



IMPORTANT!

This instruction contains important data regarding tightening, lubrication, sealing and securing of screw connections.

In order to ensure a correct assembling of the propeller equipment please see tightening instruction for screws ident no:

2036393-1

Corresponding to release 3 10 K1-02

| | | | | | | | | | |
|------------------------------------------------|-------|-------------------------------------|-------|-----------------------|-----------------------------|-------------|------------------------|----------------------|------|
| Basic Standards (MBD SB) & Suppl. Drawing No.: | | | | EN21C Surf. roughness | | Projection: | | Material / Blank: | |
| | | | | EN21F-m Tolerances | | | | | |
| | | | | | | Mass (kg): | | Final User Material: | |
| Date | Des. | Chk. | Appd. | A.C. | Change / Replacement | | | | C.No |
| | | | | * | Replaced by Ident. No.: | | | | 5 |
| | | | | * | | | | | 4 |
| | | | | * | | | | | 3 |
| | | | | * | | | | | 2 |
| 20041004 | EVA | HCM | | * | Pos 16 and 22 changed | | | | 1 |
| 20031029 | LEH | KEB | | * | | | | | 0 |
| Similar Drawing No.: | | | | | Replacement for Ident. No.: | | | | |
| Scale: | Size: | Type: | | | Page No.: | | MAN B&W Diesel A/S | | |
| | A4 | PROPELLER EQUIPMENT VBS1080 MK3/ODG | | | 01 (03) | | | | |
| Ident. No.: | | Description: | | | | | Ident. No.: | | |
| | | TIGHTENING DATA | | | | | 2057748-2 | | |
| Final User Info. No.: | | Final User Description: | | | | | Final User Ident. No.: | | |
| | | | | | | | | | |



