

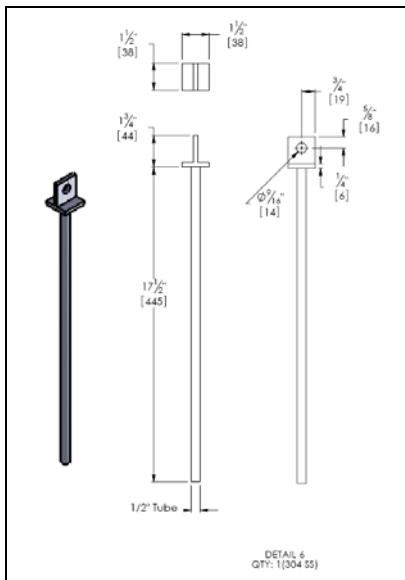
UTILIDOR ACCESS HATCH ASSEMBLY PROCEDURE

This is a guideline for hatch assembly. Contractor must also refer to "*Hatch Drawings 099947-53, Sheets 1 thru 7 of 7*". On arrival this is what the access hatch will look like (with the latch installed and frame exterior coated green).

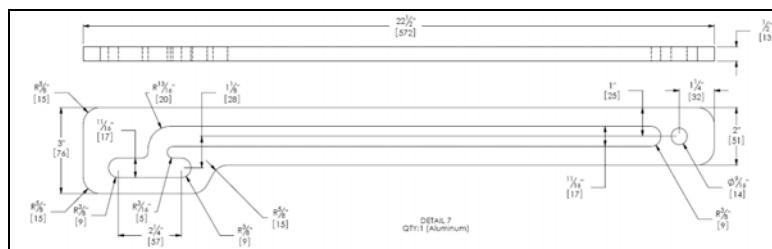


Layout of hatch and parts on arrival in Alaska

ITEMS TO ASSEMBLE:

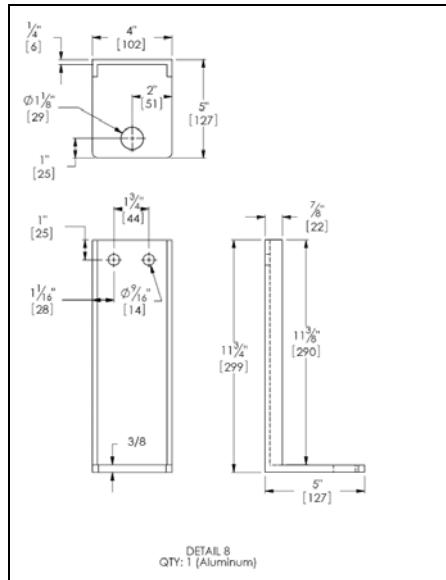


Detail 6
Stainless Steel Shock Rod.



Detail 7
Aluminium J-arm.

ITEMS TO ASSEMBLE:



Detail 8
Aluminium Shock Tower

STEPS TO ASSEMBLING THE UTILIDOR Access HATCHES:

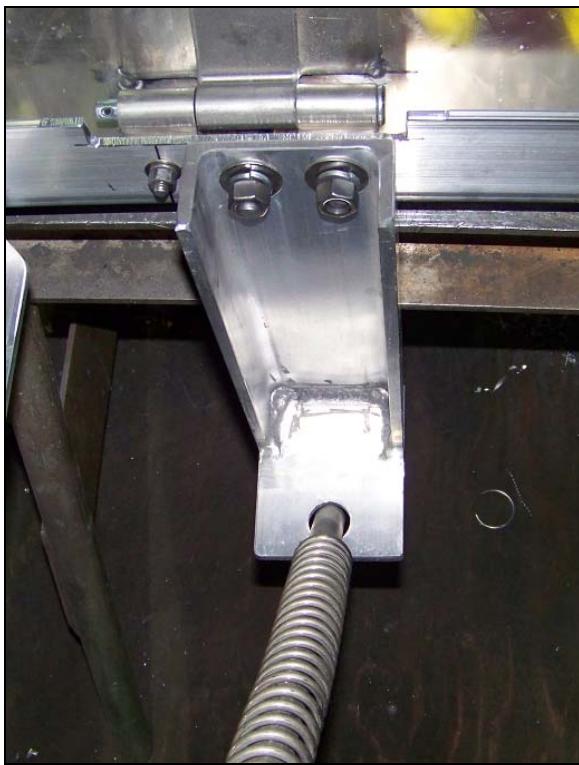
Step 1:



Remove the center and right bolts on the left hinge. Each SS bolt is $\frac{1}{2}$ " by $1\frac{1}{2}$ ", with two $\frac{1}{2}$ " SS flat washers, two $\frac{1}{2}$ " SS lock washers and two $\frac{1}{2}$ " SS nuts.

Insert the aluminum shock tower into the frame, align over center and right bolts, reinstall the washers and nuts and tighten the assembly.

Step 2:



Place spring on stainless steel shock rod and insert into bottom hole of aluminum shock tower.

STEPS TO ASSEMBLING THE UTILIDOR Access HATCHES:

Step 3:



Bolt top of stainless steel shock rod in between the two support plates, located on the lid above door hinge.

Bolt holding shock rod to the lid is one $\frac{1}{2}$ " by 2" SS bolt, two $\frac{1}{2}$ " SS flat washers and one $\frac{1}{2}$ " SS nylok nut.

Step 4:



Remove the nylok nut and one flat washer from the ready rod attached to the angle support under the frame.

Install the aluminum J-arm onto the ready rod making sure the "right" side of pivot table is facing the front of the hatch.

STEPS TO ASSEMBLING THE UTILIDOR ACCESS HATCHES:



Aluminum J-arm is attached to the ready rod with two $\frac{5}{8}$ " SS flat washers and one $\frac{5}{8}$ " SS nylok nut.

Step 5:



The bolt holding the aluminum J-arm to the lid is one $\frac{1}{2}$ " by 2" SS bolt, two $\frac{1}{2}$ " SS flat washers and one $\frac{1}{2}$ " SS nylok nut.

ACCESS HATCH IS ASSEMBLED!