

ASSEMBLY NOTES:

1) ROCKER RUBBER PAD FITTING
 USE LOCTITE 480 TO BOND RUBBER PADS TO THE PAINTED ROCKER TOP SURFACES

PREPARATION OF RUBBER STRIPS:
 TRIM CORNERS AND MAKE A 20mm DIA. HOLE TO ALIGN WITH THE ROCKER ARM TOP PLATE GRUB SCREW HOLE.

PREPARATION OF MATING SURFACES:
 SMOOTH/KEY WITH ABRASIVE PAPER
 CLEAN
 DE-GREASE

APPLICATION OF LOCTITE 480:
 APPLY TWO PARALLEL TRAILS, 20mm APART, DOWN THE CENTER OF THE ROCKER TOP PLATE. POSITION RUBBER STRIP ON THE TOP PLATE, APPLYING A HOLDING FORCE TO COMPRESS BOND REGION FOR AT LEAST 20 MINUTES. AFTER BONDING HAS OCCURRED, LIFTING UP THE EDGE OF THE RUBBER, APPLY A SECOND TRAIL 10mm IN FROM THE OUTER EDGE OF THE TOP PLATE, AGAIN A HOLDING FORCE TO COMPRESS BOND REGION FOR AT LEAST 20 MINUTES

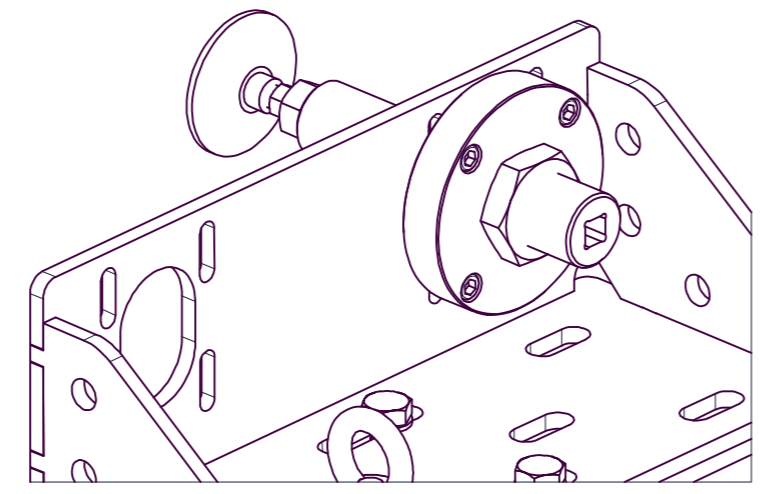
2) ROCKER PIN FITTING
 ASSEMBLE ROCKER PINS (ITEM 12) WITH MARINE GRADE GREASE. PINS ARE TOLERANCED TO FIT INTO PAINTED HOLES. RETAIN EACH PIN WITH A SINGLE M12 SET SCREW (ITEM 17), USING LOCTITE 243 THREAD LOCK.

TIGHTENING TORQUES (A4 - 70)	
THREAD:	TORQUE (Nm):
M8	10
M10	20
M12	36
M16	90
M20	170
M24	300
M30	600

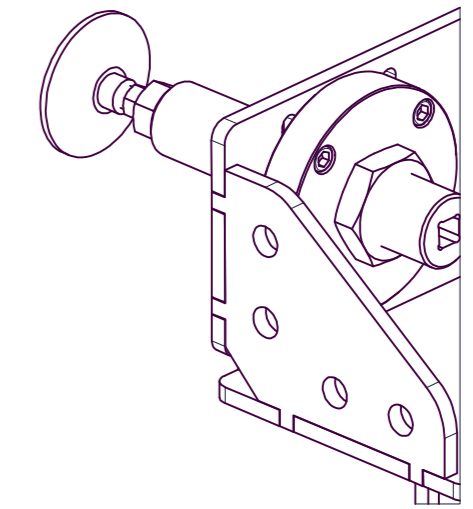
ALL FASTENERS:
 LUBRICATE ALL THREADS AND CONTACT FACES WITH LOCTITE 8023 MARINE GRADE ANTI-SEIZE UOS

