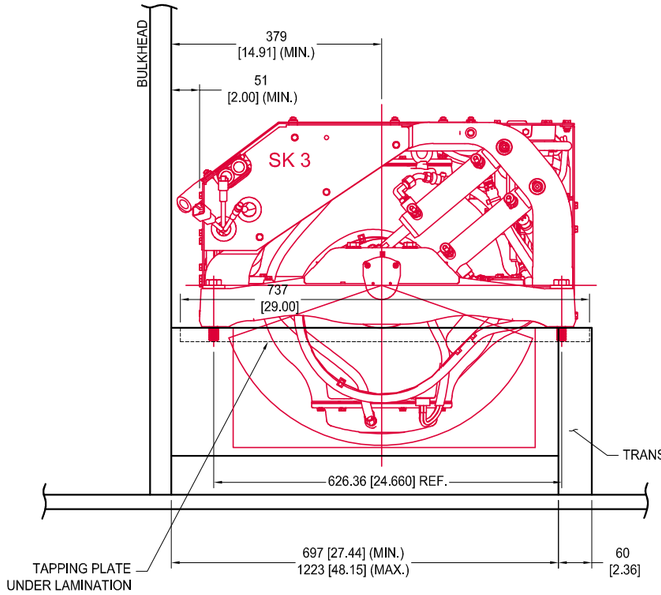
TABLE OF CONTENTS

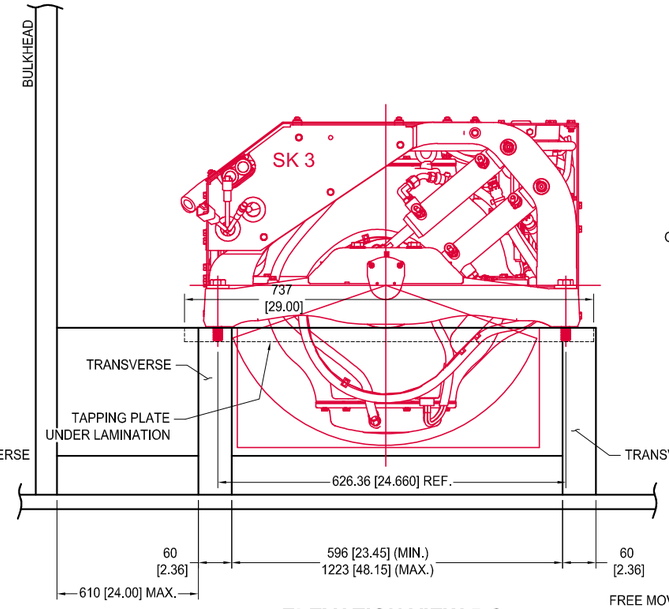
INSTALLATION OVERVIEW	INSTALLATION METHOD	PAGE #
FRP Bolt In	Laminated FRP Molded	2
	Laminated FRP Refit	3
	Laminated Transverse Beam	4
	Lamination Schedules	5-7
Aluminum Bracket	TT1 Torx Tube	8-10
Deck Mount	Installation Grid	11
Molded Stringer Grid	Stringer Grid Bolt In	12

REV. NO.	ECN NO.	ZONE	DESCRIPTION	DATE	APPRVD.
1	—		W/ NEW PAGES (SH.3 & 11)	02/24/2022	



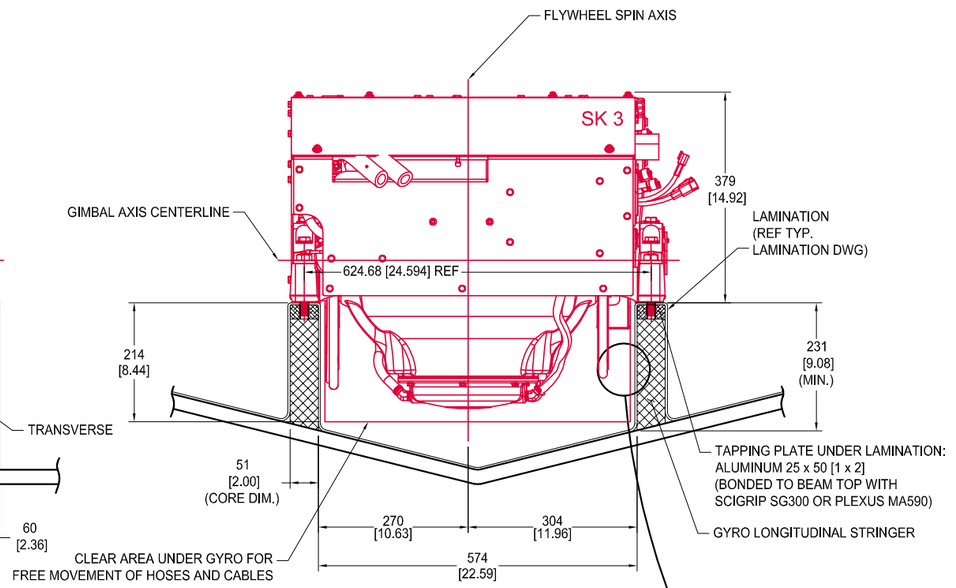
ELEVATION VIEW 7-C

(LAMINATED FRP MOLDED METHOD 1-A NEAR BULKHEAD)



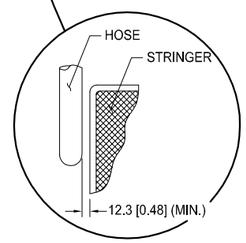
ELEVATION VIEW 5-C

(LAMINATED FRP MOLDED METHOD 1-A FAR FROM BULKHEAD)

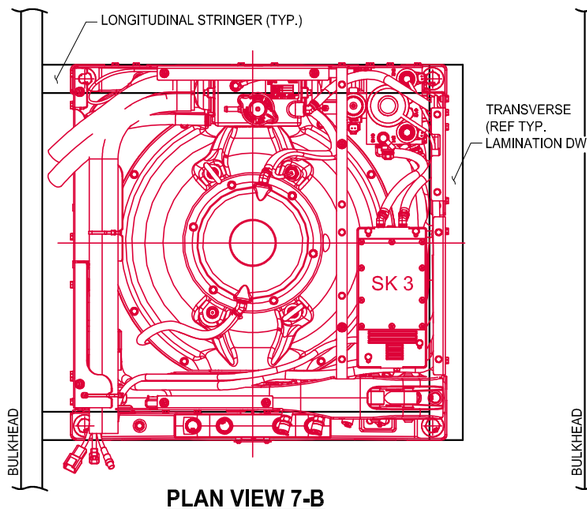


SECTION 2-C

(LAMINATED FRP MOLDED METHOD 1-A)

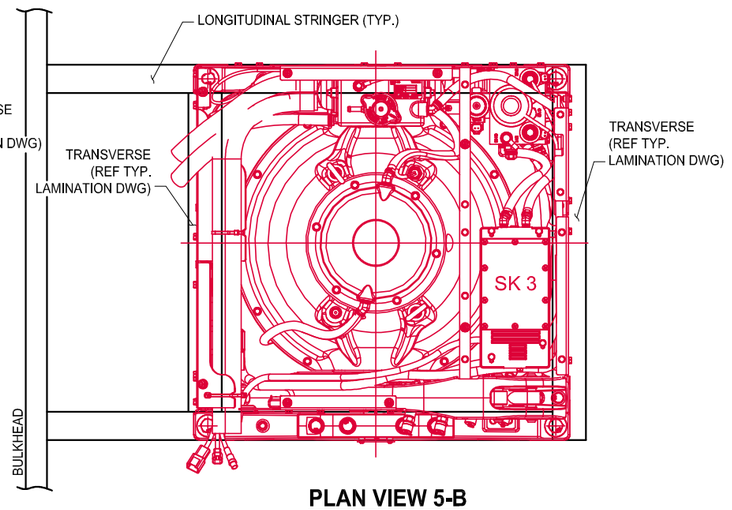


MINIMAL CLEARANCE FOR CABLES / HOSES (TYP.)



PLAN VIEW 7-B

(LAMINATED FRP MOLDED METHOD 1-A NEAR BULKHEAD)



PLAN VIEW 5-B

(LAMINATED FRP MOLDED METHOD 1-A FAR FROM BULKHEAD)

1-A

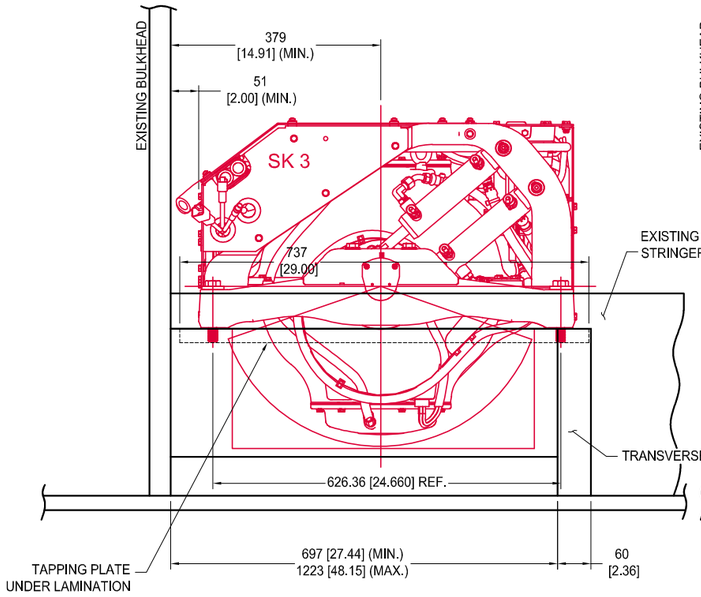
SEAKEEPER 3 GYRO, BOLT-IN LAMINATED FRP MOLDED

