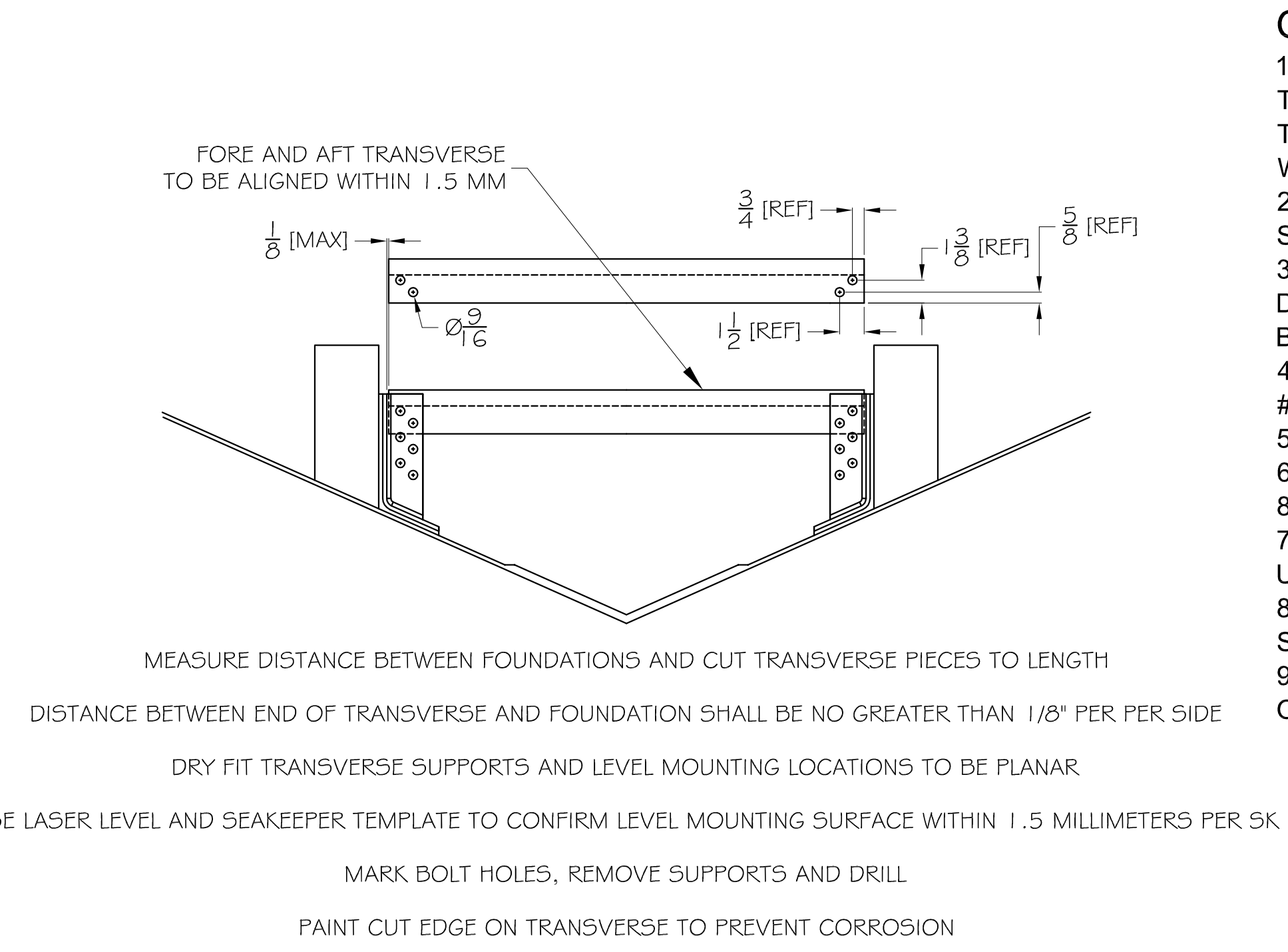
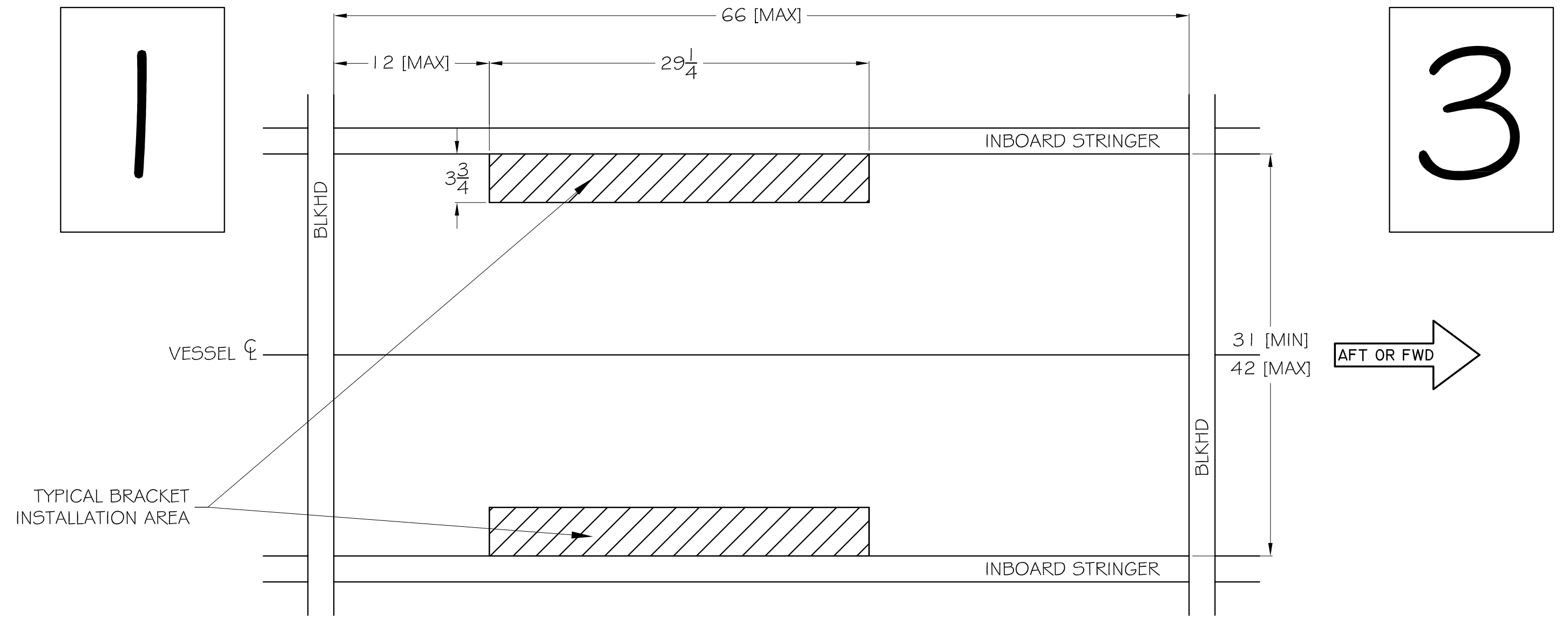


