

FIT FRONT BUOYANCY

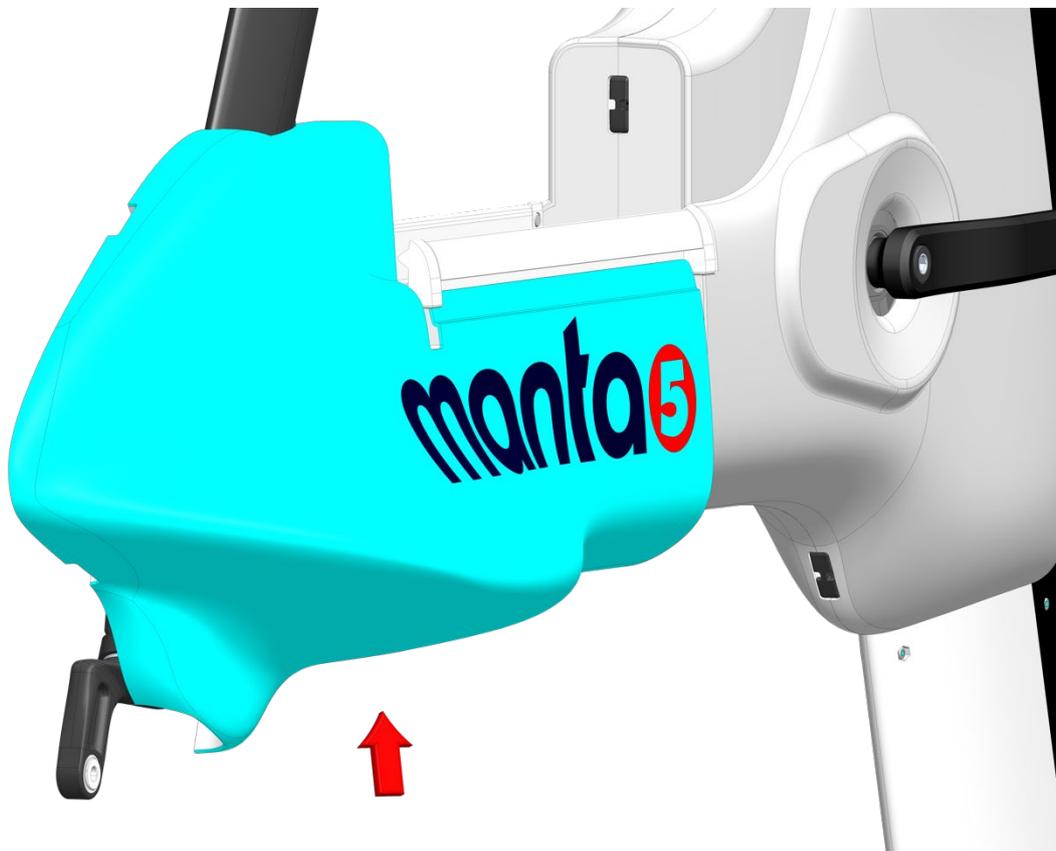
This tutorial shows how to fit the Front Buoyancy module on the XE-1.

1. Work Instruction – Fit Front Buoyancy

TOOLS REQUIRED

ID	Description	Task
	Long Nose Pliers	Remove Buoyancy Clips

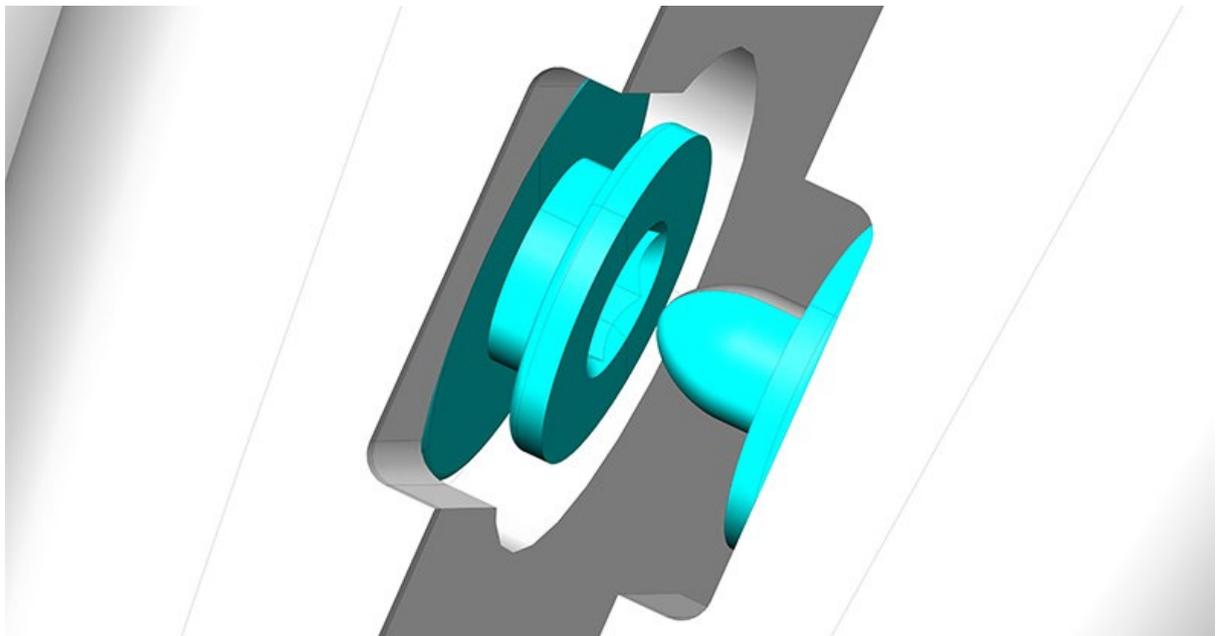
1.1 To fit the Left-Hand Front Buoyancy, align the module with the Frame and Battery Tray. Partially engage with the lip of the Battery Tray and apply pressure to the buoyancy module near the front of the battery tray while pushing upwards on a slight angle. The buoyancy module will slot into place.



