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.

REV. ECN NO. ZONE DATE APPROVED DESCRIPTION 1 0906 --- RELEASED FOR PRODUCTION 07/14/2021 TMD 2 1114 E5 60436 AND 40004 PLACEMENT. 10/24/2023 AP

8 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.	
34	
NO VACUUM GREASE IS REQUIRED	
5	4 XXXXX
	34)
	NO VACUUM GREASE IS REQUIRED
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56	70054	THREADLOCKER, LOCTITE #243, BLUE	AR	
55	70047	LOCTITE, THREAD SEALANT 564 , 50ml TUBE	AR	
54	70001	DOW CORNING, HIGH VACUUM GREASE	AR	
53	60631	WASHER, FLAT SEALING M6 SS	12	
52	60576	SCREW, SKT HD CAP, M10-1.5 X 16MM LG	14	
51	60552	SCREW, SOCKET HD CAP, M47 X 12MM LG, FULL TD BLK OXIDE CLASS 12.9	12	
50	60550	WASHER, WEDGE LOCK M4, .17ID X .30 OD, ALUM ZNC PLTD STEEL	24	
49	60468	SCREW, SOCKET HD CAP M10-1.5 X 25MM LG, CLASS 12.9	2	
48	60463	LIFTING EYEBOLT, M8-1.25 X 16MM THREAD LENGTH	2	
47	60462	SCREW, SOCKET HD CAP M4-0.7 X 45MM LG, CLASS 12.9	12	
46	60459	SCREW, SOCKET HD CAP, M4-0.7 X 30mm LG CLASS 10.9	24	
45	60411	WASHER, HI COLLAR SPLIT LOC, M4 10.9	24	
44	60410	WASHER,FLAT M4, 10.9	16	
43	60338	SCREW, SKT HD CAP, M47 X 10mm LG	2	
42	60321	SCREW, HEX HD CAP M6-1.0 X 25MM FULL TD	10	
