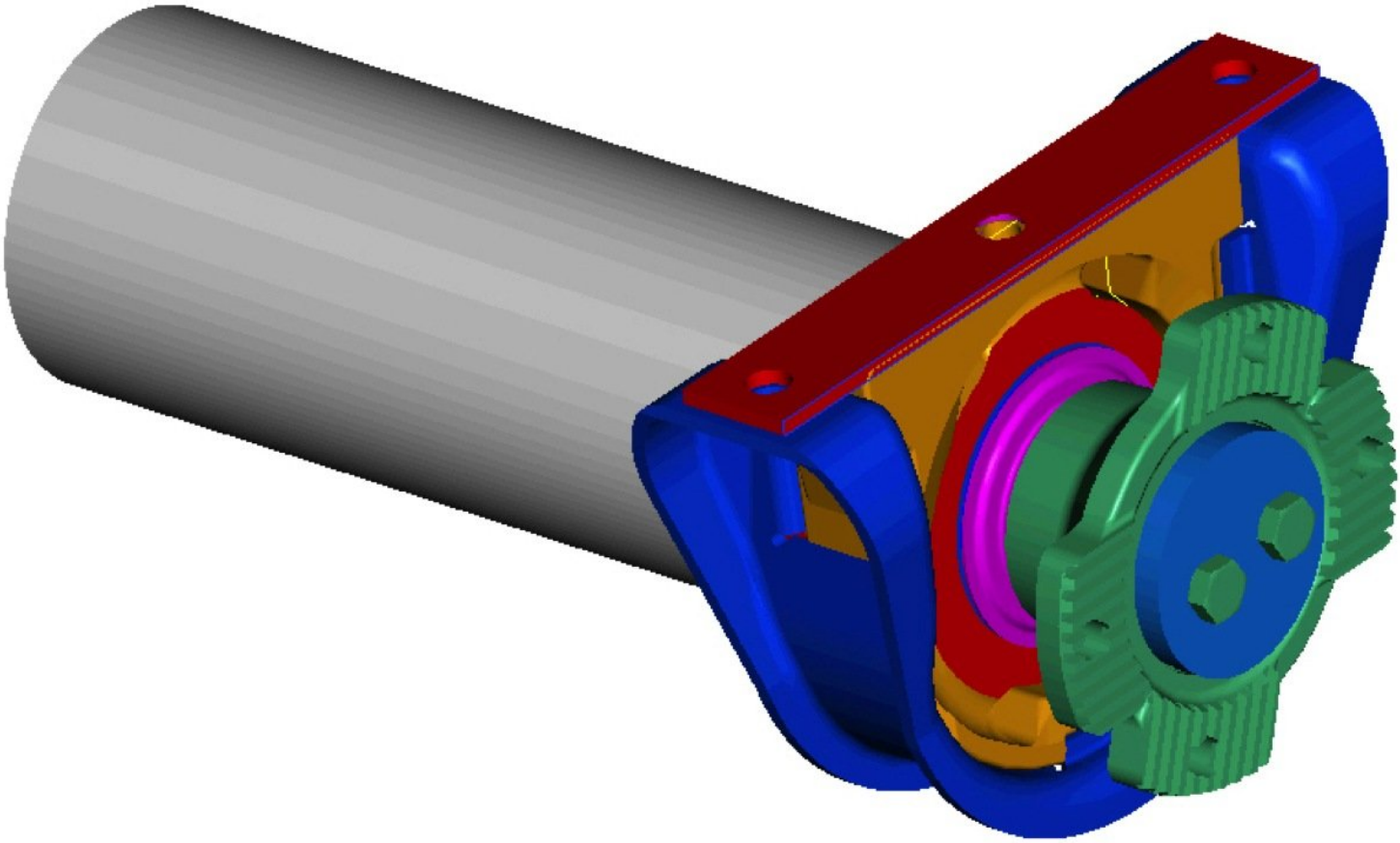
T-EPE-0007-E Assembly Instruction Midship NCB

This process demonstrates the Assembly handling instruction for replacement of the midship units of series NCB.

Redigido por: Luis Ferreira



Este documento foi gerado em 2024-06-20 01:15:48 PM (MST).

