M4 10.9  WASHER, HI COLLAR SPLIT LOC, M4 10.9  SCREW, SKT HD CAP, M47 X 10mm LG  SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING  SEAKEEPER 2 UPPER WAVE SPRING	AR AR 12 14 12 24 2 12 24 16 2 10 2 10 20 10 2 2 4 1 4 4 1
53	60631 60576 60552 60550 60468 60463 60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	WASHER, FLAT SEALING M6 SS SCREW, SKT HD CAP, M10-1.5 X 16MM LG SCREW, SOCKET HD CAP, M47 X 12MM LG, FULL TD BLK OXIDE CLASS 12.9 WASHER, WEDGE LOCK M4, .17ID X .30 OD, ALUM ZNC PLTD STEEL SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9 LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9 SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 WASHER, FLAT M4, 10.9 SCREW, SKT HD CAP, M47 X 10mm LG SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD SCREW, HEX HD CAP, M6-1.0 X 30mm LG HEX HEAD CAP SCREW, M6-1.0 X 16mm LG HEX NUT, NYLOK M6-1.0 WASHER, FLAT, M6 12MM OD SCREW, HEX HD CAP M6-1.0 X 35MM 316SS WASHER, SPLIT LOC DIN7980. M4 O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	12 14 12 24 2 2 12 24 16 2 10 2 10 2 2 2 2 4 1 1 4 4
52 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6	60576 60552 60550 60468 60463 60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, SKT HD CAP, M10-1.5 X 16MM LG SCREW, SOCKET HD CAP, M47 X 12MM LG, FULL TD BLK OXIDE CLASS 12.9 WASHER, WEDGE LOCK M4, .17ID X .30 OD, ALUM ZNC PLTD STEEL SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9 LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9 SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 WASHER, FLAT M4, 10.9 SCREW, SKT HD CAP, M47 X 10mm LG SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD SCREW, HEX HD CAP, M6-1.0 X 30mm LG HEX HEAD CAP SCREW, M6-1.0 X 16mm LG HEX NUT, NYLOK M6-1.0 WASHER, FLAT, M6 12MM OD SCREW, HEX HD CAP M6-1.0 X 35MM 316SS WASHER, SPLIT LOC DIN7980. M4 O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	14 12 24 2 12 24 16 2 10 20 10 20 2 4 1 4 4
51 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6	60552 60550 60468 60463 60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, SOCKET HD CAP, M47 X 12MM LG, FULL TD BLK OXIDE CLASS 12.9 WASHER, WEDGE LOCK M4, .17ID X .30 OD, ALUM ZNC PLTD STEEL SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9 LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9 SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 SCREW, SKT HD CAP, M47 X 10mm LG SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD SCREW, HEX HD CAP, M6-1.0 X 30mm LG HEX HEAD CAP SCREW, M6-1.0 X 16mm LG HEX NUT, NYLOK M6-1.0 WASHER, FLAT, M6 12MM OD SCREW, HEX HD CAP M6-1.0 X 35MM 316SS WASHER, SPLIT LOC DIN7980. M4 O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	12 24 2 12 24 24 16 2 10 2 10 20 10 2 2 4 1 4 4
50	60550 60468 60463 60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	WASHER, WEDGE LOCK M4, .17ID X .30 OD, ALUM ZNC PLTD STEEL SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9 LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9 SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 SCREW, SKT HD CAP, M47 X 10mm LG SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD SCREW, HEX HD CAP, M6-1.0 X 30mm LG HEX NUT, NYLOK M6-1.0 X 16mm LG HEX NUT, NYLOK M6-1.0 WASHER, FLAT, M6 12MM OD SCREW, HEX HD CAP M6-1.0 X 35MM 316SS WASHER, SPLIT LOC DIN7980. M4 O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	24 2 2 12 24 24 16 2 10 2 10 2 2 2 2 4 1 4 4