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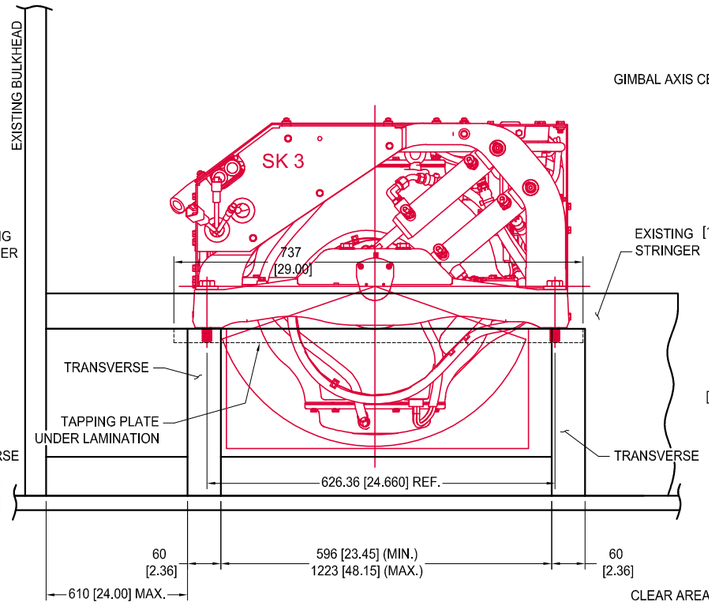
SEAKEEPER
Seakeeper Inc, 44425 Pecan Court, Suite 151 California, MD 20619

WEIGHT - LBS:		NAME:	SK3 GYRO, BOLT-IN LAMINATED FRP MOLDED
MATERIAL:	DRAWN: RLK	DATE: 24FEB2022	
	ENG APPR: JC	DATE: 24FEB2022	DWG NUMBER: 90591
	PROD APPR:	DATE:	REV. NO.: 1 SHEET NO.: 1 OF 11



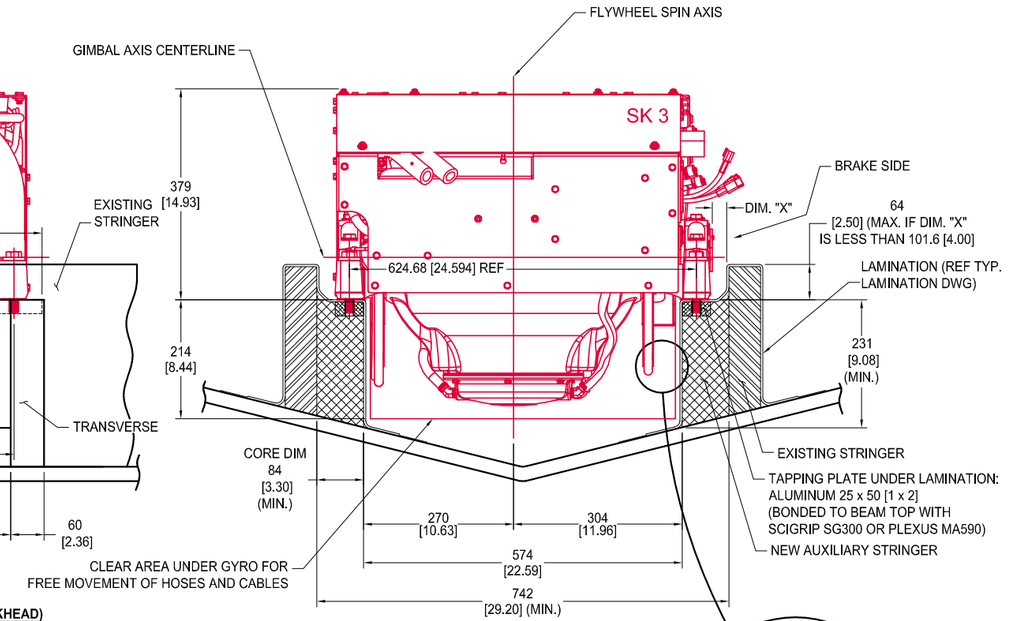
ELEVATION VIEW 7-C

(LAMINATED FRP REFITTED METHOD 1-B NEAR BULKHEAD)



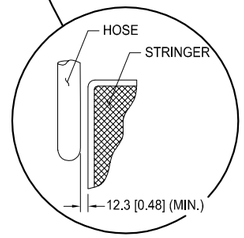
ELEVATION VIEW 5-C

(LAMINATED FRP REFITTED METHOD 1-B FAR FROM BULKHEAD)

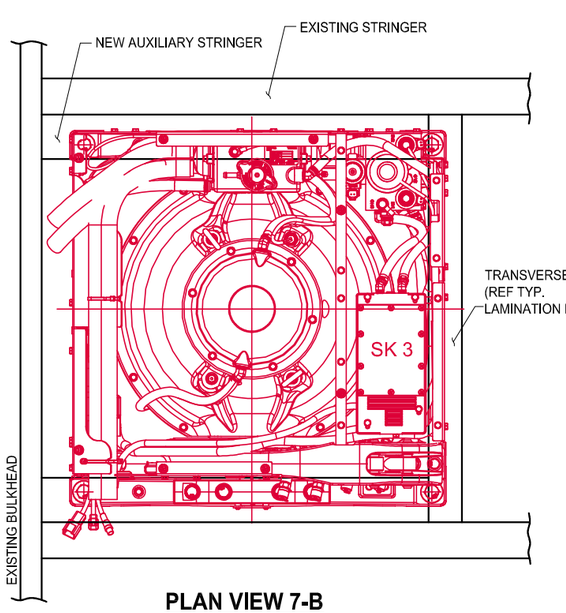


SECTION 2-C

(LAMINATED FRP REFITTED METHOD 1-B)

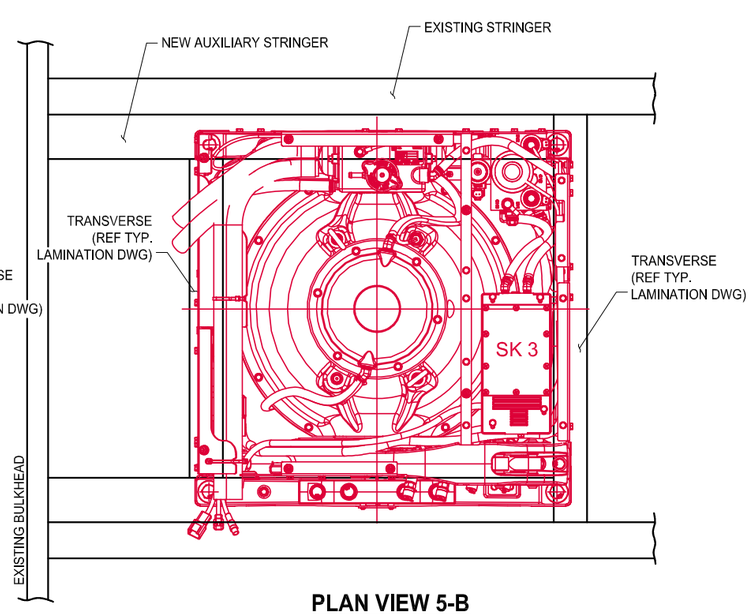


MINIMAL CLEARANCE FOR CABLES / HOSES (TYP.)



PLAN VIEW 7-B

(LAMINATED FRP REFITTED METHOD 1-B NEAR BULKHEAD)



PLAN VIEW 5-B

(LAMINATED FRP REFITTED METHOD 1-B FAR FROM BULKHEAD)

1-B

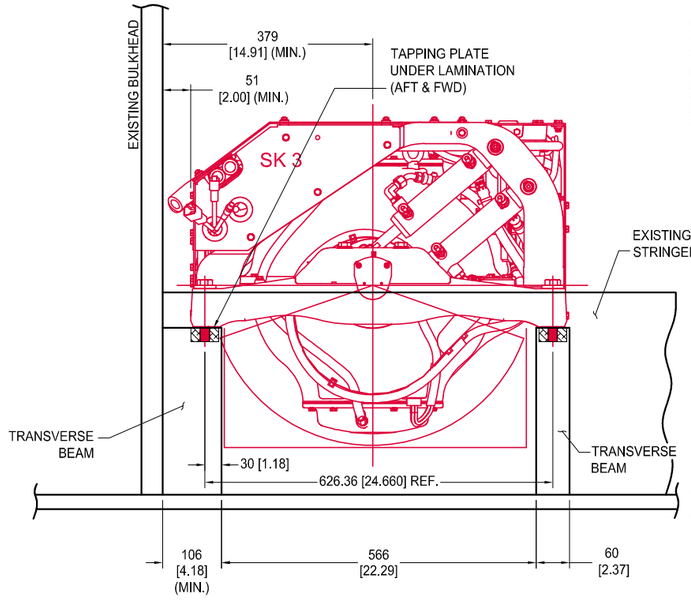
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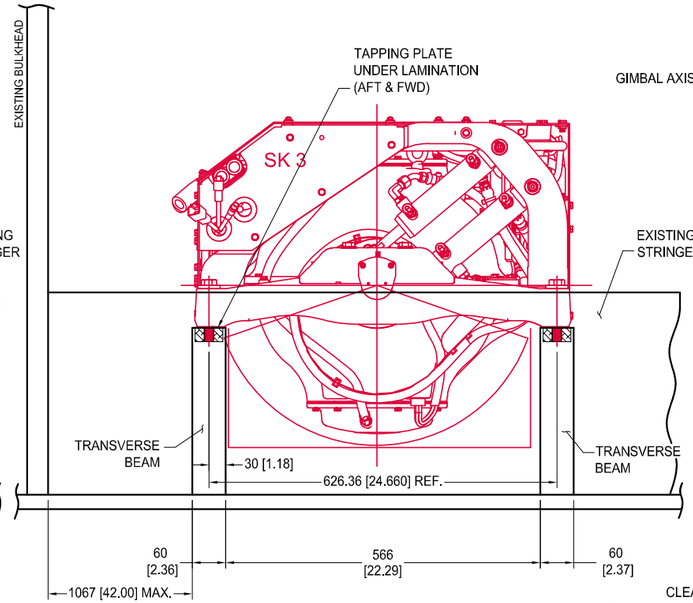
SEAKEEPER
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WEIGHT - LBS:		NAME:	SK3 GYRO, BOLT-IN LAMINATED FRP REFITTED
MATERIAL:	DRAWN: RLK	DATE: 24FEB2022	
	ENG APPR: JC	DATE: 24FEB2022	DWG NUMBER: 90591
	PROD APPR:	DATE:	REV. NO.: 1 SHEET NO.: 2 OF 11



