

**TECHNICAL NOTES ONLY:**

- 1 APPLY 15 PSI OF PRESSURE TO LCD SCREEN (ITEM 4) ONTO FRONT HSG (ITEM 1 OR 2) TO ACTIVATE ADHESIVE FOR 5 SECONDS
- 2 DISPENSE RTV 832 (ITEM 33) (AFTER LCD SCREEN (ITEM 4) HAS BEEN APPLIED) AROUND THE BACK PERIMETER OF THE FRONT HSG (ITEM 1 OR 2) AND LCD SCREEN (ITEM 4) THROUGH THE WINDOW OPENING
- 3 APPLY LUBRICANT (ITEM 32) TO BUTTONS (ITEM 5) (AROUND SEALING SURFACES ONLY)
- 4 TORQUE SCREWS (ITEM 7) TO 5 in-lbs
- 5 APPLY LUBRICANT (ITEM 32) TO MAIN GASKET (ITEM 29) BETWEEN GROOVES ON BOTH SIDE
- 6 PRESS FIT STAND-OFF (ITEM 23) TO PCB (ITEM 22)
- 7 TORQUE SCREWS (ITEM 27) TO 2 in-lbs
- 8 APPLY LUBRICANT (ITEM 32) TO USB (ITEM 10) TO SEALING SURFACE ONLY
- 9 TORQUE SCREWS (ITEM 11) TO 2.5 in-lbs
- 10 APPLY LUBRICANT (ITEM 32) TO O-RING (ITEM 18)
- 11 APPLY LUBRICANT (ITEM 32) TO SCREWS O-RING (ITEM 30) AND TORQUE TO 5 in-lbs

DASH CHART	
DASH No.	DESCRIPTION
-1	ACR TREUSE, NON DoD
-2	BLACK, NON DoD
-3	ACR TREUSE, DoD GATEWAY
-4	BLACK, DoD GATEWAY

REVISIONS				
REV	DESCRIPTION	DATE	APPROVED	
A	RELEASE PER W/1 05-EN-05	FD 8/28/15	J. GOLDA	
A1	ECO D16132 ITEM 11 WAS A1-05-0963, ITEM 27 WAS A1-05-0882. ADDED ITEMS 42 Y1-02-0523, ITEM 43 Y1-02-0526 & ITEM 44 Y1-02-0528	FD 9/4/15	J. GOLDA	
A2	ECO D16143 ITEM 21 WAS A3-06-2804	FD 9/10/15	J. GOLDA	
A3	ECO D16158 ITEM 17 WAS A3-06-2911. ADDED ITEM 45 A3-07-0438-1	FD 9/23/15	J. GOLDA	
B	ECO 16213 ITEM 22 WAS A3-07-0434, ADDED ITEMS 45-48, REMOVED ITEM 41, ADDED DASH 1 - 15 & MOVED EXPLODED VIEW TO SHEET 2	FD 11/16/15	J. GOLDA	
B1	ECO D16242 ITEM 23 TYPO QTY WAS 1	FD 12/14/15	J. GOLDA	
C	ECO 16220 ADDED ITEM 49	M.P. 12/17/15	J. GOLDA	
D	ECO 16263 ADDED ITEM 50 A1-18-2407	FD 2/11/16	C. RILEY	
E	ECO 16317 REVISED DASH CHART AND BOM. REMOVE ITEM 45, 46, 47, 48	FD 3/10/16	C. RILEY	
F	ECO 16 ADDED ITEM 51 -57 & REMOVED ITEM 36 - 38	FD		