- GENERAL NOTES:**
- EQUIPMENT: SEAKEEPER 2 GYRO, BOLT-IN METHOD, TORX TUBE 3 OUTBOARD SUPPORT BRACKETS (X2), TRANSVERSE SUPPORTS (X2), BOLTS (X8), NUTS (X12), AND WASHERS (X20)
 - ESTIMATED INSTALLATION TOTAL WEIGHT INCLUDING SK2 (414 LBS) IS 474 LBS
 - KIT TO BE USED FOR HULLS WITH 20-28 DEGREES DEADRISE ANGLES ONLY AND STRINGER SPACING BETWEEN 31 - 42"
 - DO NOT INSTALL WITHOUT SEAKEEPER FIXTURE #90362 FOR ALIGNMENT & INSTALLATION
 - USE ALL HARDWARE PROVIDED WITH KIT
 - PREP ALL BONDING SURFACES BY SANDING WITH 80 GRIT AND WIPING ALL DUST CLEAN USING ACETONE
 - RE-TORQUE ALL BOLTS AFTER FIRST 50 HOURS OF USE AND DURING EACH SERVICE OF UNIT
 - IF A BOLT IS REMOVED FROM THE FOUNDATION FOR SERVICE REPLACE WITH A NEW UNUSED BOLT
 - ALL DIMENSIONS IN INCHES (+/- 1/8" UNLESS OTHERWISE NOTED).

