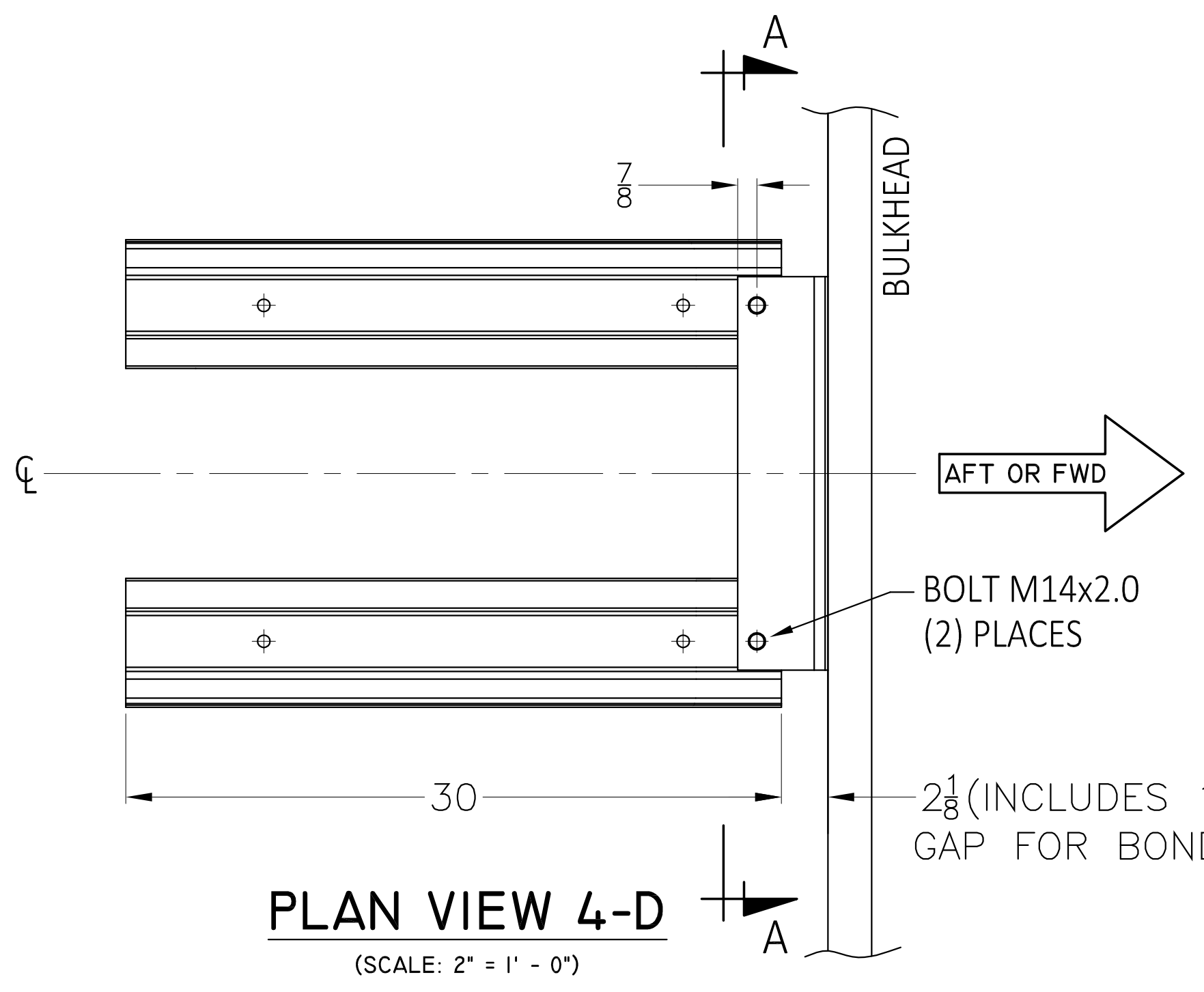
