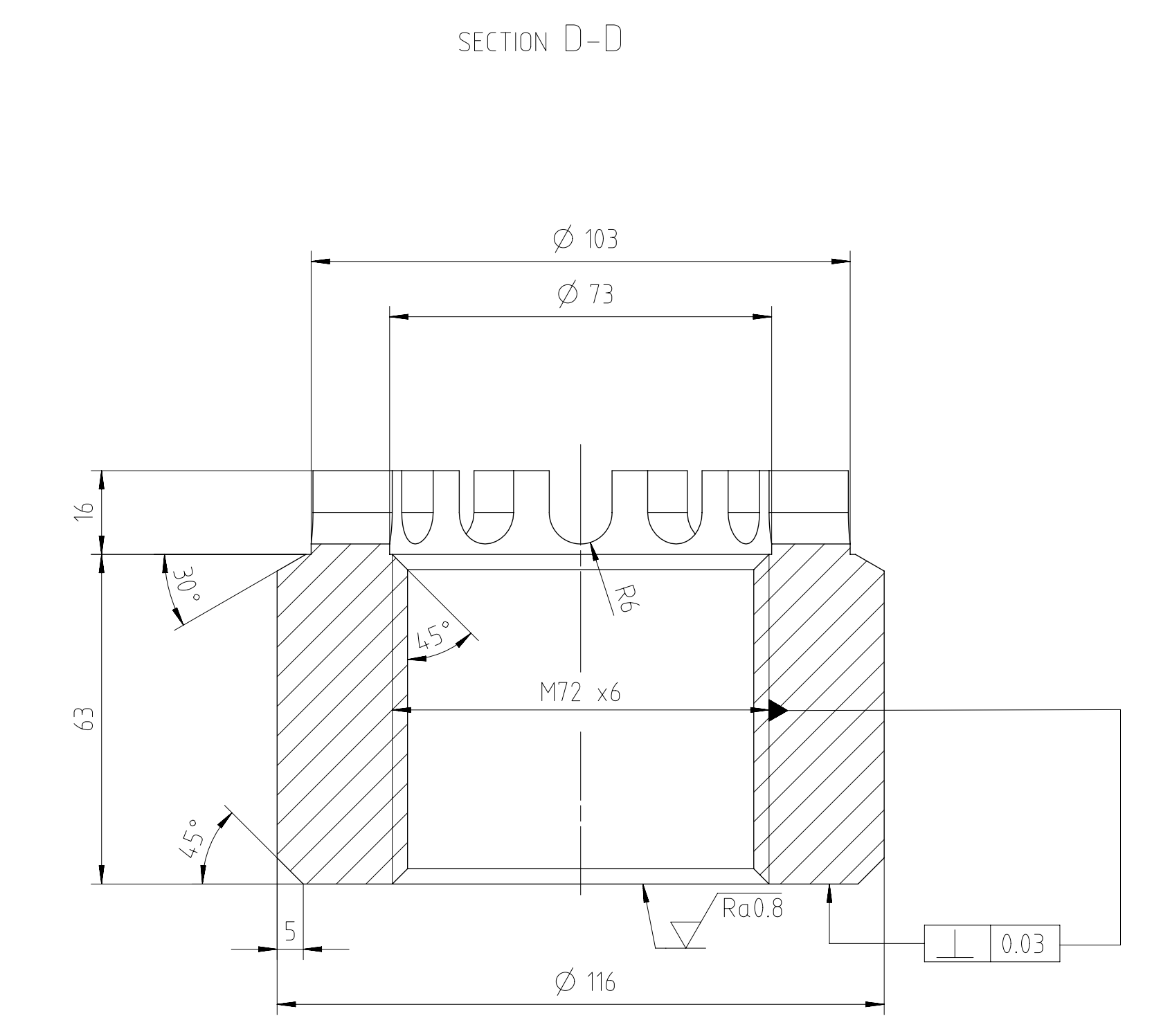
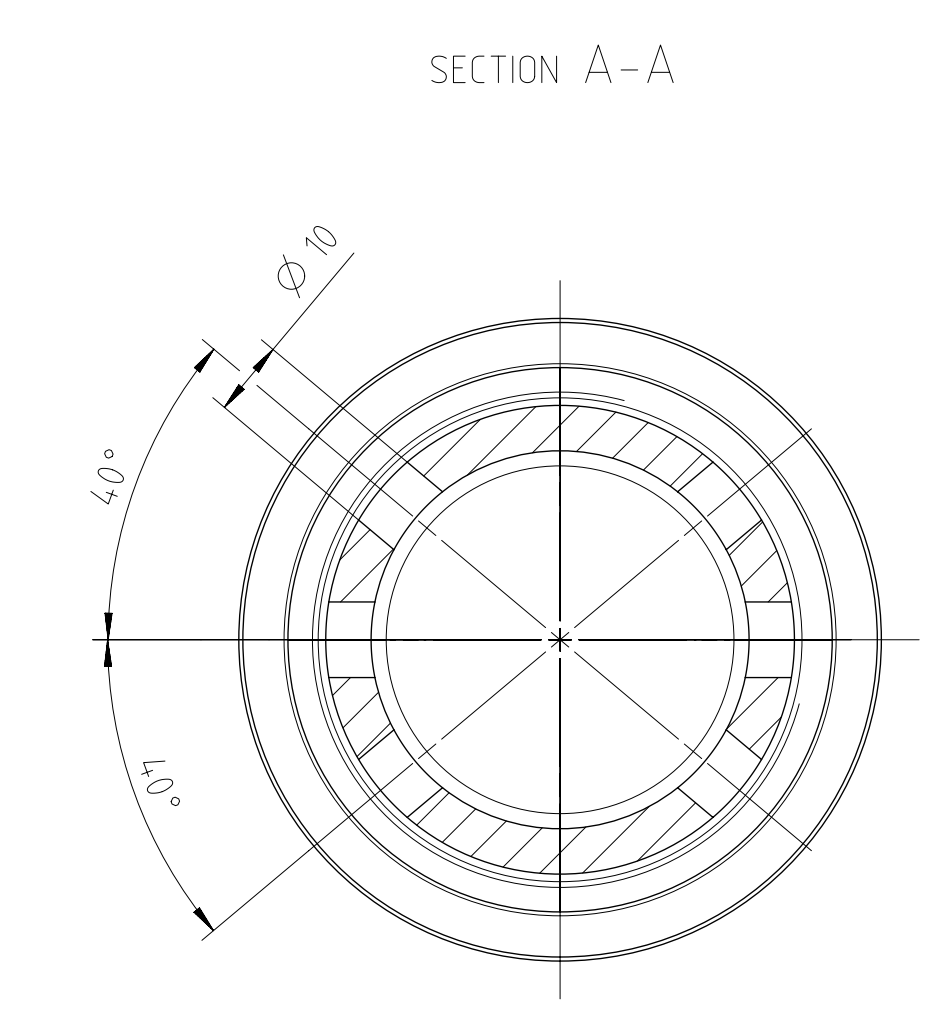
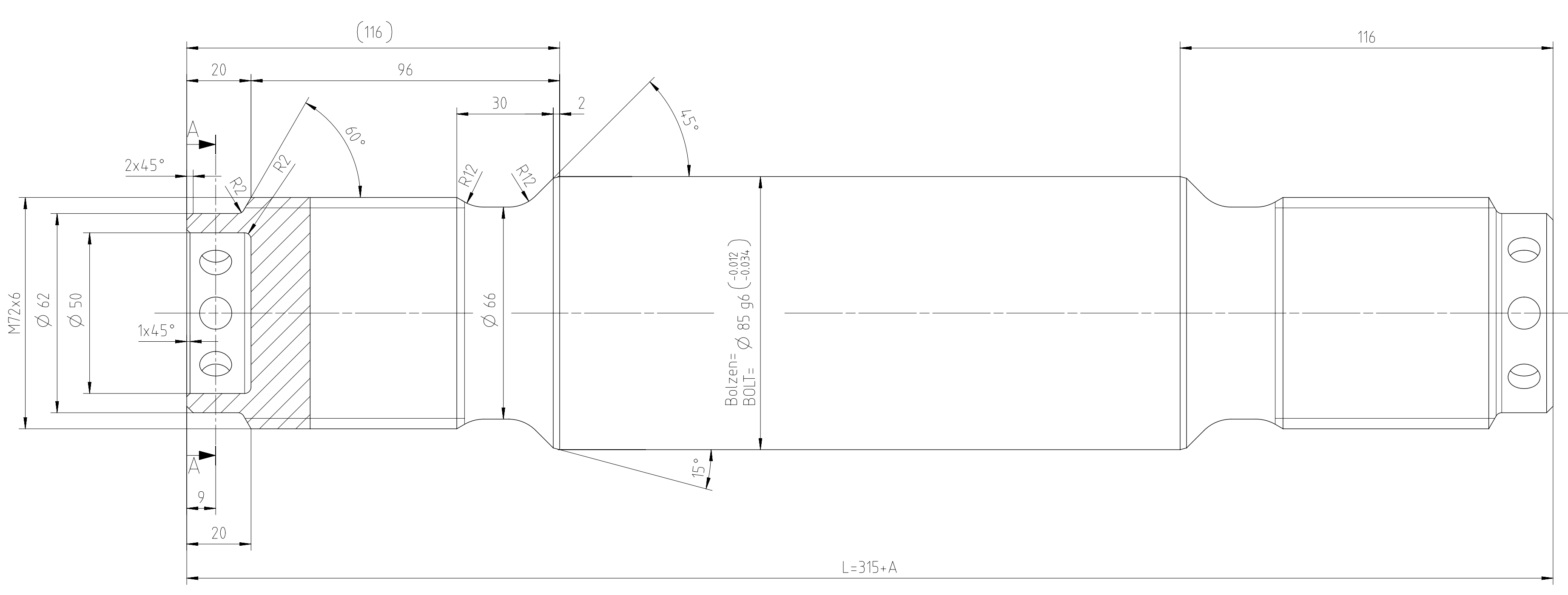


$\sqrt{Ra6.3}$  ( $\sqrt{Ra1.6}$ ) Material W-FA-42CrMo-QT  
 Material W-FA-42CrMo-QT  
 Material  
 verguetet, Rm = 900<sup>+200</sup><sub>0</sub> N/mm<sup>2</sup>  
