REV. | ECN NO. | ZONE | NOTES: 1) THIS DWG. REPRESENTS A SUB-GROUP OF COMPONENTS WITHIN THE NG9 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 0207 2) MOST ALL INTERNAL ASSEMBLY WILL BE IDENTICAL TO CURRENT M8000 PROTOCOL 3 0477 3) 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. 4 0495 4) WHEN USING #243 THREADLOCKER, REFER TO SEAKEEPER WORK INSTRUCTION WI-085 FOR PROPER APPLICATION. (27)(26)(34)APPLY SEALANT, ITEM 20 UNDER FLAT WASHER. TORQUE ALL BOLTS EQUALLY TO 120 IN/LBS. FOR TEMPERATURE SENSOR PLUG (14) FOR WIRE HARNESS (27) 27) 38) 39 APPLY SEALANT, ITEM 20 UNDER FLAT WASHERS. TORQUE EQUALLY TO **200 IN/LBS.** DO NOT RE-USE NYLOCK HEX NUTS, ALWAYS USE NEW. 70054 THREADLOCKER, LOCTITE #243 BLUE 45 70001 44 VACUUM GREASE 43 60494 SCREW, HEX HD FLANGE, 10-32 X .375 42 60487 STANDOFF, 3/8 HEX, 10-32 MALE X 10-32 FEMALE X 2" LG 41 60353 SCREW, HEX HD CAP 5/16-24UNF X 1-3/4" LG. 60245 SCREW, SOCKET HD CAP M14-2.0 X 35MM CLASS 10.9 40 60244 39 SCREW, HEX HD CAP .31-18 X 1.5 60243 38 NUT, NYLOCK HEX .31-18 60104 37 SCREW, SOCKET HD CAP 10-32 X 1.75 GRD8 36 60086 SCREW, SOCKET HD CAP .31-24 X 2.5 GRD8 35 60085 SCREW, SOCKET HD CAP .25-28 X 2.5 GRD8 60067 34 HEX HD CAP SCREW, 5/16-24 X 1.5 LG 60058 WASHER, HI COLLAR LOC 0.31 GRD8 33 60020 32 WASHER, SPRING LOCK, HI-COLLAR, 1/4 31 60019 SCREW, SOCKET HD CAP .25-28 X .75 GRD8 60018 30 SCREW, SOCKET HD CAP 1/4-28 X 2-1/4" LG G8 60015 WASHER, HI COLLAR LOC #10 29 60013 28 EYEBOLT, WITH SHOULDEDR, .38-16 X 1.25 27 60003 WASHER, FLAT TYPE B NARROW 0.31 26 60002 WASHER, SPLIT LOC .31 40574 25 FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG 40518 DESICCANT, 10G PACKET, TYVEK 24 O-RING, SIZE 025 .070 X 1.176 ID 40516 23 22 40250 SILI-THANE 803 MARINE SEALANT 21 40160 200 LB. WAVE SPRING 40012 20 O-RING, SIZE 390 40011 O-RING, SIZE 391 19 40010 O-RING, SIZE -276 18 40009 O-RING, SIZE -277 17 16 40004 VALVE, VACUUM PORT 30016 LARGE CLICK BOND WIRE TIE ANCHOR 15 (15) FOR COOLANT HOSE 30015 14 SMALL CLICK BOND WIRE TIE ANCHOR 5 更 13 11723 SEAKEEPER 9 DESICCANT CONTAINMENT GUARD 11721 SEAKEEPER 9 MOTOR POWER CABLE GUARD 12 11 11714 DESICCANT PORT PLUG 10 11695 SEAKEEPER 9 PRE-GRIND, MACHINED ENCLOSURE ASSEMBLY 9 10856 SEAKEEPER 9 UPPER INTERIOR FIXED COOLING COLLAR 10855 SEAKEEPER 9 WATER JACKET GASKET 10835 SEAKEEPER 9 LOWER INTERIOR FIXED COOLING COLLAR 10834 SEAKEEPER 9 FINISH MACHINED WATER JACKET 5 10824 SEAKEEPER 9 NON-BRAKE SIDE GIMBAL SHAFT SUB-ASSEMBLY $\sqrt{3}$ (27)(26)(41)10823 SEAKEEPER 9 BRAKE SIDE GIMBAL SHAFT SUB-ASSEMBLY 4 3 10818 SEAKEEPER 9 FINISH MACHINED COVER FOR TEMPERATURE SENSOR PLUG 10291 2 SEAKEEPER 9 LOWER BEARING EXTERIOR RETAINER APPLY SEALANT, ITEM 18 UNDER FLAT WASHER. 10288 SEAKEEPER 9 UPPER BEARING EXTERIOR RETAINER TORQUE ALL BOLTS EQUALLY TO 120 IN/LBS. DESCRIPTION ITEM NO. PART NO. PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SEAKEEPER INCORPORATED. ANY REPRODUCTION IN PART OR AS A WHOLE NAME WITHOUT THE WRITTEN PERMISSION OF SEAKEEPER IS PROHIBITED. N/A MATERIAL: SAC
ENG APPR: DATE:
RSK 17APR14
PROD APPR: DATE:

