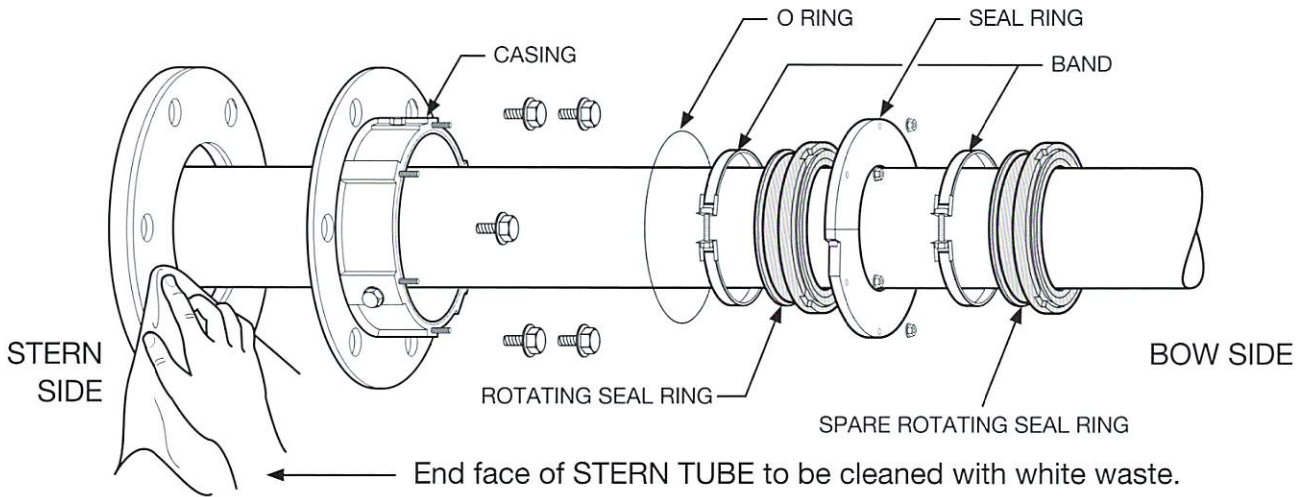

ASSEMBLY WORK MANUAL OF SKC

1. Preparation of necessary parts and assembly work.

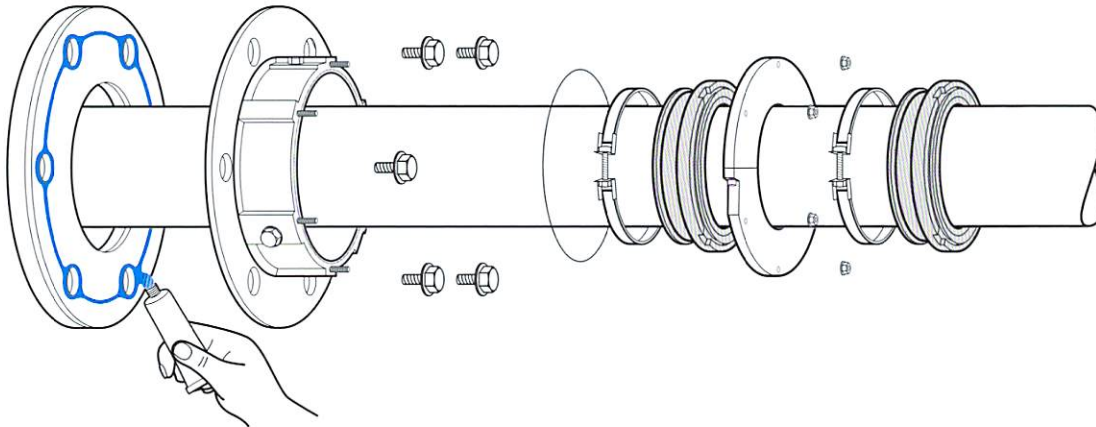
Necessary parts are set on the shaft in order as the sketch below.