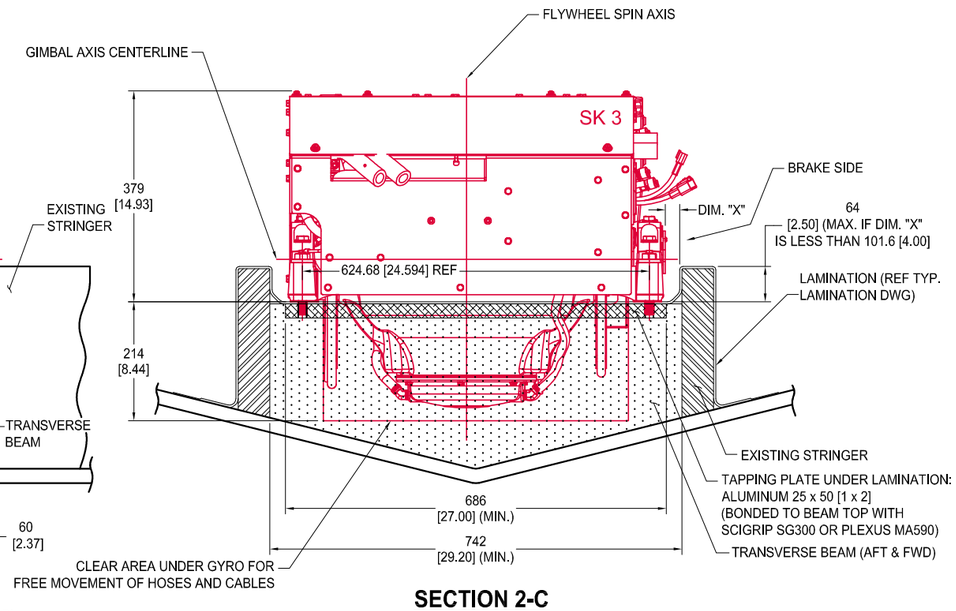
ELEVATION VIEW 7-C

(LAMINATED TRANSVERSE BEAM METHOD 1-C NEAR BULKHEAD)



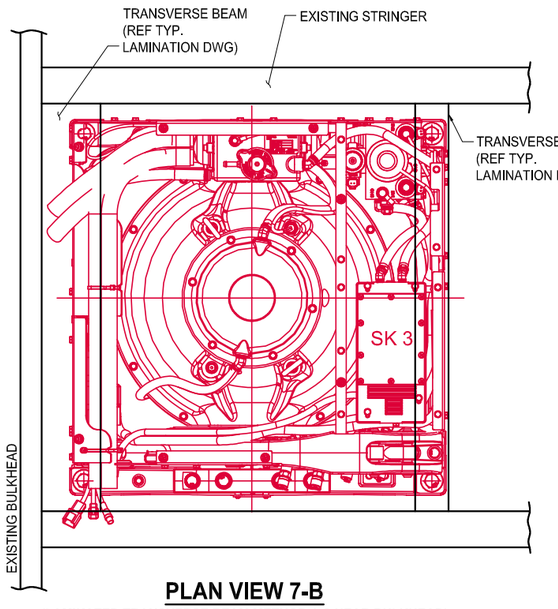
ELEVATION VIEW 5-C

(LAMINATED TRANSVERSE BEAM METHOD 1-C FAR FROM BULKHEAD)



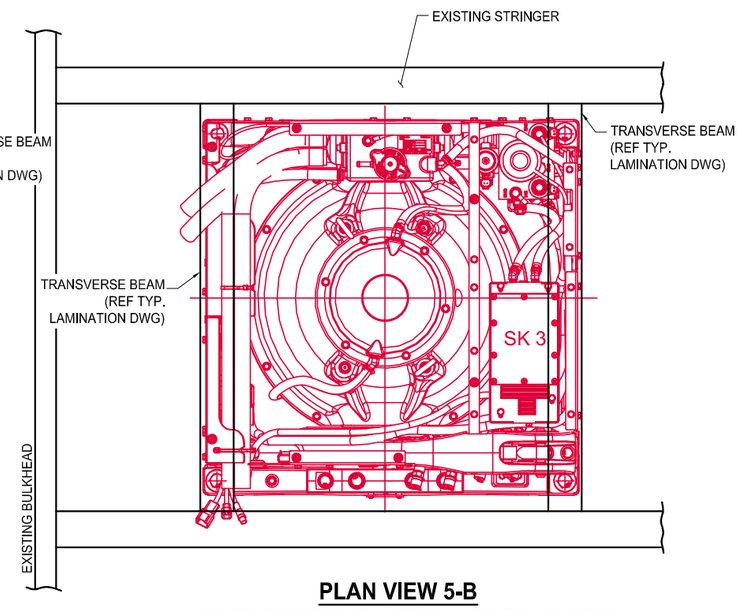
SECTION 2-C

(LAMINATED TRANSVERSE BEAM METHOD 1-C)



PLAN VIEW 7-B

(LAMINATED TRANSVERSE BEAM METHOD 1-C NEAR BULKHEAD)



PLAN VIEW 5-B

(LAMINATED TRANSVERSE BEAM METHOD 1-C FAR FROM BULKHEAD)

1-C

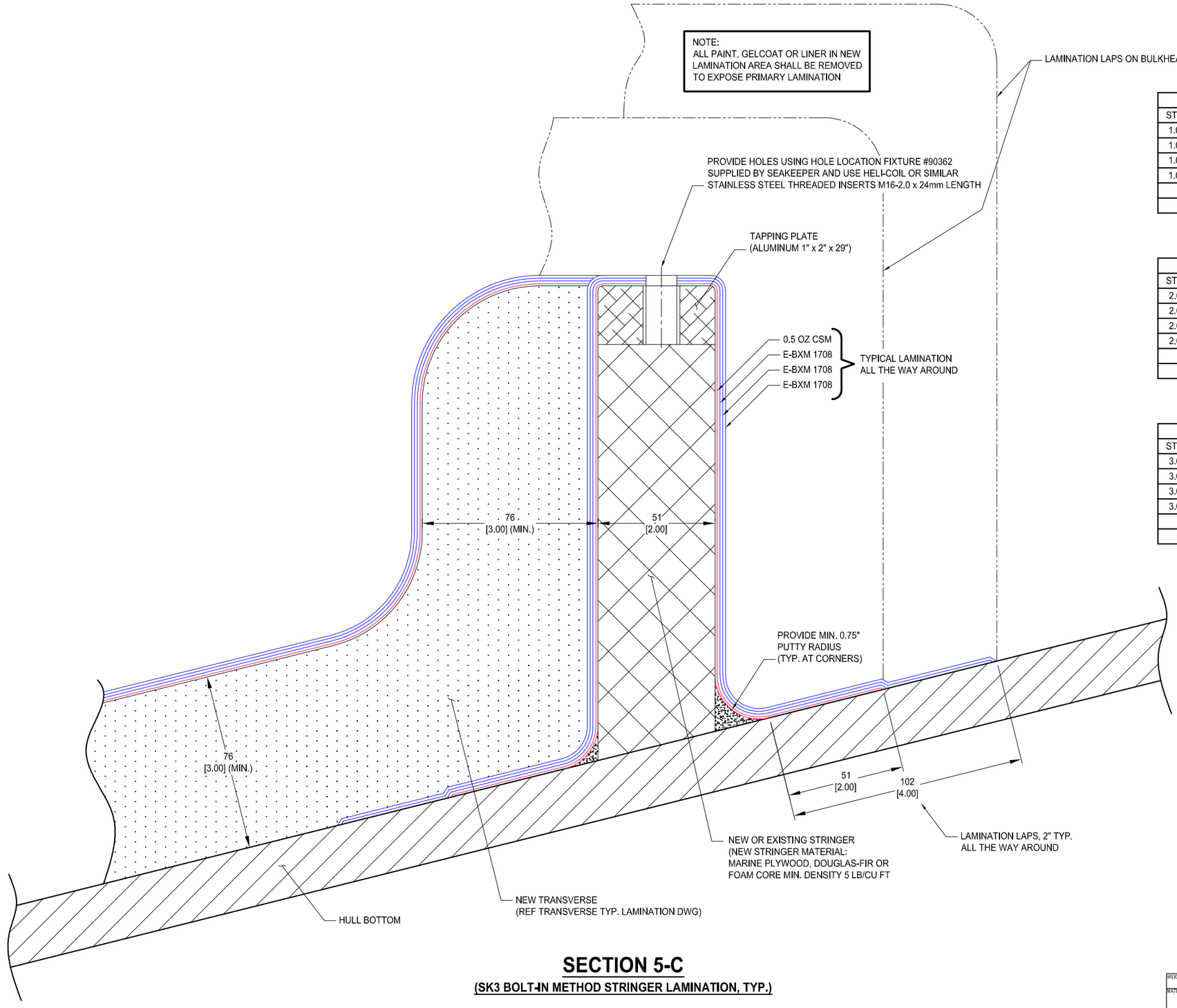
SEAKEEPER 3 GYRO, BOLT-IN LAMINATED TRANSVERSE BEAM

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WEIGHT - LBS:		NAME:	SK3 GYRO, BOLT-IN LAMINATED TRANSVERSE BEAM
MATERIAL:	DRAWN: RLK	DATE: 24FEB2022	
	ENG APPR: JC	DATE: 24FEB2022	DWG NUMBER: 90591
	PROD APPR:	DATE:	REV: 1 SHEET NO: 3 OF 11



1.TYPICAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
1.01	0.5 OZ CSM	0.012
1.02	E-BXM 1708	0.048
1.03	E-BXM 1708	0.048
1.04	E-BXM 1708	0.048
COMPOSITE THICKNESS		0.156

2. OPTIONAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
2.01	0.5 OZ CSM	0.012
2.02	E-LTM 1808	0.047
2.03	E-LTM 1808	0.047
2.04	E-LTM 1808	0.047
COMPOSITE THICKNESS		0.153

3. OPTIONAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
3.01	0.5 OZ CSM	0.012
3.02	E-LTM 2408	0.056
3.03	E-LTM 2408	0.056
3.04	E-LTM 2408	0.056
COMPOSITE THICKNESS		0.180