INTRODUÇÃO

Technical Information:

- Distribution: KL / EPE / VTK / EPT / QS / FL / FM / IL / IE

1. Purpose

This handling instruction describes the assembly and disassembly of the midship units of the series NCB.

2. Field of validity

This handling instruction is valid for the midship units of the midship bearings diameter 55 and 70 mm of the series NCB

3. Definition of term

None

4. Competence/Responsibility

All internal and external departments and workshops which have to handle the assembly and disassembly of midship units are responsible that all corresponding activities have to be carried out in conformity with point.

6. Indications:

None

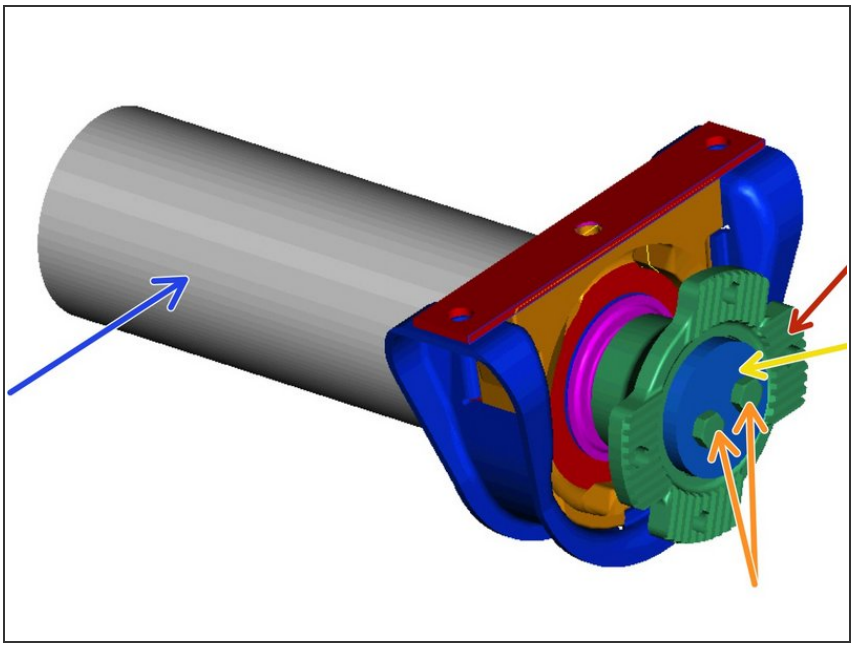
7. Documentation:

The documentation of the assembly instructions has to be done in the departments named under point 4.