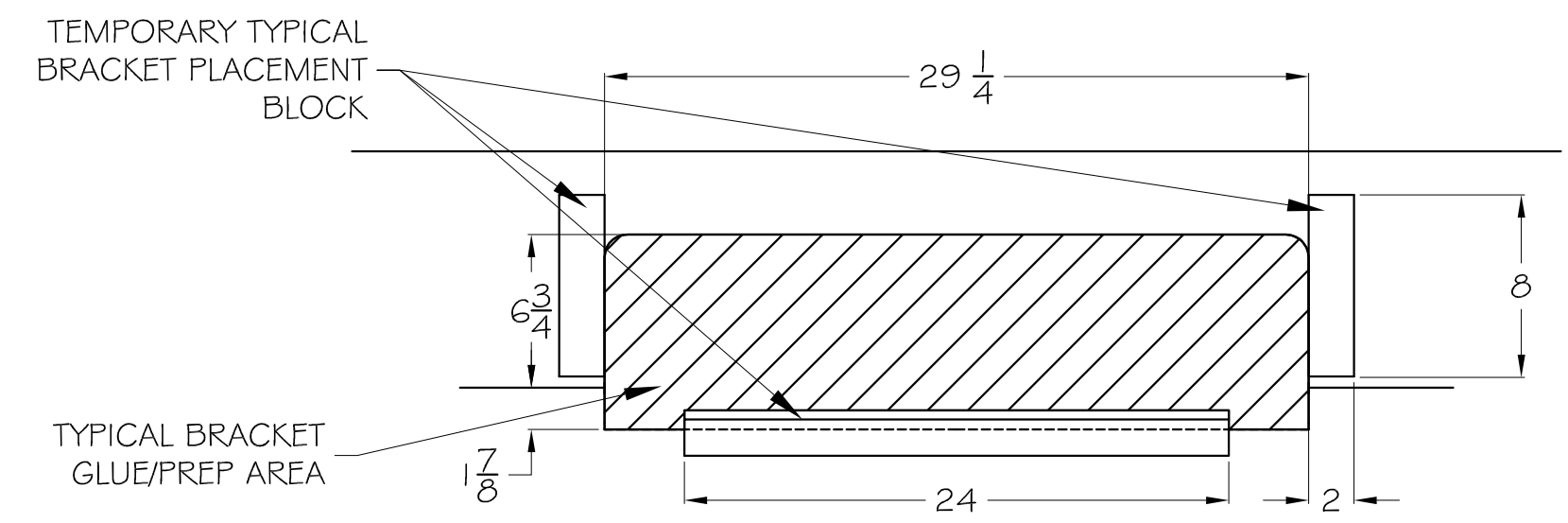
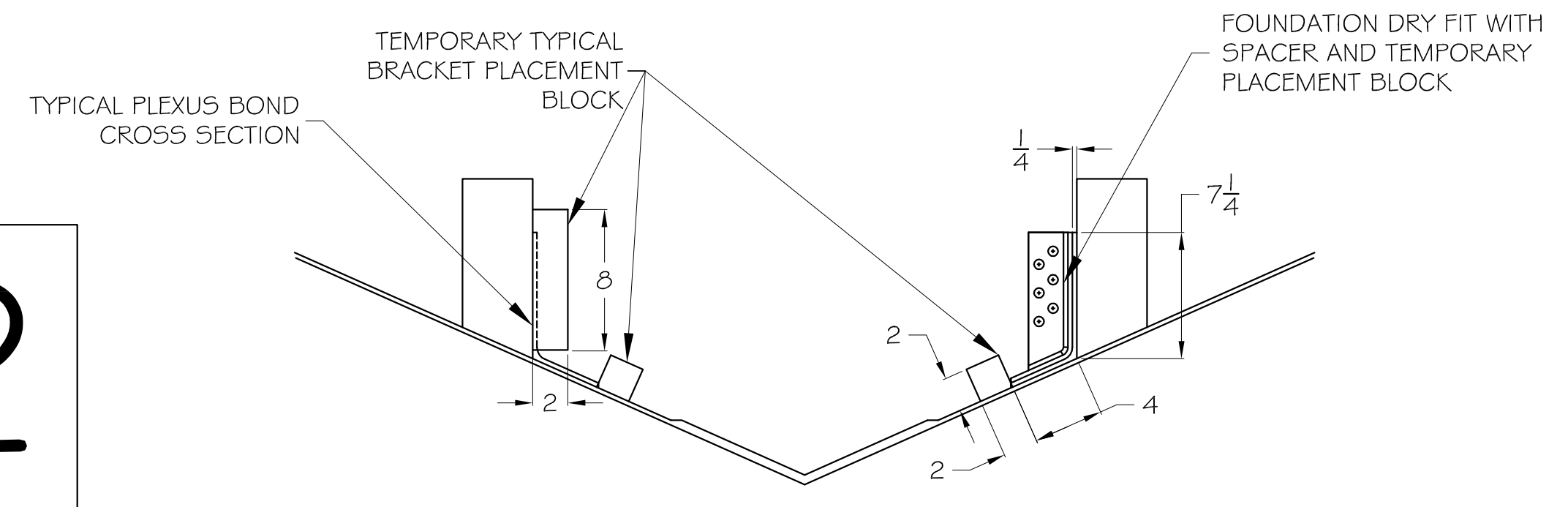


