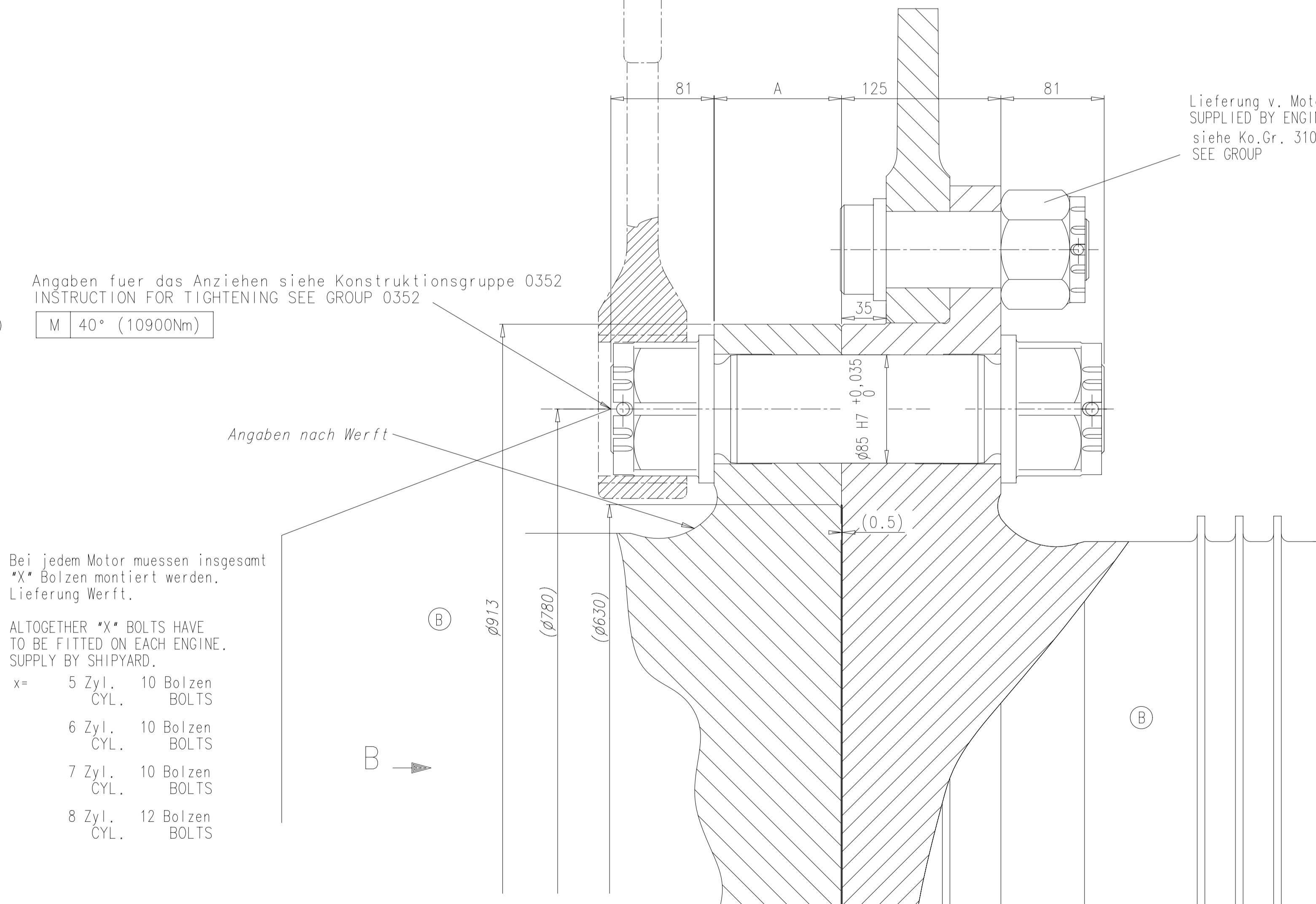