8. Additional valid documents

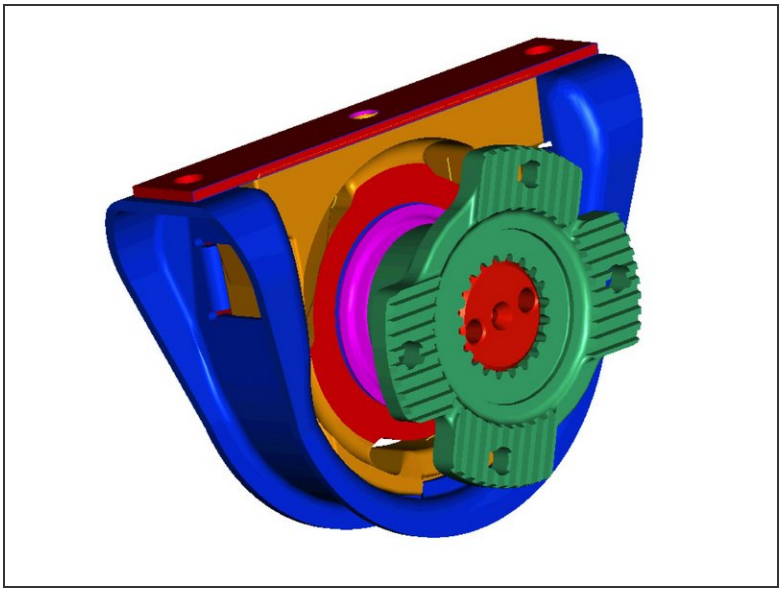
Drawing 1 000 00 80 02 269

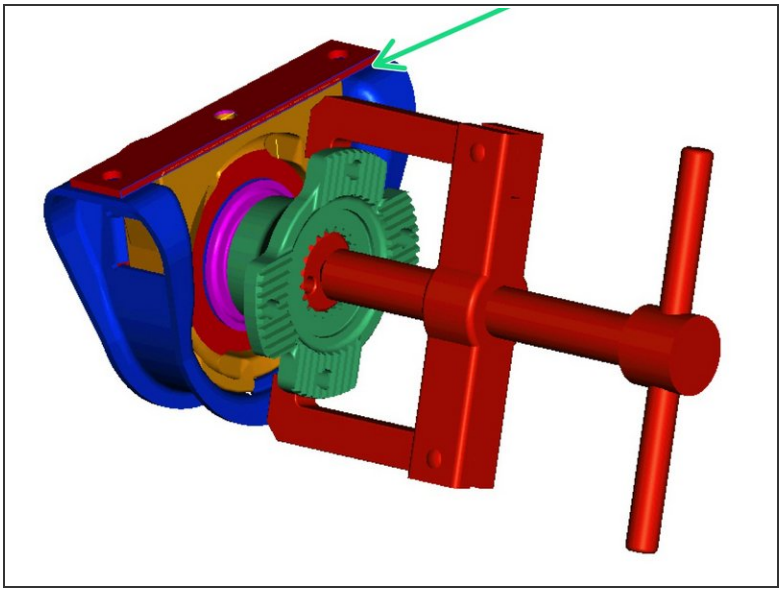
Passo 1 — Disassembly Pt. 1



- Mark the original position of the midship flange in relation to the tube.
- Identified Parts:
  - Midship Flange
  - Washer
  - Hexagon Head Bolt
  - Tube

