

Action code: **WHEN CONVENIENT**

**Tool for Turning Out Thrust Segments**  
**S80/70/60MC Engines**

SL10-524/MHPE  
 March 2010

**Concerns**

Owners and operators of MAN B&W large bore two-stroke S80/70/60MC type diesel engines.

**Summary**

Tool for turning out segments for the thrust bearing.

Dear Sirs

It has come to our attention that a number of S80MC, S70MC and S60MC type engines, which have a shrink-fitted connection between the crankshaft and the chain wheel, have been delivered with the wrong tool for turning out segments for the thrust bearing. Due to this error, it is difficult to make a thrust bearing overhaul.

Therefore, some modifications are needed to be able to use this tool on engines with shrink-fitted chain wheels. This service letter provides recommendations on how these modifications should be made.

Yours faithfully



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Before making the modifications described in this SL, check the type of chain wheel and version of the tool for turning out segments.

**Check chain wheel type**

Find the tool that is available on the specific vessel and check which type of chain wheel (see Fig. 1) is fitted on the crankshaft of the specific engine.

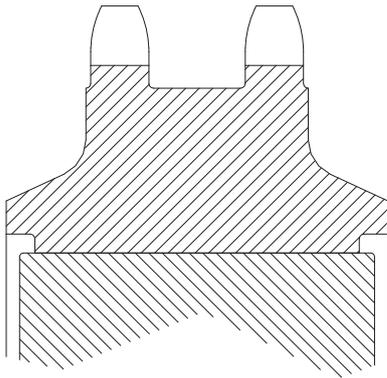
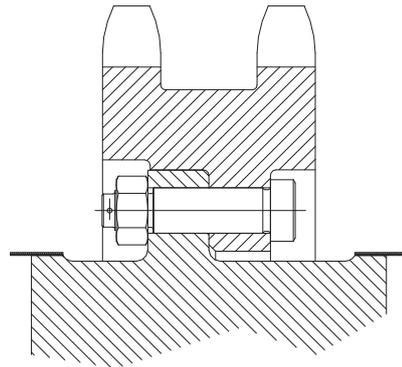


Fig. 1: *Shrink-fitted chain wheel*



*Bolted chain wheel*

**Correct tool**

The tool shown in Fig. 2 is the correct tool for engines with the shrink-fitted chain wheel. If the engine has been delivered with this tool, no further action is needed.

The tool shown in Fig. 3 is the correct tool for engines fitted with a bolted chain wheel.

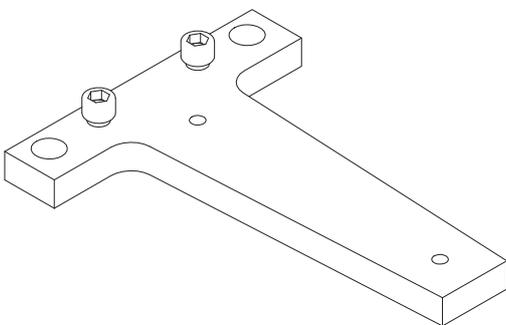


Fig. 2: *Tool for shrink-fitted chain wheel*

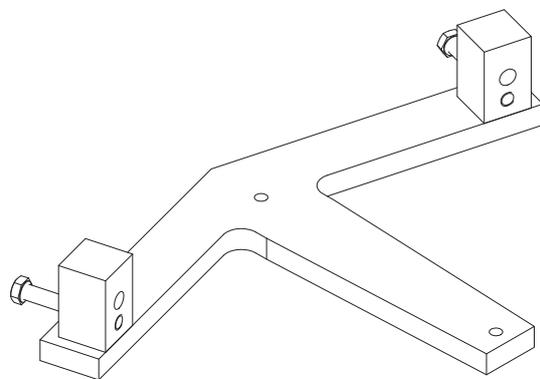


Fig. 3: *Tool for bolted chain wheel*

**Modification procedure**

If the engine has a shrink-fitted chain wheel and the tool delivered is of the wrong type, carry out the following three steps:

**First step:**

Cut off the T-piece ends approximately 125 mm from the centreline as shown in Fig. 4. The cut should be perpendicular to the T-piece.

**Second step:**

Drill two 18-mm holes in the middle of the T-piece with an offset of 100 mm from the centreline (see Fig. 4). It is important that the distance between the holes is 200 mm.

**Third step:**

Countersink the two holes (Fig. 5) deep enough for the top side of an M16 countersunk head screw to be flush with the tool.

To assemble the tool on the chain wheel, use two M16 countersunk head screws that protrude 16-18 mm through the hole.

Finally, test install the modified tool on the chain wheel, see Fig. 6, in order to make sure that the thrust segments can now be turned out without problems.

Questions or comments regarding this SL should be directed to our Dept. LEE3 (e-mail: lee3@mandiesel.com).

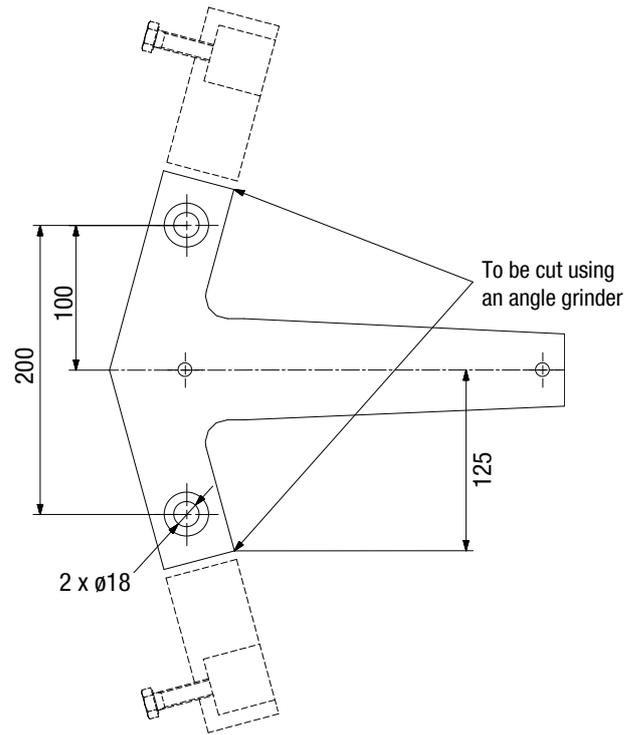


Fig. 4: Cut off T-piece ends

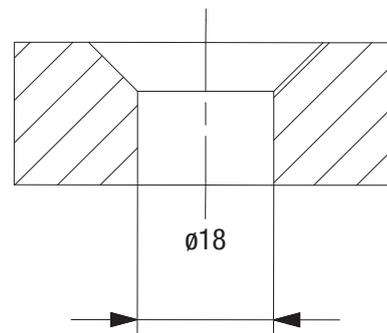


Fig. 5: Countersunk 18-mm hole

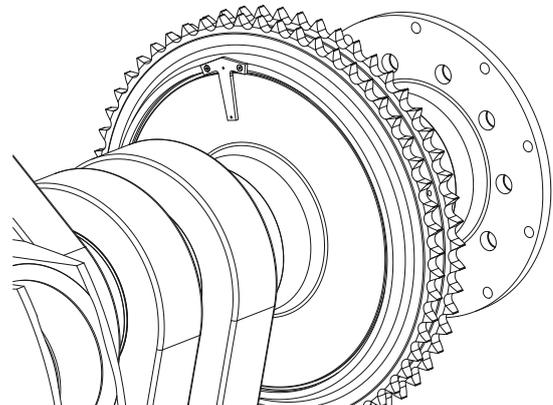


Fig. 6: Mounting of tool on chain wheel