DASH 4 QTY.	DASH 3 QTY.	DASH 2 QTY.	DASH 1 QTY.	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION
				57	A1-20-1928	CLOTH LABEL
				56	A3-06-2976	SARLINK POUCH
				55	A1-20-1927	APPROVAL LABEL
				54	A1-20-1926	REGISTRATION LABEL
				53	A1-20-1844-1	ACTIVATION LABEL
				52	A1-20-1843-1	BATTERY EXPIRATION LABEL
				51	A1-20-1716	LABEL, SCREEN PROTECTOR
				50	A1-18-2407	OVER LAMINATE POLYESTER 1.5" x 1.5"
				49	A1-18-2403	PTFE, PROTECTION VENT
				48		
				47		
				46		
				45		
REF	REF	REF	REF	44	Y1-02-0528	TEST PROCEDURE, LEAK
REF	REF	REF	REF	43	Y1-02-0526	TEST PROCEDURE, INTERIM SERIALIZATION
REF	REF	REF	REF	42	Y1-02-0523	TEST PROCEDURE, FINAL ASSEMBLY
				41		
				40	A1-20-1847	HEX ID LABEL
				39	A1-20-1661	BATTERY REPLACEMENT DATE LABEL
				38		
				37		
				36		
				35	A1-20-1845	GPS LABEL
				34	A1-18-2390	WRIST STRAP
A/R	A/R	A/R	A/R	33	A2-06-0118-1	RTV 832
A/R	A/R	A/R	A/R	32	A2-09-0087	LUBRICANT, SILICONE (SUPRE LUBE)
				31	A1-25-0196	USB COVER
6	6	6	6	30	A1-05-0952-031	SCREW 4-40 x 3/8
				29	A1-25-0194	GASKET
				28	A2-05-0182	GPS CONDUCTIVE TAPE
2	2	2	2	27	A1-05-0882-7	SCREW 2-56 x .4375
2	2	2	2	26	A1-05-0939	SPACER 3/16 OD, 7/32 LENGTH
1	1	--	--	25	A1-11-1012-1	IRIDIUM MODULE (DoD)
--	--	1	1	24	A1-11-1012	IRIDIUM MODULE
2	2	2	2	23	A1-05-0944	FORCE FIT STAND-OFF
1	1	1	1	22	A3-07-0434-1	PCB FINAL ASSY
				21	A3-06-2916	GPS ASSY
1	1	1	1	20	A1-18-2393	FOAM MINICEL 1.00 x .85 x .125
1	1	1	1	19	MS16633-4018	C-CLIP
1	1	1	1	18	A1-05-0001-77	O-RING .489 x .629 x .070
1	1	1	1	17	A3-06-2911-1	ANTENNA ASSY
3	3	3	3	16	A1-18-2376	FOAM MINICEL 1.25 x .4 x .25
1	1	1	1	15	A1-18-2378	FOAM MINICEL 1.5 x 1.0 x .125
1	1	1	1	14	A3-06-2770	3-CELL BATTERY PCK
1	1	1	1	13	A3-06-2812	RE-CHARGABLE BATTERY
2	2	2	2	12	A2-05-0179	VHB, TAPE 1.50 x 1.00 x .045
2	2	2	2	11	MS51957-3	SCREW 2-56 x 1/4
1	1	1	1	10	A3-06-2919	USB ASSY
--	1	--	1	9	A1-18-2374-1	BACK HSG, SARLink II (ACRTREUSE)
1	--	1	--	8	A1-18-2374	BACK HSG, SARLink II (BLACK)
6	6	6	6	7	A1-05-0941-7	SCREW 4-40 x 3/16"
1	1	1	1	6	A1-17-1697	BRACKET
1	1	1	1	5	A1-25-0188	3 BUTTONS
1	1	1	1	4	A3-06-2914	LCD SCREEN
1	1	1	1	3	A1-18-2382	SLIDE COVER
--	1	--	1	2	A1-18-2373-1	FRONT HSG, SARLink II (ACRTREUSE)
1	--	1	--	1	A1-18-2373	FRONT HSG, SARLink II (BLACK)

UNLESS OTHERWISE SPECIFIED:  
ALL ANGLES ARE 90°

TOLERANCES ON

MILLIMETER	FRACTIONS	DECIMALS	ANGLES
x ± .25	±1/64	.x ± .030	x ± 5°
x.x ± .125		.xx ± .010	.x ± 2°
x.xx ± .006		.xxx ± .005	.xxx ± 1°
			xxx ± 1/2°
			IMPLIED: ±1°

ANGS0 SOLIDWORKS

DRAWN: FD 8/24/15  
CHECKED: JG 8/28/15  
ENG: RR 8/28/15  
APVD: RR 8/28/15

○ DENOTES REVISION CHANGE  
⊕ DENOTES DIMENSION PLUS DRAFT ANGLE  
⊖ DENOTES DIMENSION MINUS DRAFT ANGLE  
⊗ DENOTES REFERENCE NOTE OR DIMENSION  
⊠ DENOTES CRITICAL INSPECTION DIMENSIONS

ACR ELECTRONICS, INC  
5757 RAVENSWOOD RD. FT. LAUDERDALE FL 33312

**SARLINK SOS-300  
FINAL ASSY**

SIZE: D CODE (REV. NO.): 18560 DRAWING NO.: A3-06-2918- REV: F  
SCALE: 1:4 SHEET 1 of 2

D

D

C

C

B

B

A

A

