



MARINE FIELD SERVICE BULLETIN

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| FSB Number | 1319340025 |
| Date | June 28, 1999 |
| Originator | Jamie Dozier |
| Product Group | Airguns |
| Product Name | Kit Modification Bottom Swivel |
| Product P/N | 0700152 |

Synopsis:

Long term wear on the SG-IIB sleeve chamber, body, and bottom swivel gun hanger can result in the bottom swivel coming off during use. An additional mounting plate can be installed on the bottom of the body to prevent the bottom swivel gun hanger from coming off. Note: This procedure is applicable only for SG-IIB bodies with four factory-tapped mounting holes. If the body is not equipped with four tapped mounting holes; the body will have to be replaced.

Affects:

I/O Sleeve Gun IIB airguns using bottom swivel clamps.

Problems/Symptoms:

The bottom swivel gun hanger can come off during use due to long term wear on the sleeve chamber, body, and bottom swivel gun hanger.

Action Required:

Install the bottom swivel mounting plate kit (Part Number 0700152) on the bottom of the body.

Tools Required:

- 15/16" socket with 1/2" drive
- 1/2" drive torque wrench, capable of 125 ft-lbs.
- 5/8"-18 NF Spiraloc™ tap (I/O Part Number 63239)

Parts Required:

- Kit Modification Bottom Swivel (I/O Part Number 0700152)

The kit contains the following:

- 1/ea Bottom swivel plate
- 4/ea 5/8" x 1 3/4" hex head SS bolts
- 4/ea 5/8" SS lock washers

Safety Issues:

- Follow all back deck safety procedures, provided by the vessel management.
- Make sure gun is pressured down and the fire controller is disabled.

Procedure:

Clean the threads of the four tapped mounting holes on the bottom of the body with a 5/8"-18 Spiraloc™ tap. Do not use a standard 5/8"-18 tap. Fit the mounting plate on the body and align the four mounting holes. Apply Loctite™ 271 to the threads of the four mounting bolts, and install the four bolts and lock washers. Torque the bolts to 125 ft-lbs.

Q.C. Process:

Periodically check the torque on the bolts.

References:

I/O Drawing 0700152

FSB's Superseded:

None

United States - Stafford, TX
Input/Output, Inc.
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Phone 281.552.3002

United States - New Orleans
Input/Output, Inc.
Fax 504.734.8627
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