ITEM	PART NUMBER	DESCRIPTION	QTY	MATERIAL	MASS
1	1001501	NBR70 STRIP 140mm WIDE, 12mm THICK	2	NBR70 Rubber	
2	DCS1-SE-03-01	HANDLING TROLLEY - REMOVABLE LEG ASSEMBLY	4	SEE DRAWING	593.983 kg
3	DCS1-SE-03-03	HANDLING TROLLEY - SPINE WITH ARMS WELDMENT	1	SEE DRAWING	2548.166 kg
4	DCS1-SE-03-09	HANDLING TROLLEY - ROCKER (FWD) WELDMENT	1	S355 (t<16mm), EN 10025-1 : 2004	123.286 kg
5	DCS1-SE-03-10	HANDLING TROLLEY - ROCKER (AFT) WELDMENT	1	S355 (t<16mm), EN 10025-1 : 2004	125.517 kg
6	DCS1-SE-03-11	HANDLING TROLLEY - BATTERY POD SHELF WELDMENT	4	SEE DRAWING	89.842 kg
7	DCS1-SE-03-12	HANDLING TROLLEY - TOW BAR GA	1	SEE DRAWING	76.083 kg
8	DCS1-SE-03-13	HANDLING TROLLEY - SWINGING ARM - TOP BRACKET WELDMENT	4	SEE DRAWING	22.714 kg
9	DCS1-SE-03-14	HANDLING TROLLEY - SWINGING ARM - LEVELLING FOOT SUB-ASSEMBLY	4	SEE DRAWING	11.350 kg
10	DCS1-SE-03-20-06	HANDLING TROLLEY - GUIDE PLATE A	2	S355 (t<16mm), EN 10025-1 : 2004	6.758 kg
11	DCS1-SE-03-20-07	HANDLING TROLLEY - GUIDE PLATE B	2	S355 (t<16mm), EN 10025-1 : 2004	6.758 kg
12	DCS1-SE-03-20-08	HANDLING TROLLEY - ROCKER PIVOT PIN	2	1.4404 Bar (316L STAINLESS) (<= 160mm Dia) TO BS EN 10088-3: 2005	12.552 kg
13	DCS1-SE-03-20-09	HANDLING TROLLEY - GUIDE PLATE BRACE	2	S355 (t<16mm), EN 10025-1 : 2004	1.935 kg
14	ISO 4017 - M12 x 35	Hexagon head screws	16	A4 - 70	0.046 kg
15	ISO 4017 - M12 x 40	Hexagon head screws	8	A4 - 70	0.051 kg
16	ISO 4017 - M20 x 65	Hexagon head screws	28	A4 - 70	0.232 kg
17	ISO 4029 - M12 x 30	Hexagon socket set screw with cup point	2	A4 - 70	0.023 kg
18	ISO 4032 - M12	Hexagon nuts, style 1 - Product grades A and B	24	A4 - 50	0.016 kg
19	ISO 4032 - M20	Hexagon nuts, style 1 - Product grades A and B	28	A4 - 50	0.074 kg
20	ISO 7092 - ST 12 - 140 HV	Plain washers-Small series-Product grade A	48	A4	0.003 kg
21	ISO 7092 - ST 20 - 140 HV	Plain washers-Small series-Product grade A	44	A4	0.014 kg
22	ISO 7093 C - ST 20 - 100 HV	Plain washers - Large series - Product grade C	12	A4	0.077 kg
23	PC4000 CUSTOM	DCS1 HANDLING TROLLEY - SIDEWIND PROP JACK	4	Stainless Steel	5.980 kg