DETERMINE DESIRED INSTALLATION LOCATION AND ENSURE THAT THE DISTANCE FROM A BULKHEAD IS 12" OR LESS
 ENSURE HULL AND STRINGER LAMINATE IN WAY OF THE INSTALLATION IS CLEAR OF ANY AIR POCKETS OR DELAMINATION
 CONFIRM THE HULL LAMINATE, STRINGER LAMINATE, HULL PANEL SIZE, AND STRINGER SIZE AND SPACING ARE WITHIN THE GUIDELINES FROM DWG TT3-600-110

USE LASER LEVEL AND SEAKEEPER TEMPLATE TO CONFIRM LEVEL MOUNTING SURFACE WITHIN 1.5 MILLIMETERS PER SK
 MARK BOLT HOLES, REMOVE SUPPORTS AND DRILL
 PAINT CUT EDGE ON TRANSVERSE TO PREVENT CORROSION

BARE HULL TOP VIEW 7-D
 (SCALE: 1-1/2" = 1')

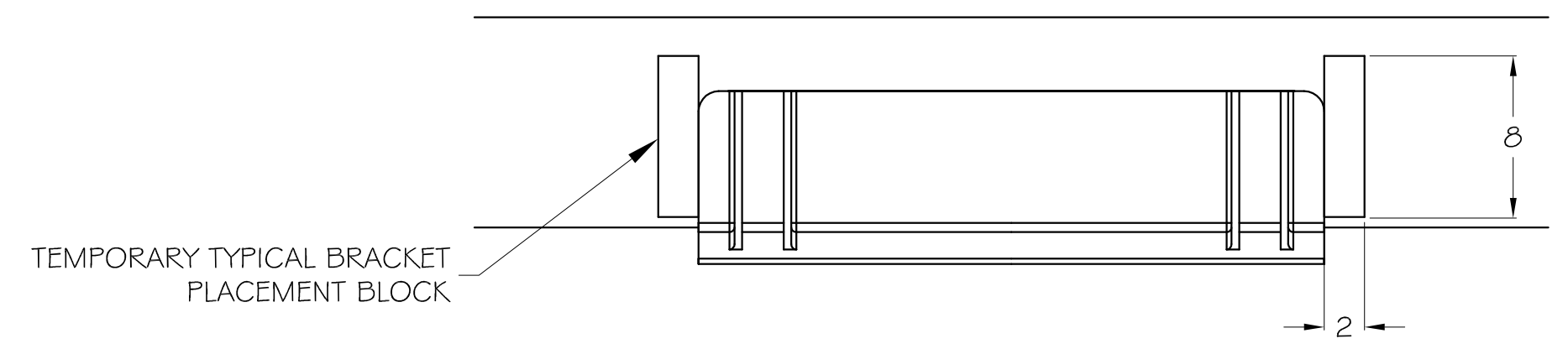
EXPLODED TRANSVERSE SECTION 3-D
 (SCALE: 1-1/2" = 1')



TYP TRANSVERSE SECTION 7-C
 (SCALE: 1-1/2" = 1')

DRY FIT FOR FINAL INSTALLATION AND CONFIRM THAT TRANSVERSE SUPPORTS ARE LEVEL AND PLANAR
 MARK GLUE AREA ON HULL AND STRINGERS
 BUILD TEMPORARY MOUNTING JIG TO HOLD BRACKETS IN PLACE DURING GLUE APPLICATION
 REMOVE FOUNDATION COMPONENTS
 REMOVE ALL PAINT AND SAND FIBERGLASS WITH 80 GRIT, WIPE CLEAN WITH ACETONE OR SIMILAR
 SAND ALUMINUM FOUNDATION GLUE SURFACES WITH 80 GRIT, WIPE CLEAN WITH ACETONE OR SIMILAR

ELEVATION 3-B
 (SCALE: 1-1/2" = 1')