SECTION 5-C

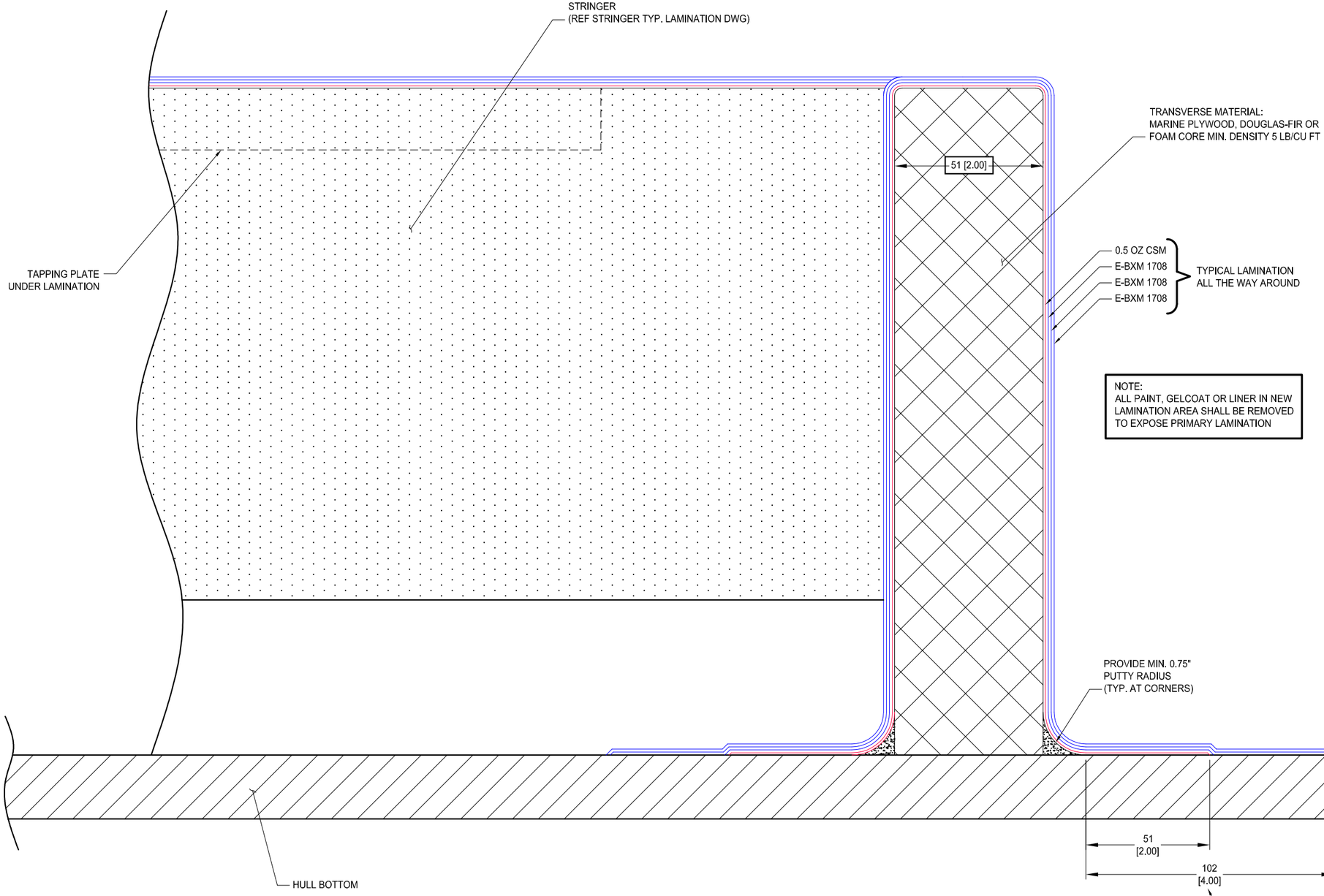
(SK3 BOLT-IN METHOD STRINGER LAMINATION, TYP.)

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WEIGHT - LBS:		NAME:	SK3 GYRO, BOLT-IN STRINGER LAMINATION
MATERIAL:	DRAWN: RLK DATE: 24FEB2022		
	ENG APPR: JC DATE: 24FEB2022	DWG NUMBER: 90591	REV. NO.: 1
	PROD APPR: DATE:		SHEET NO.: 4 OF 11



1.TYPICAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
1.01	0.5 OZ CSM	0.012
1.02	E-BXM 1708	0.048
1.03	E-BXM 1708	0.048
1.04	E-BXM 1708	0.048
COMPOSITE THICKNESS		0.156

2. OPTIONAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
2.01	0.5 OZ CSM	0.012
2.02	E-LTM 1808	0.047
2.03	E-LTM 1808	0.047
2.04	E-LTM 1808	0.047
COMPOSITE THICKNESS		0.153

3. OPTIONAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
3.01	0.5 OZ CSM	0.012
3.02	E-LTM 2408	0.056
3.03	E-LTM 2408	0.056
3.04	E-LTM 2408	0.056
COMPOSITE THICKNESS		0.180

NOTE:
ALL PAINT, GELCOAT OR LINER IN NEW LAMINATION AREA SHALL BE REMOVED TO EXPOSE PRIMARY LAMINATION

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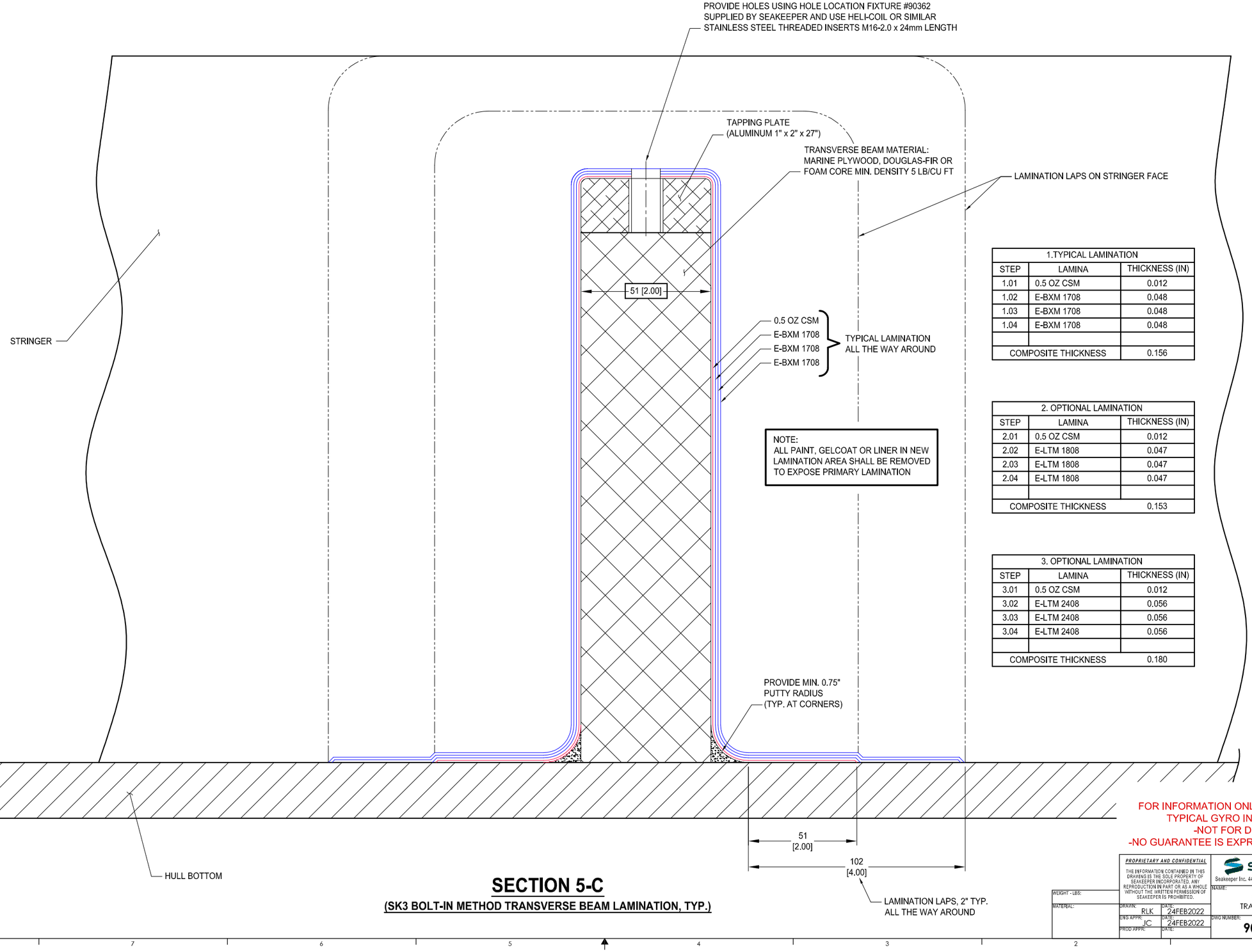
SECTION 5-C

(SK3 BOLT-IN METHOD TRANSVERSE LAMINATION, TYP.)

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WEIGHT - LBS:
MATERIAL:
DRAWN: RLK DATE: 24FEB2022
ENG APPR: JC DATE: 24FEB2022
PROD APPR: DATE:
NAME: SK3 GYRO, BOLT-IN TRANSVERSE LAMINATION
DWG NUMBER: 90591
REV. NO.: 1
SHEET NO.: 5 OF 11



1.TYPICAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
1.01	0.5 OZ CSM	0.012
1.02	E-BXM 1708	0.048
1.03	E-BXM 1708	0.048
1.04	E-BXM 1708	0.048
COMPOSITE THICKNESS		0.156

2. OPTIONAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
2.01	0.5 OZ CSM	0.012
2.02	E-LTM 1808	0.047
2.03	E-LTM 1808	0.047
2.04	E-LTM 1808	0.047
COMPOSITE THICKNESS		0.153

3. OPTIONAL LAMINATION		
STEP	LAMINA	THICKNESS (IN)
3.01	0.5 OZ CSM	0.012
3.02	E-LTM 2408	0.056
3.03	E-LTM 2408	0.056
3.04	E-LTM 2408	0.056
COMPOSITE THICKNESS		0.180

SECTION 5-C

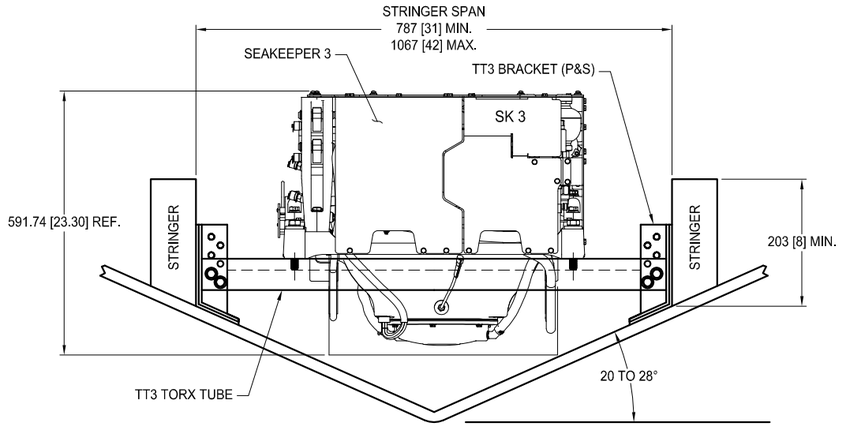
(SK3 BOLT-IN METHOD TRANSVERSE BEAM LAMINATION, TYP.)