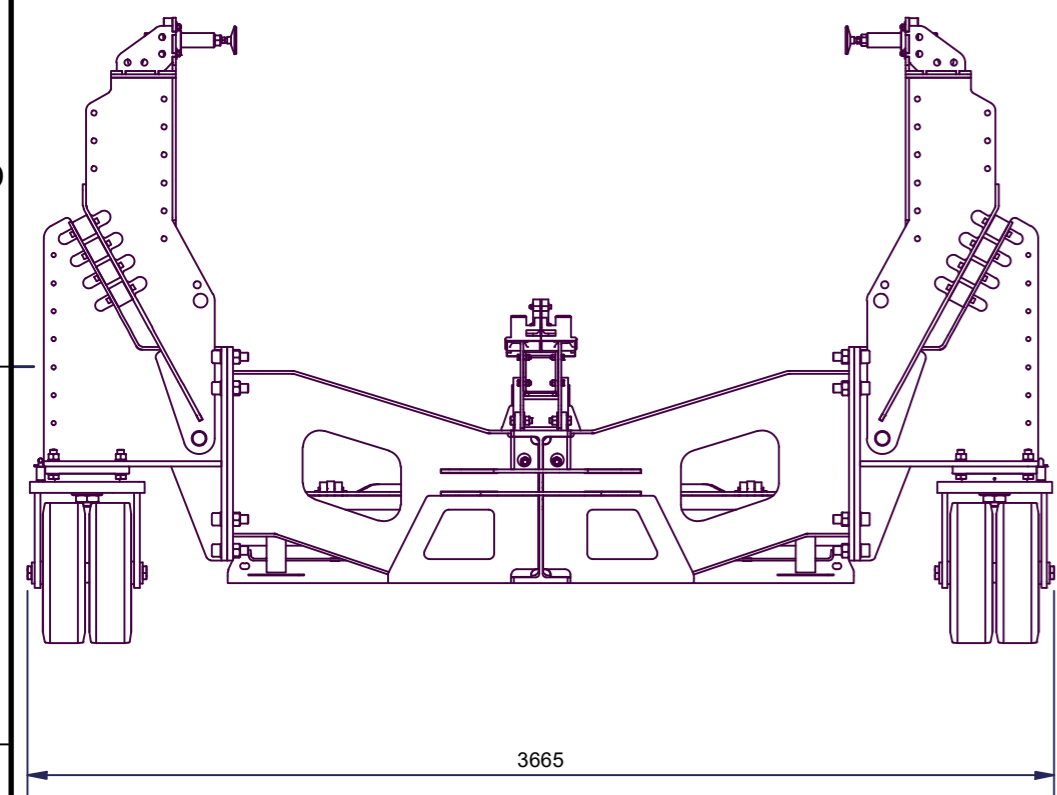
<p>M Subs Ltd UNDERWATER VEHICLES & EQUIPMENT UNIT 42 SISNA PARK ROAD PLYMOUTH UK PL6 7FH +44 (0) 1752 696069</p>		COPYRIGHT © M Subs Ltd from date of last revision. US Government Purpose Rights The US Government's rights to use, modify, reproduce, release, perform, display or disclose these technical data are restricted by paragraph (b)(2) of the Rights in Technical Data-Noncommercial Items clause contained in the below identified contract. No restrictions apply after the expiration date shown below. Any reproduction of technical data or portions thereof marked with this legend must also reproduce the markings. CONTRACT NO: US Gov't H92222-16-C-0096 / Lockheed Martin PO 4102644142	TOLERANCES U.N.O. NOT APPLICABLE	SURFACE FINISH U.N.O. NOT APPLICABLE	MATERIAL CERTIFICATION REQUIRED: NONE	STATUS Released FIRST ISSUED 28/11/2014 MATERIAL SEE BOM DRAWINGS TITLE Handling Trolley - GA PART NO. DCS1-SE-03-20	DES J.Ramsay DATE 19/12/2017	DRN MDB DATE 19/12/2017	CHK GE DATE 14/02/2022	SHEET 1 OF 4 VER 2.0
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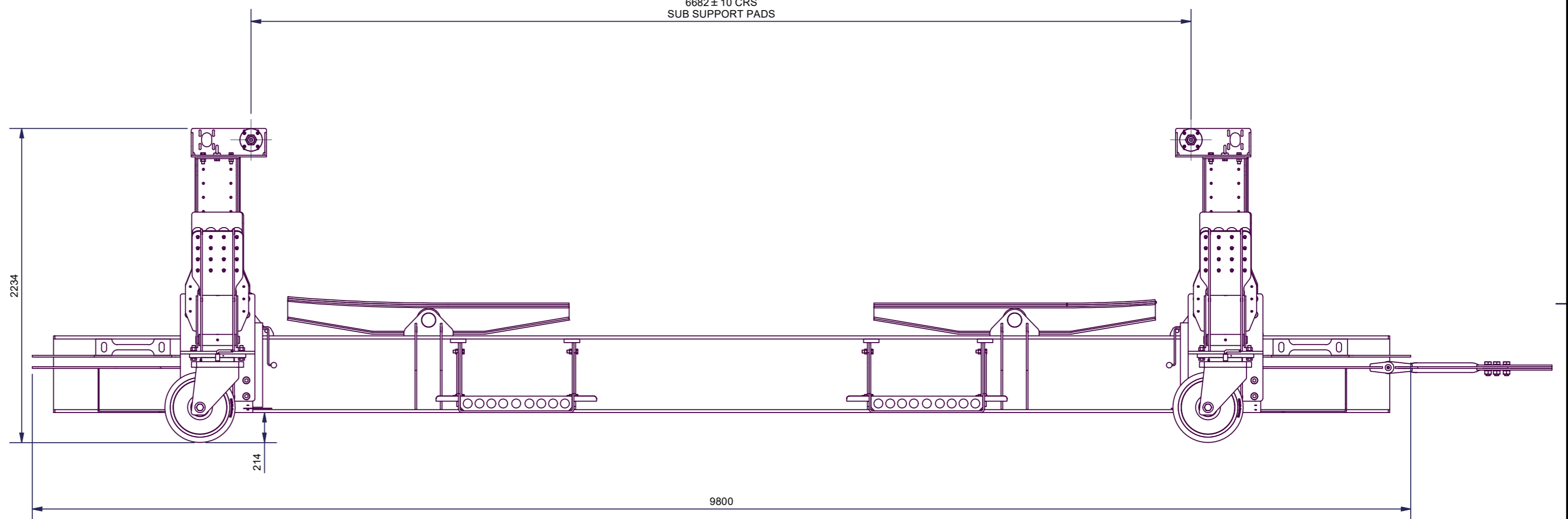
VIEW OF AFT STARBOARD HULL SUPPORT PAD



