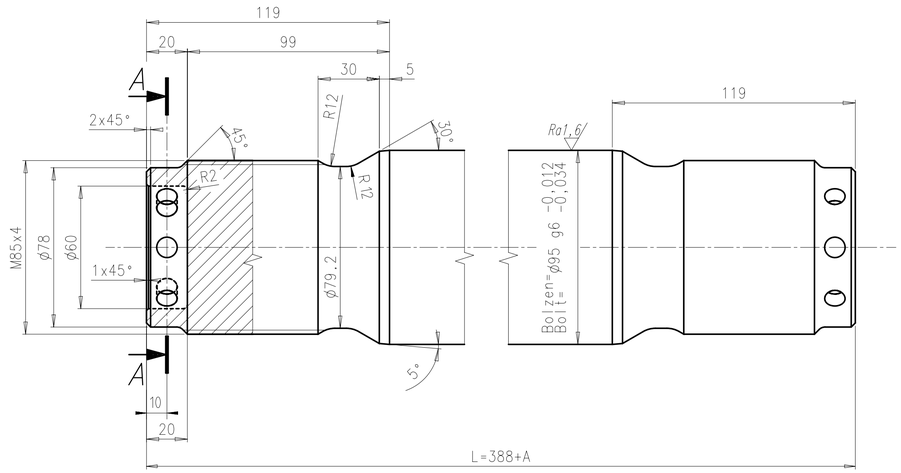
Ra6,3 (Ra1,6)

Material W-FA-42CrMo-QT
MATERIAL

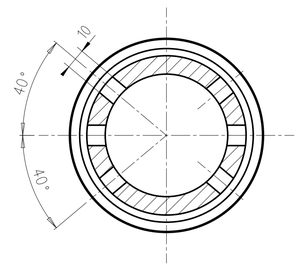
verguetet, Rm = 900^{+200}_{0} N/mm²
QUENCH HARDENED AND TEMPERED