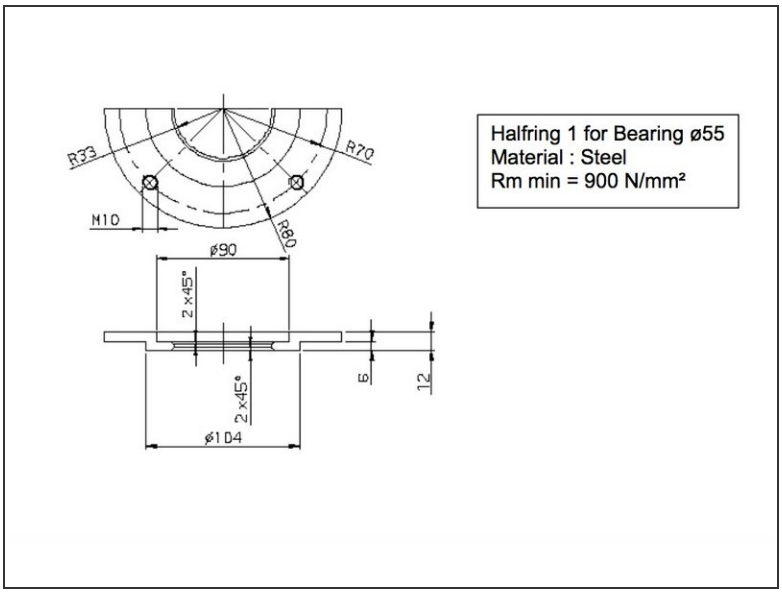
Passo 2 — Disassembly Pt. 2

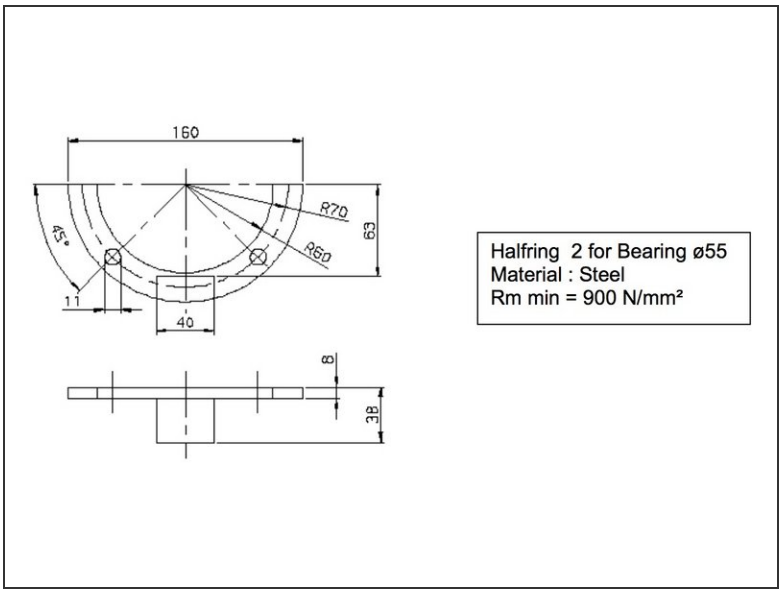




- Unscrew the hexagon head bolts M12 with a suitable tool
- Take off the midship flange from the midship stub shaft.
- Centre Bearing

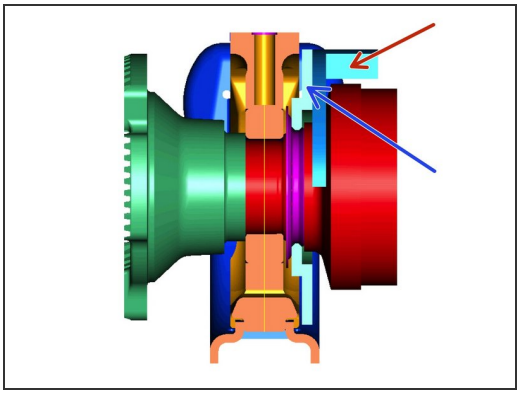
Passo 3 — Disassembly Pt. 3

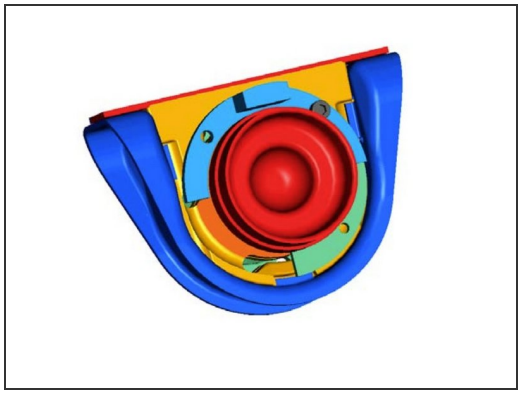


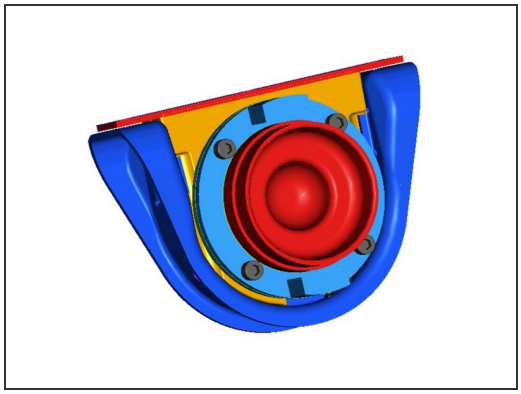


- To take off the Centre Bearing ø55 four disassembly halfrings are necessary. Two of each type.