2. Liquid packing application

Liquid packing to be applied on all bolts surrounding and through circumference on end face without gap as the sketch below.

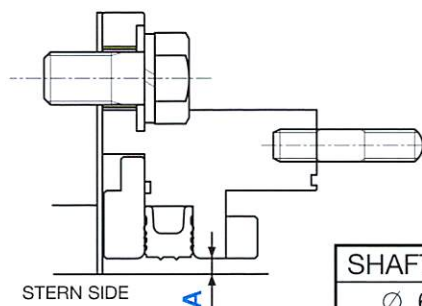
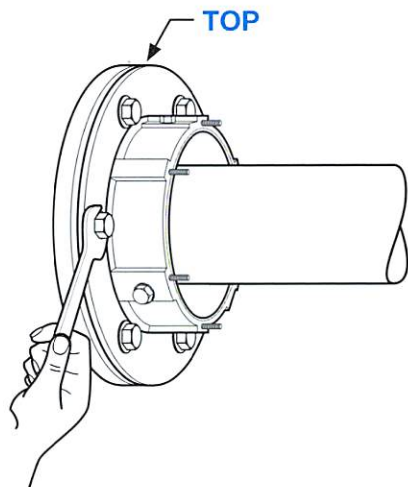
Take care that no dust or contamination is attached during work.



3. Casing installation

The CASING to be located to TOP position of STERN KEEPER marked TOP and fastened with bolts on diagonal lines.

Note : The clearance (dimension A) between outside diameter of shaft and inside diameter of the CASING to be within the value in the table attached.

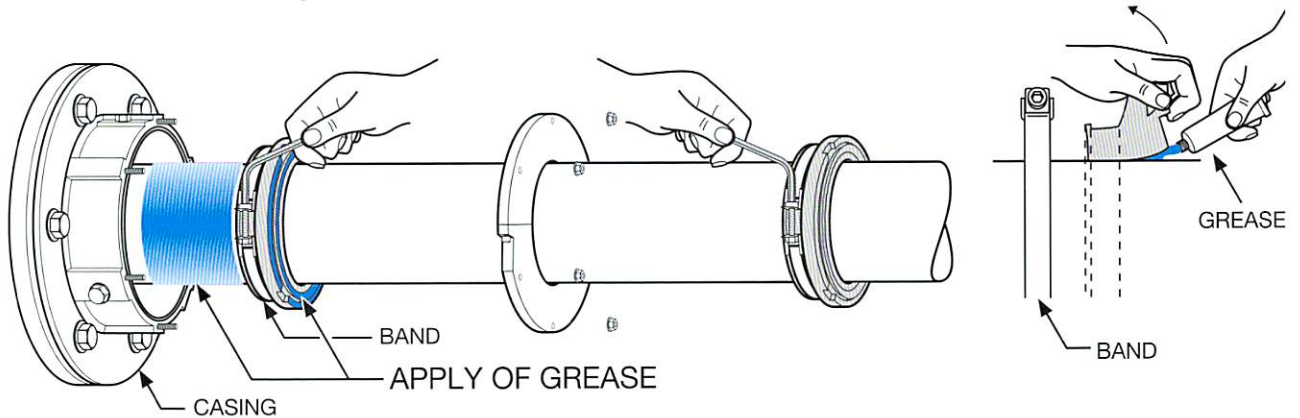


(mm)

| SHAFT DIAMETER | DIMENSION |
|----------------|-----------|
| Ø 60 ~ Ø149 | 3 ± 0.5 |
| Ø150 ~ Ø209 | 4 ± 1 |
| Ø210 ~ Ø699 | 6 ± 1 |

