



SERVICE LETTER

- Addressed to:** All customers using the Securaplane Main Ship Battery Series 9750W0350-XX (18Ah), 9750W0360-XX (25Ah), 9750W0370-XX (43Ah), 9750W0380-XX (45Ah), 9750W0390-XX (28Ah), 9750W0538 (40Ah), and 9750W0640 (25Ah)
- Subject:** Running torque levels for battery posts during main ship battery reblocking.
- Reason:** To help prevent stud breakage during the reblocking operation from possible high running torque levels on battery studs.
- Description:** The guidance provided in this Service Letter will allow torque levels to be monitored during the installation of new monoblocks in main ship battery assemblies. Current torque levels defined in the CMM call out the final amount of in-lbs. to be applied to the Binx nuts on the battery stud but there is no call to monitor the running torque as the nut moves down the length of the stud. This letter will provide a maximum torque level not to be exceeded prior to the final tightening of the Binx nuts.
- Guidance:**
1. Follow all assembly and disassembly instructions as described in the applicable CMM for the given battery part number.
 2. When installing the Binx nuts on the new monoblocks, use a calibrated torque wrench set for 15 in-lbs. to drive the nuts down the battery studs until they make contact with the washers over the bus and interconnect laminations.
 3. Make sure the torque needed to drive the nuts down the battery studs does not reach 15 in-lbs. If the torque wrench reaches 15 in-lbs. at any time before a nut makes contact with the lamination hardware, STOP installing the nut. Back the nut off the stud and clean the stud's threads and those of the Binx nut of any metal shavings or other debris. Re-install the same nut on the same stud and again, use the torque wrench to monitor the running torque until the nut makes contact with the lamination hardware. If the nut reaches 15 in-lbs. again prior to making contact with the lamination hardware, remove the nut and discard.
 4. If a new Binx nut is not available, it is permissible to use a Binx nut from the old battery blocks. Drive the old nut on the new battery stud by hand until the threads begin to exit the top of the nut. As this happens, the nut will begin to lock onto the threads of the stud and be difficult or impossible to turn by hand indicating that the nut's locking mechanism is functioning correctly. Continue to drive the nut as outlined in step 3 above.
 5. Once the Binx nut has made contact with the lamination hardware, continue torqueing until 15 in-lbs. is reached. Verify that the Binx nut and lamination hardware are in contact and that the lamination, the flat washer and the Binx nut are snug and do not move freely.
 6. Set the torque wrench to the lowest setting in the range specified in the CMM for the battery posts. In most cases, this will be 35 in-lbs. Do not exceed 35 in-lbs. Torque all battery post hardware at this level.



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- References:** Securaplane CMM for 9750W0350-1, 18AH Battery Series, F2602-0035, ATA 24-30-02
- Securaplane CMM for 9750W0350-5, 18AH Battery Series, F2602-0049, ATA 24-30-04
- Securaplane CMM for 9750W0360, 25AH Battery Series, F2602-0078, ATA 24-30-14
- Securaplane CMM for 9750W0360-5, 25AH Battery Series, F2602-0079, ATA 24-30-15
- Securaplane CMM for 9750W0370, 43AH Battery Series, F2602-0057, ATA 24-30-07
- Securaplane CMM for 9750W0370-1, 43AH Battery Series, F2602-0034, ATA 24-30-08
- Securaplane CMM for 9750W0370-10, 43AH Battery Series, F2602-0058, ATA 24-30-12
- Securaplane CMM for 9750W0370-11, 43AH Battery Series, F2602-0050, ATA 24-30-13
- Securaplane CMM for 9750W0370-18, 43AH Battery Series, F2602-0256, ATA 24-30-05
- Securaplane CMM for 9750W0370-3, 43AH Battery Series, F2602-0056, ATA 24-30-09
- Securaplane CMM for 9750W0370-6, 43AH Battery Series, F2602-0051, ATA 24-30-10
- Securaplane CMM for 9750W0370-7, 43AH Battery Series, F2602-0080, ATA 24-30-06
- Securaplane CMM for 9750W0370-8, 43AH Battery Series, F2602-0054, ATA 24-30-11
- Securaplane CMM for 9750W0370-19, 43AH Battery Series, MM-0226-01, ATA 24-30-16
- Securaplane CMM for 9750W0380-1, 45AH Battery Series, F2602-0033, ATA 24-32-33
- Securaplane CMM for 9750W0390-5, 28AH Battery Series, MM-0235-01, ATA 24-30-18
- Securaplane CMM for 9750W0538, 40AH Battery Series, F2602-0032, ATA 24-30-01
- Securaplane CMM for 9750W0640, 25AH Battery Series, F2602-0031, ATA 24-30-03