



SEA-BIRD ELECTRONICS, INC.

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SBE P/N 50133

DATE	REV	REVISION RECORD	AUTH	DR	CHK
07.03	A	Remove old screws, Add Drawing	DB	MJ	
11.04	B	New Drawing Revision		KLP	
7.05.05	C	ECN #855: Screw replacement	CB	KLP	
5.31.07	D	ECN #1091: Update parts	CB	PC	

Titanium Latch, Pylon Spares Kit

Kit Contents – O-Rings

SBE P/N	Manufacturer P/N	Primary SBE Application	QTY
30097	Parker, 2-111N674-70	Actuator O-Ring	4
30618	Parker, 2-106E962-90	Latch Spacer O-Ring	12
30815	Parker, 2-233E603-70	Pylon Endcap O-Rings	2

Kit Contents – Hardware

SBE P/N	Manufacturer P/N	Primary SBE Application	QTY
23684	SBE 32 Ground strap	Pylon ground strap, connector endcap	1
30044	Seacat Anode	Replacement anodes for pylons, hubs, and cages, Aluminum	2
30116	Mach screw 2-56 x 3/8 PH SS	Actuator Endcap: Secure coil terminate PCB to endcap	2
30137	Mach screw 6-32 x 1/4 PH SS	Attaches SBE32 ground strap to coil/actuator endcap	1
30154	Mach screw 8-32 x 3/8	Attaches CTD grounding strap to connector endcap	1
30164	Mach screw 8-32 x 1-1/8 PH SS	Fastens bottom endcap to housing.	4
30235	Washer, #2 nylon	Actuator Endcap: Use with coil terminate screws (30116)	2
30238	Washer, #4 flat	Actuator Endcap Assembly: Use after lock washer with actuator endcap securing screws (30586)	6
30241	Washer, #6 nylon	For ground strap securing screw (30137)	6
30249	Washer, #10 flat	For trigger mount disk hardware (30587)	3
30250	Washer, # 10 split ring lock	For trigger mount disk hardware (30587)	3
30254	Washer, 1/4 split ring lock	For Pylon Hardware, 30602, 30570, 30294	6
30267	Screw Insul, #8 x 1/2	Used with endcap to housing fastening screws (30164)	4
30271	Spacer, #2 x 1/8, nylon	Actuator Endcap: Under coil terminate with screws (30116)	2
30294	Screw Insul, 1/4 x 1/4	Actuator Endcap to Hub	6
30526	Mach screw 1/4-20 x 3/4, plastic	Plug Jackscrew holes	3
30570	Washer, 1/4 flat, SS	Pylon hub to Bale	6
30586	Screw, 4-40 x 1-1/2 Socket head	Actuator Endcap: Secure Actuator into recesses in endcap	6
30587	10-32 x 3/4 Socket Head	Trigger mount disk to Actuator Endcap / coil	3
30588	Screw, 6-32 x 2" PH	Secure actuator endcap to trigger housing	6
30602	Screw, 1/4-20 x 2-1/4 S SH SS	Hub to Actuator Endcap	6
30604	Screw Insul, #10 x 1/4	For Trigger Mount Disk Hardware (30587)	3
30606	Screw Insul, #4 x 1/2"	For Actuator Endcap Hardware (30586)	6
30657	Mach screw 2-56 x 3/8 FH	Trigger: Secure cover plate and slider to side plate	6
30658	Mach screw 6-32 x 11/16 FH	Trigger Assembly: Secure retainer disk to mount disk	6
30659	Mach screw 4-40 x 13/16 FH	Trigger Assembly: Attach support bars to trigger assembly	12
30663	SBE 32 Latch spring	Trigger Assembly: Provide recoil motion in slider	3
31394	Mach screw 10-24 x 1/2 FH	Secure Trigger Dummies to mount disk	6

SBE Drawings:

76064D Pylon Latch Assembly

Sea-Bird Electronics Procedure

PROCEDURE NUMBER: **67023**

TITLE: **SBE 32 Pylon Ti Latch Spares**

REVISION: **D**

EFFECTIVE DATE: **07/05/2005**

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PAGE 1 of 2



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APPLICATIONS:

Pylon Assemblies, 6800m

SBE P/N	Part Description	Primary SBE Application	QTY
30815	Parker, 2-233E603-70	Pylon Endcap O-Rings	2
23684	SBE 32 Ground strap	Pylon ground strap, connector endcap	1
30044	Seacat Anode	Replacement anodes for pylons, hubs, and cages, Aluminum	2
30137	Mach screw 6-32 x 1/4 PH SS	Attaches SBE32 ground strap to coil/actuator endcap	1
30154	Mach screw 8-32 x 3/8	Attaches SBE32 ground strap to connector endcap	1
30241	Washer, #6 nylon	For ground strap securing screw (30137) Used with actuator endcap to housing securing screws (30588)	1 6
30254	Washer, 1/4 split ring lock	For Pylon Hardware, 30602, 30570, 30294	6
30526	Mach screw 1/4-20 x 3/4, plastic	Plug Jackscrew holes	3
30570	Washer, 1/4 flat, SS	Pylon hub to Bale	6
30588	Screw, 6-32 x 2" PH	Pylon Endcap Hardware, 6800m	6

Actuator Endcap Assembly

SBE P/N	Part Description	Primary SBE Application	QTY
30097	Parker, 2-111N674-70	Actuator O-Ring	4
30116	Mach screw 2-56 x 3/8 PH SS	Actuator Endcap: Secure coil terminate PCB to endcap	2
30235	Washer, #2 nylon	Actuator Endcap: Use with coil terminate screws (30116)	2
30238	Washer, #4 flat	Actuator Endcap: Use after lock washer with (30586)	6
30271	Spacer, #2 x 1/8, nylon	Actuator Endcap: Under coil terminate with screws (30116)	2
30294	Screw Insul, 1/4 x 1/4	Actuator Endcap to Hub	6
30586	Screw, 4-40 x 1-1/2 Socket head	Actuator Endcap: Secure Actuator into recesses in endcap	6
30587	10-32 x 3/4 Socket Head	Trigger mount disk to Actuator Endcap / coil	3
30602	Screw, 1/4-20 x 2-1/4 S SH SS	Hub to Actuator Endcap	6
30606	Screw Insul, #4 x 1/2"	For Actuator Endcap Hardware (30586)	6

Titanium Latch Assembly

SBE P/N	Part Description	Primary SBE Application	QTY
30618	Parker, 2-106E962-90	Latch Spacer O-Ring	12
30249	Washer, #10 flat	For trigger mount disk hardware (30587)	3
30250	Washer, # 10 split ring lock	For trigger mount disk hardware (30587)	3
30587	10-32 x 3/4 Socket Head	Trigger mount disk to Actuator Endcap / coil	3
30604	Screw Insul, #10 x 1/4	For Trigger Mount Disk Hardware (30587)	3
30657	Mach screw 2-56 x 3/8 FH	Trigger Assembly: Secure cover plate and slider to side plate	6
30658	Mach screw 6-32 x 11/16 FH	Trigger Assembly: Secure retainer disk to mount disk	6
30659	Mach screw 4-40 x 13/16 FH	Trigger Assembly: Attach support bars to trigger assembly	12
30663	SBE 32 Latch spring	Trigger Assembly: Provide recoil motion in slider	3
31394	Mach screw 10-24 x 1/2 FH	Secure Trigger Dummies to mount disk	6

SBE Drawings:

76064D Pylon Latch Assembly

Sea-Bird Electronics Procedure

PROCEDURE NUMBER: **67023**

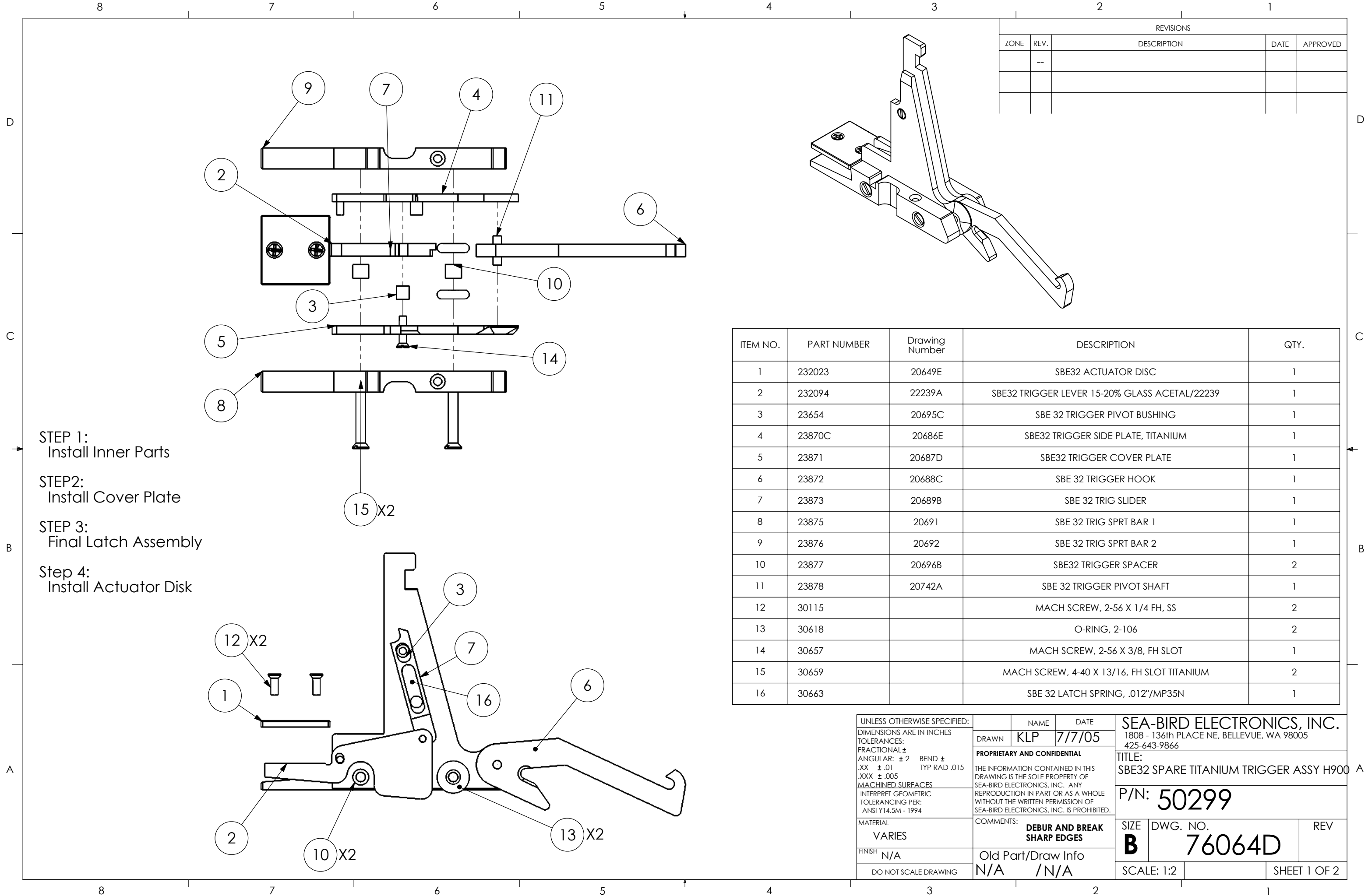
TITLE: **SBE 32 Pylon Ti Latch Spares**

REVISION: **D**

EFFECTIVE DATE: **07/05/2005**

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- STEP 1:
Install Inner Parts
- STEP 2:
Install Cover Plate
- STEP 3:
Final Latch Assembly
- Step 4:
Install Actuator Disk

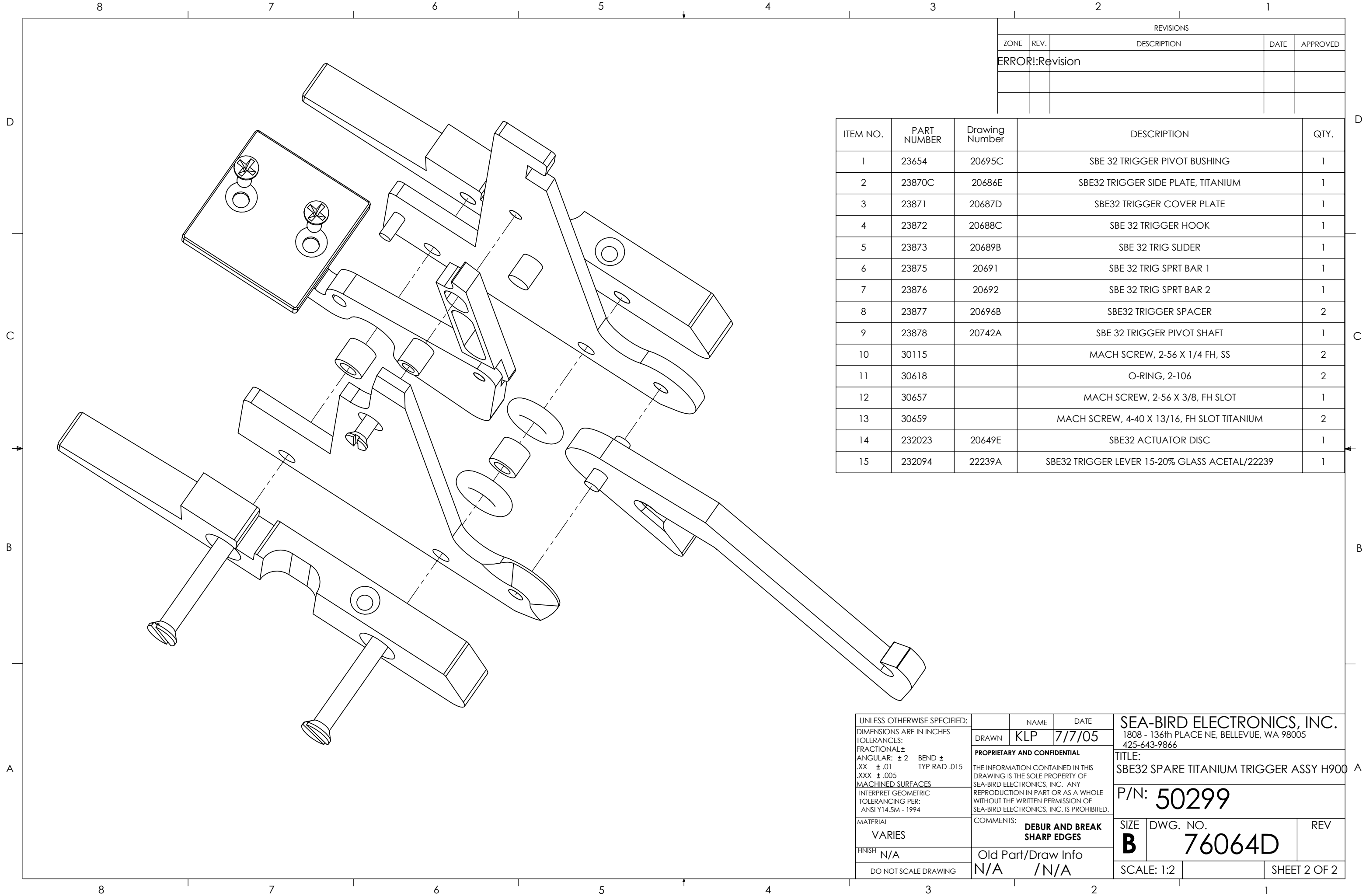
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	--			

ITEM NO.	PART NUMBER	Drawing Number	DESCRIPTION	QTY.
1	232023	20649E	SBE32 ACTUATOR DISC	1
2	232094	22239A	SBE32 TRIGGER LEVER 15-20% GLASS ACETAL/22239	1
3	23654	20695C	SBE 32 TRIGGER PIVOT BUSHING	1
4	23870C	20686E	SBE32 TRIGGER SIDE PLATE, TITANIUM	1
5	23871	20687D	SBE32 TRIGGER COVER PLATE	1
6	23872	20688C	SBE 32 TRIGGER HOOK	1
7	23873	20689B	SBE 32 TRIG SLIDER	1
8	23875	20691	SBE 32 TRIG SPRT BAR 1	1
9	23876	20692	SBE 32 TRIG SPRT BAR 2	1
10	23877	20696B	SBE32 TRIGGER SPACER	2
11	23878	20742A	SBE 32 TRIGGER PIVOT SHAFT	1
12	30115		MACH SCREW, 2-56 X 1/4 FH, SS	2
13	30618		O-RING, 2-106	2
14	30657		MACH SCREW, 2-56 X 3/8, FH SLOT	1
15	30659		MACH SCREW, 4-40 X 13/16, FH SLOT TITANIUM	2
16	30663		SBE 32 LATCH SPRING, .012"/MP35N	1

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: ± 2 BEND ± .XX ± .01 TYP RAD .015 .XXX ± .005 MACHINED SURFACES INTERPRET GEOMETRIC TOLERANCING PER: ANSI Y14.5M - 1994	NAME	DATE	SEA-BIRD ELECTRONICS, INC. 1808 - 136th PLACE NE, BELLEVUE, WA 98005 425-643-9866	
	DRAWN	KLP		7/7/05
	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SEA-BIRD ELECTRONICS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SEA-BIRD ELECTRONICS, INC. IS PROHIBITED.		TITLE: SBE32 SPARE TITANIUM TRIGGER ASSY H900	
	MATERIAL VARIES		COMMENTS: DEBUR AND BREAK SHARP EDGES	
FINISH	N/A	Old Part/Draw Info N/A /N/A		
DO NOT SCALE DRAWING		SCALE: 1:2	SHEET 1 OF 2	

P/N: **50299**

SIZE **B** DWG. NO. **76064D** REV



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
		ERROR! Revision		

ITEM NO.	PART NUMBER	Drawing Number	DESCRIPTION	QTY.
1	23654	20695C	SBE 32 TRIGGER PIVOT BUSHING	1
2	23870C	20686E	SBE32 TRIGGER SIDE PLATE, TITANIUM	1
3	23871	20687D	SBE32 TRIGGER COVER PLATE	1
4	23872	20688C	SBE 32 TRIGGER HOOK	1
5	23873	20689B	SBE 32 TRIG SLIDER	1
6	23875	20691	SBE 32 TRIG SPRT BAR 1	1
7	23876	20692	SBE 32 TRIG SPRT BAR 2	1
8	23877	20696B	SBE32 TRIGGER SPACER	2
9	23878	20742A	SBE 32 TRIGGER PIVOT SHAFT	1
10	30115		MACH SCREW, 2-56 X 1/4 FH, SS	2
11	30618		O-RING, 2-106	2
12	30657		MACH SCREW, 2-56 X 3/8, FH SLOT	1
13	30659		MACH SCREW, 4-40 X 13/16, FH SLOT TITANIUM	2
14	232023	20649E	SBE32 ACTUATOR DISC	1
15	232094	22239A	SBE32 TRIGGER LEVER 15-20% GLASS ACETAL/22239	1

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TOLERANCES:		KLP		425-643-9866	
FRACTIONAL ±		PROPRIETARY AND CONFIDENTIAL		TITLE:	
ANGULAR: ± 2 BEND ±		THE INFORMATION CONTAINED IN THIS		SBE32 SPARE TITANIUM TRIGGER ASSY H900	
.XX ± .01 TYP RAD .015		DRAWING IS THE SOLE PROPERTY OF		P/N: 50299	
.XXX ± .005		SEA-BIRD ELECTRONICS, INC. ANY		SIZE DWG. NO. REV	
MACHINED SURFACES		REPRODUCTION IN PART OR AS A WHOLE		B 76064D	
INTERPRET GEOMETRIC		WITHOUT THE WRITTEN PERMISSION OF		SCALE: 1:2 SHEET 2 OF 2	
TOLERANCING PER:		SEA-BIRD ELECTRONICS, INC. IS PROHIBITED.			
ANSI Y14.5M - 1994		COMMENTS:			
MATERIAL		DEBUR AND BREAK			
VARIES		SHARP EDGES			
FINISH		Old Part/Draw Info			
N/A		N/A /N/A			
DO NOT SCALE DRAWING					