Passo 4 — Disassembly Pt. 4

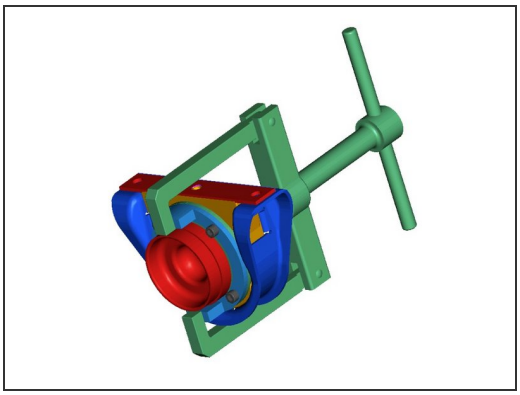


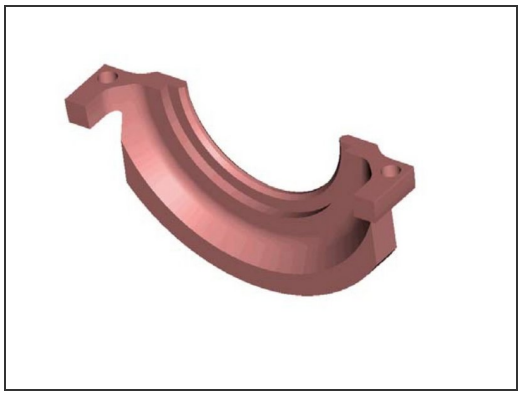


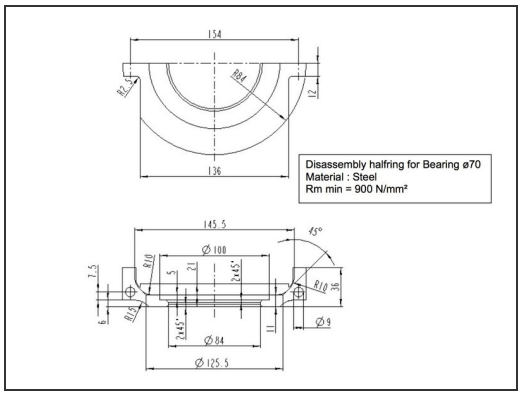


- The Halfrings will be screwed together with 4 bolts M10x16 – DIN912 turned by 90° to each other. Make sure that the Inner-ø of Halfring1 is placed in the groove of the outer flinger.
- Halfring 1
- Halfring 2

Passo 5 — Disassembly Pt. 5

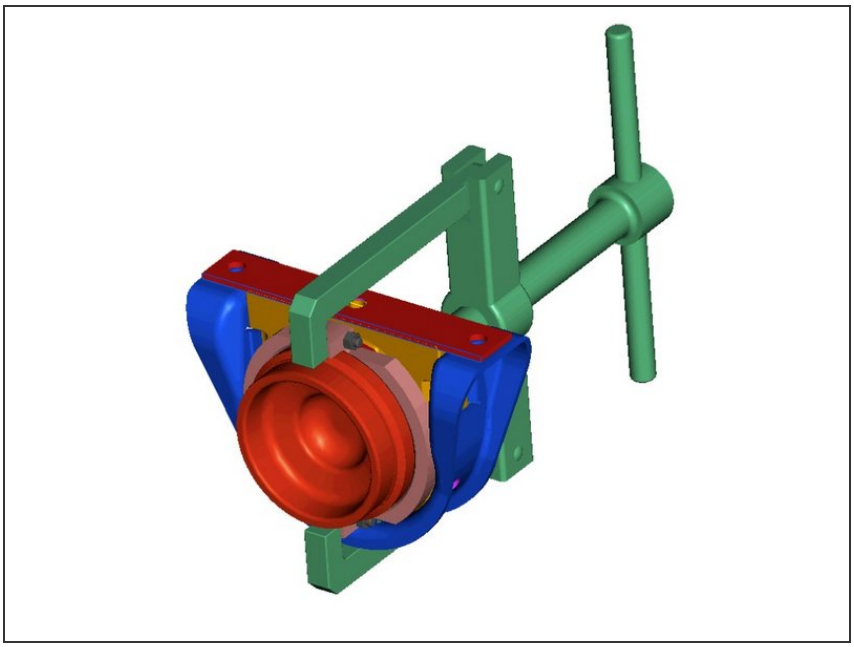






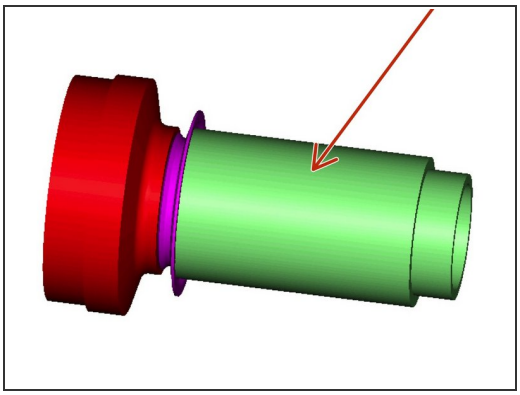
- Take off the Centre Bearing from the midship stub shaft.
- To take off the Centre Bearing ø70 two disassembly halfrings are necessary .

