

Scanned in four sections

A1	B1
A2	B2

A1

STANDARD 'P' BRACKET INSTALLATIONS

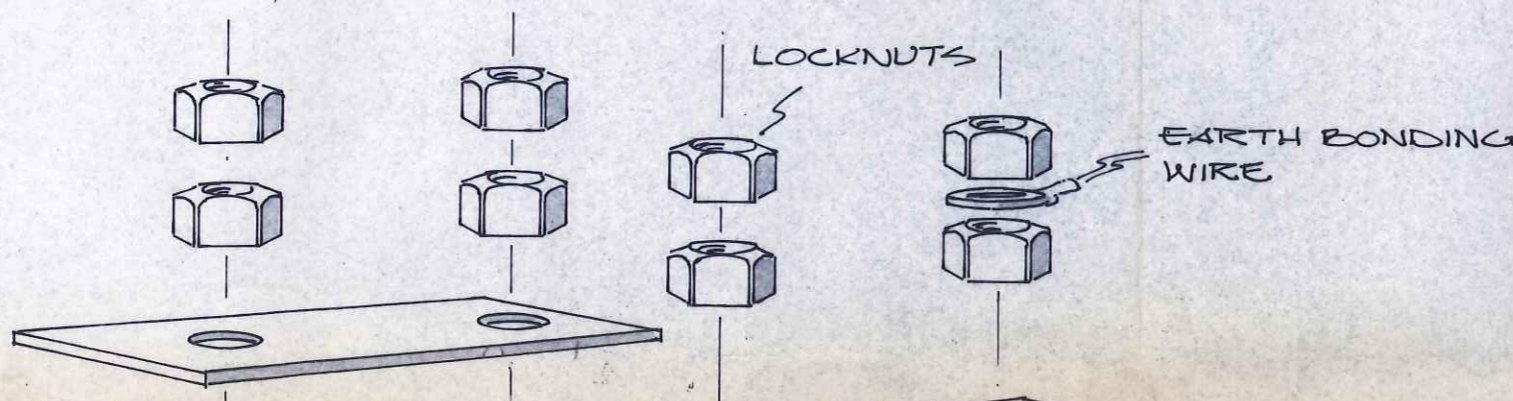
STAGE 1

PREPARATION & INSTALLATION OF PROPELLER BRACKET. (PALM TYPE)

- POSITION 'P' BRACKET INTO RECESS AND DRILL HOLES 0.5MM LARGER THAN BOLT DIAMETER:-
(e.g. 12M BOLT = 12.5mm Ø HOLE)
- REMOVE 'P' BRACKET, CLEAN RECESS FROM ANY DIRT & DUST.
- COAT RECESS & PALM WITH R.B. PRIMER.
- APPLY A 6MM-8MM LAYER OF SQ/50 RALLIBONDITE SELF CURING MIXTURE TO 'P' BRACKET PALM.
- SECURE 'P' BRACKET INTO POSITION WITH M'SCREWS PROVIDED. COAT M'SCREWS WITH MASTIC AND WIND CAULKING COTTON AROUND BOTTOM HALF OF M'SCREW
- TIGHTEN 'P' BRACKET INTO POSITION.
- RETIGHTEN M'SCREWS AFTER 5 - 6 HOURS.

TORQUE SETTINGS
12M BOLT. 25 lbs.ft
10M BOLT. 15 lbs.ft

PALM TYPE PROPELLER BRACKET



STAGE

GRP STERN TUBE AND INSTALLATION

- FIND STERN TUBE CENTRE AND APPROPRIATE DIAMETER
- INSERT SHAFT THROUGH STERN TUBE.
- CONTINUE TO SLIDE SHAFT UP TO ENGINE AND MATCH UP TO ENGINE
- SLIDE STERN TUBE THROUGH TO FINISHED POSITION.

