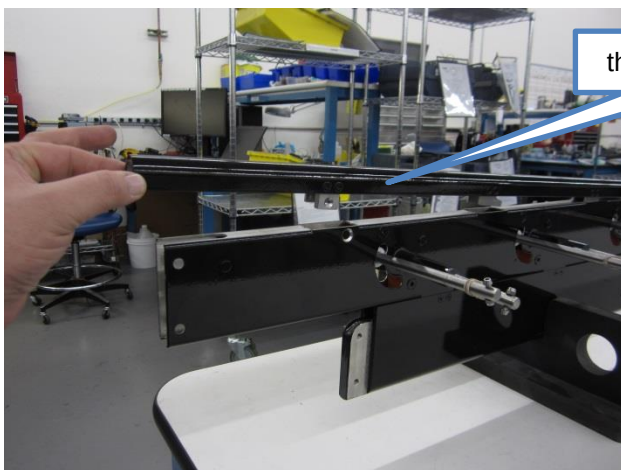
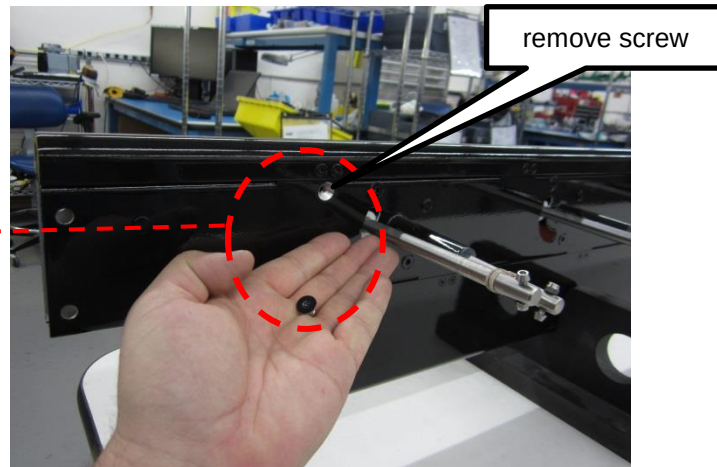
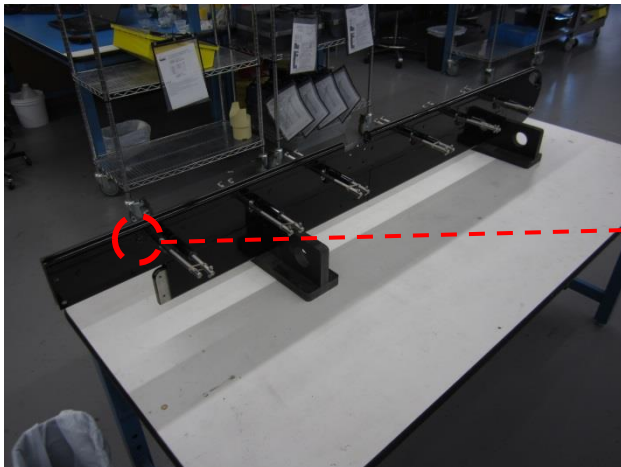
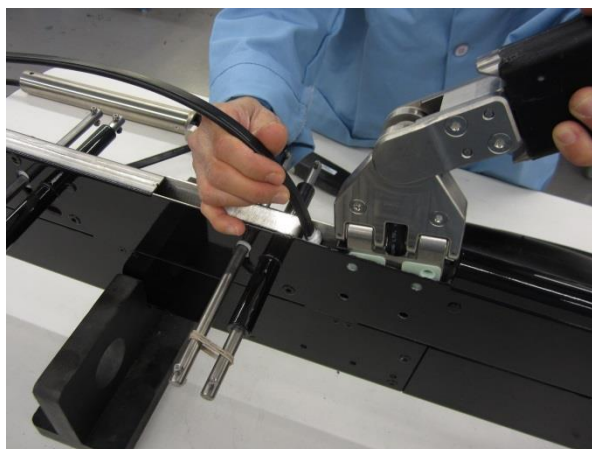
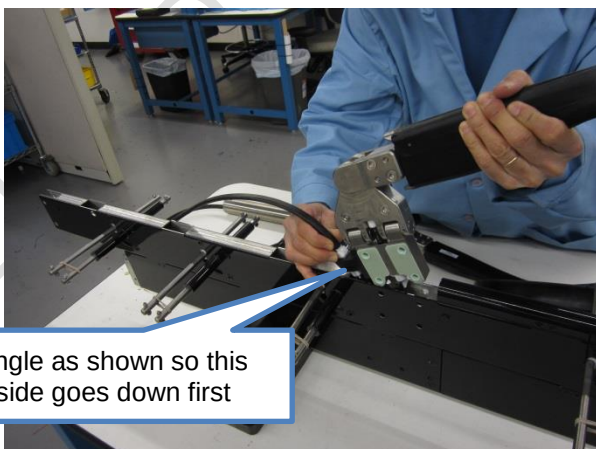