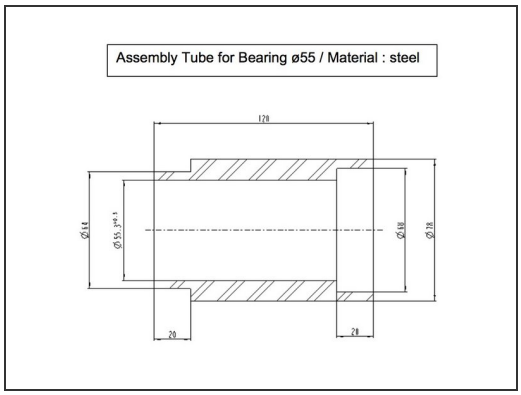
Passo 6 — Disassembly Pt. 6

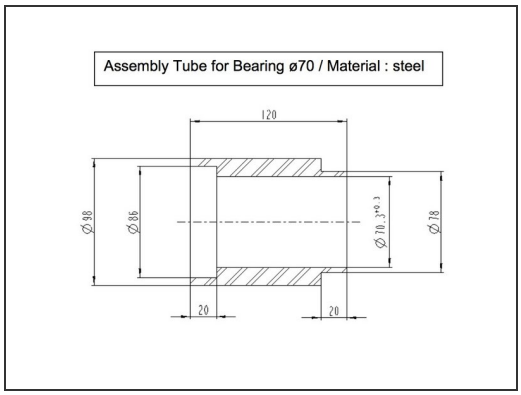


- The Disassembly Halfrings will be screwed together with 2 bolts M8x35 DIN912 and 2 hexagon nuts M8 DIN934 .
- Make sure that the Inner-ø of Halfring1 is placed in the groove of the outer flinger .
- Take off the Centre Bearing from the midship stub shaft.

Passo 7 — Assembly Pt. 1

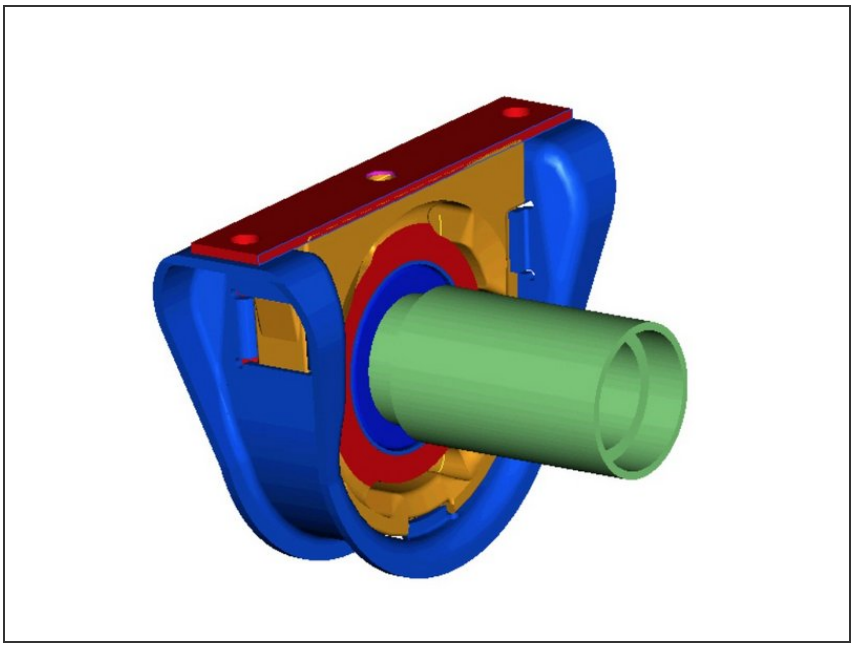






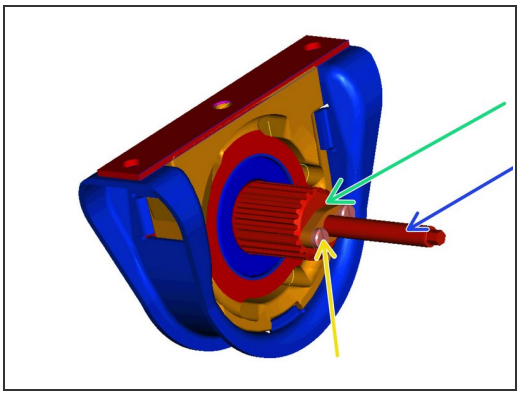
- In case of deformation or damage of the outer flinger at the midship flange, take it off.
- The new outer flinger will be mounted, using an assembly tube to press on.
- Assembly tube

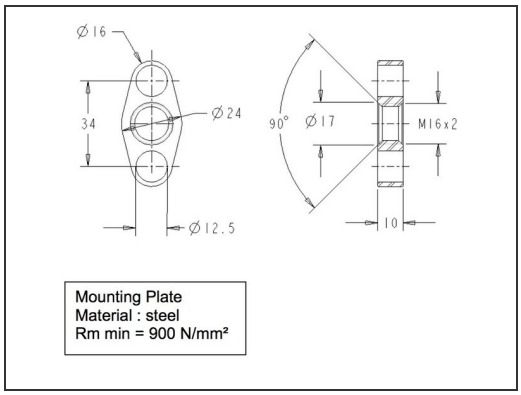
Passo 8 — Assembly Pt. 2

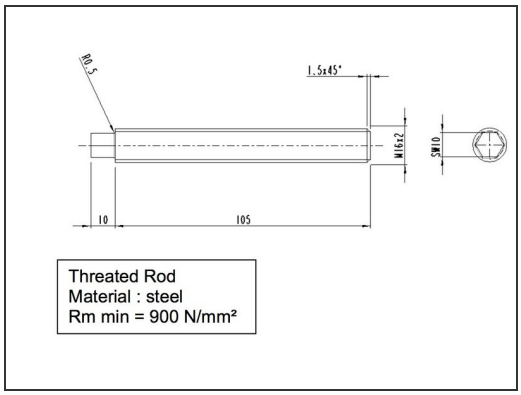


- Mount with the same assembly tube the centre bearing.