FINAL INSTALLATION

- MAKE SURE SHAFT AND STERN TUBE ARE PROPERLY ALIGNED & PROCEED WITH INSTALLATION
- LAMINATE STERN TUBE TO SHIP'S HULL. ANY GAPS AROUND STERN TUBE INTERSECTION ARE COVERED WITH CSM & RESIN. CONTINUE WITH LAMINATION USING 9oz MIN. CSM. STAGE 1
- WHEN MATS AROUND STERN TUBE ARE HARDENED, AREA MUST BE FINISHED OFF BY
- REMOVE SHAFT FROM STERN TUBE AND REMOVE EXCESS STERN TUBE
- FILL ANY GAPS ON OR AROUND STERN TUBE WITH A *P.F.P.. FINISH OFF BY JOIN ONLY. SEE BELOW

BRACKET & STERN TUBE FOR SAILBOATS

(B)

STAGE 2

POSITIONING

MARK CENTERLINE AND DRILL
HOLE AT CORRECT ANGLE.
FIT 'P' BRACKET AND SLIDE
IT THROUGH HULL AND
COUPLING OR JIG.
MEASURE HULL & DETERMINE
POSITION.
STERN TUBE ALIGNED
WITH LAMINATING.
ON HULL, MAKE SURE THAT
STERN TUBE AND HULL
ARE COMPLETELY FILLED WITH
EPOXY TO LAMINATE STERN TUBE.
USE FIBER MATS UP TO A 12" Ø.
STERN TUBE HAVE
TO BE TOPCOATED.
REMOVE COAT & CUT AWAY
EXCESS MATERIAL. SEE BELOW.
FINISH INSIDE OF HULL USING
GELCOATING AROUND

STRUT TYPE PROPELLER BRACKET.

PREPARATION & INSTALLATION OF PROPELLER BRACKET 'STRUT TYPE'

- FIND CENTRE OF STRUT USING DIMENSIONS GIVEN.
- DRILL SHAPED HOLE TO SUIT 'P' BRACKET STRUT 'SEE ONE BELOW'.
- COMPLETE 'A' IN STAGE 2.
- INSERT 'P' BRACKET THROUGH SLOT IN BOAT & PROCEED WITH 'B' 'C' AND 'D' IN STAGE TWO.
- FIND POSITION FOR 12mm Ø STAINLESS STEEL PINS WHICH RUN THROUGH 'P' BRACKET AND DRILL HOLES TO SUIT. MAKE SURE THAT THE PINS AT THEIR NEAREST POINTS ARE NOT CLOSER TO THE HULL THAN 1/8", OR NOT FARTHER AWAY THAN 1/4".

FINAL INSTALLATION.

- REFIT 'P' BRACKET INTO BOAT, SUPPORT FROM OUTSIDE & FIT STAINLESS STEEL PINS. AT THIS POINT PRIME METAL SURFACES INC. S/S PINS
 - REFIT SHAFT THROUGH 'P' BRACKET & STERN TUBE. CHECK ANGLE IS CORRECT & 'P' BRACKET IS PLUMB IN ALL DIRECTIONS.
 - 'SEE 2 BELOW' APPLY P.F.P. AROUND AND APPROX. 1/4" ABOVE EACH PIN. IT IS VERY IMPORTANT TO FORCE FILLER DOWN THE SIDES OF SLOT CUT FOR 'P' BRACKET. ALLOW TO HARDEN.
 - 'SEE 3 BELOW' APPLY 3x2 oz CSM OVER PINS & STRUT COVERING UP TO A 9" SQUARE AROUND STRUT, FINISHING 1/2" BELOW TOP.
 - 'SEE 4 BELOW' CUT TWO HARDWOOD BLOCKS EACH APPROX. 9" x 4 1/2". DETERMINE DEPTH OF BLOCK BY ALLOWING TOP 1/2" OF STRUT TO REMAIN UNCOVERED. CUT BLOCKS TO FIT OVER PINS AND AROUND STRUT. POSITION BLOCKS ON A 10mm THICK LAYER OF P.F.P. ALLOW TO HARDEN THEN COVER USING 3x2 oz CSM. STAGGER MATS.
 - TOPCOAT AREA. THEN DRILL & TAP FOR EARTH BONDING WIRE.
- NOTE: INSTALLATIONS WILL VARY IN SHAPE FROM BOAT TO BOAT.
- FINISH OFF ON OUTSIDE WITH P.F.P. & GELCOAT. 'SEE 4 BELOW'.