49	60468 60463 60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9 LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9 SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9 WASHER, HI COLLAR SPLIT LOC, M4 10.9 WASHER, FLAT M4, 10.9 SCREW, SKT HD CAP, M47 X 10mm LG SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD SCREW, HEX HD CAP, M6-1.0 X 30mm LG HEX NUT, NYLOK M6-1.0 X 16mm LG HEX NUT, NYLOK M6-1.0 WASHER, FLAT, M6 12MM OD SCREW, HEX HD CAP M6-1.0 X 35MM 316SS WASHER, SPLIT LOC DIN7980. M4 O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	2 2 12 24 16 2 10 2 10 20 10 2 2 2 4 1 4 4
48	60463 60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH  SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9  SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9  WASHER, HI COLLAR SPLIT LOC, M4 10.9  WASHER, FLAT M4, 10.9  SCREW, SKT HD CAP, M47 X 10mm LG  SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	2 12 24 16 2 10 2 1 10 20 10 2 2 2 4 1 4 4
47	60462 60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9  SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9  WASHER, HI COLLAR SPLIT LOC, M4 10.9  WASHER, FLAT M4, 10.9  SCREW, SKT HD CAP, M47 X 10mm LG  SCREW, HEX HD CAP, M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	12 24 24 16 2 10 2 10 20 10 2 2 2 4 1 4 4
46	60459 60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9  WASHER, HI COLLAR SPLIT LOC, M4 10.9  WASHER,FLAT M4, 10.9  SCREW, SKT HD CAP, M47 X 10mm LG  SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	24 24 16 2 10 2 1 10 20 10 2 2 2 2 4 1 4 4
45	60411 60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	WASHER, HI COLLAR SPLIT LOC, M4 10.9  WASHER,FLAT M4, 10.9  SCREW, SKT HD CAP, M47 X 10mm LG  SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	24 16 2 10 2 1 10 20 10 2 2 2 4 1 4 4
44	60410 60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	WASHER, FLAT M4, 10.9  SCREW, SKT HD CAP, M47 X 10mm LG  SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	16 2 10 2 1 10 20 10 2 2 2 4 1 4 4
43	60338 60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, SKT HD CAP, M47 X 10mm LG SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD SCREW, HEX HD CAP, M6-1.0 X 30mm LG HEX HEAD CAP SCREW, M6-1.0 X 16mm LG HEX NUT, NYLOK M6-1.0 WASHER, FLAT, M6 12MM OD SCREW, HEX HD CAP M6-1.0 X 35MM 316SS WASHER, SPLIT LOC DIN7980. M4 O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	2 10 2 1 10 20 10 2 2 2 4 1 4 4
42	60321 60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD  SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	10 2 1 10 20 10 2 2 2 4 1 4 4
41 6 40 6 39 6 38 6 37 6 36 6 35 2 34 2 31 2 31 2 30 2 29 2 28 2 27 26 2 24 23 2	60262 60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, HEX HD CAP, M6-1.0 X 30mm LG  HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	2 1 10 20 10 2 2 2 4 1 4 4