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DATE APPROVED

4/18/2014 RSK

5/30/2017 SAC

AR NOTE 4

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QTY. NOTE

4 1 OF 2

16

GRD 5 STL

316 SS

316 SS

ALLOY STL

316SS

316SS

BLK OXIDE STL

BLK OXIDE STL

BLK OXIDE STL

316SS

BLK OXIDE STL

STEEL

BLK OXIDE STL

ALLOY STEEL

316 SS

316SS

URETHANE

75A VITON,

BROWN

STEEL

VITON 75

VITON 75

VITON 75

VITON 75

302SS

COMPOSITE

COMPOSITE

SEE NOTES

SEE NOTES

6061 ALUM.

CAST ALUM

CAST ALUM

CAST ALUM

CAST ALUM

1018 STEEL

1018 STEEL

MATERIAL

10812-SP

SEAKEEPER®

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

SEAKEEPER 9 ENCLOSURE SUB-

SYSTEM, SERVICE REFERENCE

BLACK SILICONE 2

BLK OXIDE STL | 12

FORGED STEEL 2

1/18/2017

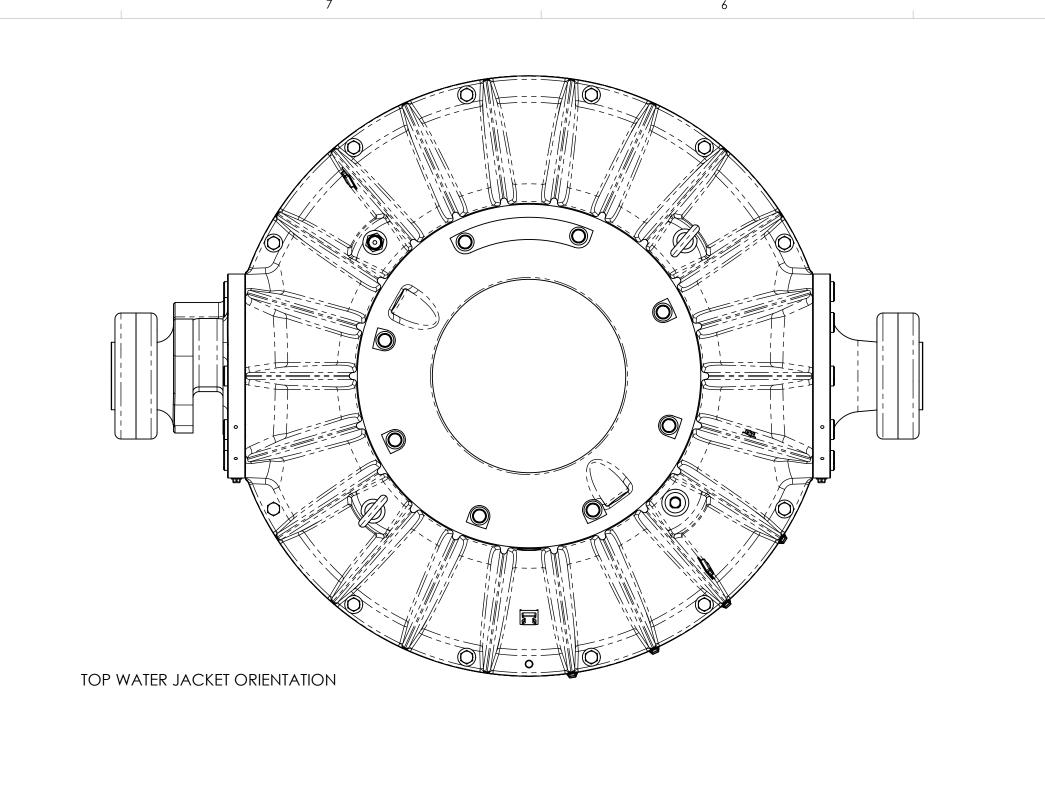
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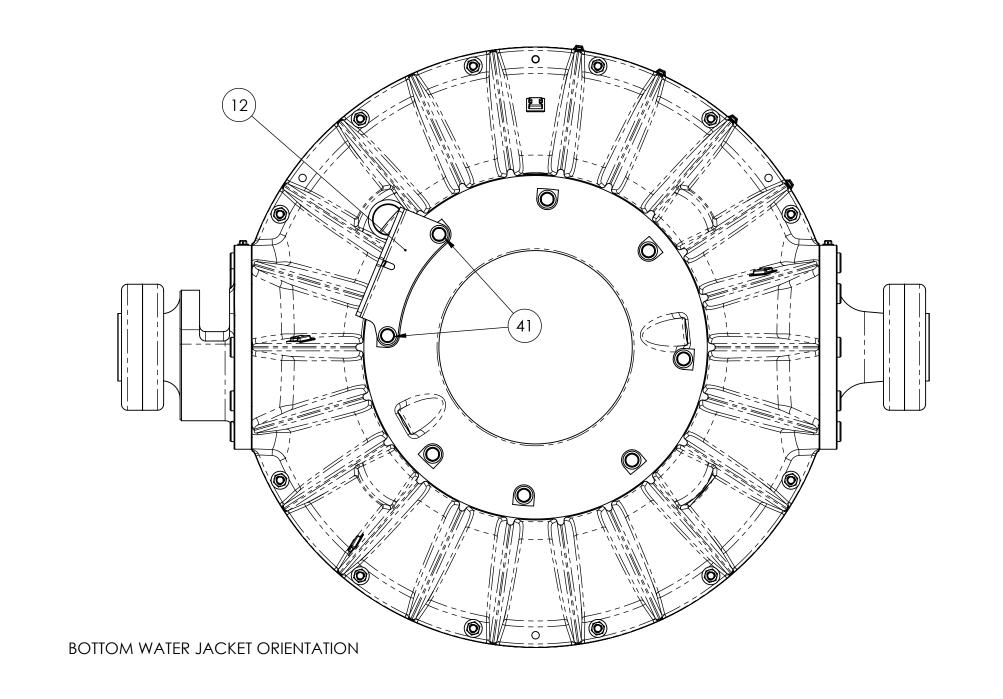
RELEASED FOR PRODUCTION

REVISION ONLY

OWER WATER JACKET, ADDED LONGER SCREWS (2X) DESICCANT IS NOW ADDED TO INSIDE OF SPHERE

10834(ITEM 7)-RAW MATERIAL CHANGE, NETSUITE BOM 7/30/2014 RSK





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SEAKEEPER 9 ENCLOSURE SUB-SYSTEM, SERVICE REFERENCE

10812-SP

4 2 OF 2

MATERIAL:

