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SBE P/N 50021

DATE	SYM	REVISION RECORD	AUTH	DR	CHK

SBE 19 Profiler to SeaTech Fluorometer Mount Kit

Instructions

A. INSTALLING TEFLON TAPE ON HOSE CLAMPS

1. Hose clamps should have a layer of Teflon tape on the inside. This will insulate against any unlike metal contact.
2. Cut a 20.75" length of Teflon tape for each hose clamp.
3. Clean inside of hose clamps with alcohol, and apply the tape.
4. You may press against the tape to keep it aligned.
5. You may also peel it back off to correct as you go.
6. Use a sharp blade to cut a notch next to the clamp area.
7. Remove any tape hanging over the edge of the hose clamps, leaving a small flap to protect the clamp.

B. Preparing the clamps and the Fluorometer.

1. You will need to drill a hole through both the clamp and the fluorometer, in order to use screws to secure the fluorometer onto the clamps.
2. For best results, install clamps onto the fluorometer and the SBE19, such that hose clamp hardware is parallel to the flat connector protection mechanism when tight.
3. Drill through clamp and fluorometer to a depth of $\approx 3/8"$, no more than $1/2"$, using a drill bit size 29. (Pre-Tapping bit size)
4. Remove clamps and fluorometer from SBE19, and return the 19 to test.
5. Drill out the clamp to clear the 8-32 screw, using bit size 17. (to clear 8-32)
6. Tap both holes in the fluorometer with an 8-32 starter tap, and finish with a bottom tap.
7. **!!DO NOT SKIP THE STARTER TAP STEP!!**
8. If you are not installing clamps onto the fluorometer now, include them and the screws (30154) with the kit.

C. Mounting and Finishing the Clamp Assembly

1. Fluorometer mounts to SBE19 such that connector point to seacat battery endcap.
2. Secure clamps to fluorometer first, then install fluorometer and clamps onto the SBE19 with the mount block (23197).
3. Thread nut (30231) all the way up the lift eye (23199), and follow with the flat washer (30259).
4. Install lift eye such that it points toward battery endcap, and secure with nylon stop nut.
5. Use the flat nut to tighten the assembly.
6. Install fluorometer onto 19 as with any hose clamp mount.

SBE DRAWING: 67100

TITLE: SB19 to SeaTech Fluorometer
Assembly Photo

REV:

Sea-Bird Electronics Procedure

PROCEDURE NUMBER: **67100**

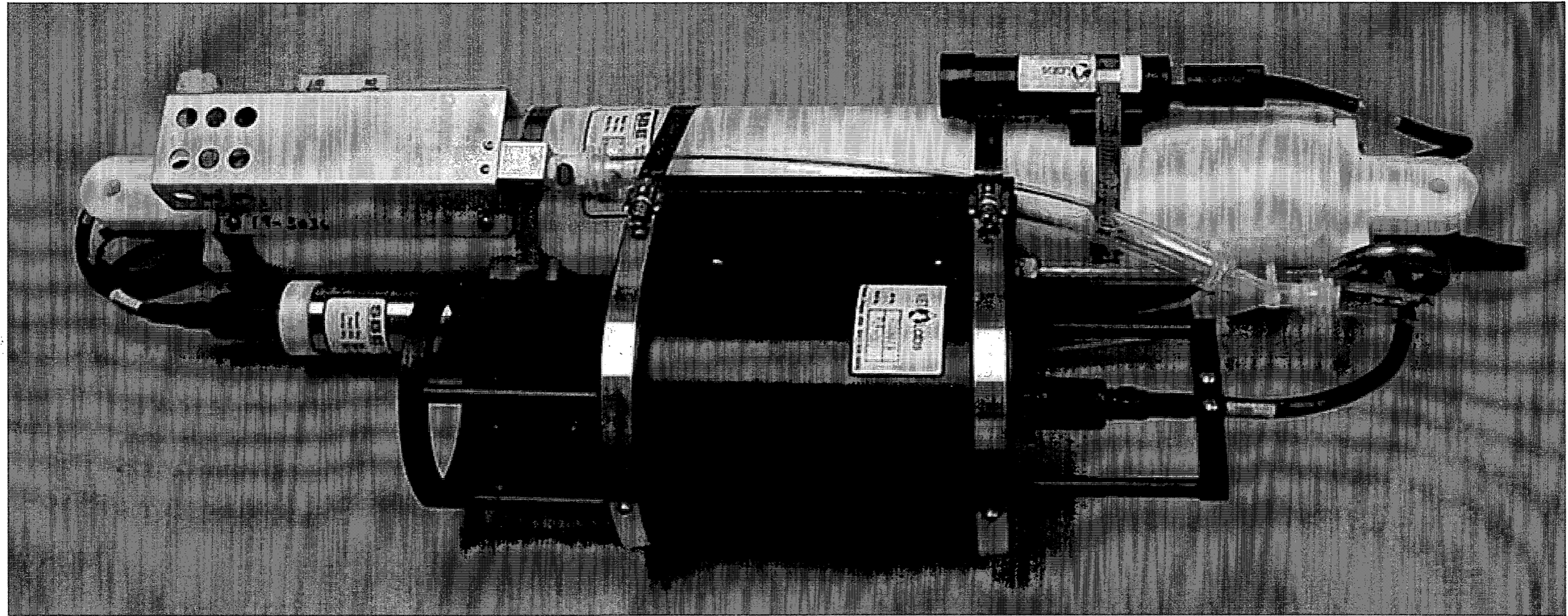
TITLE: **SBE 19 to Fluorometer Mount Kit**

REVISION:

EFFECTIVE DATE: **11/25/2002**

CHECKED BY: _____ PAGE 1 of 1

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Tolerances	SEA-BIRD ELECTRONICS, INC			
Fractional	P/N	Scale	Drawn By MJ	
	50021	N/A	Approved By MJ	
Decimal	Title SBE-19 to Sea-Tech Fluorometer Mount Kit			
Angular	Date	Drawing Number		Rev
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