40 6 39 6 38 6 37 6 36 6 35 2 34 2 31 2 31 2 29 2 28 2 27 2 26 2 24 2 23 2	60256 60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	HEX HEAD CAP SCREW, M6-1.0 X 16mm LG  HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	1 10 20 10 2 2 2 4 1 4 4
39 6 38 6 37 6 36 6 35 2 34 2 33 2 31 2 30 2 29 2 28 2 27 2 26 2 24 2 23 2	60255 60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	HEX NUT, NYLOK M6-1.0  WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	10 20 10 2 2 2 4 1 4 4
38	60223 60222 60035 40588 40587 40579 40574 40518 40482 40476	WASHER, FLAT, M6 12MM OD  SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	20 10 2 2 2 4 1 4
37 6 36 6 35 2 4 33 2 4 33 2 4 4 2 4 2 4 2 3 4 4 2 4 2	60222 60035 40588 40587 40579 40574 40518 40482 40476	SCREW, HEX HD CAP M6-1.0 X 35MM 316SS  WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	10 2 2 2 4 1 4 4
36 6 6 35 2 4 33 2 4 33 2 4 33 2 4 2 4 2 4 2 3 4 4 2 4 2	60035 40588 40587 40579 40574 40518 40482 40476	WASHER, SPLIT LOC DIN7980. M4  O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK  O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK  SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31 LG  FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	2 2 2 4 1 4 4
35	40588 40587 40579 40574 40518 40482 40476	O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31 LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	2 2 4 1 4 4
34	40587 40579 40574 40518 40482 40476	O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	2 4 1 4 4
33	40579 40574 40518 40482 40476	SK2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	4 1 4 4
32	40574 40518 40482 40476	FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG  DESICCANT, 10G PACKET  HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW  SEAKEEPER 2 LOWER WAVE SPRING	1 4 4
31	40518 40482 40476	DESICCANT, 10G PACKET HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	4 4
30	40482 40476	HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW SEAKEEPER 2 LOWER WAVE SPRING	4
29	40476	SEAKEEPER 2 LOWER WAVE SPRING	
28			1
27	40475	CEAVEEDED O LIDDED WAVE CODING	
26			1
25 4 24 4 23 4		O-RING, SIZE SAE-164, VITON	2
24 22 23		O-RING, SAE-017	2
23 4		O-RING, SIZE SAE-166, VITON	4
		O-RING, SK2 OUTSIDE EQUATOR CUSTOM, VITON	1
22 + 1		O-RING, SIZE #020 .070 X .864 ID	2
		SEAKEEPER 3 GIMBAL BEARING	2
		EXTERNAL RETAINING RING, 1 INCH SHAFT	1
		SILI-THANE 803 MARINE SEALANT	1
		O-RING, .139 DIA X 15.955 ID	1
		O-RING, SIZE 024 A75 DUROMETER	2
		COOLANT HOSE, 3/8" ID X 20 1/4"	1
		HOSE CLAMP SIZE -04, .31 BAND WIDTH, 301SS	2
_		VALVE, VACUUM PORT	10
		LARGE CLICK BOND WIRE TIE ANCHOR	10
	12566	SEAKEEPER 2 FLYWHEEL ASSEMBLY	1
		SEAKEEPER 2 MOTOR CABLE GUARD	1
	11801	SEAKEEPER 2 ENCLOSURE, FINAL GRIND	1
	11762 11544	DESICCANT PORT PLUG, 1.25 PORT SIZE SEAKEEPER 2 GIMBAL BEARING ISOLATION BUSHING	1
			4
	11538	SEAKEEPER 2 WATER JACKET, FINISH MACHINED	2
	11536	SEAKEEPER 2 COOLING COVER, FINISH MACHINED  SEAKEEPER 2 UPPER & LOWER EXTERIOR BEARING RETAINER	2
	11524		
	11523	SEAKEEPER 2 GIMBAL SHAFT, NON-BRAKE SIDE	1
	11521	SEAKEEPER 2 GIMBAL SHAFT, BRAKE SIDE	1
	11507 11505	SEAKEEPER 2 UPPER FIXED COOLING COLLAR, FINISH MACHINED	1
2 1	1 1 51 15	SEAKEEPER 2 LOWER FIXED COOLING COLLAR, FINISH MACHINED	1 1