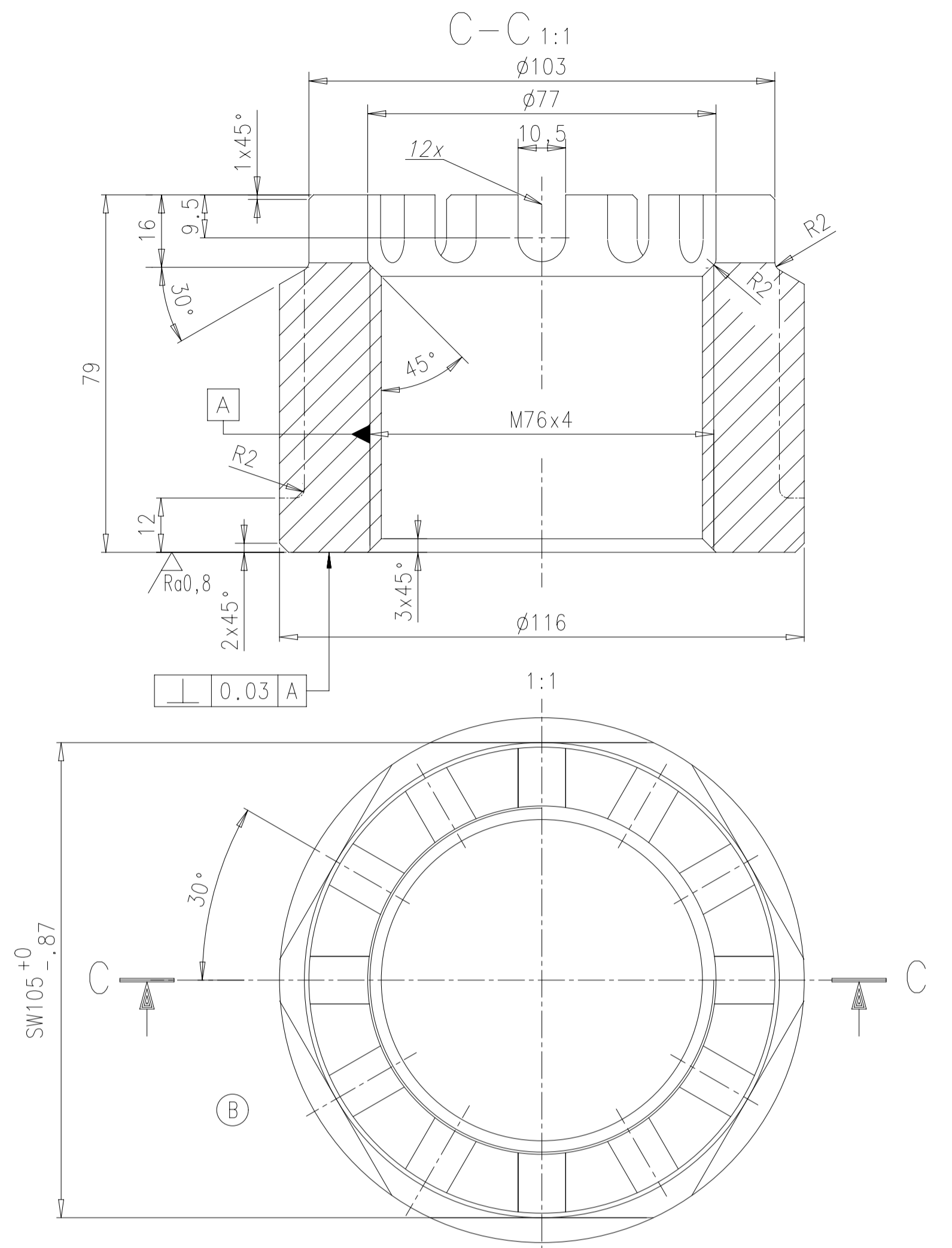
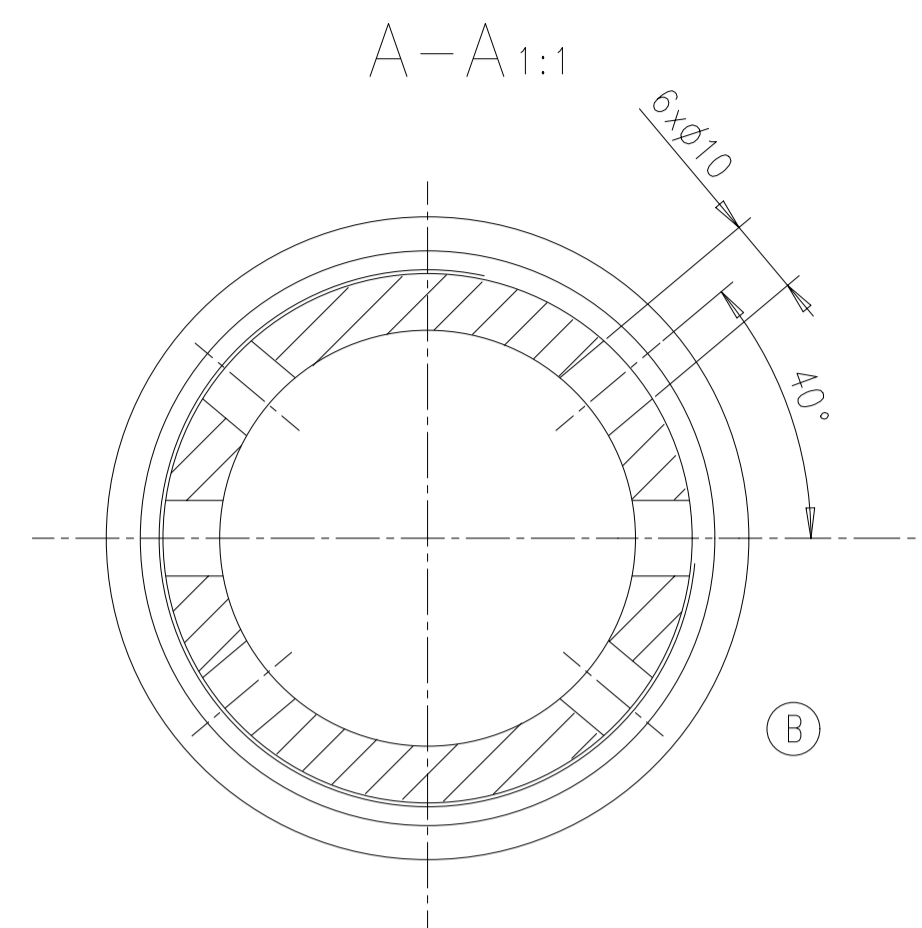
