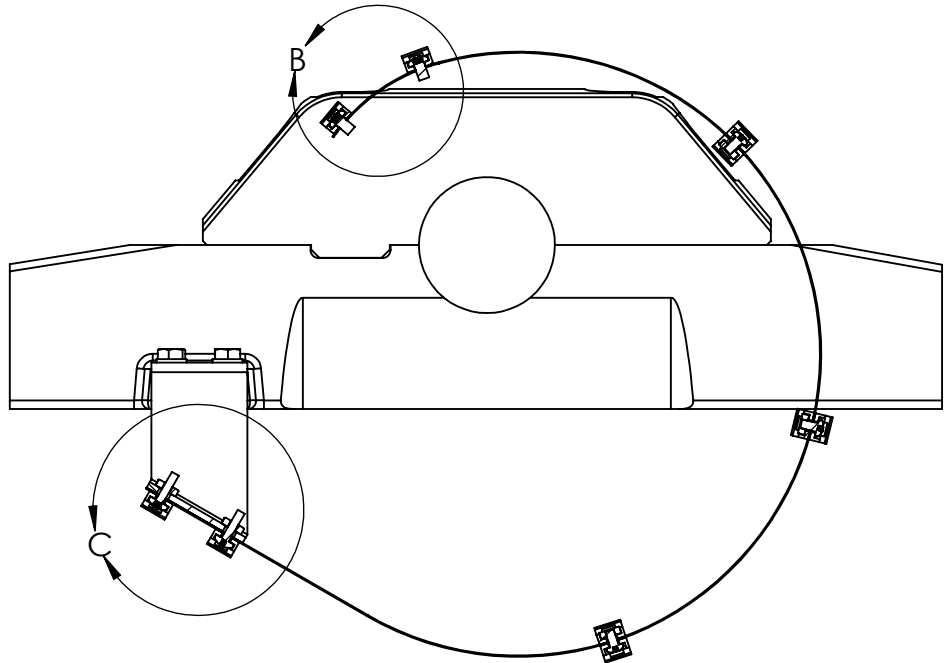
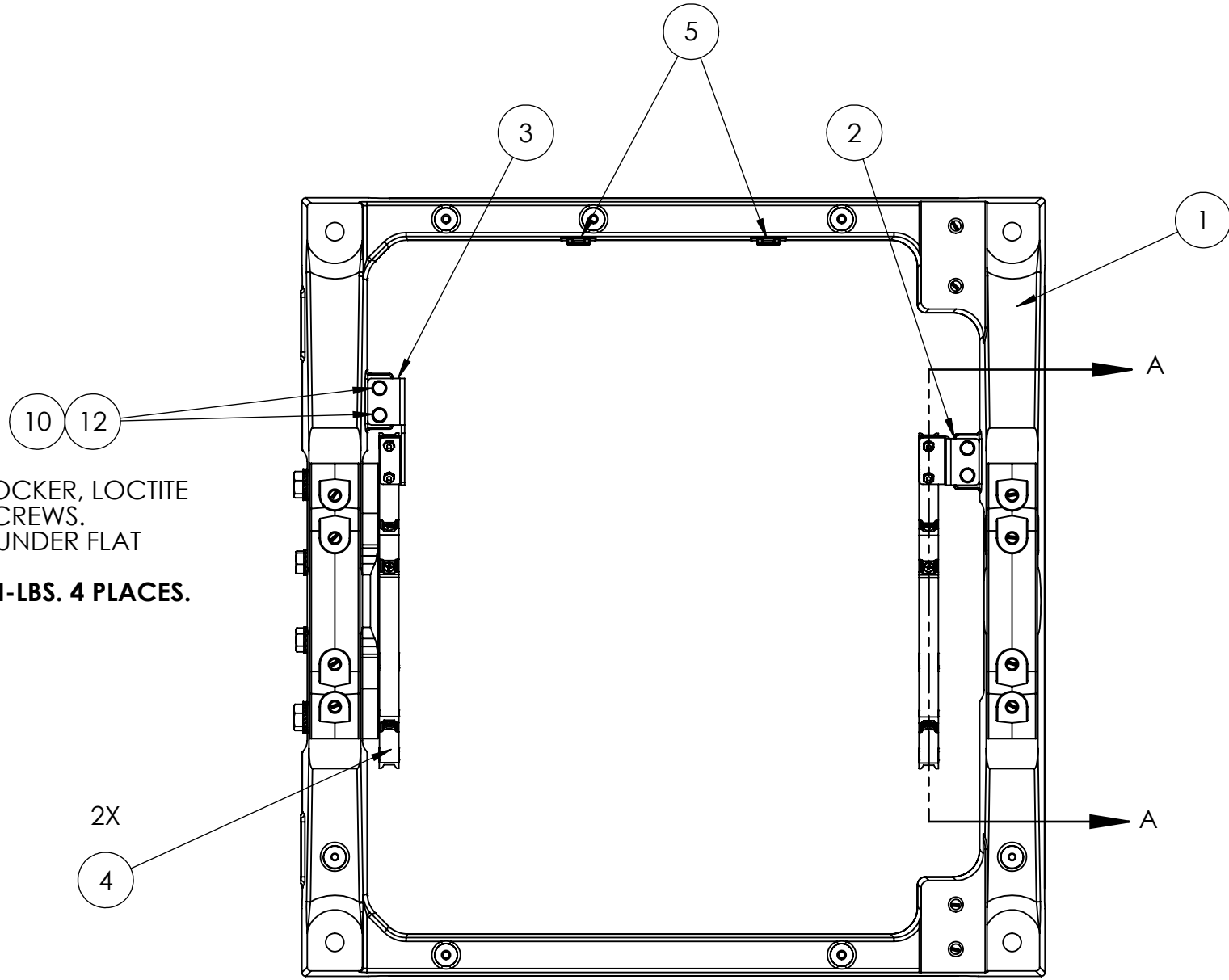


- NOTES:
1. CLEAN ALL MATING SURFACES AND TAPPED HOLES FROM ANY OIL OR DEBRIS.
 2. WHEN USING LOCTITE #243 THREADLOCKER, REFER TO WORK INSTRUCTION WI-085 FOR PROPER APPLICATION.