DRY FIT FOUNDATION PLATES IN DESIRED INSTALLATION AREA
 USE 1/4" SPACERS ON HULL BOTTOM AND STRINGER SURFACES TO ACCOUNT FOR GLUE
 SECURE FOUNDATIONS IN PLACE USING TEMPORARY SET SCREW, FIXTURE, BLOCKS, OR CLAMPS
 MEASURE GLUE GAP -- CANNOT BE GREATER THAN 1"
 USE STRAIGHT EDGE AND DIGITAL LEVEL TO POSITION BRACKETS TO BE PARALLEL
 SEAKEEPER RECOMMENDS A SURFACE FLATNESS WITHIN 1.5 MILLIMETERS

ELEVATION 7-B
 (SCALE: 1-1/2" = 1')



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REV	ZONE	DESCRIPTION	DATE	APPROVED
B	ALL	ADD SCIGRP SG300 AS ALTERNATIVE	12/09/2020	JHC
REVISIONS				

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PREPARED VN	CUSTOMER APPROVED BY T. NICHOLS	DATE 12/09/2020	DATE 12/09/2020	DESCRIPTION TORX TUBE 2 INSTALLATION
CHECKED JHC	CLASS APPROVED BY	DATE	DATE	ESWS 600
APPROVED	SOLICITATION NUMBER	SCALE 1-1/2" = 1"	MASS (WEIGHT) LBS	DWG NO. TTC2-600-140
			DATE 12/09/2020	REV B
			SHEET 1/2	