5 POPULATE GLIDER

- 5.1 Remove rear, top fairing from glider (05051). To accomplish this, remove the screw shown and then slide the fairing back and up.

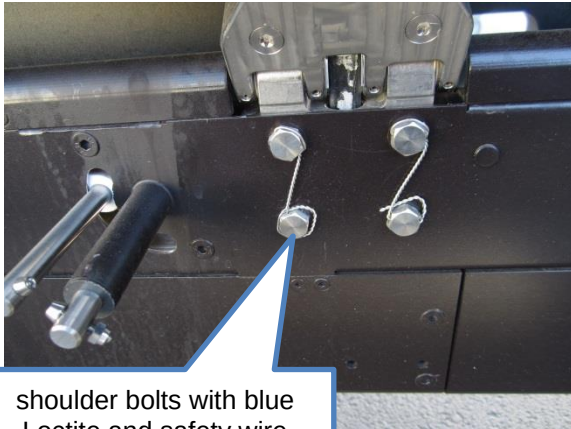


- 5.2 Slide Umbilical Assembly, into Glider Assembly as shown.

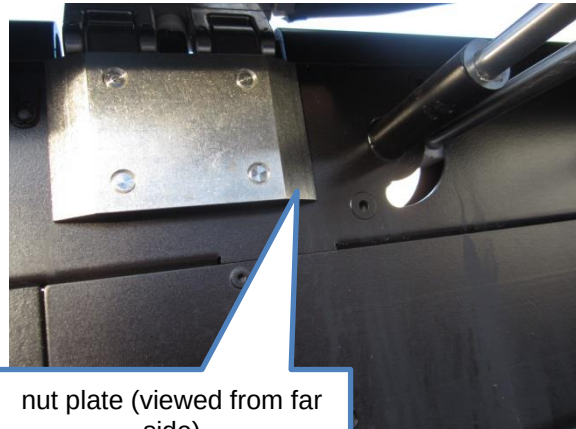


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- 5.3 Fasten Umbilical to Glider using shoulder screws and four-hole nut plates (these parts come with Glider Assy). **To prevent galling, ensure you can thread the screws into place by hand and use anti-seize compound 08795 on the screws.** . Only use a tool to torque the fasteners at the end. Safety wire screws as shown.

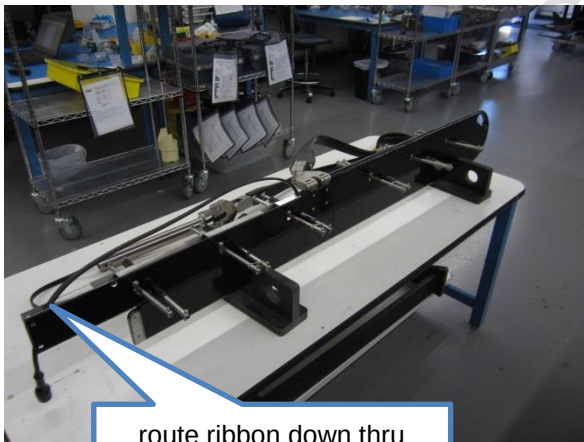


shoulder bolts with blue Loctite and safety wire

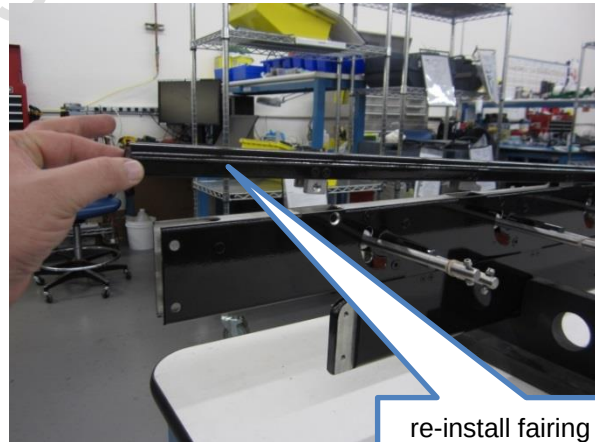


nut plate (viewed from far side)

- 5.4 Route the umbilical's ribbon cable down rear of glider. Re-install the glider's rear, top fairing. Blue Loctite is used on this screw.