1.2 To fit the Right-Hand Front Buoyancy set, align the Buoyancy Module with the frame and Battery Tray. Apply pressure just below the front of the Battery Tray and push the Buoyancy set upwards on a slight angle until it slots in behind the lip of the Battery Tray. Maintain sufficient separation between the Left-Hand and Right-Hand buoyancy modules so that the locating inserts on the right hand side module and locating pins on the left hand side module can align and fit together.

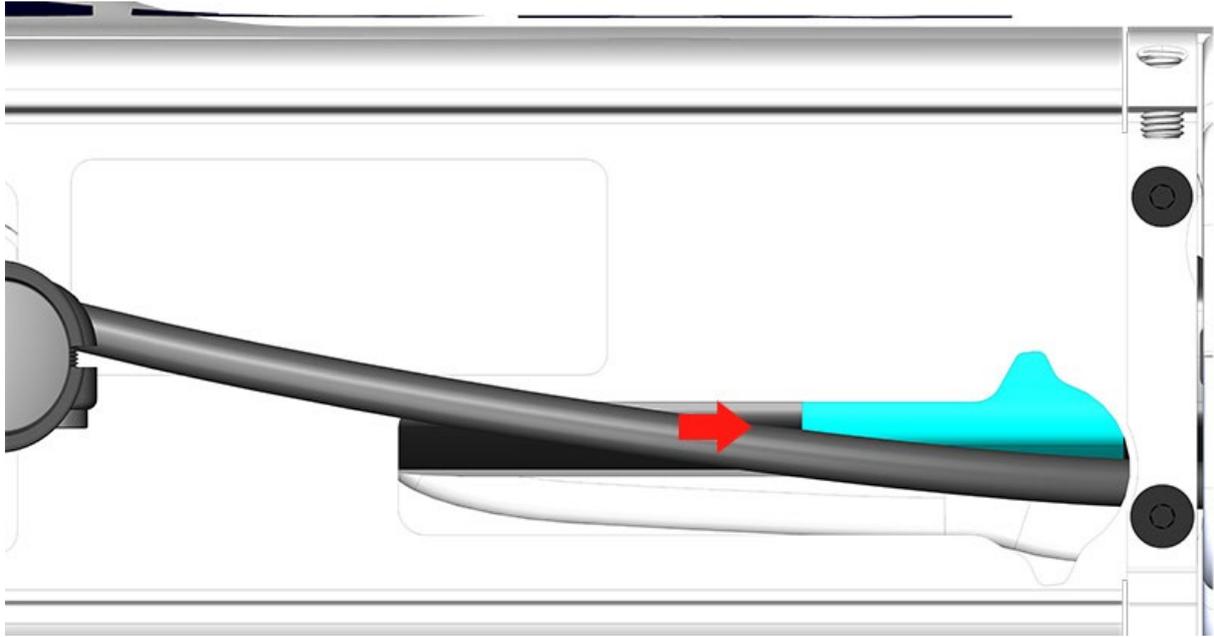


1.3 Ensure that all five the inserts engage with the corresponding inserts with pins.



INFORMATION: With the Front Buoyancy fitted the inserts should fit together with little or no gap to ensure that the Buoyancy Clips will fit properly.

1.4 Looking down onto the top of the Battery Tray, reach into the aft slot past the Motor Battery Cable and slide the Stirrup (highlighted in the image) backwards into the locked position. The Stirrup provides alignment support and locks the Front Buoyancy to the Battery Tray.



1.5 To complete the assembly, fit all 5 Buoyancy Clips that lock the two halves together. If any one of the clips do not lock properly or do not pull the two buoyancy halves together, remove the clip using Long Nose Pliers and refit.