16

15

14

13

12

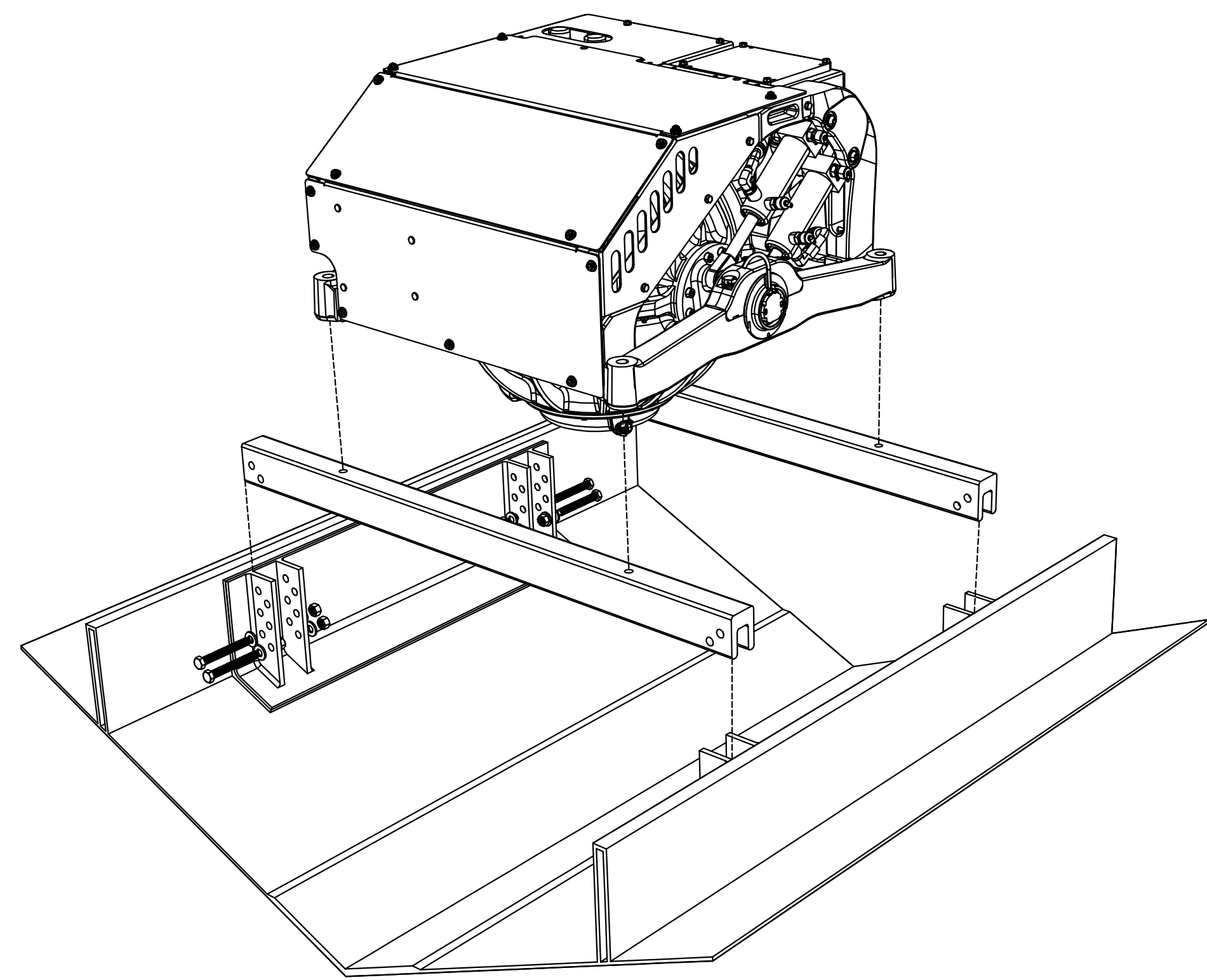
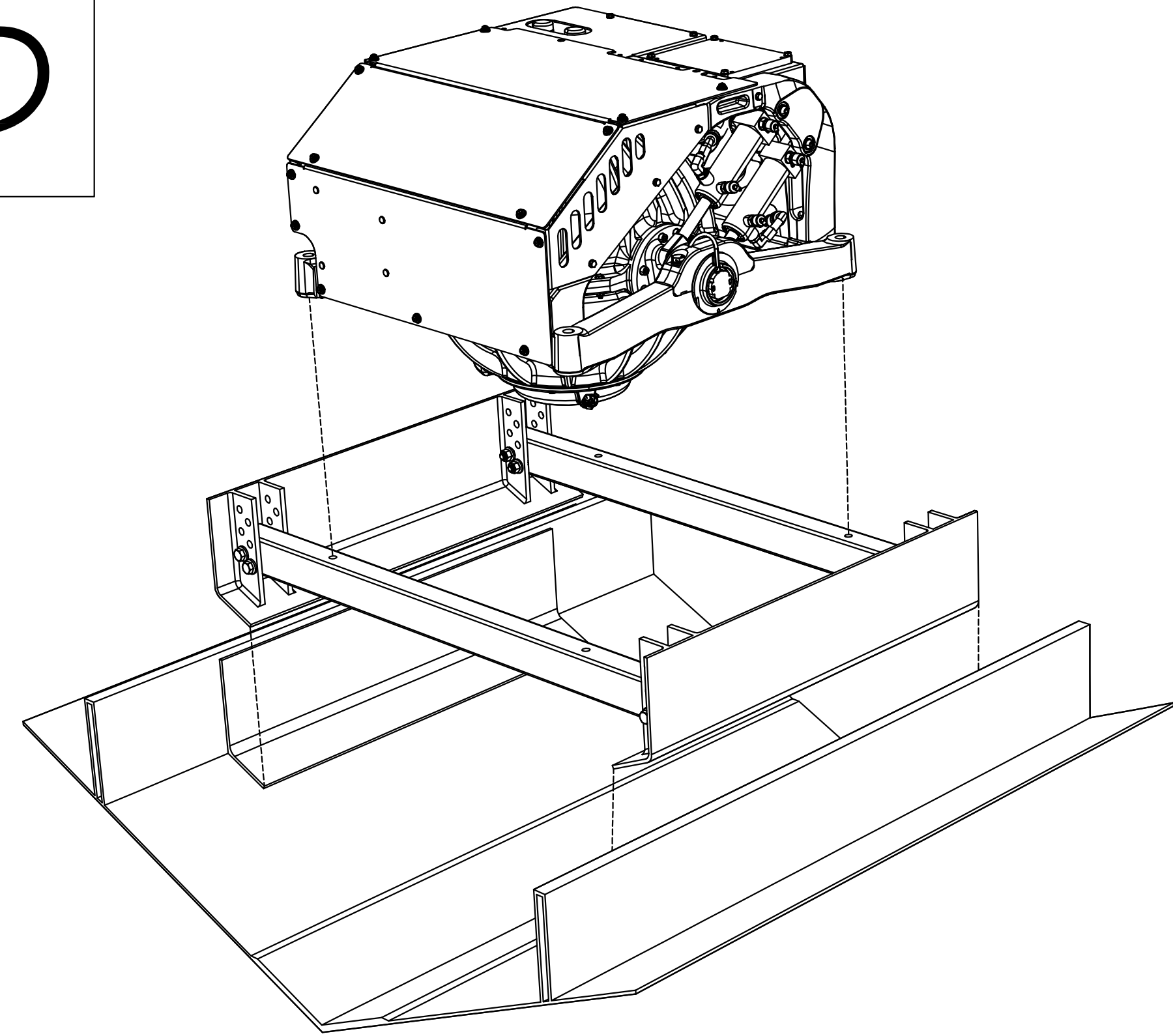
11