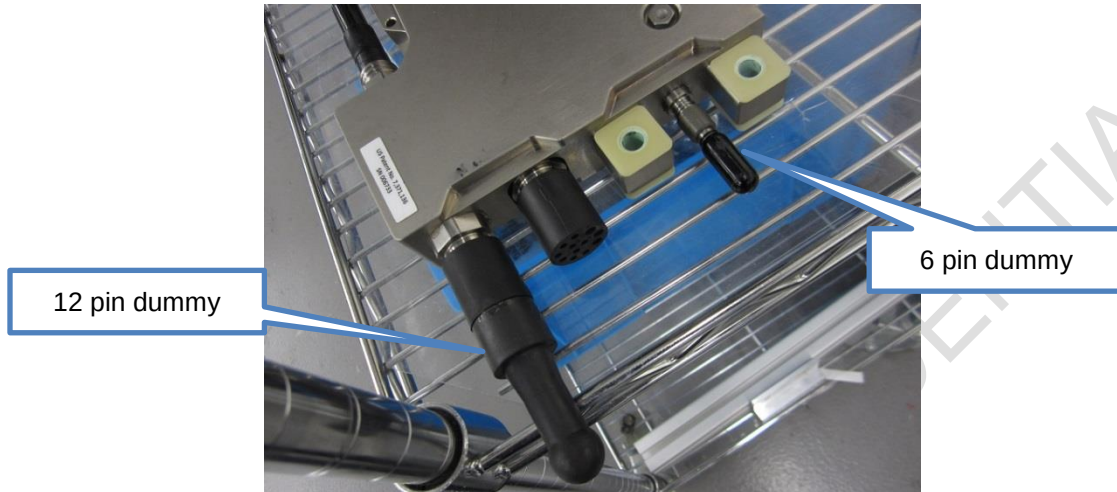
route ribbon down thru rear of glider



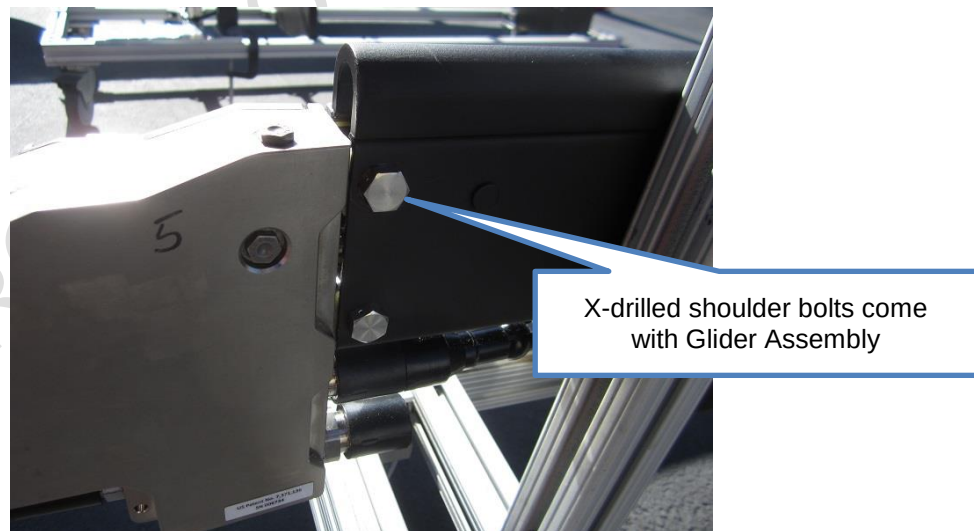
re-install fairing – ensure screw has blue Loctite

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- 5.5 Prior to installing Thrudder (05969) into glider, ensure a 6 pin dummy plug is installed into compass calibration connector. Also ensure a 12 pin dummy plug is installed into thrudder's T1 connector.