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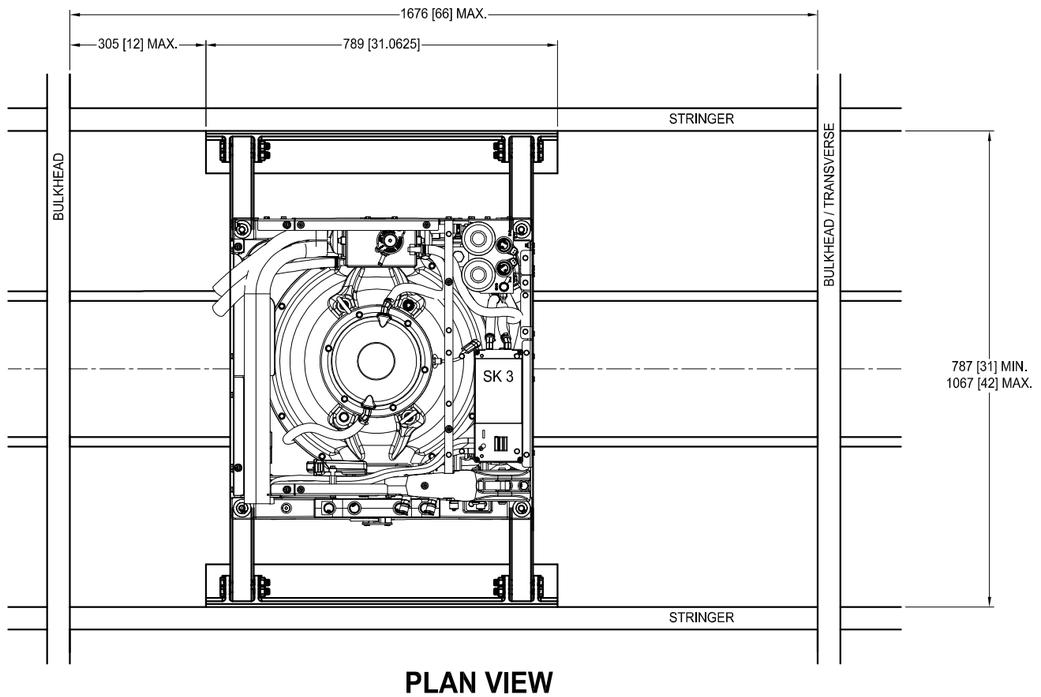
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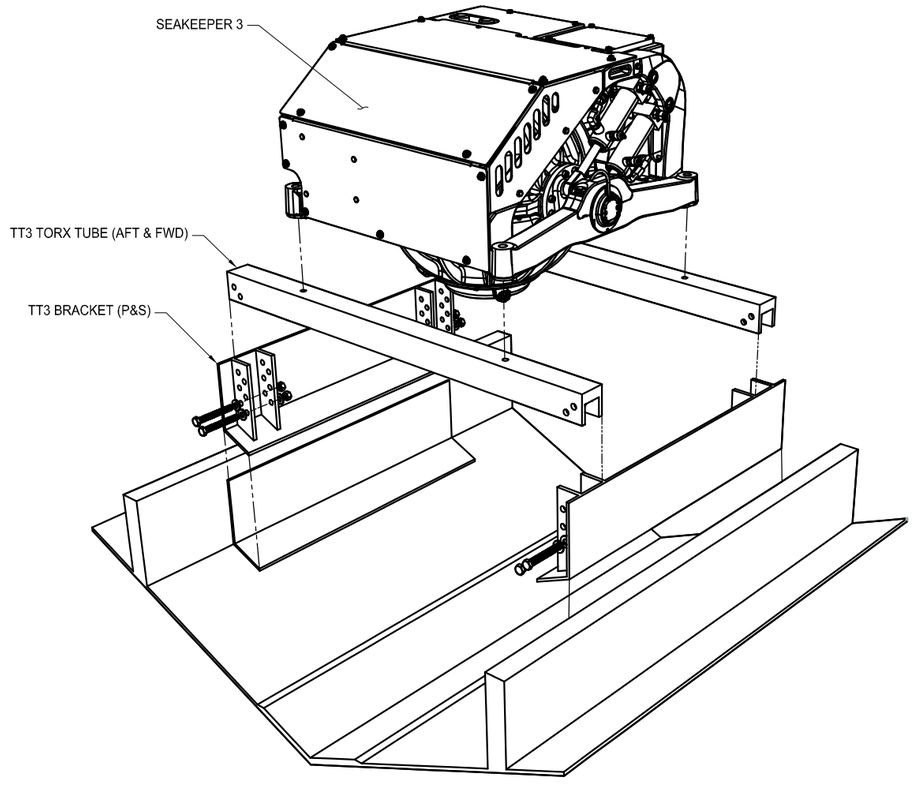
WEIGHT - LBS:		NAME:	SK2 GYRO, BOLT-IN TRANSVERSE LAMINATION
MATERIAL:		DRAWN: RLK	DATE: 24FEB2022
		ENG APPR: JC	DATE: 24FEB2022
		PROD APPR:	DATE:
		DWG NUMBER: 90591	REV: 1 SHEET NO: 6 OF 11



SECTION



PLAN VIEW



ISO VIEW

NOTES FOR TT3 TORX TUBE APPLICABILITY RANGE:
1) DEADRISE CAN VARY FROM 20-28 DEGREES
2) CROSS BRACES ARE PROVIDED AT FULL LENGTH AND CAN BE CUT TO LENGTH FOR STRINGERS SPACED BETWEEN 31" AND 42".
3) OUTBOARD SADDLES TO BE GLUED TO STRINGERS USING PLEXUS MA590 WITH MINIMUM BOND THICKNESS OF 0.125" AND MAX BOND THICKNESS OF 0.625".
4) MINIMUM HULL LAMINATION REQUIREMENT OUTLINED IN 4.1 AND 4.2 -- NOTE THAT THE LAMINATE THICKNESS, STRENGTH, AND STIFFNESS. MUST BE EQUAL TO OR GREATER THAN EITHER OF THE LAMINATES SUGGESTED:
   4.1) 3 OZ CSM, 3 X E-LTM 2415
   4.2) 3 OZ CSM, 3 X E-WMV 2415
5) MINIMUM STRINGER LAMINATION OUTLINED IN 5.1 AND 5.2 -- NOTE THAT THE LAMINATE THICKNESS, STRENGTH, AND STIFFNESS MUST BE EQUAL TO OR GREATER THAN EITHER OF THE LAMINATES SUGGESTED:
   5.1) 3 X 3 OZ CSM
   5.2) 2 X E-LTM 2408
6) MINIMUM STRINGER HEIGHT IS 7.5" MEASURED FROM THE STRINGER CAP TO THE HULL BOTTOM INNER SKIN.
7) STRINGER WIDTH SHALL BE BETWEEN 1" AND 6".
8) IF CORED, THE STRINGER ULTIMATE SHEAR STRESS X CORE THICKNESS NEEDS TO BE GREATER THAN 355 LBS/IN.
9) STRINGER ATTACHMENT TO HULL BOTTOM IS ASSUMED TO BE ROBUST WITH LAMINATE LAPS AND FILLETS TO MINIMIZE STRESS.
10) IF STRINGERS ARE MADE OF WOOD, MINIMUM THICKNESS IS 0.75" AND THEY MUST BE REINFORCED WITH THE MINIMUM LAMINATE AS DESCRIBED IN NOTE 5.
11) MINIMUM DISTANCE FROM BULKHEAD IS 12", TOTAL MAX PANEL LENGTH IS 66".
12) INSTALLATIONS OUTSIDE OF THE RECOMMENDED REQUIREMENTS ARE NOT WITHIN WARRANTY PROVISIONS AND NEED TO BE ANALYZED ON A CASE BY CASE BASIS.

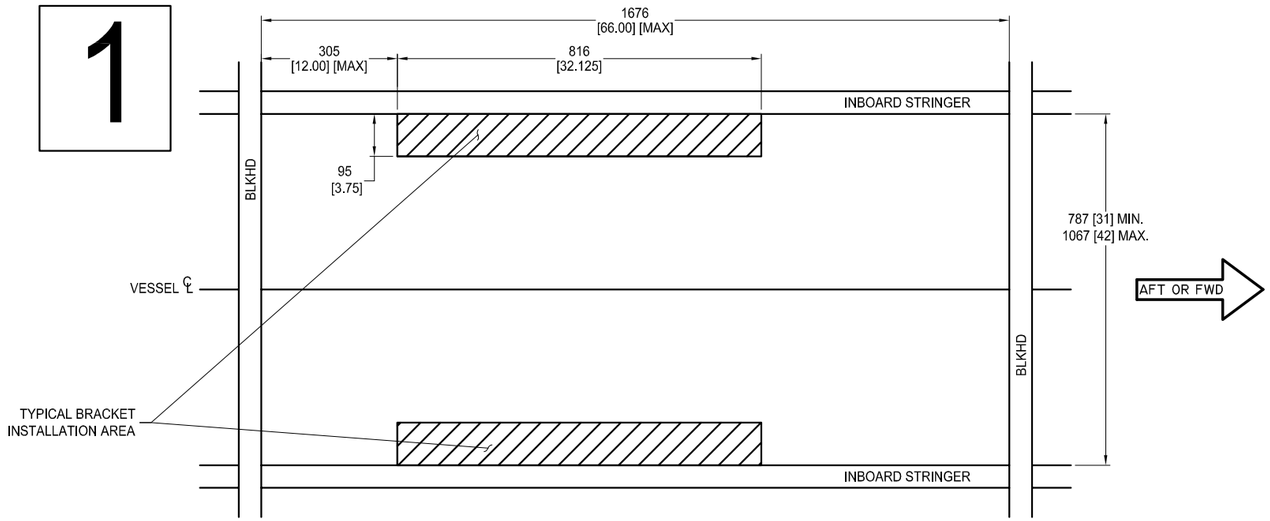
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WEIGHT - LBS:		NAME:	TT3 TORX TUBE APPLICABILITY RANGE
MATERIAL:	DRAWN: RLK	DATE: 24FEB2022	
	ENG APPR: JC	DATE: 24FEB2022	DWG NUMBER: 90591
	PROD APPR:	DATE:	REV. NO: 1 SHEET NO: 7 OF 11