10

9

5

6



OPTION 1
 ASSEMBLE ALL COMPONENTS OUTSIDE OF THE VESSEL AND LOWER INTO HULL
 AFTER DRY FIT AND TRANSVERSE HOLE DRILLING, ASSEMBLE ALL FOUR PIECES
 TORQUE BOLTS TO 45 FT-LBS
 REFERENCE BOLTING DETAIL 13-A
 APPLY PLEXUS MA590 OR SCIGRIP SG300 - TROWEL ON USING 0.5" V-GROOVE TOOL
 SET FOUNDATIONS IN PLACE - ENSURING GLUE SQUEEZE OUT - ADD 45 DEGREE BEVEL TO OUTER EDGES OF PLATE AND BACKFILL WHERE VOIDS ARE PRESENT
 SECURE BRACKET INTO JIG TO CONFIRM SET WILL BE PLANAR
 USE SEAKEEPER TEMPLATE TO MARK AND DRILL MOUNTING HOLES
 USE MCMASTER #91732A675 HELICOIL
 INSTALL UNIT IN ACCORDANCE WITH SEAKEEPER INSTALLATION MANUAL

OPTION 2
 GLUE FOUNDATIONS IN PLACE THEN BOLT IN TRANSVERSE AFTERWARDS
 AFTER DRY FIT AND TRANSVERSE HOLE DRILLING, GLUE FOUNDATIONS INTO PLACE
 APPLY PLEXUS MA590 OR SCIGRIP SG300 - TROWEL ON USING 0.5" V-GROOVE TOOL
 SET FOUNDATIONS IN PLACE - ENSURING GLUE SQUEEZE OUT - ADD 45 DEGREE BEVEL TO OUTER EDGES OF PLATE AND BACKFILL WHERE VOIDS ARE PRESENT
 SECURE FOUNDATIONS INTO JIG TO CONFIRM SET WILL BE PLANAR
 PLACE TRANSVERSES AND BOLT HAND TIGHT
 USE SEAKEEPER TEMPLATE TO ENSURE PLANAR ALIGNMENT THEN MARK HOLES
 TORQUE BOLTS TO 45 FT-LBS
 DRILL SEAKEEPER MOUNTING HOLES
 USE MCMASTER #91732A675 HELICOIL
 INSTALL UNIT IN ACCORDANCE WITH SEAKEEPER INSTALLATION MANUAL