VIEW OF FORWARD STARBOARD HULL SUPPORT PAD



3665

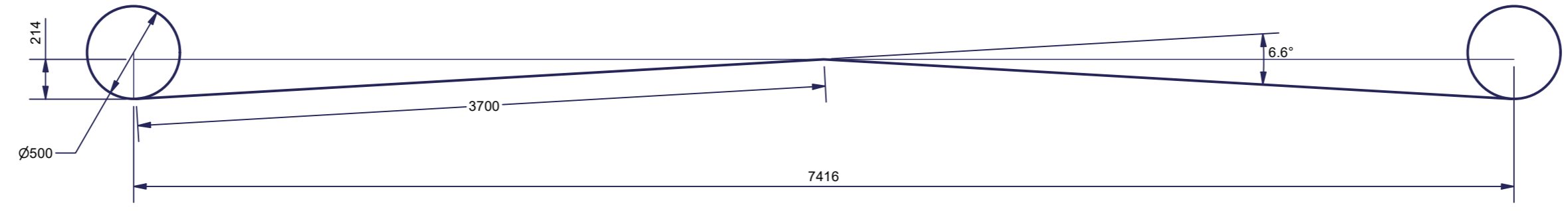


6682 ± 10 CRS
SUB SUPPORT PADS

2234

214

9800



GROUND CLEARANCE PROFILE

DATE	ZONE	REV	CHANGE	CHKD
14/02/2022	VARIOUS	2.0	CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO.	GE