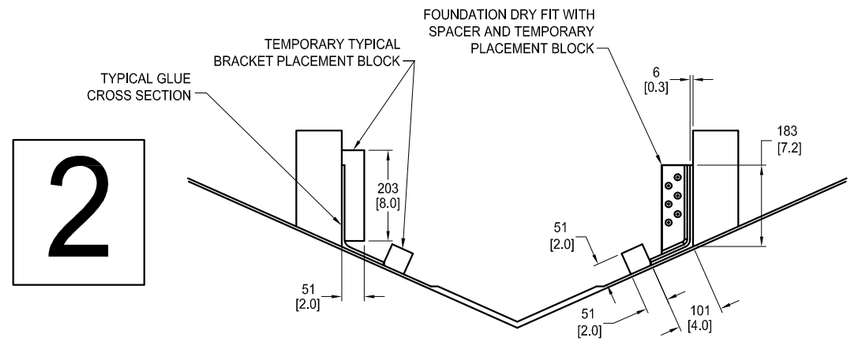
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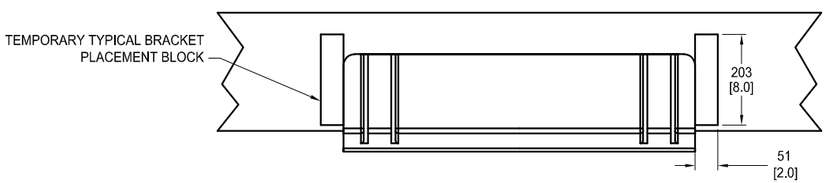
DETERMINE DESIRED INSTALLATION LOCATION AND ENSURE THAT THE DISTANCE FROM A BULKHEAD IS 12" OR LESS.
ENSURE HULL AND STRINGER LAMINATE IN WAY OF THE INSTALLATION IS CLEAR OF ANY AIR POCKETS OR DELAMINATION.
CONFIRM THE HULL LAMINATE, STRINGER LAMINATE, HULL PANEL SIZE, AND STRINGER SIZE AND SPACING ARE WITHIN THE GUIDELINES FOR TT3 TORX TUBE APPLICABILITY.
DRILL VISIBILITY HOLE IN SIDEWALL OF STRINGER TO MEASURE LAMINATE THICKNESS.

BARE HULL TOP VIEW

2



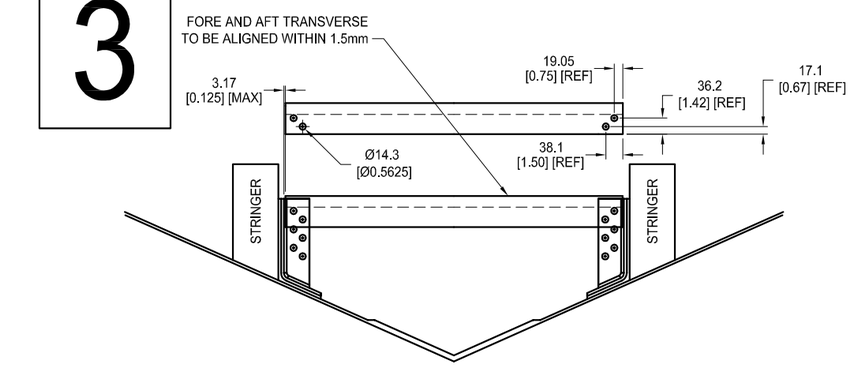
TYPICAL SECTION



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
SHOWN BRACKET PLACEMENT BLOCK

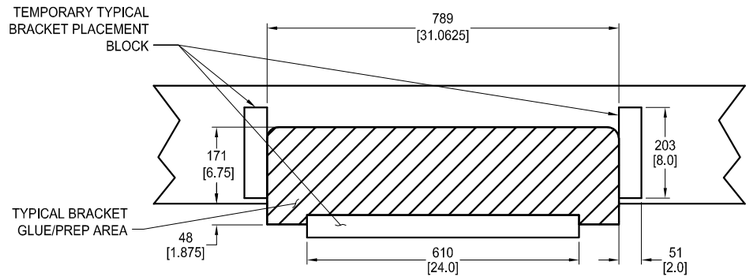
3



MEASURE DISTANCE BETWEEN FOUNDATIONS AND CUT TRANSVERSE PIECES TO LENGTH.
DISTANCE BETWEEN END OF TRANSVERSE AND FOUNDATION SHALL BE NO GREATER THAN 1/8" PER PER SIDE.
DRY FIT TRANSVERSE SUPPORTS AND LEVEL MOUNTING LOCATIONS TO BE PLANAR.
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.

EXPLODED SECTION

4



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
SHOWN GLUE PREPARATION AREA

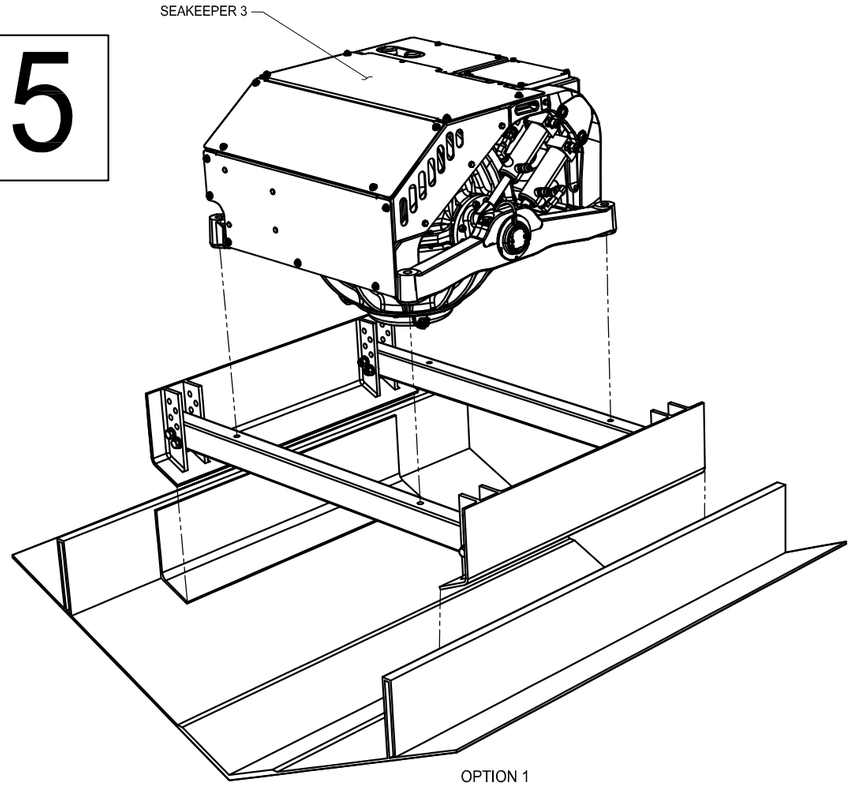
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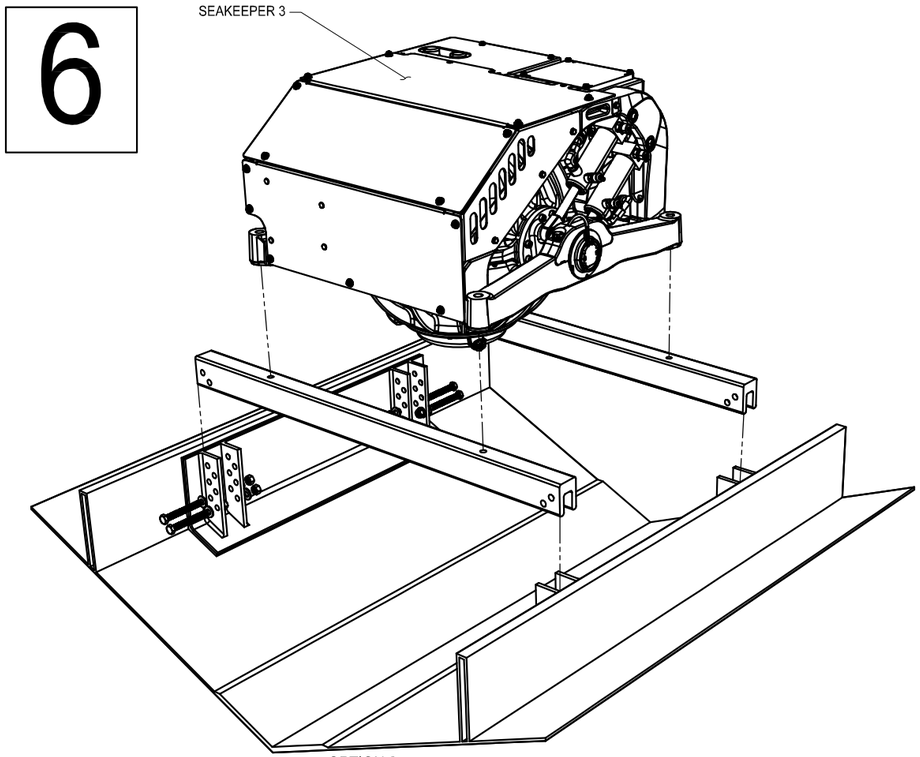
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MATERIAL:	DRAWN: RLK DATE: 24FEB2022		
	ENG APPR: JC DATE: 24FEB2022	DWG NUMBER: 90591	REV. NO: 1
	PROD APPR: DATE:		SHEET NO: 8 OF 11