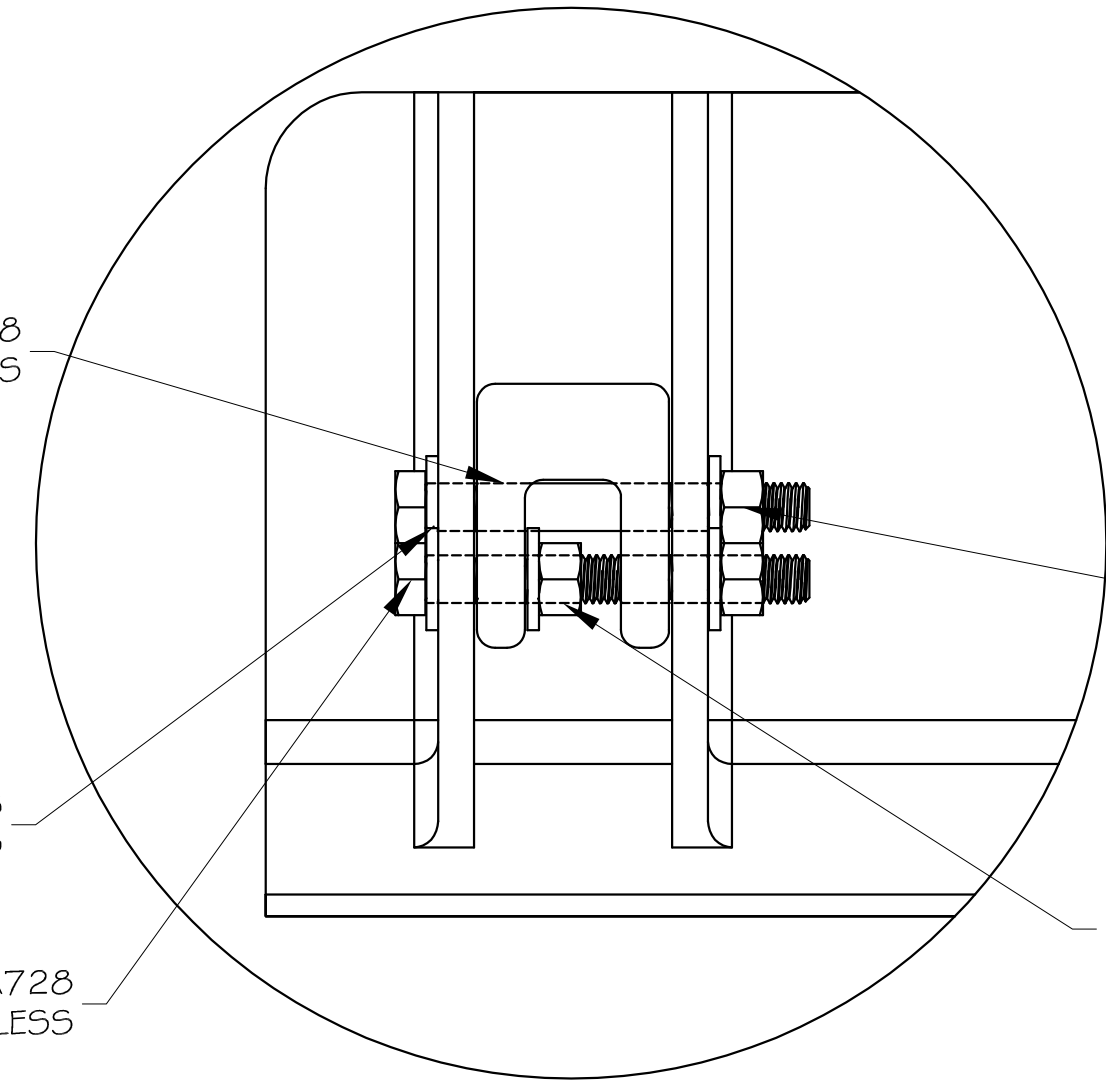
EXPLODED ISO VIEW 15-C

(NTS)

UPPER BOLT - MCMASTER #92186A728
1/2"-13 PARTIALLY THREADED X 4" 316 STAINLESS

WASHER - MCMASTER #91950A033
SAE 1/2" 316 STAINLESS

LOWER BOLT - MCMASTER #93190A728
1/2"-13 FULLY THREADED X 4" 316 STAINLESS



BOLT DETAIL 13-A

(SCALE: 6" = 1')

EXPLODED ISO VIEW 10-C

(NTS)

NUT - MCMASTER #94819A055
1/2" - 13 THREAD 316 STAINLESS
APPLY LOC-TITE 272 PERMANENT
THREADLOCKER ON ALL NUTS

SECURE INNER NUT ON
BOTTOM BOLT TO REDUCE
VIBRATION



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PREPARED FOR TRI SEA STABILIZERS 2200 MARINA BAY DRIVE E. FT. LAUDERDALE, FL 33312 PH: (954) 383-0100 EMAIL: INFO@TRISEAKEEPER.COM	VESSEL / PROJECT TORX TUBE 2 FOR SEAKEEPER 2	THIS COPY AND ANY COPY THEREOF ARE STRICTLY CONFIDENTIAL AND REMAIN THE SOLE AND EXCLUSIVE INTELLECTUAL PROPERTY OF OCEAN INC. ANY CHANGES, PUBLICATION OR UNAUTHORIZED USE IS PROHIBITED UNLESS APPROVED BY TORX MARINE.	SIZE D	CUSTOMER TORX TUBE
CUSTOMER APPROVED BY T. NICHOLS	DATE 12/09/2020	PREPARED VN	DATE 12/09/2020	DESCRIPTION TORX TUBE 2 INSTALLATION
CLASS APPROVED BY	DATE	CHECKED JHC	DATE 12/09/2020	ESWS 600
CAGE CODE	SOLICITATION NUMBER	APPROVED	DATE 12/09/2020	DWG NO. TTC2-600-140
SCALE 1-1/2" = 1' MASS (WEIGHT)			DATE	REVISION B
			DATE 12/09/2020	SHEET 2/2

TTC2-600-140 DWG NO. B 2/2 SHEET 600 ESWS