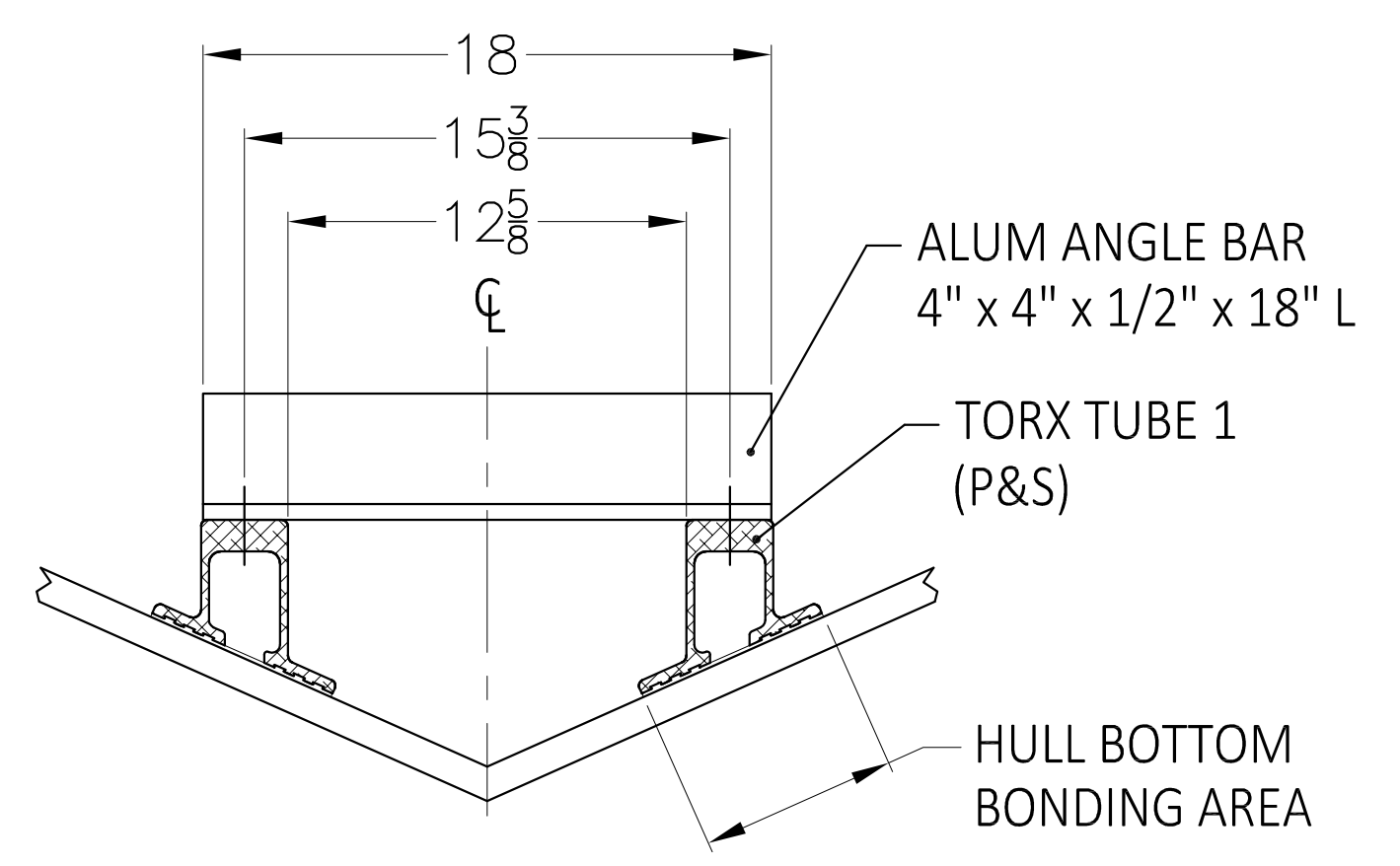