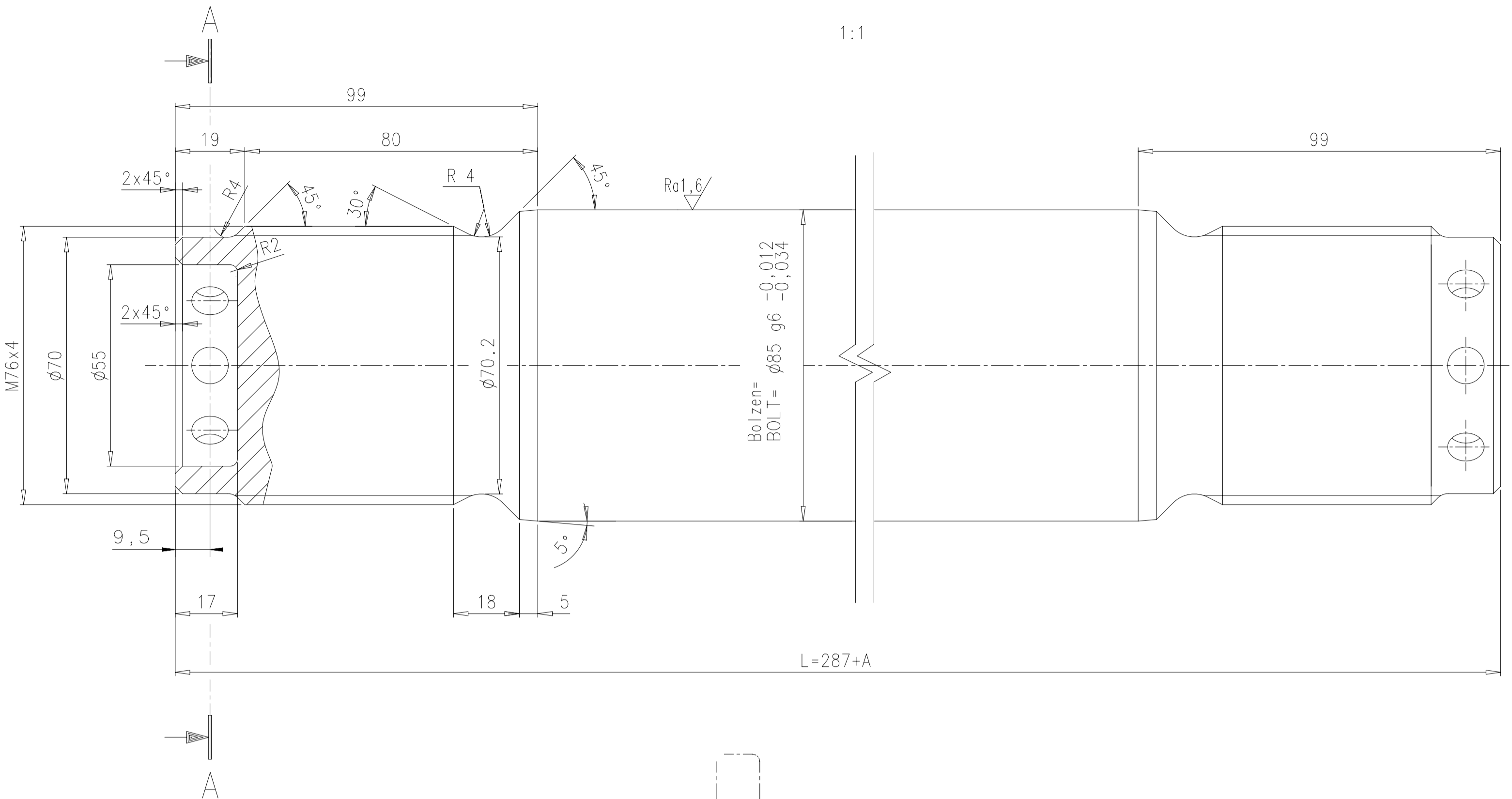


