



Service Letter

No: SL90-271/HY  
October 1990

L50, L60, L70 & L80MC  
Chain Tightener for Camshaft Drive

Dear Sirs,

We have received a few reports of wear at "Y" on the enclosed drwg. 1391444-2 between shaft for tightening bolt and hub in bedplate aft end. If this wear becomes too large, this may cause the tightening bolt to break.

Furthermore, we can inform you that wear in the fore end of the shaft has been negligible.

This means that the supply of oil at the shaft suspension at "Y" has not been large enough to prevent wear. On the other hand, the shaft suspension in the fore end is supplied with additional splash oil from the cylinder side, which explains why there is no wear in this place.

We recommend that you carry out the following check:

Dismantle cover "X" in the aft end, and measure the clearance "Y" with feeler blades. Check the shaft end for the presence of oil.

Plants with clearances below 0.4 mm at "Y" are acceptable. However, in order to improve lubrication, we recommend the mounting of a pipe with spray nozzle, see drwg. 1391444-2, and thereafter, at suitable intervals, to check whether the clearance has changed.

If the clearance "Y" exceeds 0.4 mm, it is necessary to repair at the earliest opportunity. In order to avoid delaying the ship, it is possible to make a temporary repair until such time as the suggested final repair can be carried out.

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Temporary repair

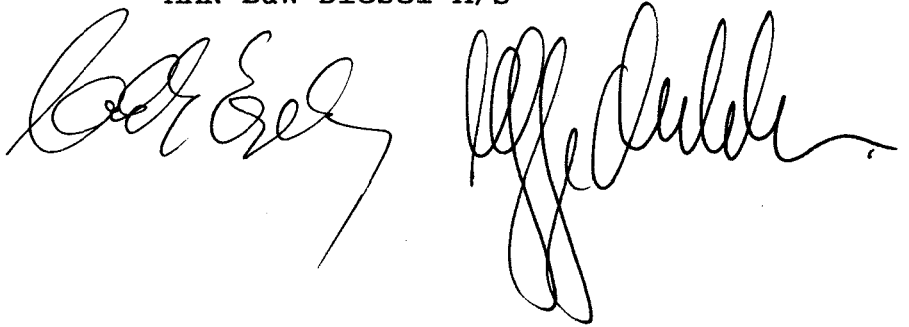
The spray nozzle, drwg. 1392783-7, is to be mounted by drilling a 1/2" pipe thread hole in the web plate of the bedplate. The nozzle is connected to the lub. oil pipe to supply splash oil to the shaft. The clearance at "Y" is to be filled with 10-15 mm wide shims, without gap. The shims are to be cut from steel plate. The thickest shim is to be inserted at the largest clearance so that centering of the shaft is ensured, see drwg. 1391444-2.

Final repair

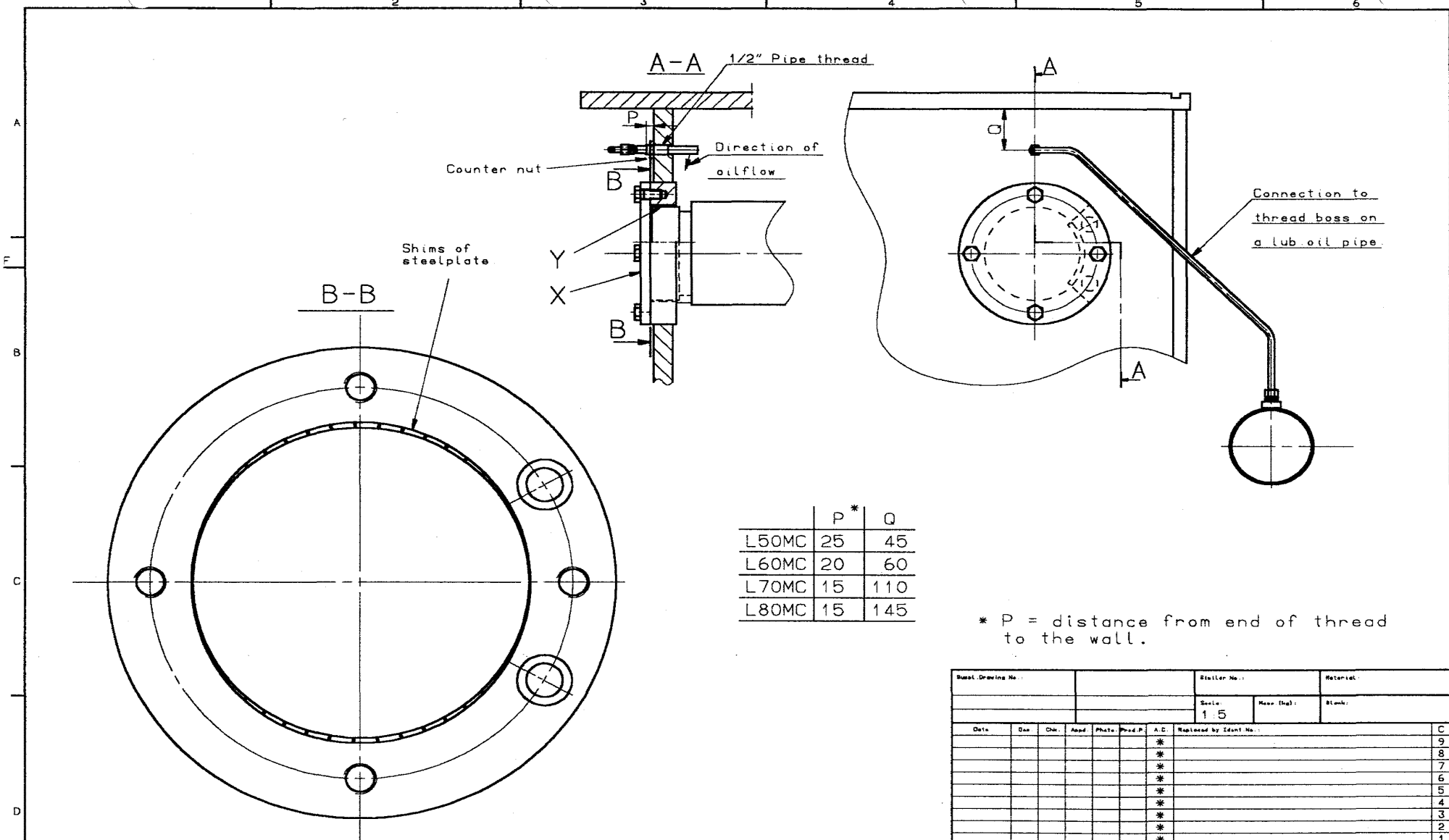
The final repair should be made as shown on drwg. 1397295-2. The worn shaft has to be dismantled and turned off at the worn end. A flange bearing in which the shaft is embedded is introduced. This is tightened to the existing threaded holes in the hub. Furthermore, two guide pins for fixing of the flange bearing are adopted. The correct axial location of the shaft is secured by a distance piece. In the web plate of the bedplate, a 1/2" pipe thread is to be drilled and a spray nozzle for supply of oil to the shaft is fitted.