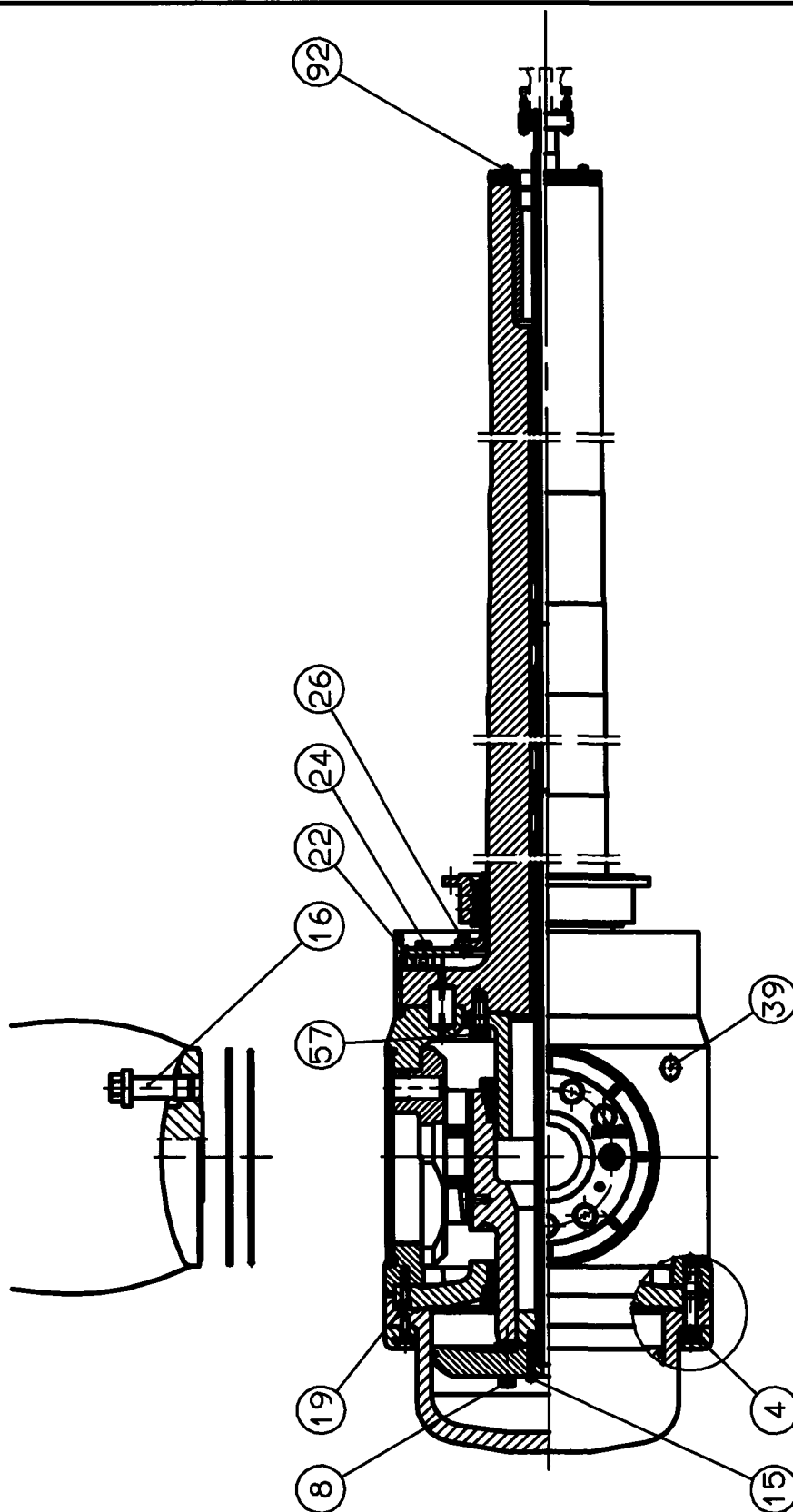
| Pos no | Description screw for- | Dimension | Width cross flats | Tightening | Securing | Sealing |
|--------|------------------------|-------------------------------------------------------------|-------------------|---------------|-----------------------|---------|
| 4 | Servo cylinder | M30 x 160 | 22 | 560 Nm | Nylon lock | 1)Yes |
| 8 | Servo piston | M24 x 140 | 19 | 420 Nm | Ø1.5 mm wire securing | No |
| 15 | Servo oil pipe aft | M12 x 160 | 10 | 50 Nm | Ø1.5 mm wire securing | No |
| 16 | Propeller blade | M64 x 176 | 65 | 300 Nm +56 mm | Welding Ø8 mm A4 wire | No |
| 19 | End cover, fore | M20 x 80 | 17 | 155 Nm | Nylon lock | No |
| 22 | Shaft/hub | M64 x 165 | 65 | 300 Nm +44 mm | Welding Ø6 mm wire | No |
| 24 | Guard | M24 x 50 | 36 | 280 Nm | Nylon lock | 2)Yes |
| 26 | Shaft seal, aft | Please see propeller equipment drawing or shaft seal manual | | | | |
| 39 | Hub (plug screw) | 3/4" BSP | 32 | 135 Nm | Nylon lock | Yes |
| 57 | Guide cylinder | M30 x 70 | 22 | 640 Nm | Nylon lock | No |
| 92 | Sealing flange | M16 x 50 | 14 | 105 Nm | Nylon lock | No |

- 1) Sealing compound is added between servo cylinder, end cover and hub contact face
 2) Sealing compound is added between guard and screw pos no 22

NOTE All screws to be lubricated by molycote pasta type GN+

| | | | | | | | |
|-----------------------|-------------------------|-------|----------------|---------|---------|----------------------|------------------------|
| Date | 20041004 | Des. | CHK. | Appd. | A.C. | Change / Replacement | C.No |
| Scale: | A4 | Type: | PROP.EQUIPMENT | VBS1080 | MK3/ODG | Page No.: 02 (03) | MAN B&W Diesel A/S |
| Ident. No.: | TIGHTENING DATA | | | | | | 2057748-2 |
| Final User Info. No.: | Final User Description: | | | | | | Final User Ident. No.: |

SCREW POSITIONS



| Date | Des. | Chk. | Appd. | A.C. | Change / Replacement | C.No. |
|-----------------------|--------------------|-----------------------------------------|-------|------|-----------------------|------------------------------|
| 20041004 | EVA | HCM | | * | Pos 16 and 22 changed | 1 |
| Scale: | Size: A4 | Type: PROP.EQUIPMENT VBS1080 MK3/ODG | | | Page No.: 03 (03) | MAN B&W Diesel A/S |
| Ident. No.: | | Description: TIGHTENING DATA | | | | Ident. No.: 2057748-2 |
| Final User Info. No.: | | Final User Description: | | | | Final User Ident. No.: |