



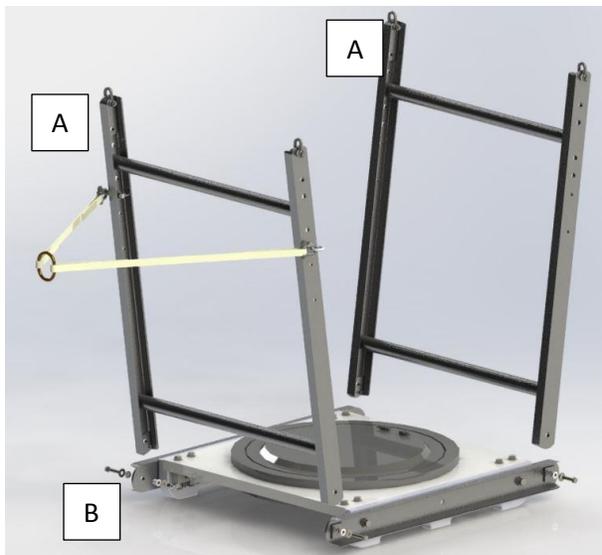
## Field Assembly Process of B620-205 Vehicle Frame and Floats.

The B620-205 vehicle is shipped dis-assembled to prevent damage during shipping, reduce shipping costs and make for easier handling by freight handlers. There are a total of 16 bolt connections that need to be made and it will take roughly 1 man hour to complete.

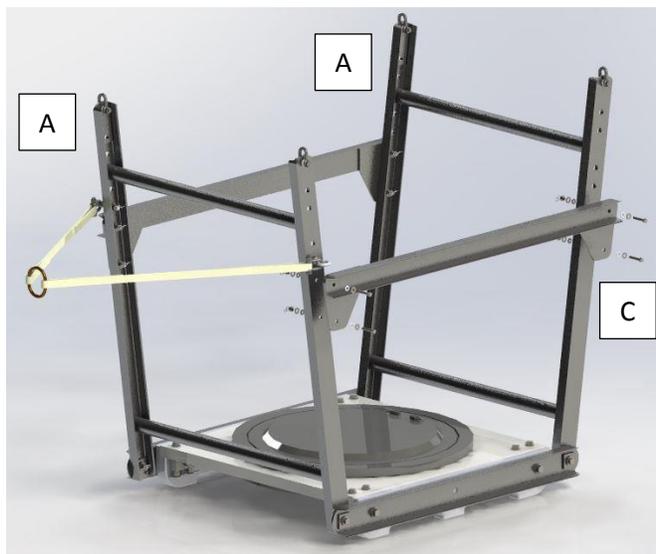
### Notes:

- All bolts come with nylon insulators, 316 stainless steel washers, lock nuts, and cotter pins.
- All Hardware should be placed loosely before tightening all bolts.
- All Bolts must be pinned before deployment

Step 1. Attach Swing Arms (A) to fore and aft of transducer on channels (B) attached to the midplate using provided hardware. Place swing arm with attached straps to the end of the transducer away from the connectors on the plate. The required hardware is attached to the correct hole of the swing arm. If in doubt, the correct side to mount has a single  $\frac{3}{4}$ " hole below the cross tube. (The top has two  $\frac{3}{4}$ " holes above the cross tube.)



Step 2. Mount Side Gussets (C) to Swing Arms (A). The gussets mount to the first set of  $\frac{1}{2}$ " holes from the top of the swing arms. The upper bolts are  $\frac{3}{8}$ -16 X 2" long bolts and the lower bolts are  $\frac{3}{8}$ -16x 1.5" long. Longer bolts will bottom out on threads before tightening completely on the bottom holes.





Step 3. Remove fill plugs from flotation fenders then fill with air until fold wrinkles are smoothed. Replace plug snugly into fill port. (Be Careful not to cross thread plug). Correct Hardware is secured to eyelets on each end of floats. Attach to outside of swing arms in the second hole from the top. Place bolt washers and nut loosely on one end then the other. It may be required pulling the second bolt up to the through hole at an angle then threading in the bolt on the insulator. It may also be possible to add air to float to grow it to the correct length as float vary in size. Once all hardware is placed, tighten all hardware on the vehicle and cotter pin to prevent hardware losses during deployment.



Step 4. Four shackles and a four point harness are also provided in this shipment. Attach a shackle and one of the points to the top holes in the swing arms (A). This will serve as the overhead lifting point for the vehicle. The shackles should also be secured for the deployment using wire ties.