Passo 9 — Assembly Pt. 3

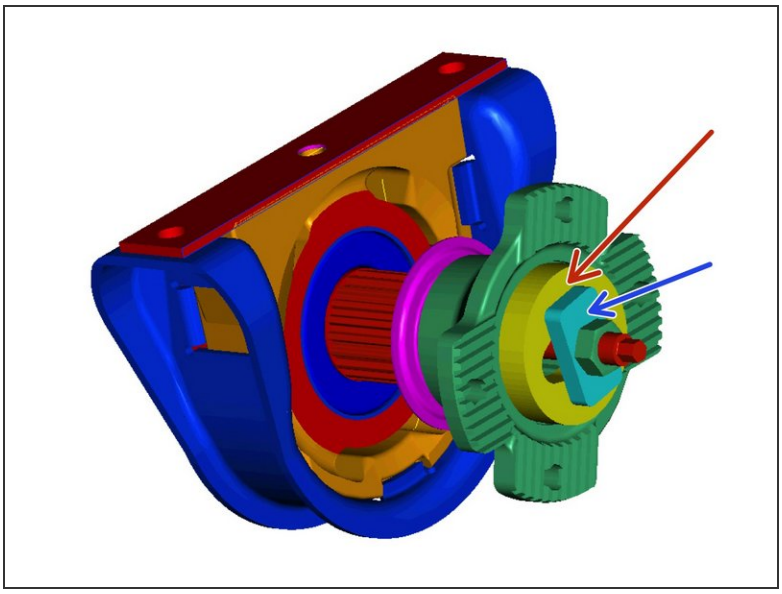


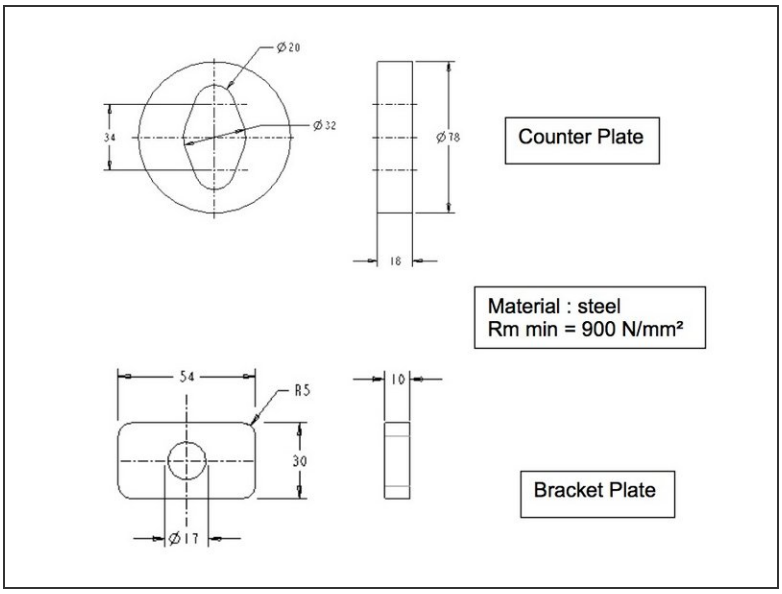




- Fix the mounting plate with 2 bolts M12 x 1,5 x 30 – 8.8 DIN 920 on the midship stub shaft.
  - Mounting plate
  - Threaded rod
  - Bolt
- Screw in the threaded rod as deep as possible to the mounting plate.
- Coat the spline of the midship stub shaft with MoS2-assembly paste.
- If a new midship flange is used, apply the old marking to the new flange. Unconditional the correct hole pattern has to be secured, to avoid misalignment.
- With attention to the markings of midship flange and tube push on the flange as much as possible.

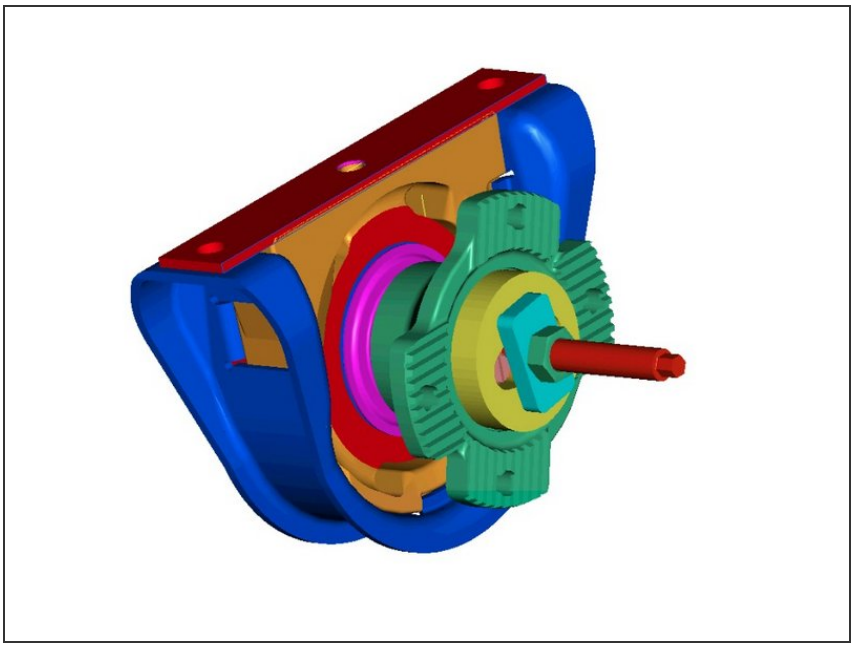
Passo 10 — Assembly Pt. 4





- Put the counter plate with recess oriented according to the mounting plate against the midship flange and screw it together with the bracket plate and a hexagon nut M16- 8 by hand up to the bracket plate is close to the counter plate.
  - Counter plate
  - Bracket plate
- Push on the midship flange to the midship stub shaft with a suitable tool through the hexagon nut up to the shoulder of the flange is close to the ball bearing.

Passo 11 — Assembly Pt. 5



- Remove the assembly parts and fix the washer with 2 new hexagon bolts M12 according to SGWB drawing 1 000 00 80 02 269 . Tightening torque: 137 Nm