Material W-FA-34CrMo-QT
MATERIAL
verguetet Rm 800 $\frac{+150}{0}$ N/mm²
QUENCHED AND TEMPERED

Empfohlene Ausfuehrung der Bolzen und Muttern fuer Kurbelwellen-Verschraubung.
RECOMMENDED DESIGN OF BOLTS AND NUTS FOR CRANKSHAFT SCREWING.

Material W-FU-325-N
MATERIAL
normalgeglueht Rm 580 $\frac{+140}{0}$ N/mm²
NORMALIZED



Angaben fuer das Anziehen siehe Konstruktionsgruppe 0352
INSTRUCTION FOR TIGHTENING SEE GROUP 0352

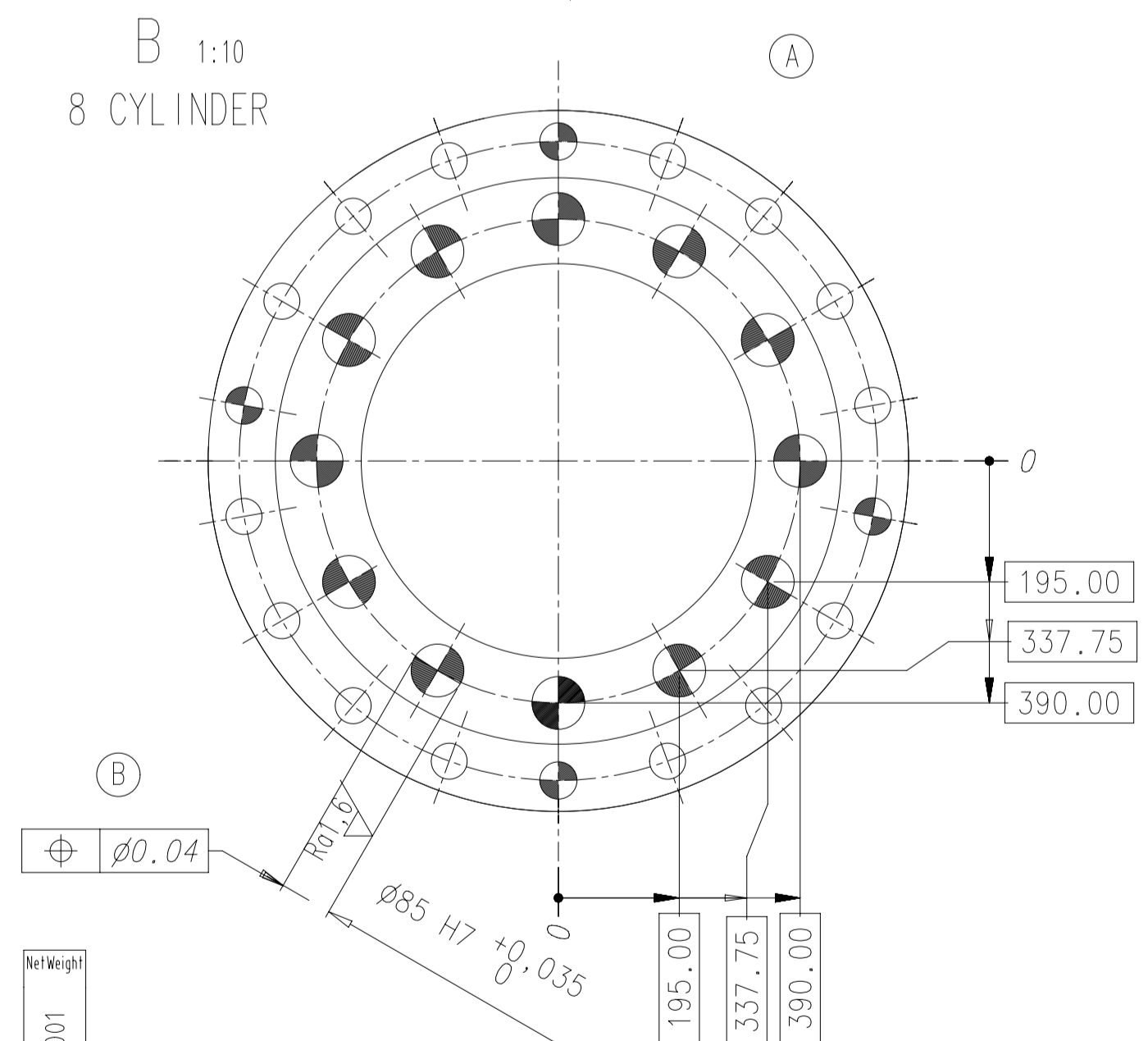
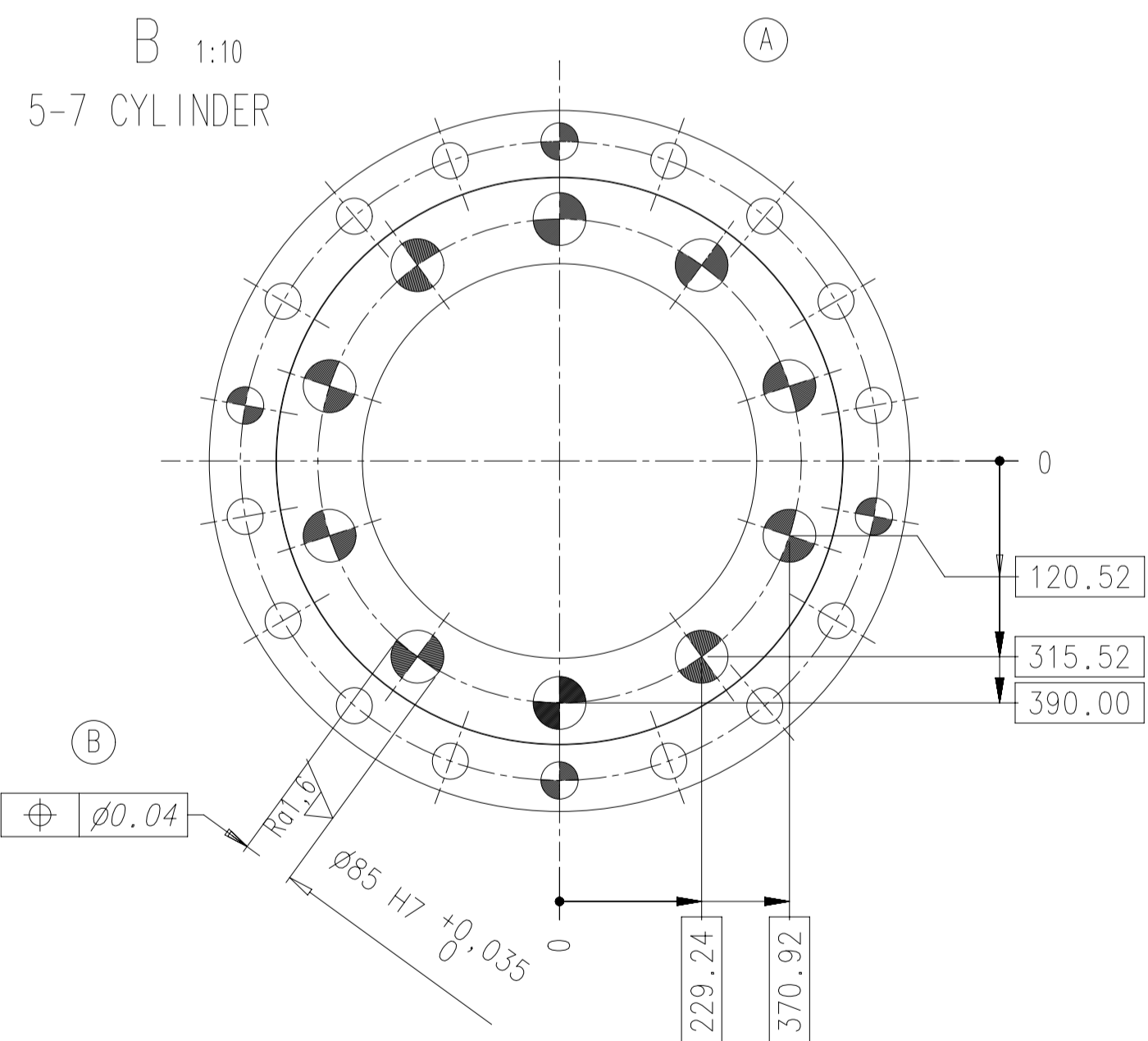
M 40° (10900Nm)