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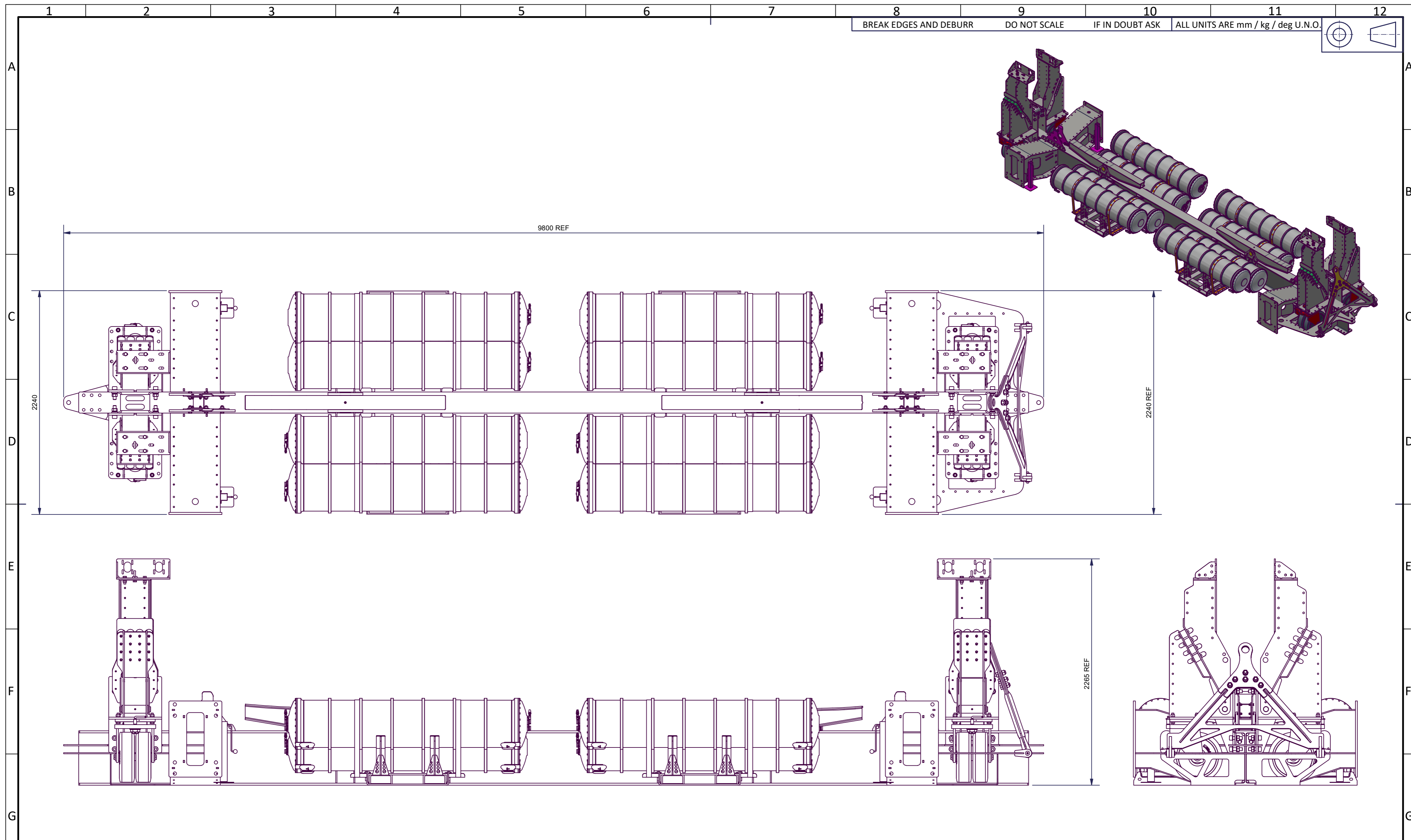
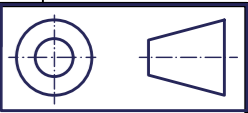
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TOLERANCES U.N.O.
X ±3.00
X.X ±2.00
X.XX ±1.00
ANGULAR TOLERANCE ±1.0°

SURFACE FINISH U.N.O.	MATERIAL CERTIFICATION REQUIRED:
NOT APPLICABLE	NONE
EXPIRATION DATE:	13th July 2036

STATUS	Released	DES	J.Ramsay	DRN	MDB	CHK	GE
FIRST ISSUED	28/11/2014	DATE	19/12/2017	DATE	19/12/2017	DATE	14/02/2022
MATERIAL	SEE BOM DRAWINGS						
TITLE	Handling Trolley - GA						
PART NO.	DCS1-SE-03-20						
							SHEET 2 OF 4
							VER 2.0

BREAK EDGES AND DEBURR DO NOT SCALE IF IN DOUBT ASK ALL UNITS ARE mm / kg / deg U.N.O.