 QUENCH HARDENED AND TEMPERED

$\sqrt{Ra6.3}$  ( $\sqrt{Ra0.8}$ ) Material W-FU-325-N  
 Material W-FU-325-N  
 Material  
 normalisiert, Rm = 590<sup>+130</sup><sub>0</sub> N/mm<sup>2</sup>  
 NORMALIZED

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

Lieferung Werft  
 SUPPLY BY SHIPYARD

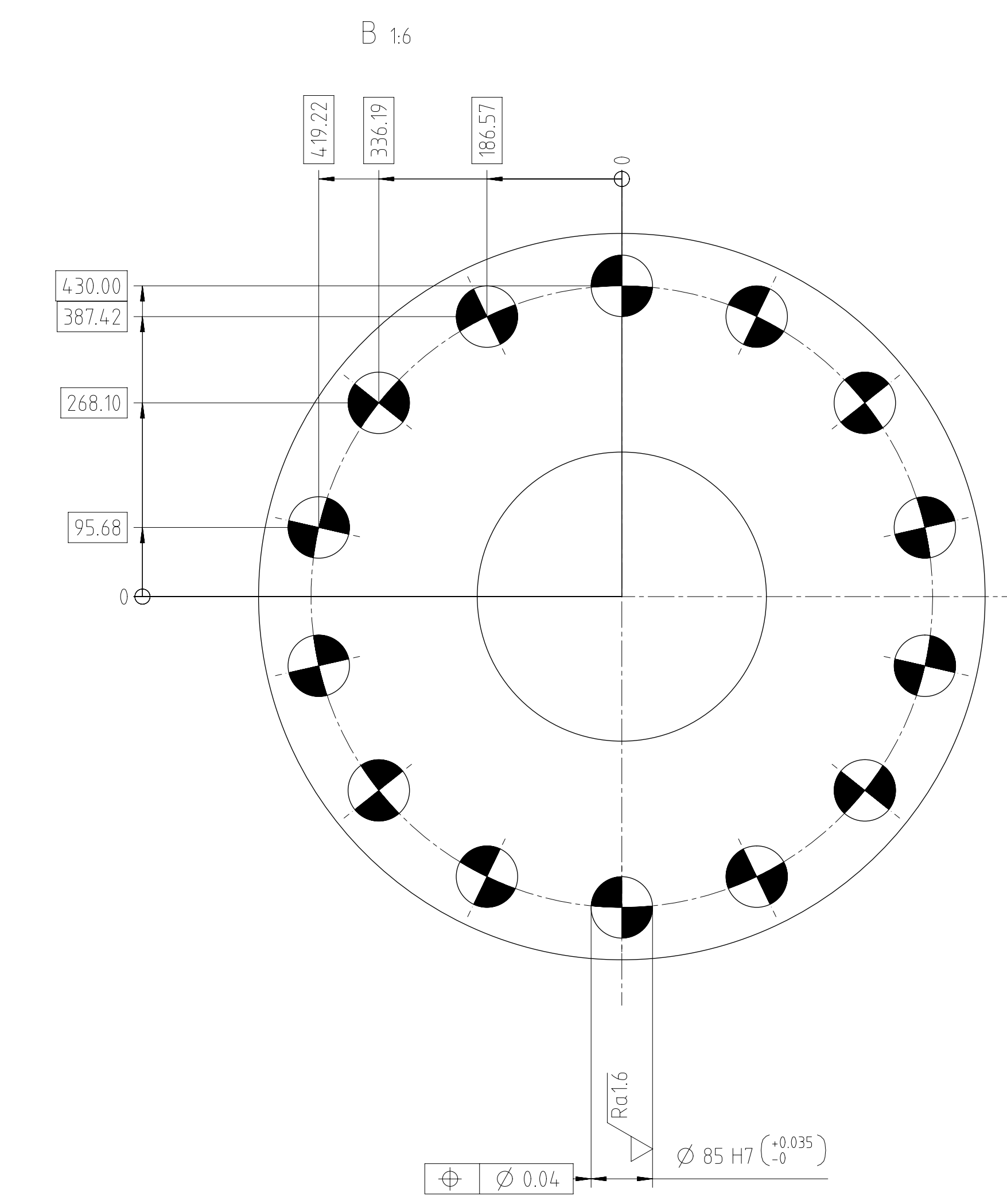
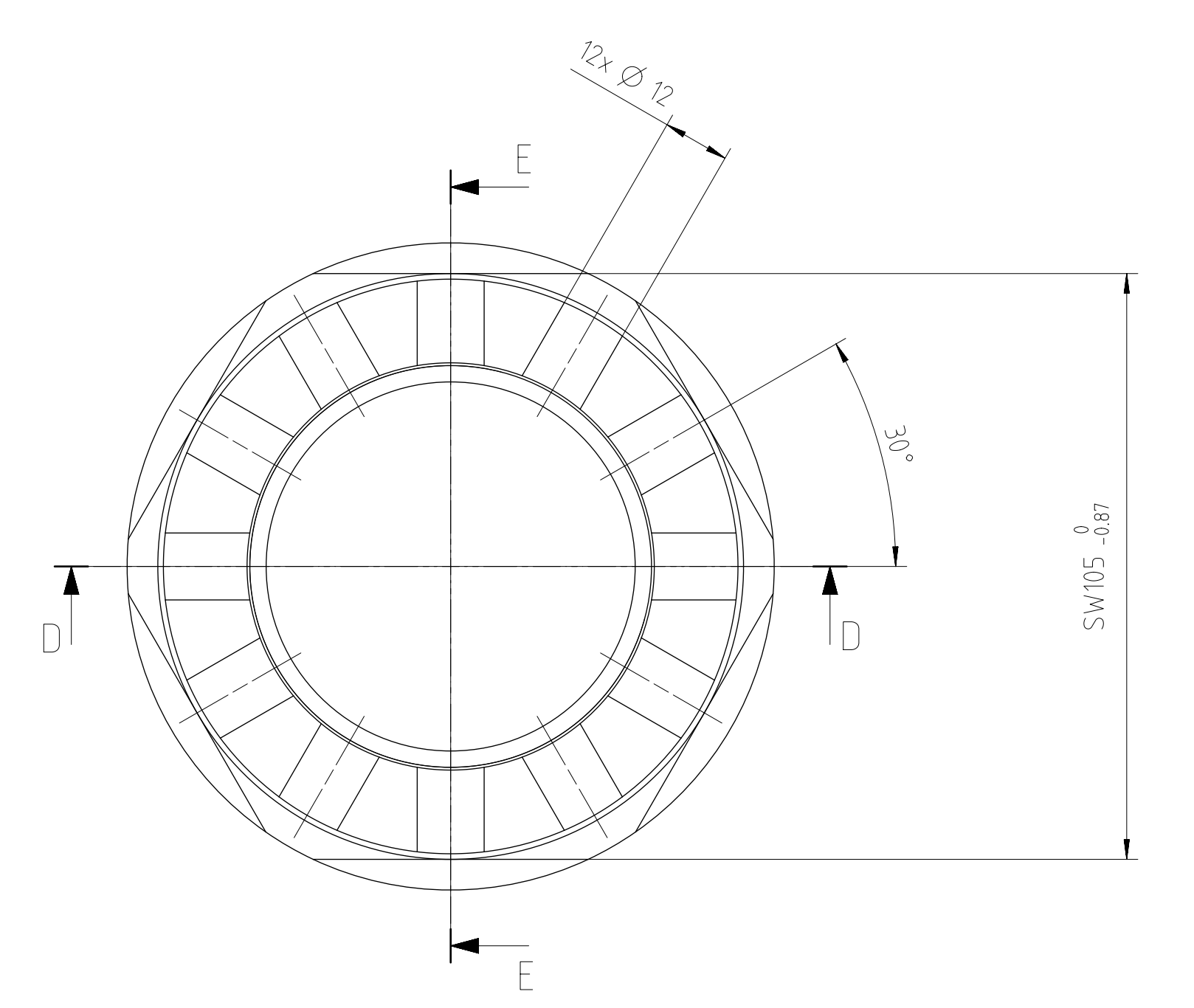
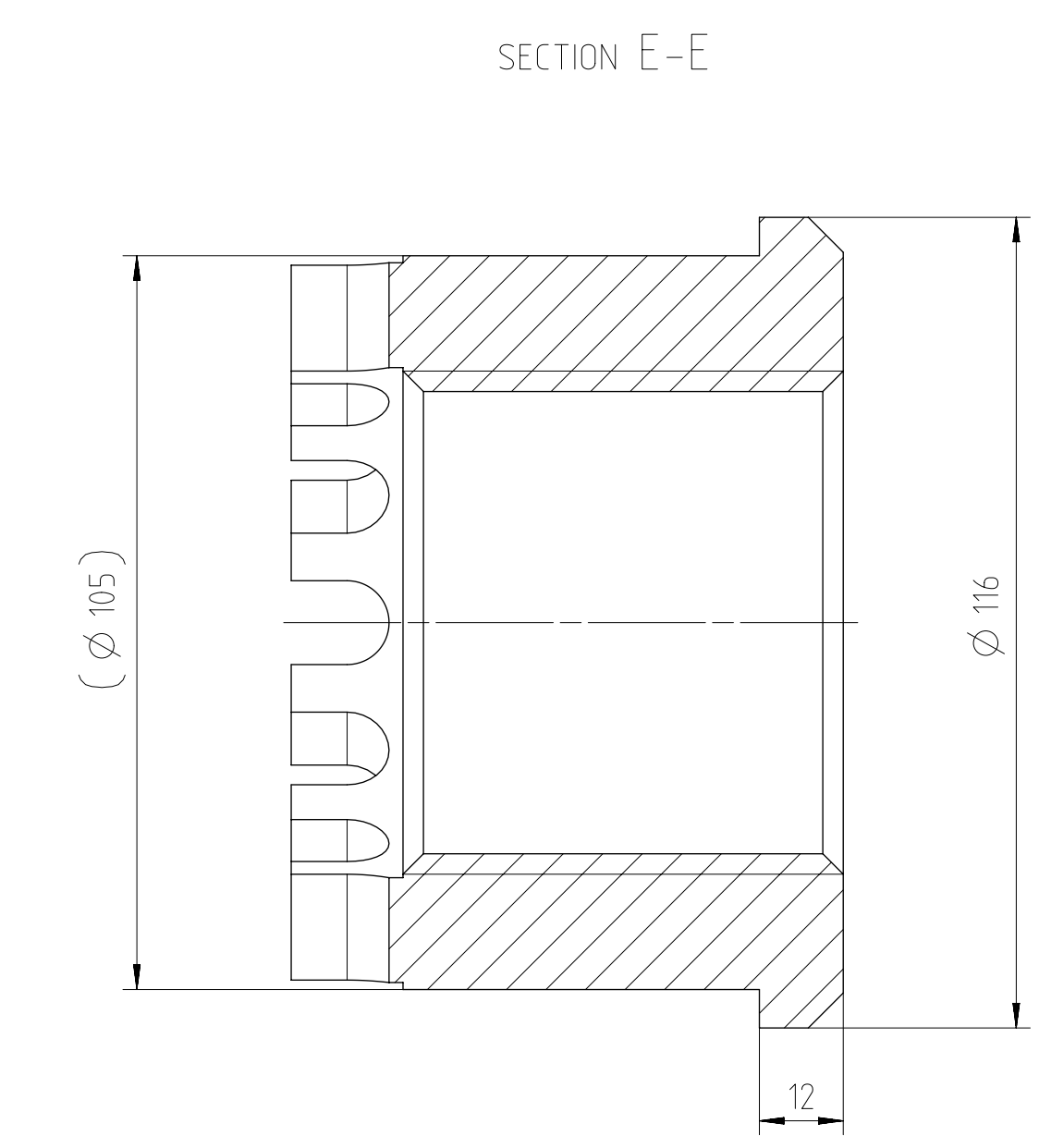
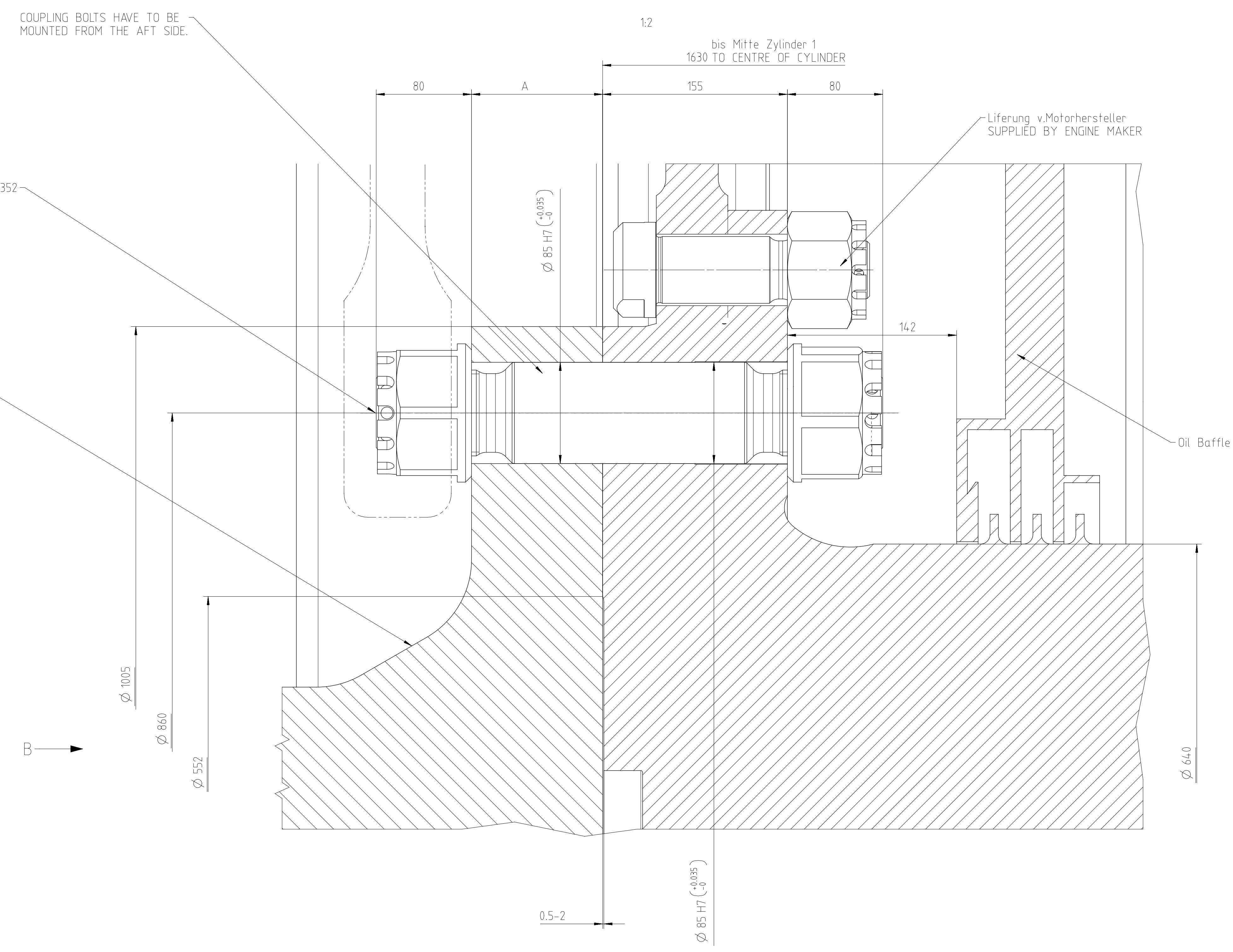


COUPLING BOLTS HAVE TO BE MOUNTED FROM THE AFT SIDE.