ISO EXPLODED VIEW 7-D
BONDING AREA
(NOT TO SCALE)



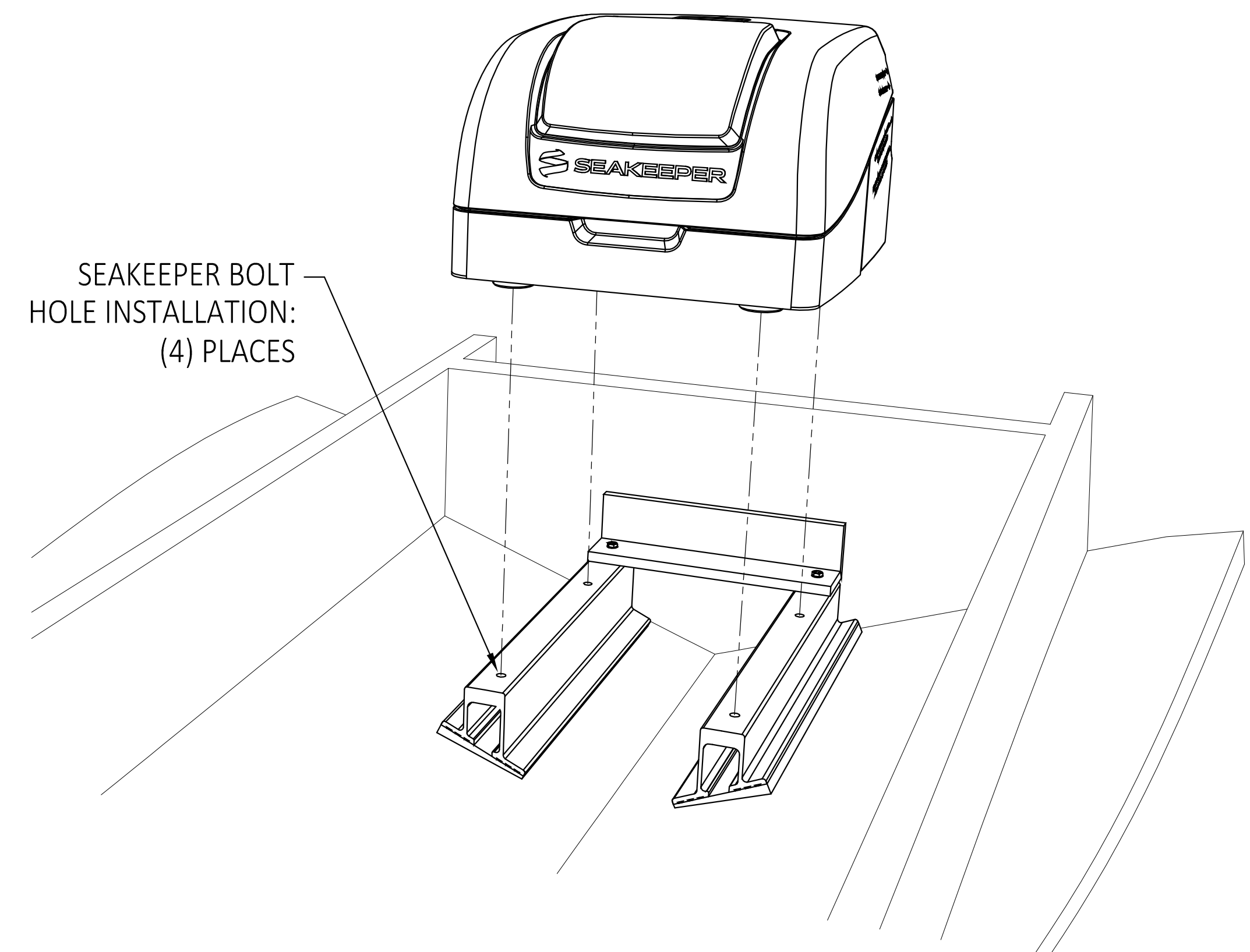
PLAN VIEW 4-D
(SCALE: 2" = 1' - 0")



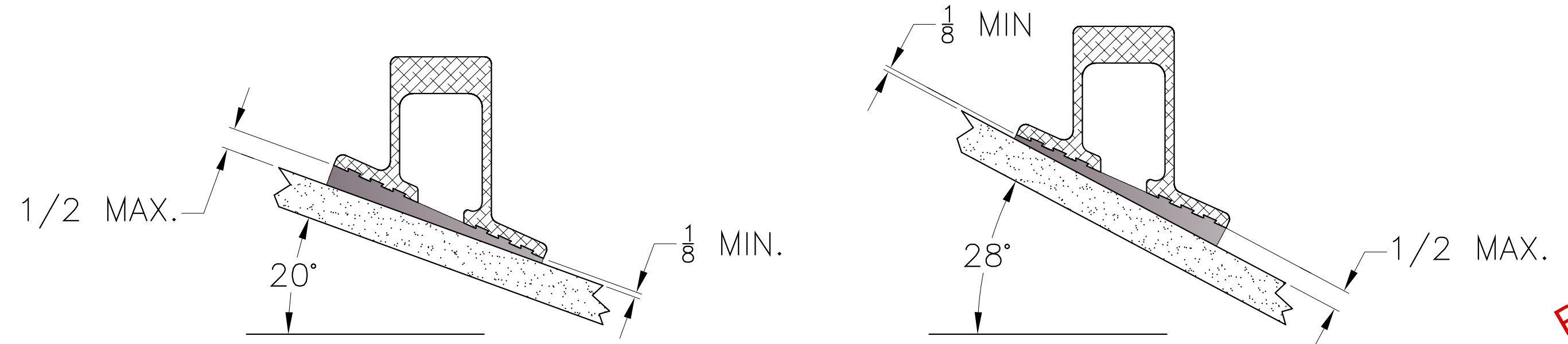
SECTION A-A
(SCALE: 2" = 1' - 0")

