ISO 484-1:2015-12 (E)

Shipbuilding - Ship screw propellers - Manufacturing tolerances - Part 1: Propellers of diameter greater than 2,50 m

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Field of application 1

4 Methods for measuring pitch 1
4.1.1 Use of marking gauges 1
4.1.2 Method with a graduated ring 1
4.1.3 Method using coordinate measuring machine 1

5 Methods for measuring the thickness of the section 2

6 Accuracy classes 3

7 Tolerances on the pitch 4

8 Tolerances on the extreme radius of the screw propeller 5

9 Tolerances on the thickness of the blade section 5

10 Checking and tolerances of the form of blade sections 5

11 Tolerances on the length of the blade sections 8

12 Tolerances on the location of blades, reference lines, and blade contours 8
12.1 Marking of lines of reference 8
12.2 Tolerances on the contour of the leading edge 9
12.3 Tolerances on the angular deviation between two consecutive blades 10

13 Tolerances on rake, axial position, and relative axial position of consecutive blades 10

14 Surfacefinish 11

15 Static balancing 11

16 Measuring equipment 12

Bibliography 13