

A

B

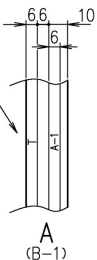
C

D

E

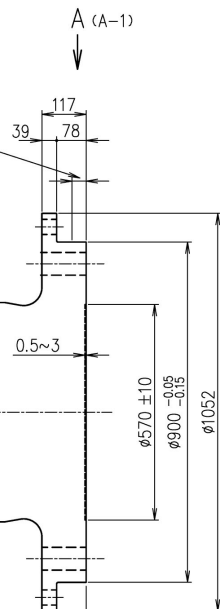
A2

TO BE MARKED WITH "I"
AT TOP POS.OF NO.1
CYLINDER.
NO.1 シリンダトップ位置に
Tマークを刻印のこと。



01

SET MARKS FOR COUPLING BOLTS.
本領所に軸継手ボルト合マークを
備考に示す要領で刻印のこと。



ENGINE SIDE
機関側

FROM CENTER OF NO.1 CYL
NO.1 シリンダ中心より 1324

INTERMEDIATE SHAFT SIDE
中間軸側

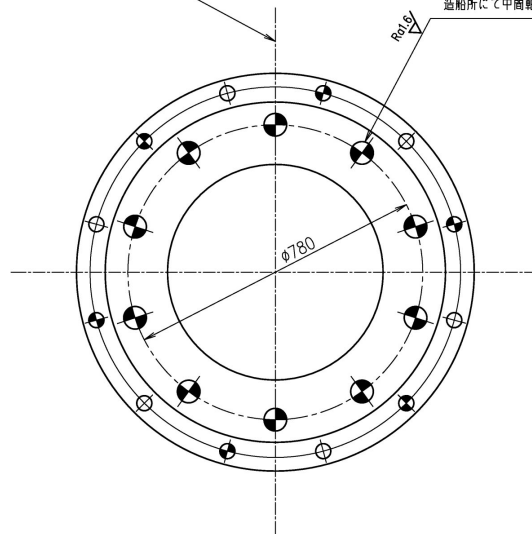
RUNNING DIRECTION
回転方向

TOP POS. OF NO.1 CYL.
NO.1 シリンダトップ

AHEAD
前進

10-φ58 HOLES (PRE DRILL WITH MACHINERY ALLOWANCE 2mm)
REAM TOGETHER WITH INTERMEDIATE SHAFT
TO φ60H7^{+0.030}₀ BY SHIP BUILDER.

10-φ58 (リーマ下穴 2mm残し)
造船所にて中間軸と共にφ60H7^{+0.030}₀リーマ仕上願います。



B (C-2)

中間軸との取付ボルト穴を本図に従って
スラスト軸に追加加工のこと。
TO BE WORKED ON THE THRUST
SHAFT ACCORDING TO THE DIMENSIONS
IN THIS DRAWING

REMARKS

1.MARKING WORKS

- (1) TO BE MARKED ON THE SURFACE OF FLANGE.
- (2) TO PUT A MARK "A-1" AT THE TOP POS.OF NO.1 CYLINDER.
- (3) VIEWING FROM AFT SIDE, TO THE COUNTER CLOCKWISE DIRECTION, TO BE MARKED "A-1, A-2... A-10" IN ORDER.
- (4) THE SIZE OF MARKS TO BE 6mm.
- (5) THE LETTERING TO BE ARRANGED ACCORDING TO THIS DRAWING.
- (6) TO CONFIRM THE MARKS WHEN ASSEMBLING THE SHAFTS.

備考

1. 軸継手ボルト合マーク刻印要領

- (1) ボルト穴 (10-φ58) 上のフランジ部外周面に刻印すること。
- (2) NO.1シリンダトップ位置に対応したボルト穴を "A-1" とする。
- (3) 船尾側より見て反時計方向に順次 "A-1, A-2... A-10" まで刻印する。
- (4) 刻印文字の大きさ 6mm とする。
- (5) 文字方向は本図通りとする。
- (6) 組立の際ボルト穴番号を確認のこと。

COMMON VARI- ATION OF TOLERANCE (MACHINING) (M.M)	RATINGS OF NOMINAL DIMENSION	OVER 0.5 TO 8	OVER 6 TO 30	OVER 30 TO 120	OVER 120 TO 400	OVER 400 TO 1000	OVER 1000 TO 2000	OVER 2000 TO 4000	OVER 4000 TO 8000	OVER 8000 TO 16000
TOLERANCE		± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2.0	± 2.0	± 2.5

ACAD

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FOR MAKING DRAWINGS OR APPARATUS EXCEPT FOR THE CASE WHERE
JAPAN ENGINE CORPORATION AGREES WITH WRITTEN MATERIALS.

SURFACE FINISHES		RATINGS	UNDER 0.8	UNDER 0.3	UNDER 0.25	UNDER 0.1	UNDER 0.05	UNDER 0.025	UNDER 0.0125	UNDER 0.00625	UNDER 0.003125	UNDER 0.0015625	UNDER 0.00078125	UNDER 0.000390625	UNDER 0.0001953125	UNDER 0.00009765625	UNDER 0.000048828125	UNDER 0.0000244140625	UNDER 0.00001220703125	UNDER 0.000006103515625	UNDER 0.0000030517578125	UNDER 0.00000152587890625	UNDER 0.000000762939453125	UNDER 0.0000003814697265625	UNDER 0.00000019073486328125	UNDER 0.000000095367431640625	UNDER 0.0000000476837158203125	UNDER 0.00000002384185791015625	UNDER 0.000000011920928955078125	UNDER 0.0000000059604644775390625	UNDER 0.00000000298023223876953125	UNDER 0.000000001490116119384765625	UNDER 0.0000000007450580596923828125	UNDER 0.00000000037252902984619140625	UNDER 0.000000000186264514923095703125	UNDER 0.0000000000931322574615478515625	UNDER 0.00000000004656612873077392578125	UNDER 0.000000000023283064365386962890625	UNDER 0.0000000000116415321826934814453125	UNDER 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