



### Assembly Parts

|                                      |                           |
|--------------------------------------|---------------------------|
| A. Fin Nut *                         | L. Locking Cylinder Screw |
| B. Hull Flange Assembly (Note 2)     | O. Yoke Clamping Screw    |
| C. Augmented hull thickness (Note 1) | P. Top Plate              |
| D. Platform Gusset (Note 3)          | R. Top Plate Screw        |
| E. Platform Flange (Note 3)          | S. Actuator Cylinder      |
| F. Hull Framing (Note 3)             | T. Position Sensor Cover  |
| G. Actuator Flange Bolt (Note 4)     | U. Sensor Cable Cover     |
| H. Actuator Flange                   | W. Weld-in Hull Flange    |
| J. Locking Cylinder Platform         | X. Bolt-on Hull Flange    |
| K. Yoke Locking Cylinder             | Y. Hull Flange Screw      |

### Assembly Fasteners

| Part | Description            | Qty | Size     | Install Torque<br>ft-lb / (Nm) | Install with<br>Coating *** |
|------|------------------------|-----|----------|--------------------------------|-----------------------------|
| A.   | Fin Nut *              | 1   | M48 -5.0 | 1000 / (1356)                  | Loctite® 262                |
| G.   | Actuator Flange Bolt   | 8   | M24 -3.0 | 400 / (542)                    | H                           |
| L.   | Locking Cylinder Screw | 4   | M16 -2.0 | 180 / (244)                    | M                           |
| O.   | Yoke Clamping Screw    | 1   | 1" -14   | 500 / (678)                    | H                           |
| R.   | Top Plate Screw ****   | 8   | M20 -2.5 | 95 / (129)                     | M                           |
| R.   | Top Plate Screw        | 1   | M16 -2.0 | 70 / (95)                      | M                           |
| T.   | Sensor Cover Screw     | 6   | M5 -0.8  | 1.5 / (2.0)                    | --                          |
| U.   | Cable Cover Screw      | 6   | M3 -0.5  | 0.3 / (0.4)                    | --                          |
| Y.   | Hull Flange Screw      | 8   | M20 -2.5 | 140 / (190)                    | M                           |

\* Requires 80 mm hex socket.

\*\*\* M = Medium strength thread lock compound; H = High Strength thread lock compound.

Installation torques shown here require coating on threads and also, as lubricant, under bolt head or nut, whichever is turned.

\*\*\*\* 0.75" x 2" dowel pins at each of four main top plate legs.

### NOTES:

- It is the responsibility of the installer to determine what reinforcement measures should be taken to properly strengthen the hull for withstanding forces that may be encountered if the fin or the fin shaft strikes an immovable object while the vessel is under way. Recommendations made by American Bow Thruster are to be used as starting guidelines only. American Bow Thruster is NOT a naval architecture firm and is NOT qualified to advise on structural matters. American Bow Thruster strongly recommends that you seek the advice of a naval architect familiar with your make of vessel.
- See inset "Detail B" for Hull Flange Assembly details.
- The Platform Flange with its integrated gussets, hull framing and stringers, are provided by the customer according to the naval architect's specifications. Consult the TRAC Stabilizer Installation Manual for recommended and required details applicable to the platform flange.
- Actuator Flange Bolts are provided by the customer according to the thickness of the platform flange. Fasteners should include grade 8 bolts with nuts and flat washers.
- Actuator specifications and dimensions are subject to change without prior notice. Do not use this print for final installation without contacting the factory for certified dimensions.

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|  | DRAWN   | RJP        | Parts & Dimensions for METAL Hull Installation<br>All DIMENSIONS are inches unless noted |      |               |
|  | CHECKED |            | SCALE:   | NONE | SHEET: 1 OF 1 |
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