<u>42</u> 41	60262	SCREW, HEX HD CAP, M6-1.0 X 30mm LG	2	
	+		1	
40	60256	HEX HEAD CAP SCREW, M6-1.0 X 16mm LG	10	
39	60255	HEX NUT, NYLOK M6-1.0	10	
38	60223	WASHER, FLAT, M6 12MM OD	20	
37	60222	SCREW, HEX HD CAP M6-1.0 X 35MM 316SS	10	
36	60035	WASHER, SPLIT LOC DIN7980. M4	2	
35	40588	O-RING, SQUARE SIZE 268 DUROMETER 70A, BUNA N RUBBER BLK	2	
34	40587	O-RING, SQUARE SIZE 254 DUROMETER 70A, BUNA N RUBBER BLK	2	
33	40579	SEAKEEPER 2 GIMBAL SHAFT BUSHING, .63 X .50 X .31LG	4	
32	40574	FOAM DAMPENER STRIP, 1" X 1/2" X 16" LG	1	
31	40518	DESICCANT, 10G PACKET	4	
30	40482	HOSE BARB FITTING, 3/8 X 1/4 NPT MALE, 45 DEGREE ELBOW	4	
29	40476	SEAKEEPER 2 LOWER WAVE SPRING	1	
28	40475	SEAKEEPER 2 UPPER WAVE SPRING	1	
27	40473	O-RING, SIZE SAE-164, VITON	2	
26	40472	O-RING, SAE-017	2	
25	40471	O-RING, SIZE SAE-166, VITON	4	
24	40470	O-RING, SK2 OUTSIDE EQUATOR CUSTOM, VITON	1	
23	40465	O-RING, SIZE #020 .070 X .864 ID	2	
<u> 22</u>	40444	SEAKEEPER 3 GIMBAL BEARING	2	
<u>22</u> 21	40382	EXTERNAL RETAINING RING, 1 INCH SHAFT	1	
20	40250	SILI-THANE 803 MARINE SEALANT	1	
<u> 19</u>	40189	O-RING, .139 DIA X 15.955 ID	1	
18	40142	O-RING, SIZE 024 A75 DUROMETER	2	
		·	1	