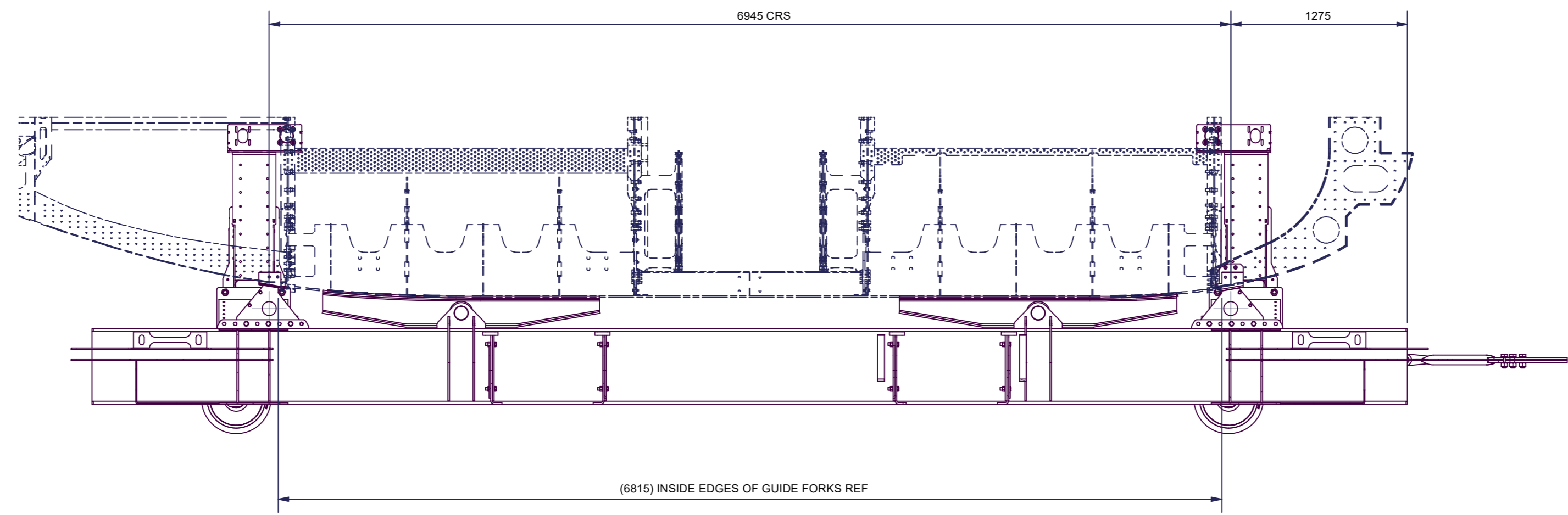
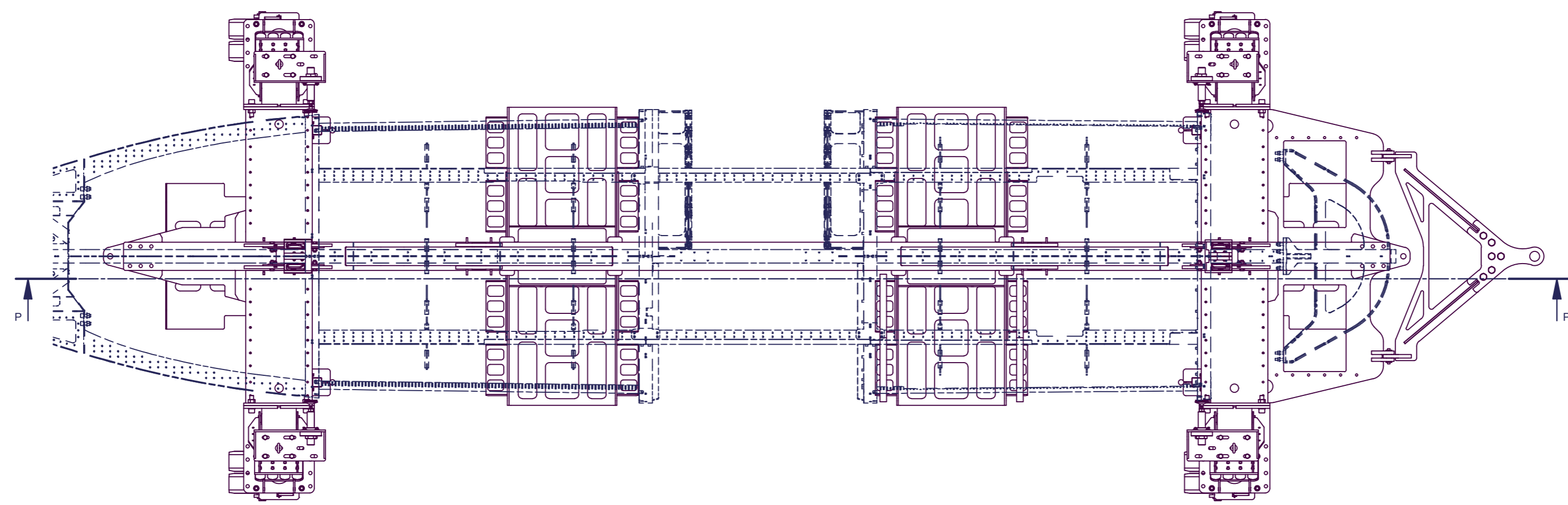
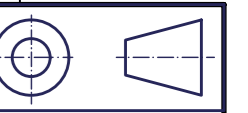


