

Recommendation for tightening of pin on blades

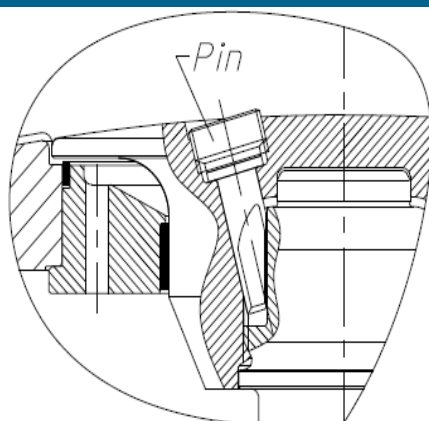


Figure 1

Sectional view of the blade assembly on Hub

Howden Engineering has reviewed the installation instruction for the pawl and pin and on the basis of this review they have provided a new installation instruction for torque of pins to blades.

The pin is used to restrain the pawl, which is used to position the blade on the blade pivot (figure 1).

Howden have revised the existing instruction which states that all pins are torqued to 60 Nm (44,3 lb.ft). This instruction has been used since 1992.

The new engineering standard requires adapting a new differentiating torque value where the thread dimension and the blade material is taken in to account.

All pawls and pins must be lubricated with MolyKote GN Paste + prior to mounting and torquing.

The engineering specification is 4239869-0 (figure 2).

Pin Material	Blade material				
	Size	SG-iron	Aluminum	Steel	Hastelloy
M22 x 1,5 Steel	40 Nm 29,5 lb. ft	25 Nm 18,4 lb. ft	40 Nm 29,5 lb. ft		
M24 x 1,5 Steel	50 Nm 36,9 lb. ft	30 Nm 22,1 lb. ft	50 Nm 36,9 lb. ft		
M24 x 3 Steel	100 Nm 73,6 lb. ft	60 Nm 44,3 lb. ft	100 Nm 73,6 lb. ft		
M24 x 3 SMO254					100 Nm 73,6 lb. ft
M27 x 1,5 Steel	75 Nm 55,3 lb. ft	45 Nm 33,2 lb. ft	75 Nm 55,3 lb. ft		
M35 x 1,5 Steel	140 Nm 103,3 lb. ft	85 Nm 62,7 lb. ft	140 Nm 103,3 lb. ft		
M35 x 1,5 SMO254					140 Nm 103,3 lb. ft

BE/HDK 09.01.2014 - 4239869-0

Figure 2

For more information please **contact your local Howden office.**

This bulletin has been released by:

Howden Denmark ApS, Industrivej 23, DK-4700, Næstved, Denmark

Tel: +45 55 77 62 62

Web: www.howden.com

Email: variax@howden.com

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