ONE CUT SLOT AS HERE
BEVELL SIDES.
ROUND CORNERS ON INSIDE

HULL

2 WASHER PLATES

* POLYESTER FILLER PASTE

A2

GRP STERN TUBE

WHEN LAMINATING STERN INTO POSITION DO NOT MATS ABOVE THIS POINT

THEN CAULKING COTTON.

MASTIC APPROX TO THIS LENGTH

BRONZE

HULL

STERN TUBE

SHAFT

CUT AWAY EXC WHEN SHAFT H

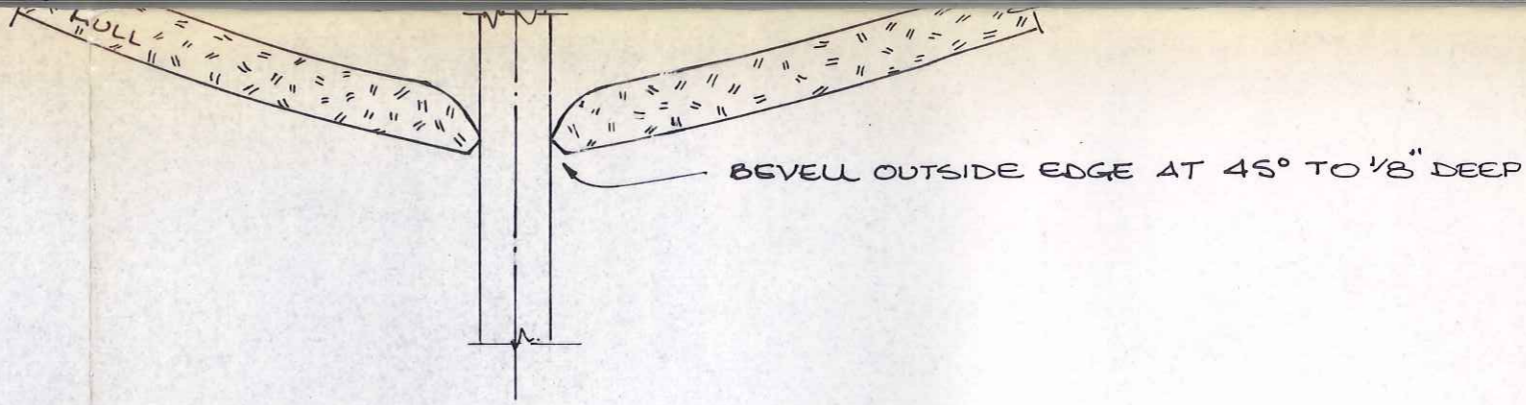
LLOYD'S RECOMMENDED
4/10/89
DAB

ISSUE	DATE	MODIFICATION	NAME
D	3.8.89	LLOYD'S RECOM'S. ADDED:- NOTE ON GELCOAT. AN EXTRA 20Z GSM REQD. OVER S/S PINS. CORNERS RADIUSED ON HARDWOOD BLOCKS.	E.TAYLOR
C	6.2.89	DRAWING & TEXT NOW INCLUDE INTRUCTIONS TO INSTALL TWO S/S PINS. NOT JUST ONE (RE: STERN)	E.TAYLOR
B	20.7.88	TEXT/INSTRUCTION CHANGES. MATERIAL CHANGES. ILLUSTRATION CHANGES	E.TAYLOR
A			