READ SEAKEEPER INSTALLATION MANUAL FIRST AND INSTALL IN ACCORDANCE WITH MANUFACTURER'S DIRECTIONS AS REVISIONS MAY OCCUR

- NOTES:
- 1) REFER TO DWG TTC1-600-130 FOR TORX TUBE 1 APPLICABILITY RANGE.
 - 2) INSPECT INSTALLATION AREA TO DETERMINE LOCATION FOR TORX TUBE AT BULKHEAD (DISTANCE 2 1/8" AS PER VIEW 4-D).
 - 3) USE BOLT HOLE LOCATION FIXTURE # 90517 AVAILABLE FROM SEAKEEPER AND TEMPORARY BOLT BOTH TORX TUBES APPLYING MODERATE TORQUE (ENSURE CORRECT SEAKEEPER ORIENTATION).
 - 4) INSTALL ANGLE BAR ON TORX TUBES WITH (2) HEX HEAD CAP SCREW, GRADE 10.9 ZINC-NICKEL COATED BOLTS M14x2.0x40mm AND FLAT WASHERS. USE A MODERATE COAT OF REMOVABLE CHEMICAL THREADLOCKER. TORQUE BOLTS TO 115 FT-LBS.
 - 5) DRY FIT TORX TUBES WITH FIXTURE TEMPLATE AND ANGLE BAR TO HULL BOTTOM INSTALLATION AREA USING BOND THICKNESS SPACERS AND MARK EXTERIOR DIMENSIONS OF BONDING AREA IN HULL BOTTOM (P&S) AND BULKHEAD.
 - 6) VERIFY THE GAP BETWEEN TORX TUBE BOTTOM FACE AND VESSEL DEADRISE ANGLE. KEEP IN MIND THE AMOUNT OF BOND WILL BE NEEDED TO FIT TORX FOUNDATION IN PLACE (SEE DETAIL 3-A).
 - 7) REMOVE TORX FOUNDATION.
 - 8) SAND HULL BOTTOM AND BULKHEAD BONDING AREAS WITH 80 GRIT TO REMOVE PAINT OR GELCOAT AND EXPOSE PRIMARY LAMINATION. WIPE CLEAN WITH ACETONE OR SIMILAR.
 - 9) SAND ALUMINUM BONDING SURFACES WITH 80 GRIT. WIPE CLEAN WITH ACETONE OR SIMILAR.
 - 10) SPREAD SCIGRIP SG300 ADHESIVE ON HULL BOTTOM AND BULKHEAD BONDING AREAS. ENSURE MINIMAL THICKNESS OF 1/8" AND COMPLETE WITH THE NEEDED AMOUNT VERIFIED IN NOTE 6. USE SPACERS TO ENGINEER CORRECT BOND THICKNESS AND A V-GROOVE SPREADER TOOL TO LEVEL THE BOND SURFACE (ESTIMATED: (2) CARTRIDGES OF 490 ml FOR MIN. BOND LINER AND (6) CARTRIDGES OF 490 ml FOR MAX. BOND LINER).
 - 11) INSTALL TORX FOUNDATION ENSURING CORRECT ALIGNMENT AND PLANE. CLEAN EXCESS OF BOND AND WAIT FOR THE FIXTURE TIME.
 - 12) REMOVE FIXTURE TEMPLATE AND AUXILIARY MATERIAL, CLEAN UP AND FINISH APPROPRIATELY ALL AROUND.



ISO EXPLODED VIEW 7-A
SEAKEEPER I INSTALLATION
(NOT TO SCALE)



DETAIL 3-A
DEADRISE EXAMPLES FOR
BOND THICKNESS
(SCALE: 4" = 1' - 0")

PATENT PENDING



TORX MARINE ©2020

REV	ZONE	DESCRIPTION	DATE	APPROVED
C	ALL	ADHESIVE SPEC SCIGRIP SG300	12/09/2020	JHC
REVISIONS				

PREPARED FOR TRI SEA STABILIZERS 2200 MARINA BAY DRIVE E. FT. LAUDERDALE, FL 33312 TEL: +1(833) TRICRYD EMAIL: INFO@TRISEAKEEPER.COM CAGE CODE	VESSEL / PROJECT TORX TUBE 1 FOR SEAKEEPER 1	CUSTOMER APPROVED BY T. NICHOLS DATE 12/09/2020	DATE 12/09/2020	SIZE D	CUSTOMER TORX MARINE
PREPARED RLK DATE 12/09/2020 CHECKED JHC DATE 12/09/2020 APPROVED		DATE 12/09/2020		DESCRIPTION TORX TUBE 1 INSTALLATION	ESWBS 600 DWG NO. TTC1-600-140 REV C
SOLICITATION NUMBER			SCALE AS NOTED	MASS (WEIGHT) LBS	DATE 12/09/2020 SHEET 1/1