Angaben nach Werft

Bei jedem Motor muessen insgesamt *X* Bolzen montiert werden.
Lieferung Werft.

ALTOGETHER *X* BOLTS HAVE TO BE FITTED ON EACH ENGINE.
SUPPLY BY SHIPYARD.

- x= 5 Zyl. 10 Bolzen CYL. BOLTS
- 6 Zyl. 10 Bolzen CYL. BOLTS
- 7 Zyl. 10 Bolzen CYL. BOLTS
- 8 Zyl. 12 Bolzen CYL. BOLTS



• THIS TABLE REFERS TO DIN EN 10204-(2004). *TYPES OF INSPECTION DOCUMENTS*		
LISTED ARE THE MOST STRINGENT CERTIFICATION REQUIREMENTS		
ACTUAL REQUIREMENTS MUST BE AGREED WITH THE APPROPRIATE CLASSIFICATION SOCIETY		
TEST TYPE:	CERTIFICATE TYPE:	TESTING FREQUENCY:
MATERIAL	MATERIAL IDENTIFICATION	-
CHEMICAL ANALYSIS	CLASSIFICATION CERTIFICATE 3.2	TEST PER ORDER LOT OR PER CHARGE IF SEVERAL CHARGES
TENSILE TEST	CLASSIFICATION CERTIFICATE 3.2	TEST PER ORDER LOT OR PER CHARGE IF SEVERAL CHARGES
IMPACT TEST	CLASSIFICATION CERTIFICATE 3.2	TEST PER ORDER LOT OR PER CHARGE IF SEVERAL CHARGES
HARDNESS TEST	INSPECTION CERTIFICATE 3.1 (INDEPENDENT AUTHORITY)	EXAMINATION OF EACH PART
SURFACE CRACK DETECTION TEST	CLASSIFICATION CERTIFICATE 3.2	EXAMINATION OF EACH PART

Quantity PER ENGINE	SEQ. NO.	Material ID	Material Name	Dimension, Occ.	Standard or Drawing	Basic Material Material Standard	Weight GR./NET
1	001	PAAD24.6065	MATERIAL AND TEST SPECIFICATION For sleeves, nuts and bolts		DAAD083901		0,006



5-8RT-f1ex48T-D
5-8RTA48
5-8RTA48T-B
5-8RTA48T-D
CONNECTION CRANK/PROPELLER SHAFT
Verbindung Kurbel-/Propellerwelle

M	MOLYKOTE PASTE G-n On threads and contact surfaces	O	OIL On threads and contact surfaces	N	NEVER SEEZ NSBT8 On threads and contact surfaces	K	NO ADDITIONAL LUBRICATION
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Units	mm kg	NX	Basic Material	Net Weight
Scale	1:2.5	Design Group	3114	107.221.589
Surface Protection	SEE GROUP 0344	Material	W-FU-325-N	
Tolerancing Principle	ISO8015	Design Group	3114	
General Tolerances	ACCORDING TO ISO2768-mK	Design Group	3114	