5

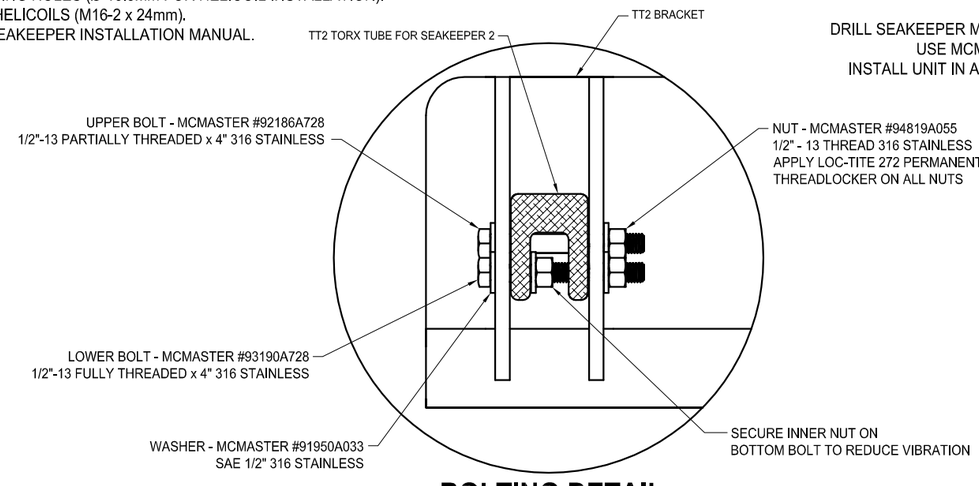


OPTION 1
ASSEMBLE ALL COMPONENTS OUTSIDE OF THE VESSEL AND LOWER INTO HULL.
AFTER DRY FIT AND TRANSVERSE HOLE DRILLING, ASSEMBLE ALL FOUR PIECES.
REFER TO BOLTING DETAIL.
TORQUE BOLTS TO 45 FT-LBS.
APPLY PLEXUS MA590 OR SCIGRIP SG300 - TROWEL ON USING 0.5" V-GROOVE TOOL.
SET FOUNDATIONS IN PLACE - ENSURING 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 (Ø 16.5mm FOR HELICOIL INSTALLATION).
USE MCMASTER #91732A675 HELICOILS (M16-2 x 24mm).
INSTALL UNIT IN ACCORDANCE WITH SEAKEEPER INSTALLATION MANUAL.

6



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 (Ø 16.5mm FOR HELICOIL INSTALLATION).
USE MCMASTER #91732A675 HELICOILS (M16-2 x 24mm).
INSTALL UNIT IN ACCORDANCE WITH SEAKEEPER INSTALLATION MANUAL.



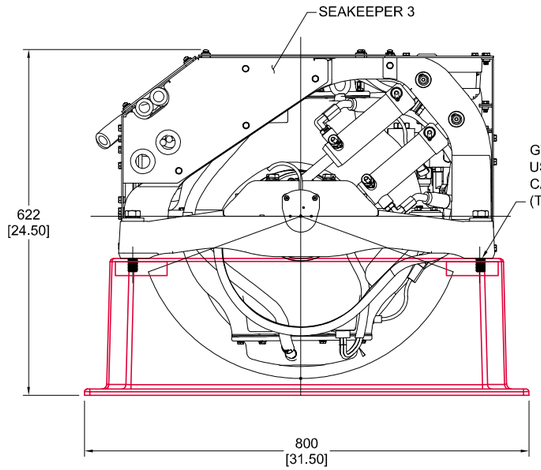
BOLTING DETAIL

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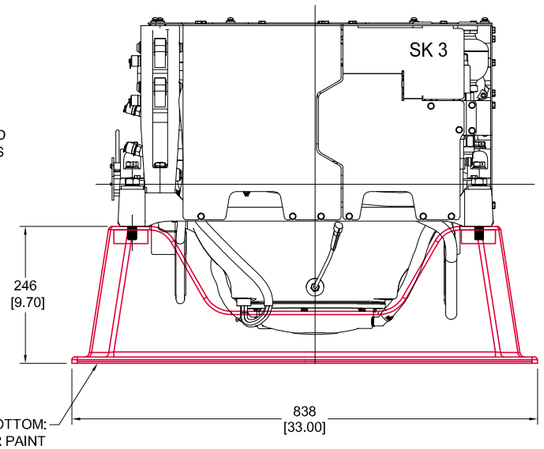
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WEIGHT - LBS:		NAME:	TT3 TORX TUBE INSTALLATION DRAWING
MATERIAL:	DRAWN: RLK	DATE: 24FEB2022	
	ENG APPR: JC	DATE: 24FEB2022	DWG NUMBER: 90591
	PROD APPR:	DATE:	REV. NO: 1
			SHEET NO: 9 OF 11



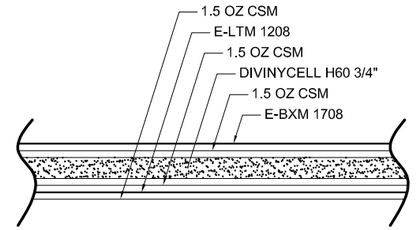
ELEVATION



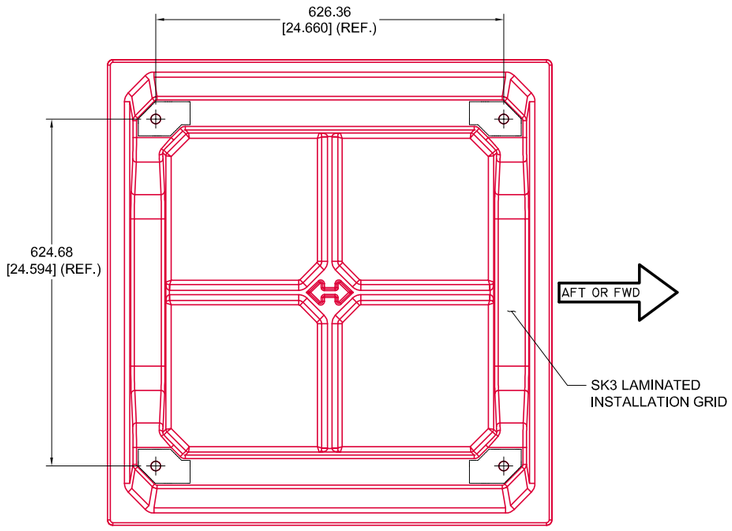
FRONT VIEW

GENERAL NOTES:

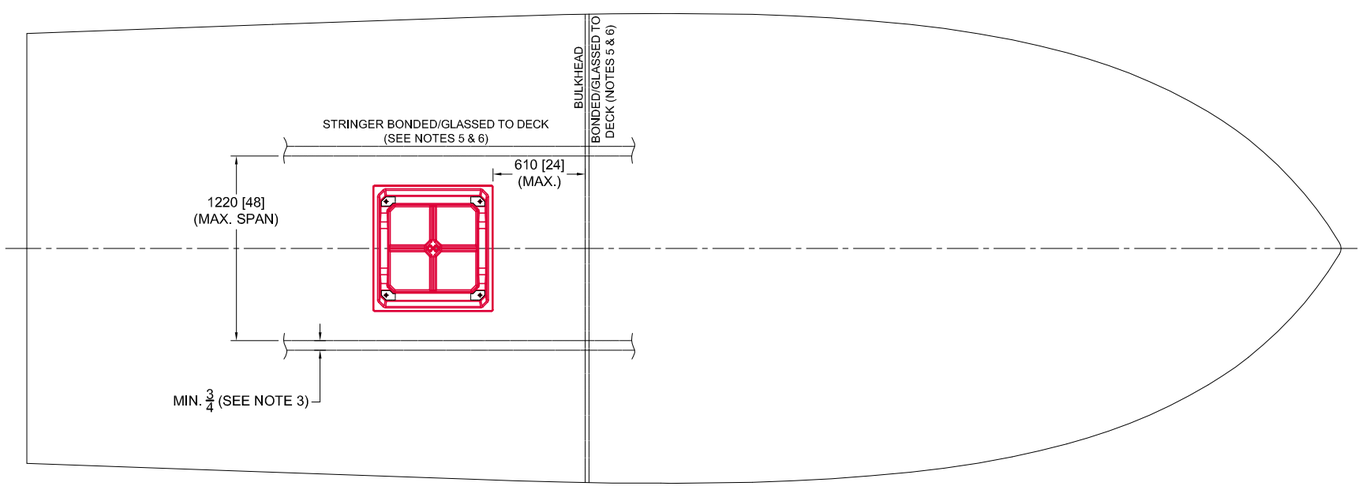
1. SEAKEEPER 3 GRID FOUNDATION SHALL BE BONDED TO DECK SOLE WITH SCIGRIP SG300 OR PLEXUS MA590 ADHESIVE (MIN. TENSILE STRENGTH OF 2000 PSI). ANY PAINT, GELCOAT OR NON-SKID PRESENT IN DECK BOND AREA SHALL BE SANDED TO EXPOSE PRIMARY LAMINATION.
2. SAND GRID BOTTOM SURFACE.
3. BOND ENTIRE GRID BOTTOM SURFACE ENSURING 0.04" TO O.12" OF BOND THICKNESS.
4. MAXIMUM SPAN IN DECK BASED IN DECK SOLE LAMINATION WITH MINIMAL LAMINATE EQUIVALENT TO 1.5 OZ CSM / E-LTM 1208 / 1.5 OZ CSM / DIVINYCELL CORE H60 3/4" / 1.5 OZ CSM / E-BXM 1708.
5. INSTALLATION CONDITION REQUESTS STRINGERS AND BULKHEAD FULLY BONDED TO DECK USING POLY-BOND B39 OR SIMILAR STRUCTURAL ADHESIVE (MIN. TENSILE STRENGTH OF 1000 PSI).
6. LAMINATION OF STRINGER & BULKHEAD TO DECK USING 2 x E-BXM 1708 TAPE IS HIGHLY RECOMMENDED.



