



Assembly Parts

A. Fin Nut*	N. Yoke Locking Cylinder	X. Cylinder Mount
B. Actuator Shaft Stud	O. Locking Housing	Xa. Cylinder Mount Bolt
C. Hull Doubler Plate (Note 2)	Oa. Locking Housing Bolt	Xb. Cylinder Mount Shoulder Screw
D. Hull Flange Bolt (Note 3)	P. Clevis Pin	Xc. Cylinder Mount Dowel Pin
E. Augmented Hull Thickness (Notes 1&5)	R. Yoke Clamping Bolt	Xd. Cylinder Mount Support Bolt
F. Inboard Hull Flange (Note 4)	S. Top Plate.	Xe. Cylinder Mount Support Bolt
G. Hull Flange Spacer (Note 5)	Sa. Top Plate Screw	Xf. Cylinder Mount Support Dowel Pin
H. Companion Flange	T. Top Plate Standoff	
I. Hull Flange Jacking Screw (Note 6)	U. Actuator Cylinder	
J. Actuator Flange Bolt	V. Position Sensor Cover	
K. Actuator Flange	Va. Position Sensor Cover Screw	
L. HDPE Washers (4X)	W. Sensor Cable Cover	
M. Lock Assembly Platform	Wa. Sensor Cable Cover Screw	

Assembly Fasteners

Part	Description	Qty	Size # or inch	Install Torque ft-lb / (Nm)	Install with Coating**
A	Fin Nut *	1	M48 - 5.0	1000 / (1356)	Loctite 262 3M 5200
D	Hull Flange Bolt	8	M24 - 3.0	250 / (339)	
I	Flange Jacking Screw	3	M16 - 2.0	-- / --	
J	Actuator Flange Bolt	8	M24 - 3.0	400 / (542)	H
Oa	Locking Housing Bolt	4	M16 - 2.0	180 / (244)	M
P	Clevis Pin	4	--	--	N
R	Yoke Clamping Bolt	1	1" - 14	500 / (678)	H
Sa	Top Plate Screw	5	1/2 - 13	15 / (20)	M
T	Top Plate Standoff	5	M20 - 2.5	215 / (295)	H
Va	Sensor Cover Screw	6	M5 - 0.8	1.5 / (2.0)	--
Wa	Cable Cover Screw	6	M3 - 0.5	0.3 / (0.4)	--
Xa	Cylinder Mount Bolt	2	M20 - 2.5	325 / (440)	H
Xb	Cylinder Mount Shoulder Screw	2	M16 - 2.0	180 / (244)	H
Xc	Cylinder Mount Dowel Pin	2	3/4 x 3.5	--	N
Xe	Cylinder Mount Support Bolt	6	M20 - 2.5	325 / (440)	H
Xf	Cylinder Mount Support Dowel Pin	2	3/4 x 3.0	--	N

* Nut requires 3.125" Hex Socket
 ** M = Medium strength thread lock compound; H = High Strength thread lock compound. Install torques shown here require coating on threads and also, as lubricant, under bolt head or nut, whichever is turned; N = Never-Seez anti seize compound or equivalent.

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.
- The Hull Doubler Plate is a retainer surface for assembly fasteners and sealants. The Hull Doubler Plate should NOT be considered to provide structural hull reinforcement.
- Hull Flange bolts will through-bolt the Hull Doubler Plate, Inboard Flange & Actuator Flange.
- Inboard Hull Flange with eight integral riser columns and adjustable spacer stacks.
- The range of hull thickness that can be accommodated by standard actuator equipment is 2.50" minimum to 4.00" maximum. See the TRAC Stabilizer Installation Manual for additional details concerning this thickness range.
- Hull Flange Jacking Screws are used during installation and removed after final flange bedding.
- The final installed position of the outboard end of the Actuator Seal Housing must be flush with or slightly extend (D0.00" / + 0.125") from the outboard plane of the Hull Doubler Plate.
- 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	BK			
	CHECKED	BK	Parts & Dimensions for Fiberglass Hull Installation All Dimensions are inches unless noted		
	ISSUED	7/2/2013			
SCALE:	N.T.S.	SHEET:	1 OF 1	REV:	B