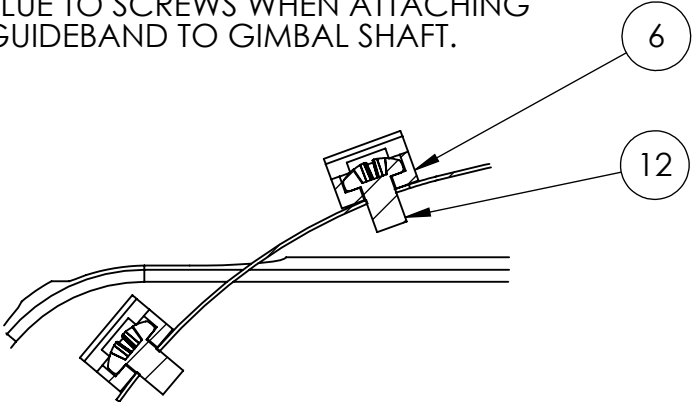
REV.	ECN NO.	ZONE	DESCRIPTION	DATE	APPROVED
1	906	---	INITIAL RELEASE	6/14/2021	TMD

APPLY THREADLOCKER, LOCTITE #243, BLUE TO SCREWS.
APPLY SEALANT UNDER FLAT WASHERS.
TORQUE TO 72 IN-LBS. 4 PLACES.



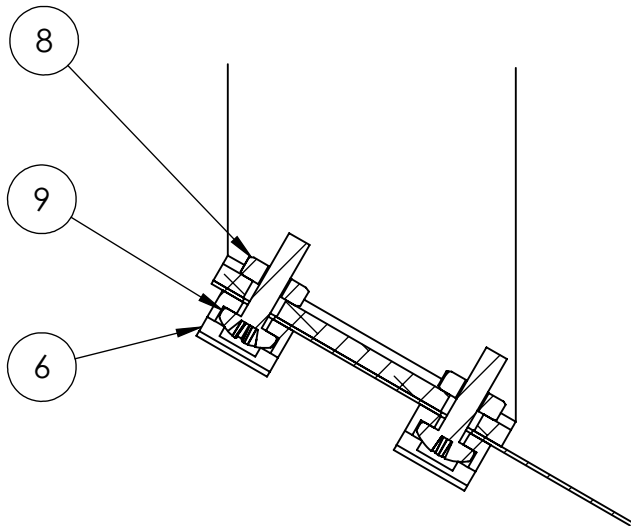
SECTION A-A
SCALE 1 : 3

APPLY THREADLOCKER, LOCTITE #243, BLUE TO SCREWS WHEN ATTACHING GUIDE BAND TO GIMBAL SHAFT.



DETAIL B
SCALE 1 : 1

APPLY THREADLOCKER, LOCTITE #277, RED TO SCREWS WHEN TIGHTENING NUTS.



DETAIL C
SCALE 1 : 1

14	70054	THREADLOCKER, LOCTITE #243, BLUE	---	AR	
13	70031	THREADLOCKER, LOCTITE #277, RED	---	AR	
12	60483	SCREW, PHILLIPS HD PAN 8-32 X .25 LG	18-8SS	4	
11	60294	SCREW, HEX HD CAP M6-1.0 X 12MM LG	316 SS	4	
10	60223	WASHER, FLAT, M6 12MM OD	316SS	4	
9	60165	SCREW, PHILLIPS HD PAN 8-32 X 1/2" LG	18-8 SS	4	
8	60164	NYLOCK HEX NUT, #6-32	18-8 SS	4	
7	40250	SILI-THANE 803 MARINE SEALANT	POLYURETHANE	AR	
6	40208	CABLE TIE MOUNT, PLASTIC, #8 SCREW	PLASTIC	8	
5	30016	LARGE CLICK BOND WIRE TIE ANCHOR	COMPOSITE	2	
4	11878	CABLE GUIDE BAND SUBASSEMBLY	---	2	
3	11550	SEAKEEPER 2 GUIDE BAND BRACKET, NON-BRAKE SIDE	5052 ALUM SHT	1	
2	11549	SEAKEEPER 2 GIMBAL GUIDE BAND BRACKET, BRAKE SIDE	5052 ALUM SHT	1	
1	11529	SEAKEEPER 2 FINAL MACHINED FOUNDATION ASSEMBLY	---	1	
ITEM NO.	PART NO.	DESCRIPTION	MATERIAL	QTY.	NOTE

WEIGHT - LBS :
35.113

MATERIAL:

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DRAWN: TMD
ENG APPR: DATE: 20MAY2021
PROD APPR: DATE:

SEAKEEPER
Seakeeper Inc. 45310 Abell House Lane, Suite 350 California, MD 20619

NAME: SEAKEEPER 2 FRAME ASSEMBLY, SERVICE REFERENCE

DWG NUMBER: 12568-SP
REV. NO. SHEET NO.: 1 1 OF 1