REV. ECN NO. ZONE DESCRIPTION

1 0906 --- RELEASED FOR PRODUCTION

DATE APPROVED 07/14/2021 TMD

DRAWN: DATE: SHAFT ...

TMD 28APR2021
ENG APPR: DATE: DWG NUMBER
EMS 27MAR2021
PROD APPR: DATE: 1

MATERIAL:

3

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.

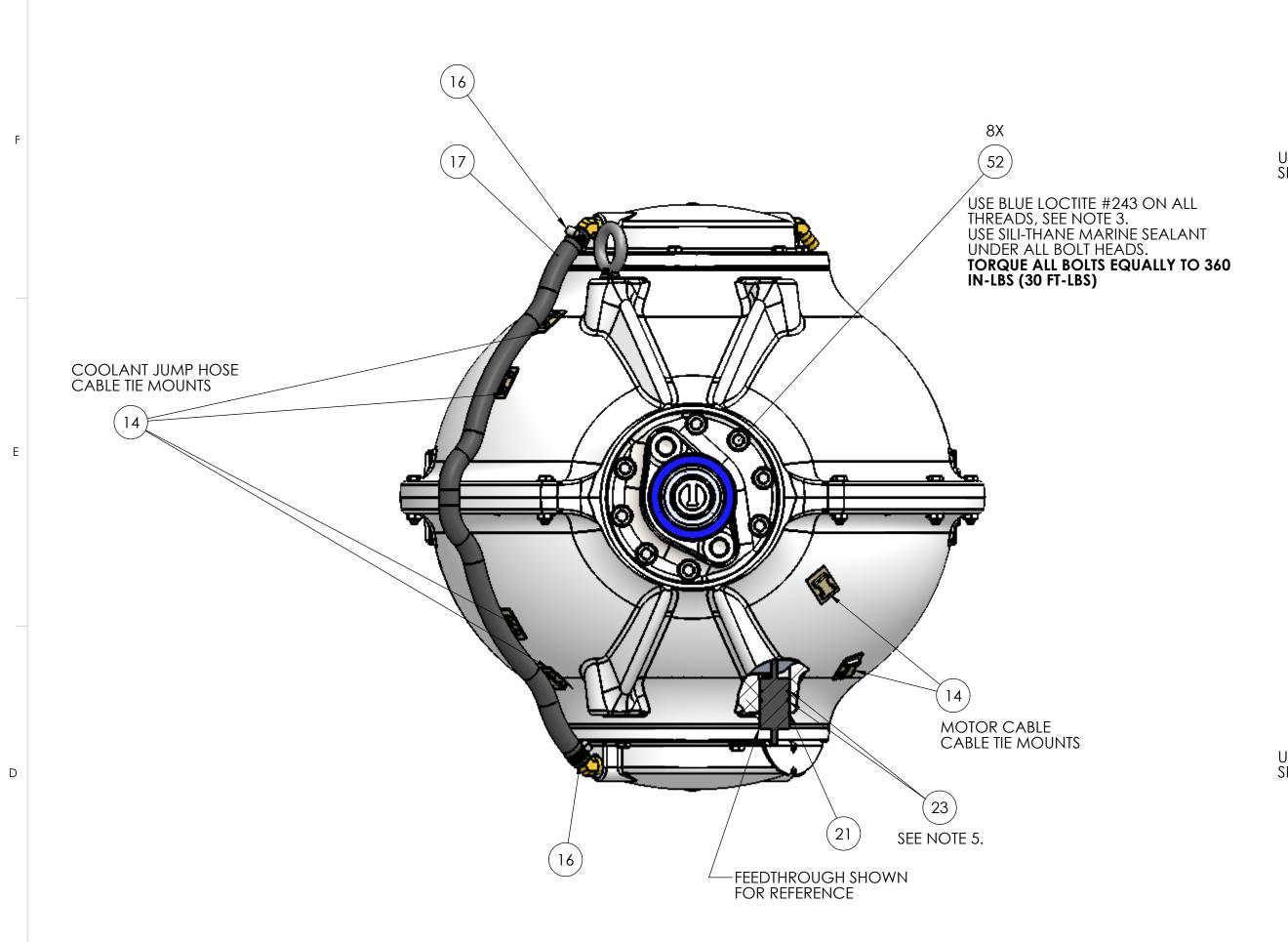
Seakeeper Inc. 44425 Pecan Court, Suite 151 California, MD 20619