Angaben fuer das Anziehen siehe Konstruktionsgruppe 0352  
 INSTRUCTION FOR TIGHTENING SEE GROUP 0352  
 [M 35° (10500Nm)]

Angaben nach Werft  
 INFORMATION ACCORDING TO SHIPYARD

Bei jedem Motor muessen insgesamt 14 Bolzen montiert werden.  
 Lieferung Werft.  
 AITOGETHER 14 BOLTS HAVE TO BE FITTED ON EACH ENGINE.  
 SUPPLY BY SHIPYART.



* 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 IDENTIFICATION	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	SEQ. NO.	Material ID	Material Name	Dimension	Doc/ Drawing	Standard or Drawing	Basic Material Material Standard	Weight kg/NET
1	001	FAAD24-6065	MATERIAL AND TEST SPECIFICATION For sleeves, nuts and bolts			DAAD083901		0,006

Units	mm	kg	NX	Basic Material	Scale	Page	Material	Net Weight
DATE	23.9.2015	11:00:09	JU		1:1	1/1		
DESIGNER	27.01.2016	sh017	Thalmann					
APPROVED	27.01.2016	sh005	Frei					

M	OIL	N	K
MOLYKOTE PASTE G-n On threads and contact surfaces	OIL On threads and contact surfaces	NEVER SEEZ NSBT8 On threads and contact surfaces	NO ADDITIONAL LUBRICATION