To have the final repair carried out, please contact MAN B&W or one of our service centres or licensees.

Yours faithfully,  
MAN B&W Diesel A/S



Encl.



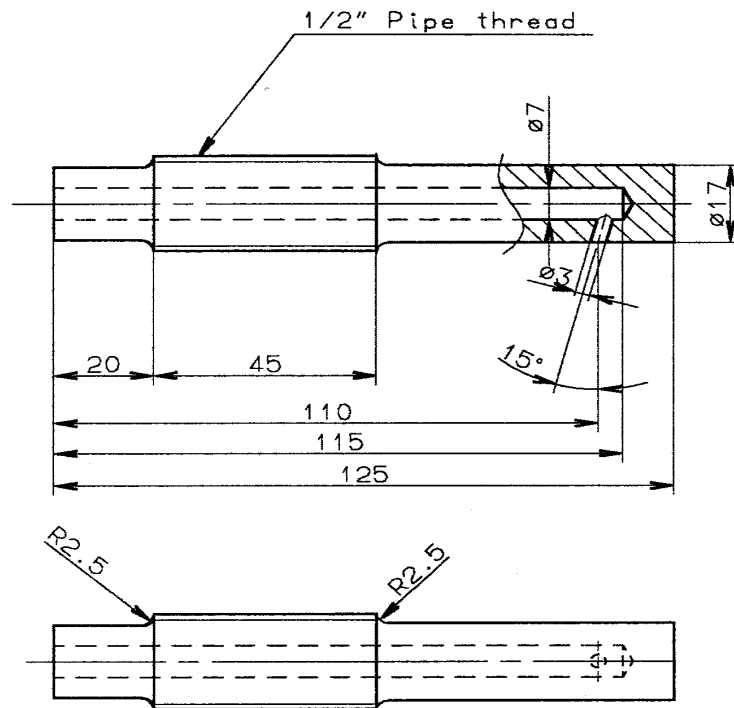
	P *	Q
L50MC	25	45
L60MC	20	60
L70MC	15	110
L80MC	15	145

\* P = distance from end of thread to the wall.

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EN21C-Standard for surface roughness												EN21F-Tolerances for dimensions without tolerance indication							
The basic symbols and alpha numbers are in accordance with ISO 1302(74-87) and VDA 1923(162-99)												This standard, which is in accordance with ISO 2768, states the permissible deviations for dimensions without direct tolerance indications on casted components manufactured by machining							
Class No.	M1	M2	M3	M4	M5	M6	M7	M8	M9	M10	M11	M12	Max. upper deviation	0.5 mm to 3 mm	3 mm to 6 mm	6 mm to 30 mm	30 mm to 100 mm	100 mm to 300 mm	300 mm to 1000 mm
R <sub>max</sub>	0,025	0,05	0,1	0,2	0,4	0,8	1,6	3,2	6,3	12,5	25	50	Medium series	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2

Sheet Drawing No.:		Stiller No.:		Material:				
Date:		Scale:		Blank:				
Date:		Scale:		Blank:				
Date	Des.	Chg.	Appr.	Photo.	Prod. P.	A.C.	Replaced by Ident. No.:	C
						*		9
						*		8
						*		7
						*		6
						*		5
						*		4
						*		3
						*		2
						*		1
						*		0
900704 BXKBXKHY							Replacement for Ident. No.:	
MAN B&W DIESEL A/S							MAN B&W DIESEL A/S	
332265							1391444-2	
Description: Mt. of shims							Description:	
Final User Info No.:							Final User Description:	
Final User Info No.:							Final User Description:	



Suppl. Drawing No.:		Similar No.:		Material: Steel					
		Scale: 1:1	Mass (kg):	Blank:					
Date	Des.	Chk.	Appd.	Photo	Prod. P.	A/C	Replaced by Ident No.:	C	
						*		9	
						*		8	
						*		7	
						*		6	
						*		5	
						*		4	
						*		3	
						*		2	
						*		1	
900704 BXK/BXK/HY							*	Replacement for Ident No.:	0
MBO Info No.:		Size:		Type:		MAN B&W DIESEL A/S			
332060		A 3		Description:		Ident no.:			
				Spray nozzle		1392783-7			
Final User Info.:		Final User Description:		Final User Ident. no.:					

Surface roughness and tolerances see MAN B&W Diesel A/S SB Standards Book: EN21C and EN21F medium

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