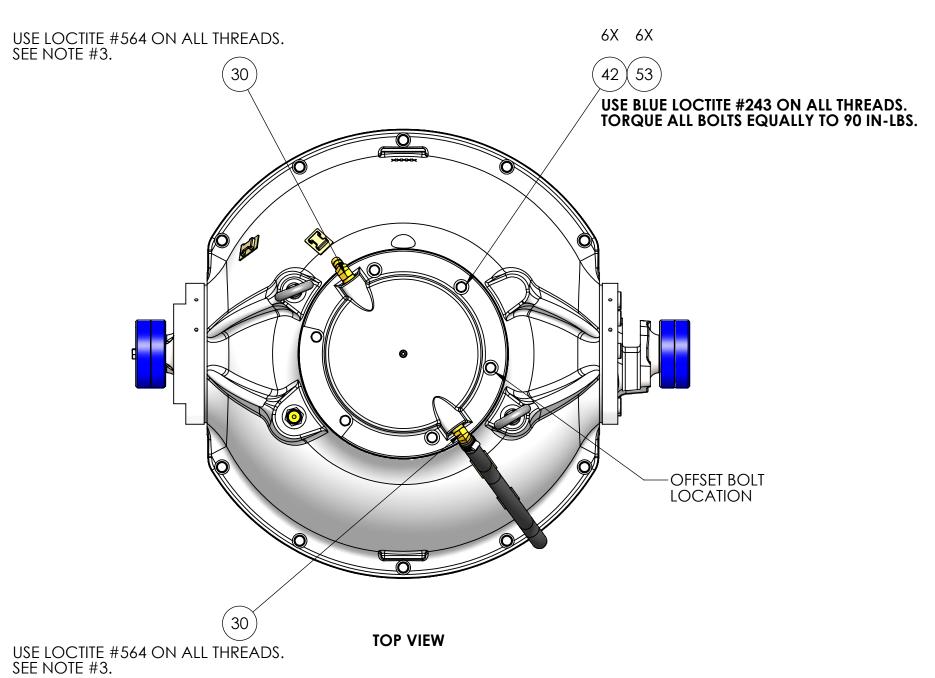
NAME:

SEAKEEPER 2 ENCLOUSURE AND GIMBAL

SEAKEEPER 2 ENCLOUSURE AND GIMBAL SHAFT ASSEMBLY, SERVICE REFERENCE

12567-SP



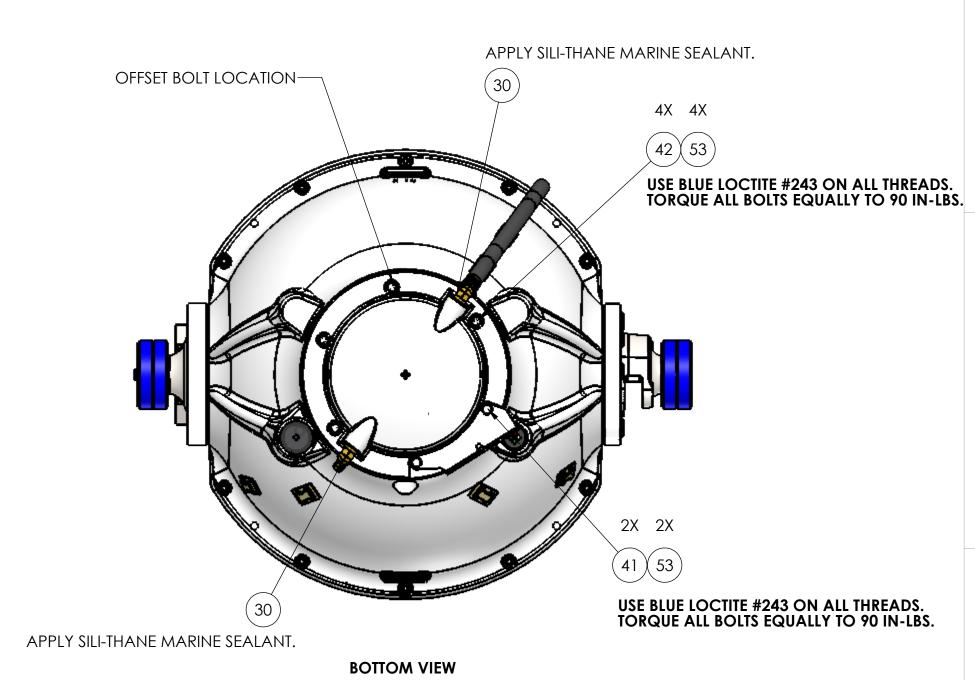


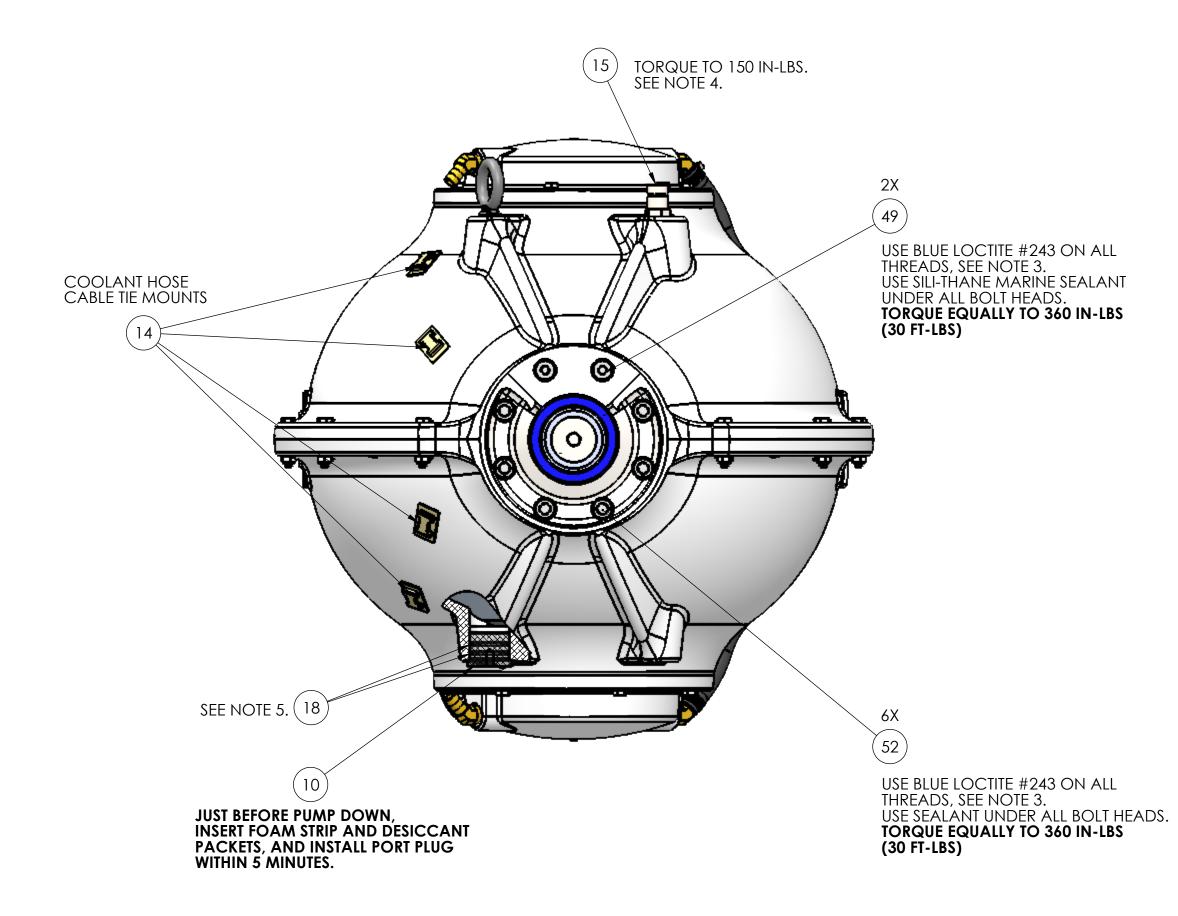
4

3

5

3





7

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. 293.143

MATERIAL:

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

SEAKEEPER 2 ENCLOUSURE AND GIMBAL SHAFT ASSEMBLY, SERVICE REFERENCE 

12567-SP

**1** 2 OF 2