GRM
7/2/89

MARINE PROJECTS (PLYMOUTH)
STANDARD PROPELLER BRACKET
DR. ECT 19.4.88

B2



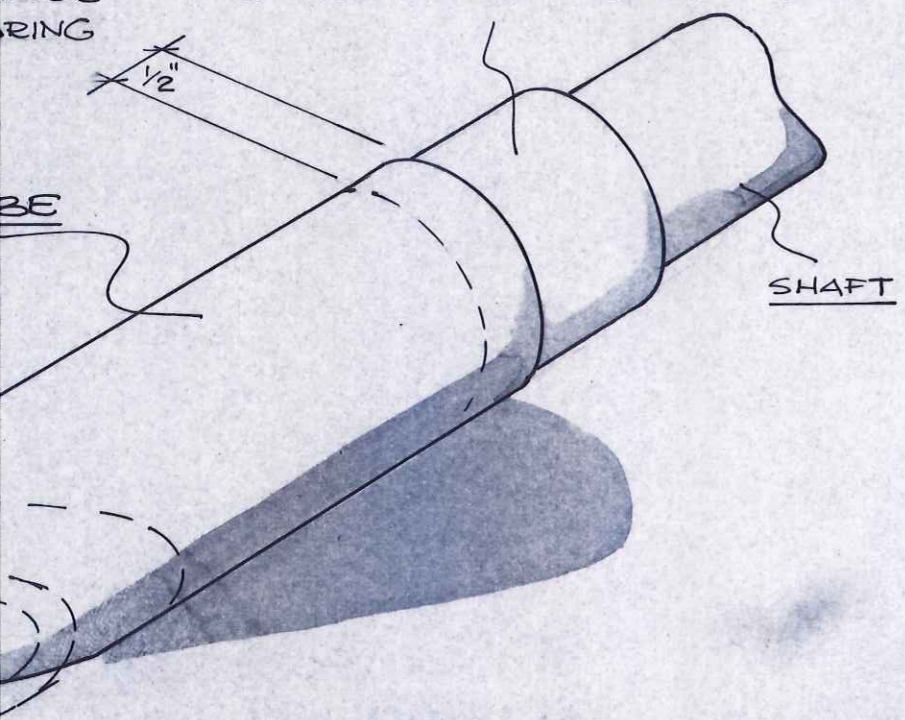
INSTALLATION

MAKE SURE THAT ALL AROUND THIS AREA OF TUBE IS CLEAN, & FREE FROM RESIN DRIPS

TUBE RING

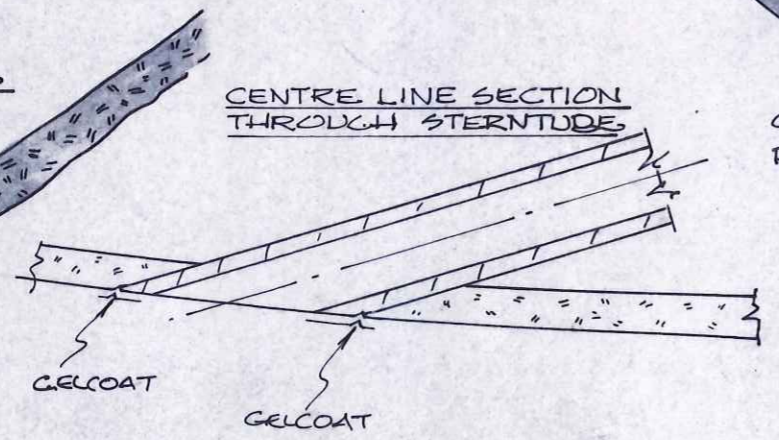