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

Lieferung Werft
SUPPLY BY SHIPYARD



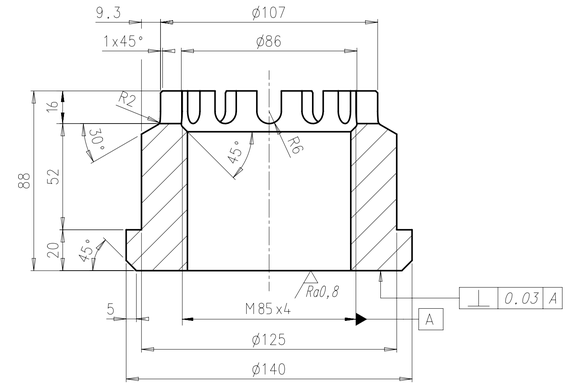
A–A

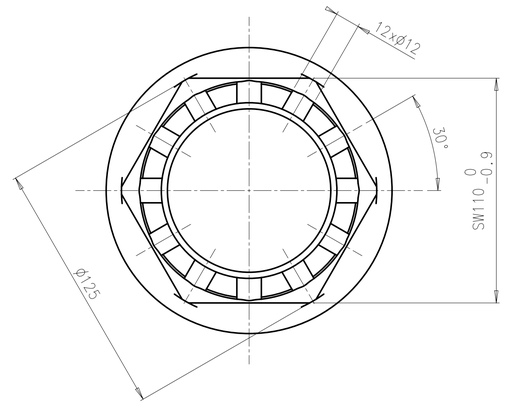


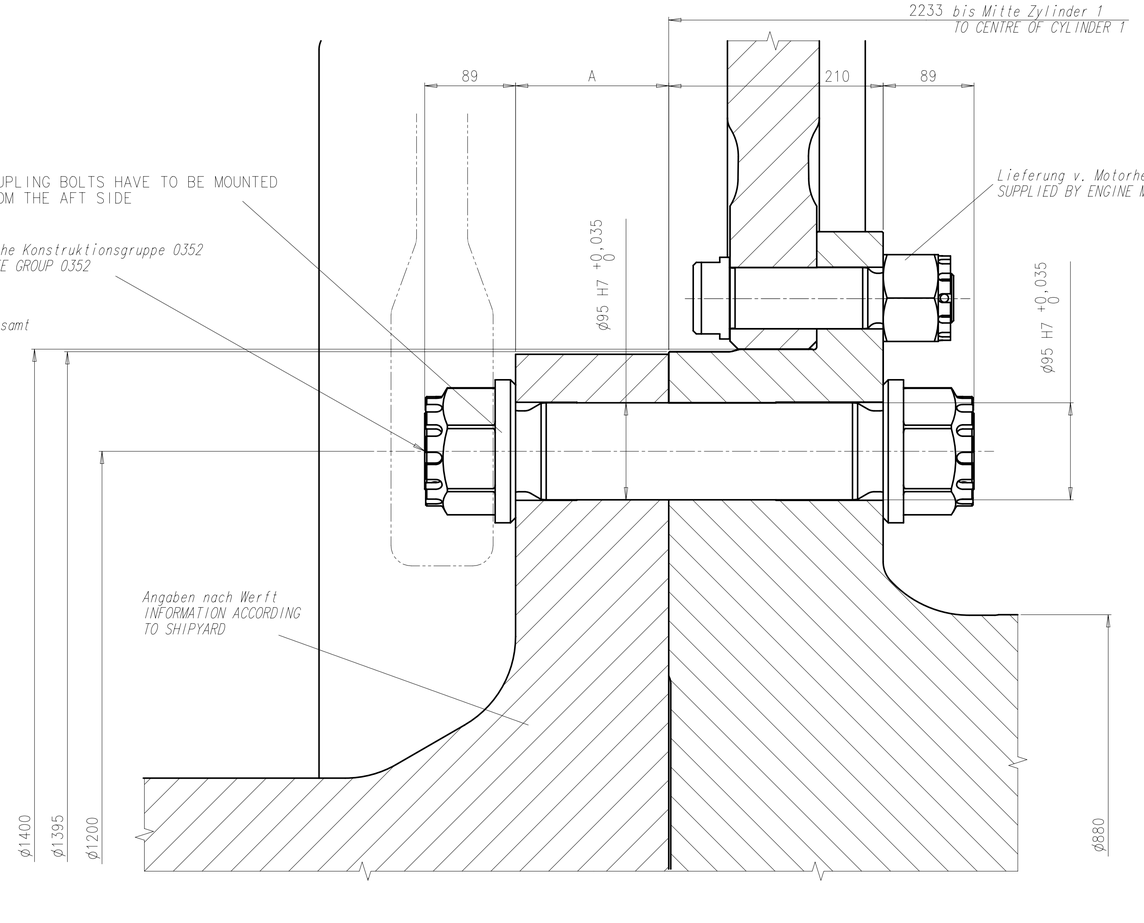
Ra6,3 (Ra0,8)

Material W-FU-325-N
MATERIAL

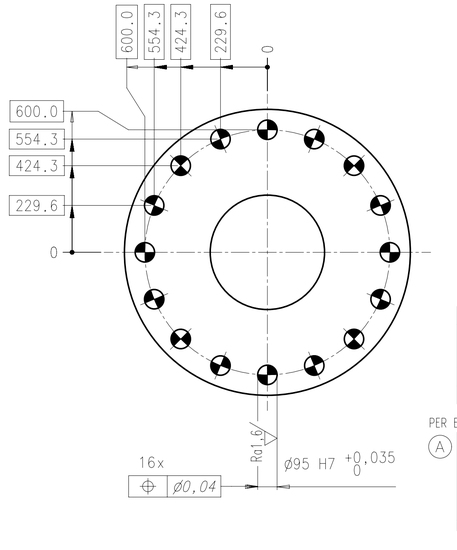
normalgegluehtet, Rm = 590^{+130}_{0} N/mm²
NORMALIZED







B 1:15



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

A

* 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

Net Weight	Quantity PER ENGINE	SEQ NO	Material ID	Material Name / Dimension, Occ	Standard or Drawing	Basic Material / Material Standard	Weight GR/NET
0,001	1	001	PAAD246065	MATERIAL AND TEST SPECIFICATION For sleeves, nuts and bolts	DAAD083901		0,006

Approved

Material ID	Modif.	Free space for ic.	Q-Code	Main Drw.
PAAD084463			1QXP1	H
			Standard: ISO; JIS	

Modif.	Number	Drawn date	Number	Drawn date	Number	Drawn date	Number	Drawn date
A	EAAD086221	19.10.2015	B EAAD087209	20.12.2016				

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WIN GD Winterthur Gas & Diesel

Product: W4-8X72, W4-8X72DF

CONNECTION CRANK/PROPELLER SHAFT

Verbindng Kurbel-/Propellerwelle

Units	mm kg	NX	Basic Material	Net Weight

SURFACE PROTECTION SEE GROUP 0344	Made	07.11.2012	ljax05 L. Jampen	Scale 1:3	Size A1	Page 1/1
TOLERANCING PRINCIPLE ISO8015	Chkd	07.11.2012	csc001 Schmutz	Design Group 3114	Drawing ID DAAD027677	Rev. B
GENERAL TOLERANCES ACCORDING TO ISO2768-mK	Appd	07.11.2012	bfr005 Frei		Material ID	

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