- 5.6 Slide Thrudder into rear of glider and align the two mounting holes. Fasten using shoulder screws and two-hole nut plates (these parts come with glider). **To prevent galling, ensure you can thread the screws into place by hand and use anti-seize compound 08795 on the screws.** Only use a tool to torque the fasteners at the end. Do NOT yet apply safety wire.



- 5.7 Fasten two plastic side covers to glider. Note that you may need to loosen the Thrudder mounting screws in order to get these to fit. Again, these parts come with glider assy. Refer to BOM and drawing for p/n 05051 for installation. Blue Loctite should be used.
- 5.8 Confirm tightness, and then apply safety wire to the two Thrudder mounting screws.

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6 GLIDER TO FLOAT INTEGRATION

- 6.1 Using a two person lift, place glider onto a rolling stand.
- 6.2 Place saddle over glider – ensure umbilical is on proper side when doing so.
- 6.3 Again using a two person lift, place float onto saddle. When looking from bottom of float, ensure water speed sensor is near front wall of saddle.
- 6.4 Remove top cap from motion isolator assy (three screws). Set these items aside.

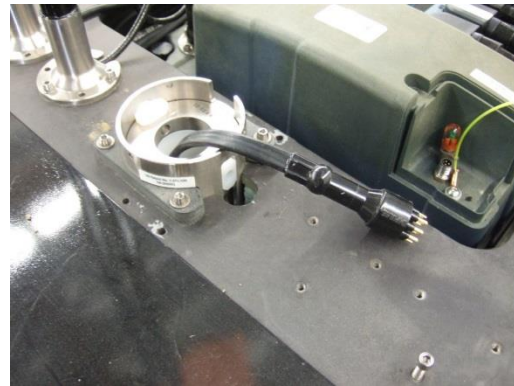


- 6.5 Remove cotter pin, nut and shoulder pin from top of motion isolator on float. Keep these items nearby for re-installation.



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- 6.6 Ensure that there is no twist in the umbilical between the glider and the float. Most importantly, orient the shaft so that the leading edge of the umbilical is pointing towards the front of the float. Feed the ribbon cable and shaft from the bottom of the float through the fairing and motion isolator housing

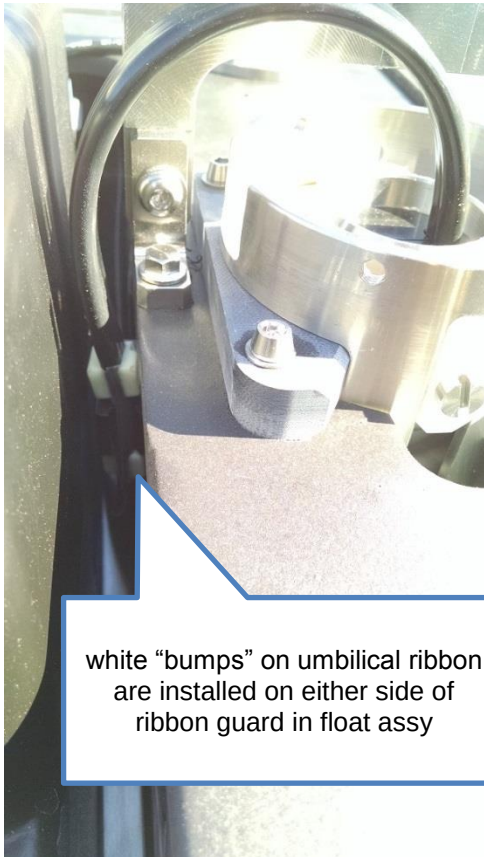


- 6.7 Push the shaft through. Align the center hole in the shaft and install the motion isolator bolt 05099. Install and tighten a new M6 Nyloc nut from the kit. Install a cotter pin (02733), but do NOT fully splay the legs around the bolt – this item will be removed later for shipment.



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- 6.8 Route the ribbon cable, connect to the CCU, reinstall the connector bridge and the foam filler and reinstall the solar panel (reverse of steps 7.1.5 and 7.1.6)



- 6.9 Reinstall ribbon guard. Hand tight only – screws will be removed later prior to shipment.



- 6.10 Now ready to begin base vehicle test and inspection.