BE

SHAFT

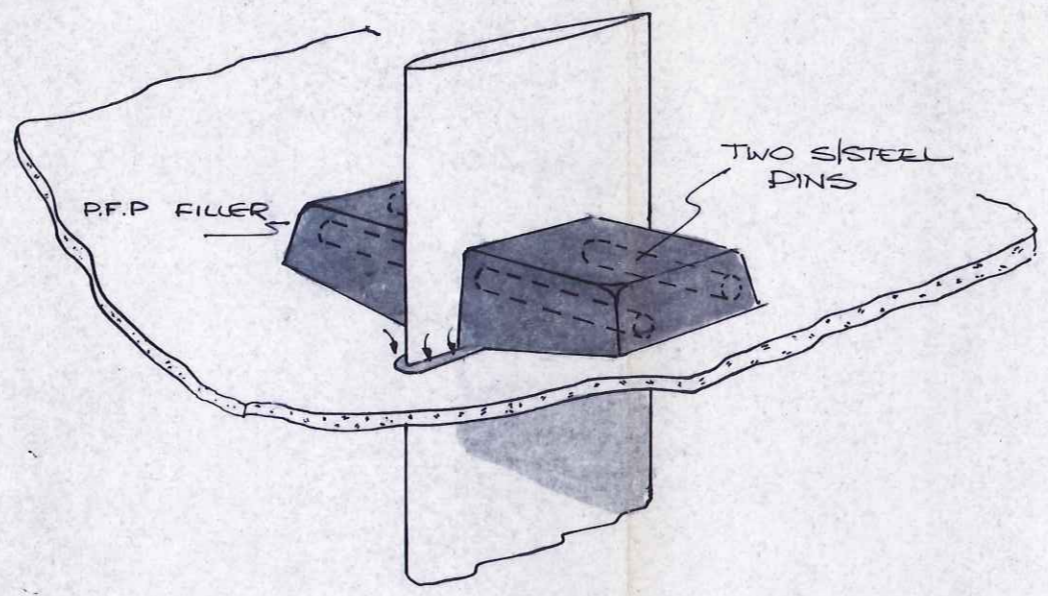


EXTERNALLY COAT AROUND THIS JOINT ONLY

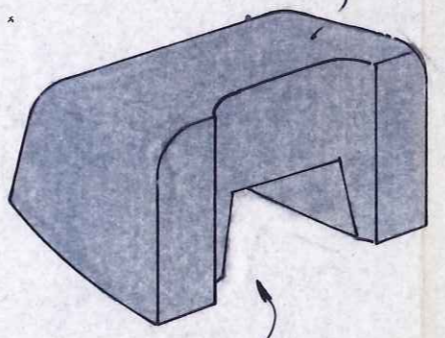
CESS MATERIAL HAS BEEN REMOVED.



TWO

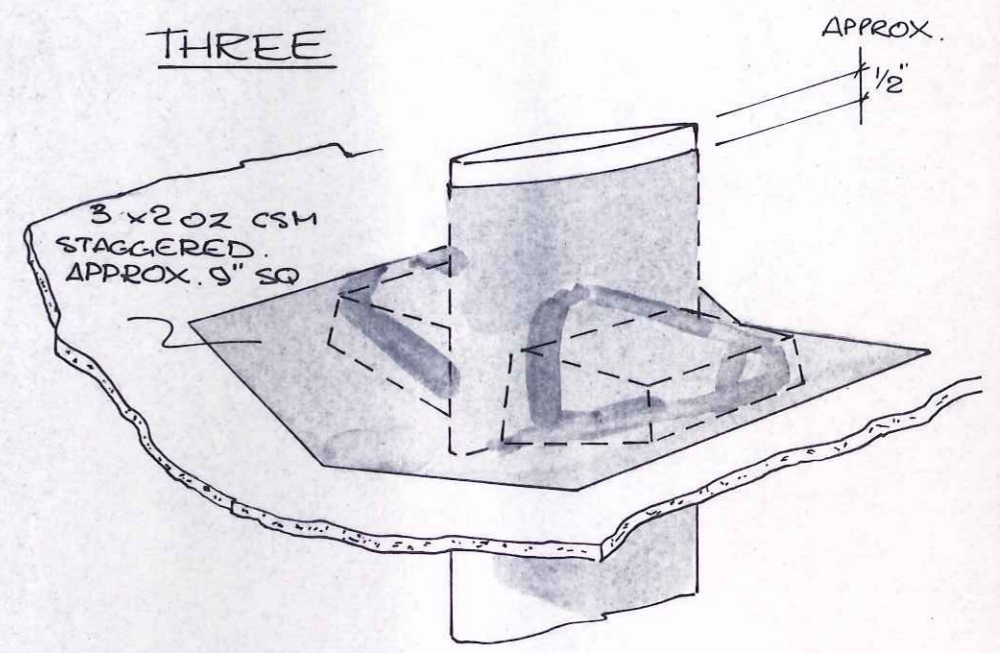


HARDWOOD BLOCKS SUPPLY 2 AT APPROX 9"x4 1/2"