17	40109	COOLANT HOSE, 3/8" ID X 20 1/4"	1	
16	40047	HOSE CLAMP SIZE -04, .31 BAND WIDTH, 301SS	2	
15	40004	VALVE, VACUUM PORT	10	
14	30016	LARGE CLICK BOND WIRE TIE ANCHOR	10	
13	12566	SEAKEEPER 2 FLYWHEEL ASSEMBLY		
12	11839	SEAKEEPER 2 MOTOR CABLE GUARD	1	
11	11801	SEAKEEPER 2 ENCLOSURE, FINAL GRIND	1	
10	11762	·	1	
9	-	SEAKEEPER 2 GIMBAL BEARING ISOLATION BUSHING	4	
8	11538	SEAKEEPER 2 WATER JACKET, FINISH MACHINED	2	
7	11536	SEAKEEPER 2 COOLING COVER, FINISH MACHINED	2	
6	11524	SEAKEEPER 2 UPPER & LOWER EXTERIOR BEARING RETAINER	2	
5	11523	SEAKEEPER 2 GIMBAL SHAFT, NON-BRAKE SIDE	1	
4	11521	SEAKEEPER 2 GIMBAL SHAFT, BRAKE SIDE	1	
3	11507	SEAKEEPER 2 UPPER FIXED COOLING COLLAR, FINISH MACHINED	1	
2	11505	SEAKEEPER 2 LOWER FIXED COOLING COLLAR, FINISH MACHINED	1	
1	11417	SEAKEEPER 3 GIMBAL BEARING RETAINER	1	
4 2 1 0	PART NO	. DESCRIPTION	QTY.	NIC

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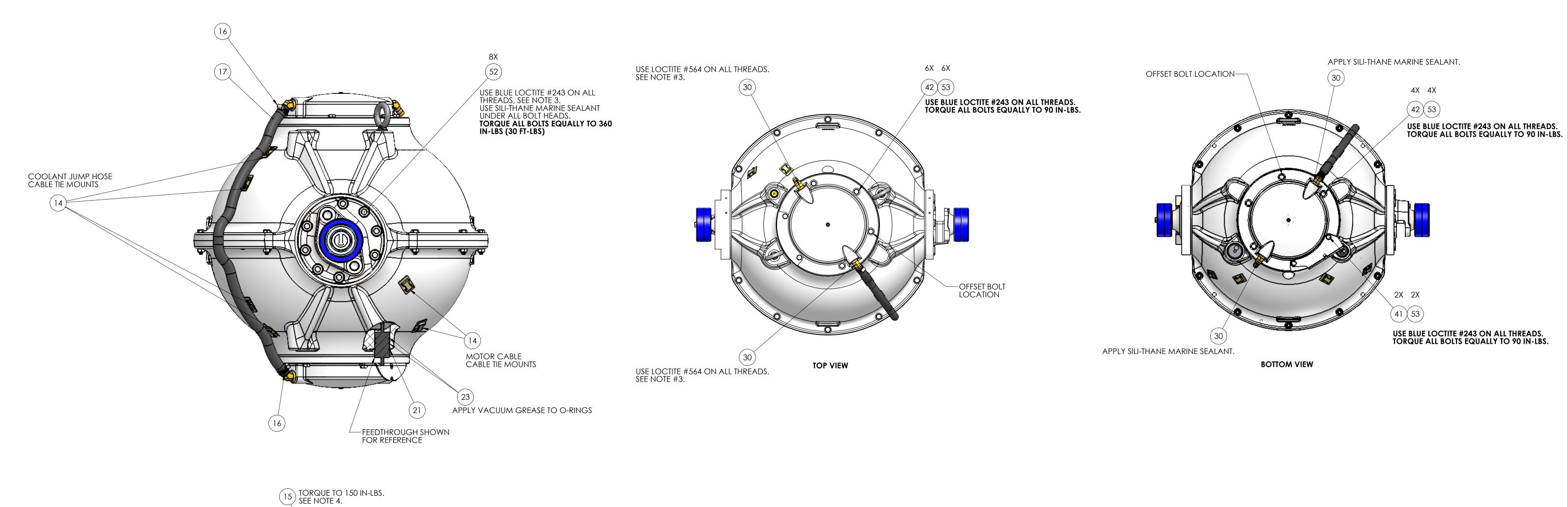
SEAKEEPER 2 ENCLOSURE AND
GIMBAL SHAFT ASSEMBLY,
SERVICE REFERENCE

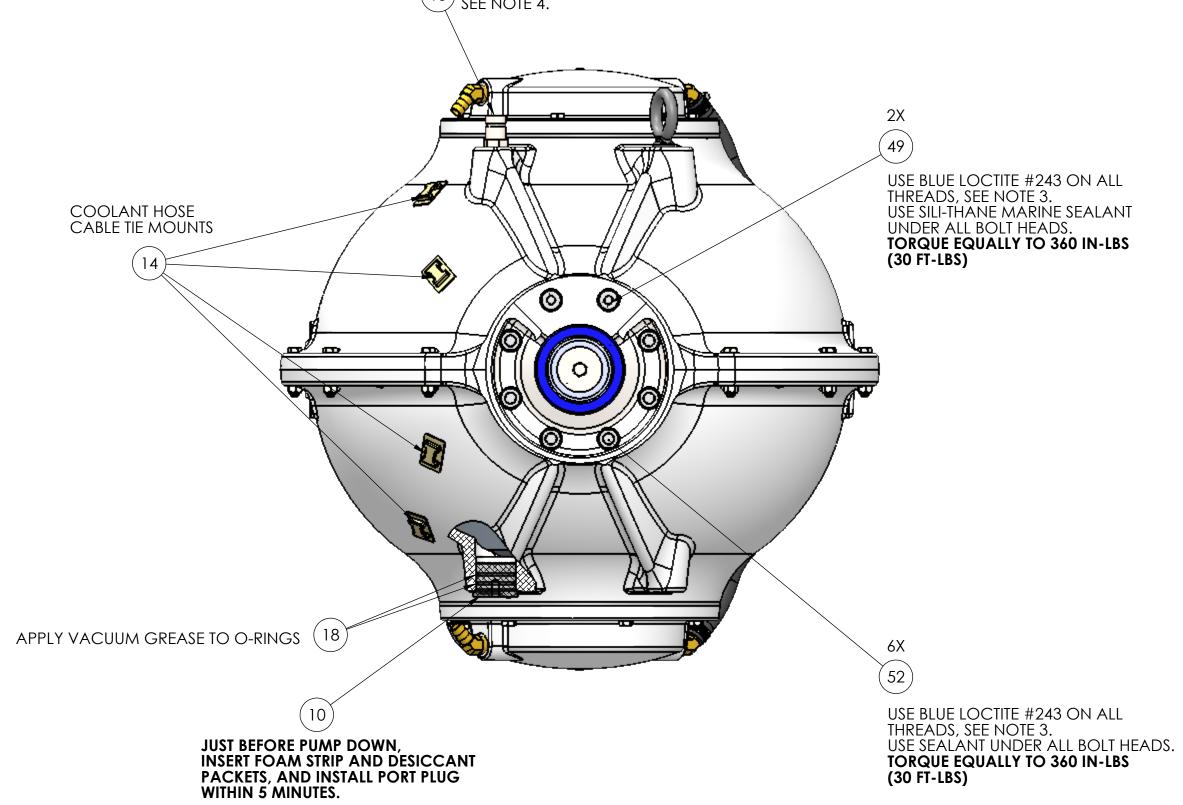
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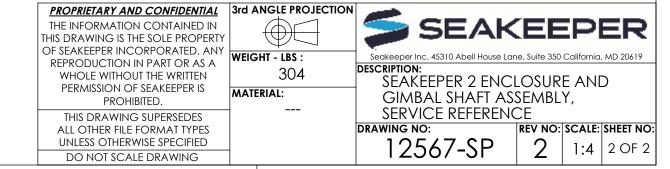
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