DECK LAMINATION CONDITION DESCRIBED IN NOTE 4



PLAN VIEW



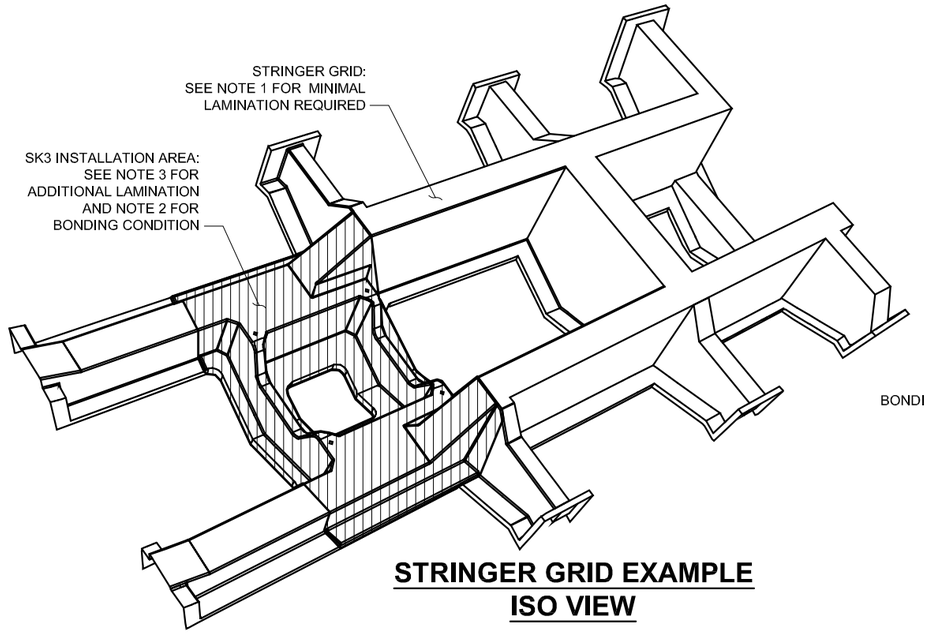
DECK INSTALLATION MINIMUM CONDITION

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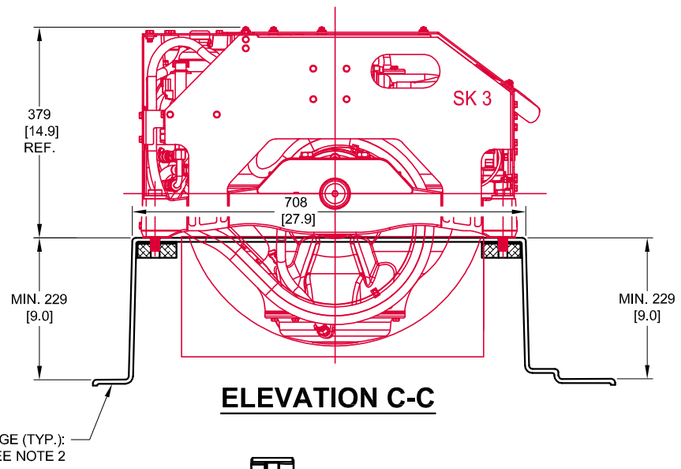
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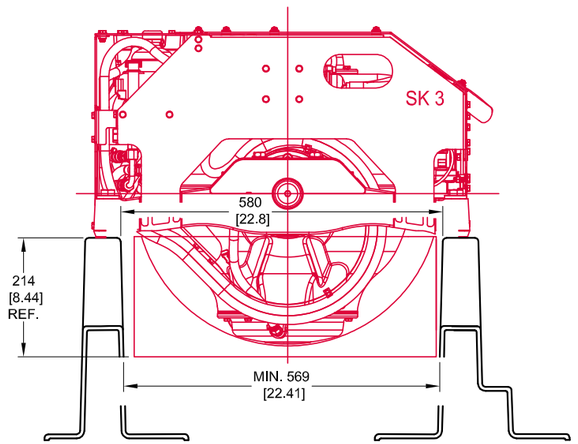
WEIGHT - LBS:		NAME:	SK3 GYRO, BOLT-IN DECK MOUNT INSTALLATION
MATERIAL:	DRAWN: RLK	DATE: 24FEB2022	
	ENG APPR: JC	DATE: 24FEB2022	
	PROD APPR:	DATE:	
	DWG NUMBER: 90591	REV: NO.1	SHEET NO. 10 OF 11



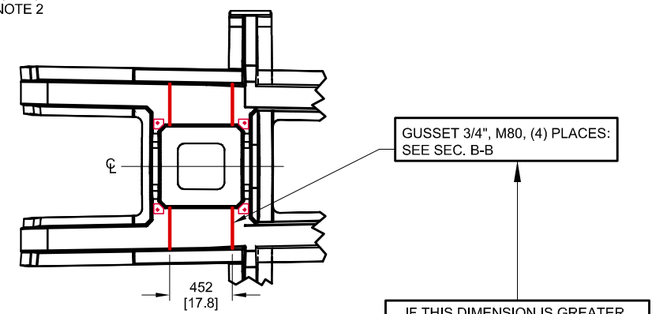
STRINGER GRID EXAMPLE ISO VIEW

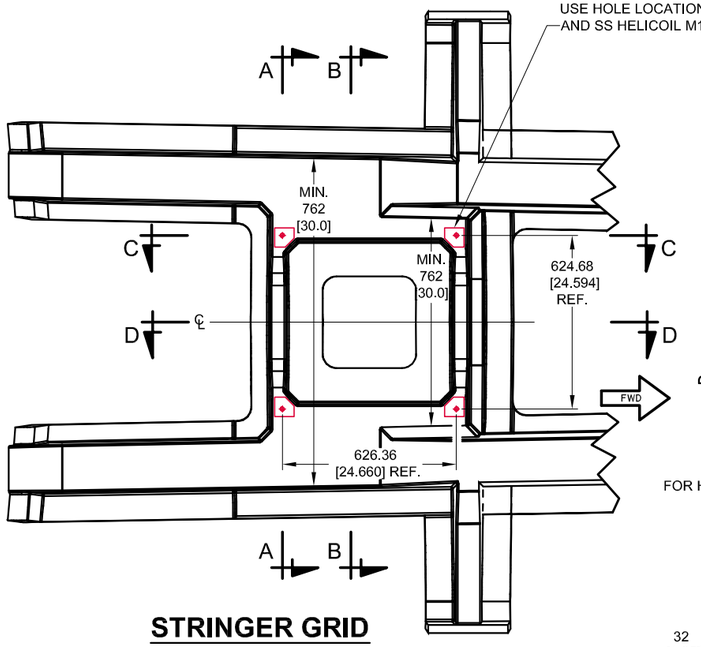


ELEVATION C-C

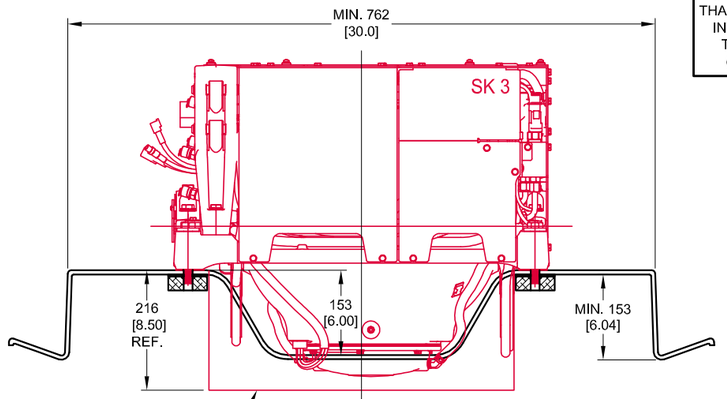


ELEVATION D-D



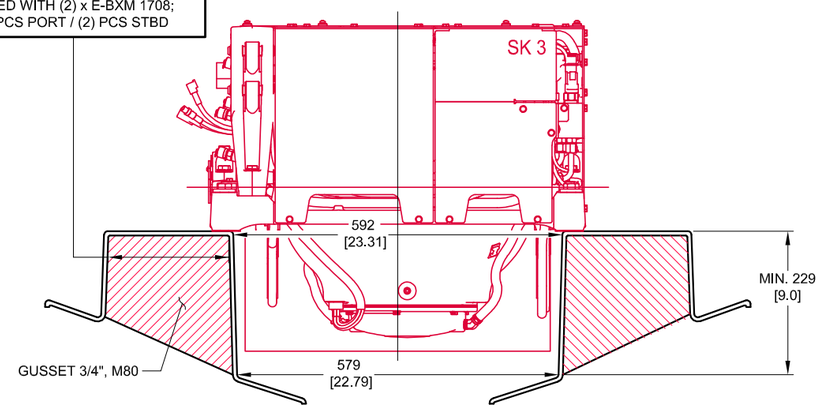


STRINGER GRID PLAN VIEW

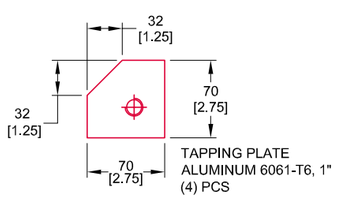


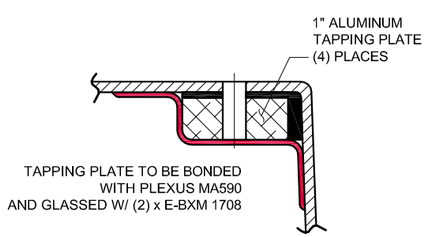
SECTION A-A

IF THIS DIMENSION IS GREATER THAN 5", INSTALL 3/4" M80 GUSSETS INTERNALLY, AND LAMINATED & TAPED WITH (2) x E-BXM 1708; (2) PCS PORT / (2) PCS STBD



SECTION B-B
LOOKING FWD





GENERAL NOTES:

1. STRINGER GRID MINIMAL LAMINATE EQUIVALENT TO 3 OZ CSM AND (2) x E-WMV 2415.
2. STRINGER GRID SHALL BE APPROPRIATELY BONDED TO HULL. SEAKEEPER AREA SHALL BE FULLY BONDED USING SCIGRIP SG300 OR PLEXUS MA590 ADHESIVES WITH MINIMAL THICKNESS OF 1/8".
3. STRINGER GRID IN SEAKEEPER INSTALLATION AREA SHALL RECEIVE ADDITIONAL LAMINATION EQUIVALENT TO 0.5 OZ CSM AND (6) x E-BXM 1708.
4. INSTALLATIONS OUTSIDE OF THE RECOMMENDED REQUIREMENTS NEED TO BE ANALYZED ON A CASE BY CASE BASIS.
5. INSTALL UNIT IN ACCORDANCE WITH SEAKEEPER INSTALLATION MANUAL.

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WEIGHT - LBS:		NAME:	SK3 GYRO, BOLT-IN MOLDED STRINGER GRID INSTALLATION
MATERIAL:		DRAWN: RLK	DATE: 05MAY2022
		ENG APPR: JC	DATE: 05MAY2022
		PROD APPR:	DATE:
		DWG NUMBER: 90591	REV: 1 SHEET NO: 11 OF 11