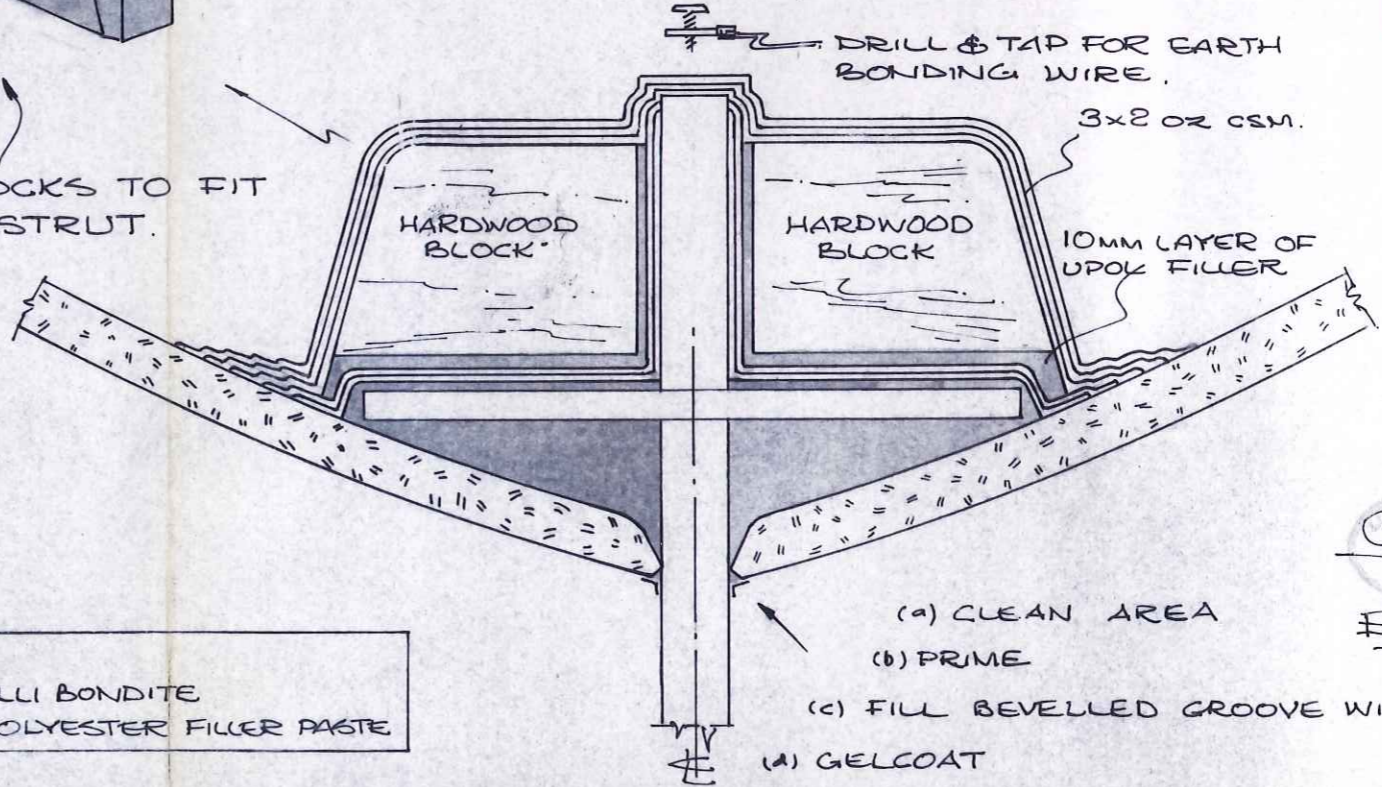


CUT BLOCKS TO FIT PINS & STRUT.

THREE



FOUR SECTION LOOKING FORWARD THROUGH 'P' BRACKET & HARDWOOD BLOCKS.



UNCONTROLLED

ISSUED BY
GRANITE PROJECTS
DRAWING OFFICE
22 JAN 1998

EC Taylor
15/11/88

OUTH) LTD.
T INSTALLATIONS.
DR. NO AB. 129

KEY.

'P' BRACKET = PROPELLER BRACKET
Ø = DIAMETER.

R.B. = RALLI BONDITE
P.F.P. = POLYESTER FILLER PASTE

(a) CLEAN AREA
(b) PRIME
(c) FILL BEVELLED GROOVE WITH P.F.P.
(d) GELCOAT