4. Grease application on ROTATING SEAL RING and SLEEVE

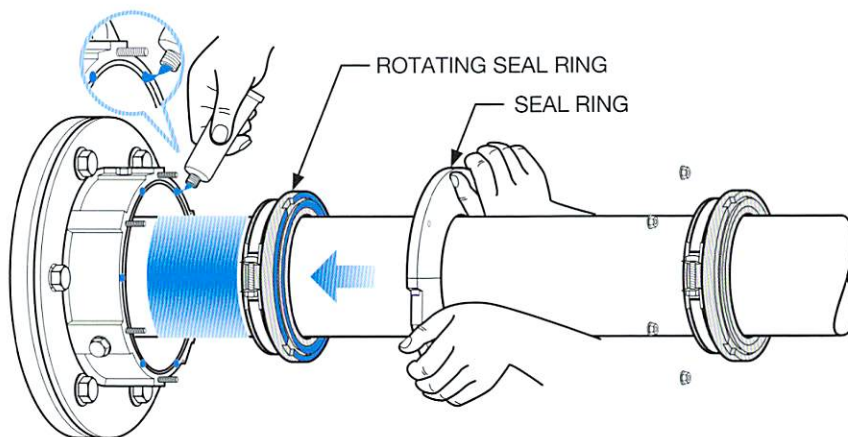
1. CLAMPING BAND on ROTATING SEAL RING to be loosened and pull the end of it up, then grease to be applied to inside diameter area of it. The grease to be applied on the SLEEVE and sliding area of the ROTATING SEAL RING as well. After that, the BAND to be set close to the CASING.
2. The band to be set onto the ROTATING SEAL RING and fixed by clamping hexagon socket head bolt with hexagonal wrench until the both parts are touched firmly each other.



5. ROTATING SEAL RING setting work

Grease to be applied on groove of the CASING partially and then the O-ring to be set into the groove.

The SEAL RING to be contacted with ROTATING SEAL RING and then the ROTATING SEAL RING to be put into the CASING by pressing the SEAL RING.

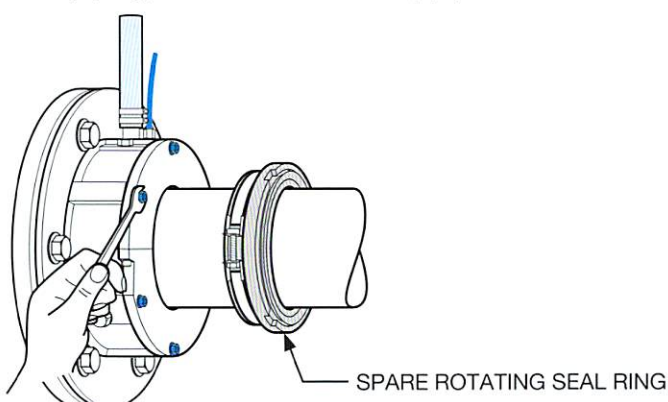


6. SEAL RING setting, Pipeline setting work.

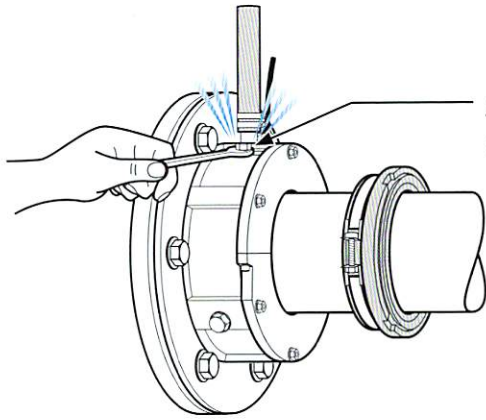
SEAL RING to be fastened with nuts on diagonal lines firmly.

A set of the SPARE ROTATING SEAL RING to be set next to the SEAL RING.

The piping for water and air supply to be constructed in accordance with piping layout.



7. Running preparation on the sea



Air plug to be released, and supply water by running pump and then discharged air inside of SEALING UNIT.

8. Initial timing of SEALING UNIT running.

At the initial timing after SEALING UNIT assembly is constructed, the temperature of inside diameter area of SEAL RING would be increased. Apply water to this area to lower it.

Touch back face of SEAL RING with hand and high temp. over 40°C to be recognized, then the inside diameter area of SEAL RING to be washed with water bottle and cooled.

