

THIS DOCUMENT AND THE DATA DISCLOSED HEREIN OR HEREWITH IS PROPERTY OF AND BELONGS TO ACR ELECTRONICS, INC., FT. LAUDERDALE, FL. IT IS FURNISHED IN CONFIDENCE SOLELY FOR INFORMATIONAL PURPOSES. IT IS NOT TO BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART TO ANYONE WITHOUT THE PERMISSION OF ACR.

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

1	1	1	1	57	A1-20-1928	CLOTH LABEL
1	1	1	1	56	A3-06-2976	SARLINK POUCH
1	1	1	1	55	A1-20-1927	APPROVAL LABEL
1	1	1	1	54	A1-20-1926	REGISTRATION LABEL
1	1	1	1	53	A1-20-1844-1	ACTIVATION LABEL
1	1	1	1	52	A1-20-1843-1	BATTERY EXPIRATION LABEL
1	1	1	1	51	A1-20-1716	LABEL, SCREEN PROTECTOR
1	1	1	1	50	A1-18-2407	OVER LAMINATE POLYESTER 1.5" x 1.5"
1	1	1	1	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		
1	1	1	1	40	A1-20-1847	HEX ID LABEL
1	1	1	1	39	A1-20-1661	BATTERY REPLACEMENT DATE LABEL
				38		
				37		
				36		
1	1	1	1	35	A1-20-1845	GPS LABEL
1	1	1	1	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)
1	1	1	1	31	A1-25-0196	USB COVER
6	6	6	6	30	A1-05-0952-031	SCREW 4-40 x 3/8
1	1	1	1	29	A1-25-0194	GASKET
1	1	1	1	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
1	1	1	1	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)
DASH 4 QTY.	DASH 3 QTY.	DASH 2 QTY.	DASH 1 QTY.	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION

UNLESS OTHERWISE SPECIFIED:
ALL ANGLES ARE 90°

TOLERANCES ON

MILLIMETER

FRACTIONS

DECIMALS

ANGLES

X. ± .25
X.X ± .125
X.XX ± .006

±1/64

.X ± .030
.XX ± .010
.XXX ± .005

X ± 5°
.X ± 2°
.XX ± 1°
.XXX ± 1/2°
IMPLIED: ±1°

ANGS

SOLIDWORKS

DRAWN

CHECKED

ENG.

APVD.

FD

JG

RR

RR

8/24/15

8/28/15

8/28/15

8/28/15

ACR ELECTRONICS, INC

5757 RAVENSWOOD RD, FT. LAUDERDALE FL 33312

SARLINK SOS-300

FINAL ASSY

SIZE

D

CODE (ENR. NO.)

18560

DRAWING NO.

A3-06-2918-

REV

F

SCALE

1:4

SHEET

1

OF

2

8

7

6

5

4

3

18560

DWG. NO.

A3-06-2918-

SHT

2

REV

F

1

D

D

C

C

B

B

A

A