ASHORE TROLLEY PACKED FOR SHIPPING WITH BATTERY PODS

<p>M Subs Ltd UNDERWATER VEHICLES & EQUIPMENT UNIT 42 SISNA PARK ROAD PLYMOUTH UK PL6 7FH +44 (0) 1752 696069</p>	<small>COPYRIGHT © M Subs Ltd from date of last revision. US Government Purpose Rights</small>		<small>TOLERANCES U.N.O.</small> X ±3.00 X.X ±2.00 X.XX ±1.00 ANGULAR TOLERANCE ±1.0°		<small>SURFACE FINISH U.N.O.</small> NOT APPLICABLE	<small>MATERIAL CERTIFICATION REQUIRED:</small> NONE	<small>STATUS</small> Released <small>FIRST ISSUED</small> 28/11/2014 <small>MATERIAL</small> SEE BOM DRAWINGS <small>TITLE</small> ASHORE TROLLEY - PACKED UP <small>PART NO.</small>	<small>DES</small> MDB <small>DATE</small> 19/12/2017	<small>DRN</small> MDB <small>DATE</small> 19/12/2017	<small>CHK</small> GE <small>DATE</small> 14/02/2022	<small>GE</small>	
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	<small>DATE</small> 14/02/2022 <small>ZONE</small> VARIOUS <small>REV</small> 2.0 <small>CHANGE</small> CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO. <small>CHKD</small> GE		<small>DATE</small> 14/02/2022 <small>ZONE</small> VARIOUS <small>REV</small> 2.0 <small>CHANGE</small> CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO. <small>CHKD</small> GE		<small>DATE</small> 14/02/2022 <small>ZONE</small> VARIOUS <small>REV</small> 2.0 <small>CHANGE</small> CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO. <small>CHKD</small> GE		<small>DATE</small> 14/02/2022 <small>ZONE</small> VARIOUS <small>REV</small> 2.0 <small>CHANGE</small> CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO. <small>CHKD</small> GE		<small>DATE</small> 14/02/2022 <small>ZONE</small> VARIOUS <small>REV</small> 2.0 <small>CHANGE</small> CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO. <small>CHKD</small> GE		<small>DATE</small> 14/02/2022 <small>ZONE</small> VARIOUS <small>REV</small> 2.0 <small>CHANGE</small> CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO. <small>CHKD</small> GE	
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BREAK EDGES AND DEBURR DO NOT SCALE IF IN DOUBT ASK ALL UNITS ARE mm / kg / deg U.N.O.

MASS: 5840.453 kg



SECTION P-P

FORK SET-UP FOR MOUNTING / DE-MOUNTING

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TOLERANCES U.N.O.	X ±3.00
	X.X ±2.00
	X.XX ±1.00
ANGULAR TOLERANCE ±1.0°	
CONTRACT NO:	US Gov't H92222-16-C-0096 / Lockheed Martin PO 4102644142

SURFACE FINISH U.N.O.	MATERIAL CERTIFICATION REQUIRED:	STATUS	Released	DES	J.Ramsay	DRN	MDB	CHK	GE
		FIRST ISSUED	28/11/2014	DATE	19/12/2017	DATE	19/12/2017	DATE	14/02/2022
NOT APPLICABLE	NONE	MATERIAL	SEE BOM DRAWINGS						
		TITLE	Handling Trolley - GA						
EXPIRATION DATE:	13th July 2036	PART NO.	DCS1-SE-03-20						VER 2.0

DATE	ZONE	REV	CHANGE	CHKD
14/02/2022	VARIOUS	2.0	CORRECT QTY'S FOR ITEM 20. UPDATE DRAWING BORDER AND ADD GPR INFO.	GE

SHEET 4 OF 4