

REV	DATE	ECN	DESCRIPTION	RC	FILE NAME	SHT	DWN
-	2/14/13	-	INITIAL RELEASE	-	HD961-INSTBI	1	AC

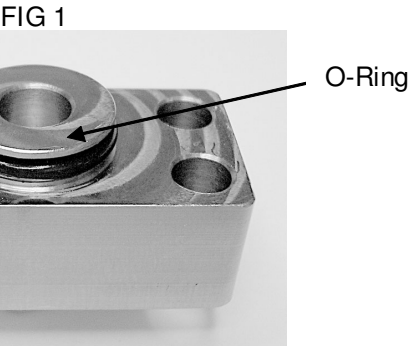
DUC 6” SKID INSTALLATION INSTRUCTIONS

- NOTES:
- 1) The four new skids MUST be installed **one at a time** to keep from compromising the seal in the lighthouse.
 - 2) The lighthouse is Aluminum. Do not over-tighten the screws as the threads may be damaged.
 - 3) Blue Loctite should be used on all hardware.
 - 4) All parts removed should be placed in a bag or box for reinstallation if required/desired.
 - 5) “AR” below equates to “as required”.

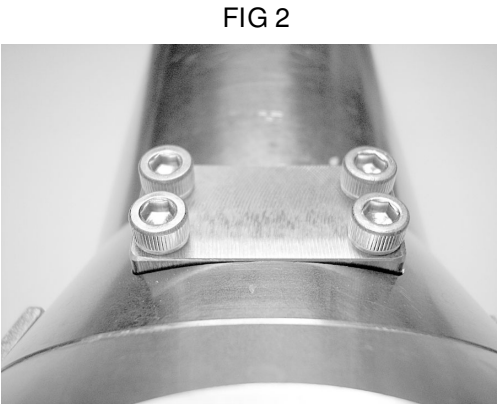
- PARTS REQUIRED:
- (4) HD105 Skids
 - (1) HD106 Plug
 - (1) HW1689 O-RING, 2-013, BUNA-N
 - (4) 100121 SCREW, CAP, SKT HD, 10-32X3/4”, SST
 - (8) HW1022 SCREW, SHCS, 6-32X3/4”, 316 SST
 - (6) 103038 SCREW, SET, 10-32X3/16” SST
 - (1) CS390 LUBE,ORING PARKER SUPER,2GM PKT
 - (1) CS036 MRO-Removable LCK, ND 121200-2, Blue
 - (1) 940601 TOOL,WRENCH HEX KIT 11 PIECE
 - (1) HD961-INST INSTR SHT,KIT,SKID,5 INCH,DUC


EQUIPMENT REQUIRED:
Allen Wrenches: 5/32”, 1/8”, 7/64”, 3/32”

- PROCEDURE:
- 1. Lightly coat the O-Ring (HW1689) with O-Ring Lube and install on the plug (HD106). See FIG 1.



- 2. Using the 5/32” Allen Wrench, remove the bottom skid and install the plug with the four 10-32X3/4” screws (100121). See FIG 2.



		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES .X ±.1 ANGLES ±1/2° .XX ±.01 FRACTIONS ±1/32 .XXX ±.005 SURFACE FINISH 63	THIS DOCUMENT IS PROTECTED BY COPYRIGHT AND THE DATA DESCRIBED HEREIN OR HEREWITH CONTAINS PROPRIETARY INFORMATION AND TRADE SECRETS OF CUES, INC. NEITHER THE DOCUMENT NOR THE DATA IS TO BE REPRODUCED, USED OR DISCLOSED TO ANYONE, IN WHOLE OR PART, WITHOUT THE PERMISSION OF CUES, INC., 3600 RIO VISTA AVENUE, ORLANDO, FL. 32805. 407-849-0190.	<div>CUES</div> <div>ORLANDO, FLORIDA</div> <div></div>						
				DFTSMN	AC	2/12/2013	TITLE INSTR SHT, KIT, SKID, 6 INCH, DUC			
				MATERIAL	SEE BOM	CHKR	B	DWG NO	HD961-INST	REV -
	HD961			FINISH	NONE	ENGR				
PART DASH NO.	NEXT ASSY / USED ON	PRODUCT		MFG						
	APPLICATION		I CHECK IAM, IPN, AND IDW		SCALE	NONE		SHEET 1 OF 3		

REV	DATE	ECN	DESCRIPTION	RC	FILE NAME	SHT	DWN
-	2/14/13	-	INITIAL RELEASE	-	HD961-INSTBI	2	AC

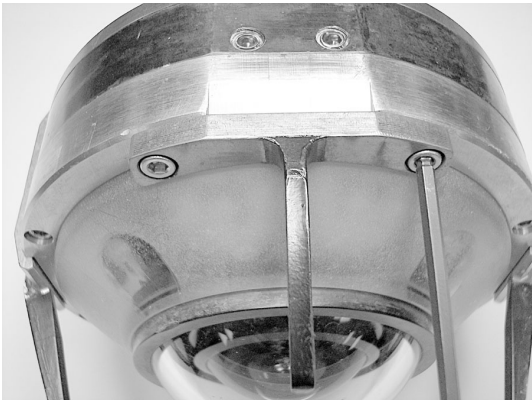
3. Using the 7/64" Allen Wrench, remove the two screws in the retaining ring that straddle the bottom skid position. See FIG 3.

FIG 3



4. Using two 6-32x3/4" screws (HW1022) and the 7/64" Allen Wrench, install a skid (HD105) as shown in FIG 4.

FIG 4



5. Remove the top skid using the 1/8" Allen Wrench.
6. Using the 7/64" Allen Wrench, remove the two screws in the retaining ring that straddle the top skid position. See FIG 5.

FIG 5



CUES		ORLANDO, FLORIDA			
TITLE INSTR SHT, KIT, SKID, 6 INCH, DUC					
B	DWG NO	HD961-INST			REV -
SCALE	NONE		SHEET	2 OF	3

REV	DATE	ECN	DESCRIPTION	RC	FILE NAME	SHT	DWN
-	2/14/13	-	INITIAL RELEASE	-	HD961-INSTBI	3	AC

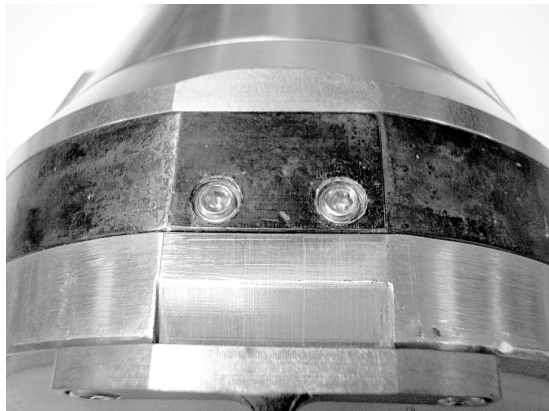
7. Using two 6-32x3/4" screws (HW1022) and the 7/64" Allen Wrench, install a skid (HD106) as shown in FIG 6.

FIG 6



8. Using the 3/32" Allen Wrench, install the two 10-32x3/16" set screws (103038) in the standard top skid mounting holes. See FIG 7.

FIG 7



9. Repeat steps 5 through 8 for the two sides skids.

10. Installation Complete.

CUES

ORLANDO, FLORIDA



TITLE

INSTR SHT, KIT, SKID, 6 INCH, DUC

B

DWG NO

HD961-INST

REV

-

SCALE

NONE

SHEET

3

OF

3