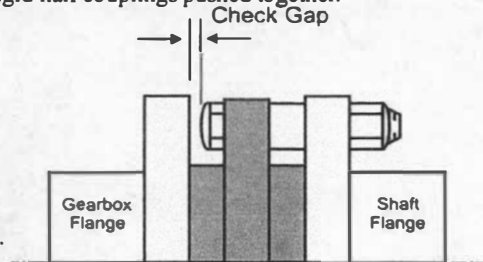


INSTALLATION PROCEDURE FOR R & D MARINE COUPLINGS

Please Note: All couplings will give electrical isolation. If electrical conductivity is required an earthing connector can be supplied

1. Roughly align engine and stern gear without flexible coupling i.e. only two rigid half couplings pushed together.
2. Bolt "R & D Marine" coupling between the two rigid couplings.
Tightening details as below.
- 3 Check alignment of engine by placing feeler gauges between the **RED CONE HEADED BOLT** and the rigid half coupling.
Repeat for the **SAME** bolt at 90° intervals by rotating the shaft.
4. If the gap is the same in all four positions, the engine is accurately aligned.
Recommended minimum to maximum gap difference: 0.010 inch / 0.25 mm.
5. Run installation to bring engine compartment to working temperature. Re-check torque settings.



Recommended tightening torque:

M8 – 27 Nm 20 *lbsft* 3/8 UNF – 40 Nm 30 *lbsft* M10 – 54 Nm 40 *lbsft* 7/16 UNF – 81 Nm 60 *lbsft* M12 – 108 Nm 80 *lbsft*
1/2 UNF – 100 Nm 75 *lbsft* 5/8 UNF – 210 Nm 155 *lbsft* M18 – 340 Nm 250 *lbsft* 3/4 UNF – 366 Nm 270 *lbsft*

R & D MARINE, MEADOW WORKS, CLOTHALL ROAD, BALDOCK, HERTS, SG7 6PD

TELEPHONE: +44(0)1462 892391 FAX: +44(0)1462 896448

Email: info@randdmarine.com website: www.randdmarine.com

**PART No.
910-018**