

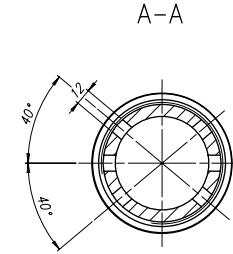
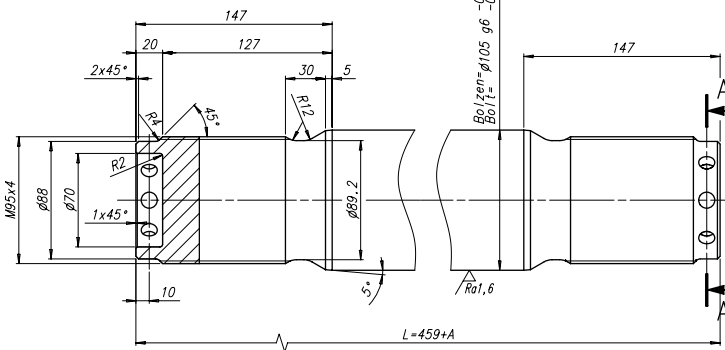
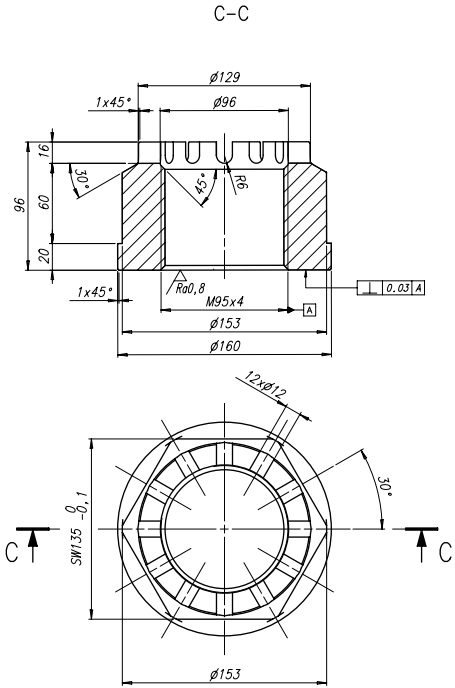
Material W-FU-325-N normalgeglueht, Rm = 590⁺¹³⁰ N/mm²
 MATERIAL NORMALIZED

Material W-FA-42CrMo-QT
 MATERIAL

verguetet, Rm = 900⁺²⁰⁰ N/mm²
 QUENCH HARDENED AND TEMPERED

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

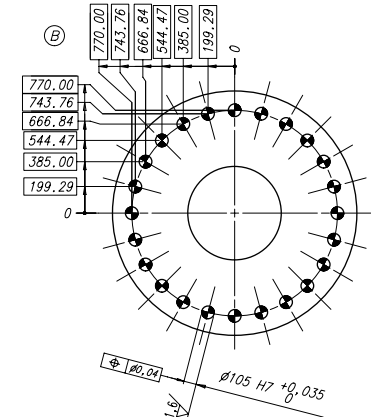
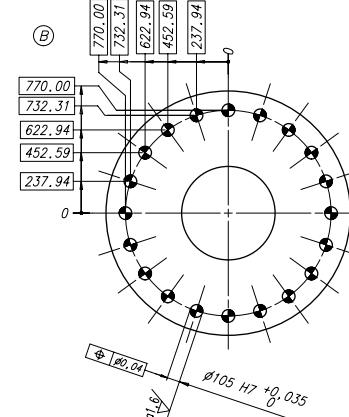
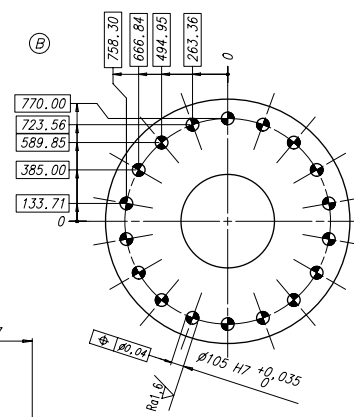
Lieferung Werft
 SUPPLY BY SHIPYARD



B 6,7 CYL
 18 BOLTS

B 8,9 CYL
 20 BOLTS

B 10-12 CYL
 24 BOLTS



COUPLING BOLTS HAVE TO BE MOUNTED FROM THE AFT SIDE

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

M 75° (22000Nm)

Lieferung v. Motorhersteller
 SUPPLIED BY ENGINE MAKER

Angaben nach Werft
 INFORMATION ACCORDING TO SHIPYARD

* 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

QTY	SEQ NO	Material ID	Material Name	Dimension/Occ Dimension	Standard of Drawing	Basic Material Standard	Weight or NET
1	001	107.427.450.200	MATERIAL AND TEST SPECIFICATION ELASTIC BOLT	107.427.450			0.006

Model	Number	Draw date	Number	Draw date	Number	Draw date
EAAD085189	30.04.2014		EAAD086221	29.10.2015		

WIN GD
 Wintorther Gas & Diesel

Product: WG-12X92
 CONNECTION CRANK/PROPELLER SHAFT
 Verbindung Kurbel-/Propellerwelle

Scale: 1:20
 Page: 1/1
 Material ID: PAAD124210
 Drawing ID: DAAD038753

M MOLYKOTE PASTE G-n On threads and contact surfaces	O OIL On threads and contact surfaces	N NEVER SEEZ NSBT8	K NO ADDITIONAL LUBRICATION
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Units	mm kg	IDE	Basic Material	Net Weight	0.001
SURFACE PROTECTION SEE GROUP 0344	Mode	03.06.2013	anas07 A_Nagy	Scale	1:20
TOLERANCING PRINCIPLE ISO8015	Chad	04.06.2013	pn001 Neracher	Design Group	A1
GENERAL TOLERANCES ACCORDING TO ISO2768-mK	Appd	29.10.2015	bfr005 Frei	3114	DAAD038753