

IPS Prop Installation

Propeller installation Procedure



Remove any nuts from shaft.



Expose and clean any debris from bare shaft.



Apply water resistant grease (Volvo part no. 828250) to the splines and threads on shaft.



Carefully slide on aft prop and aft nut. Tighten nut by hand until it bottoms.



Slide on aft lock ring.



Install four socket cap screws.



Torque to 25 +/- 3 Nm (15.5 +/- 2.2 lb-ft).
Note: Use 1/2" torque drive wrench for this.



Install fwd prop



Install fwd nut.



Install fwd lock ring and capscrews.

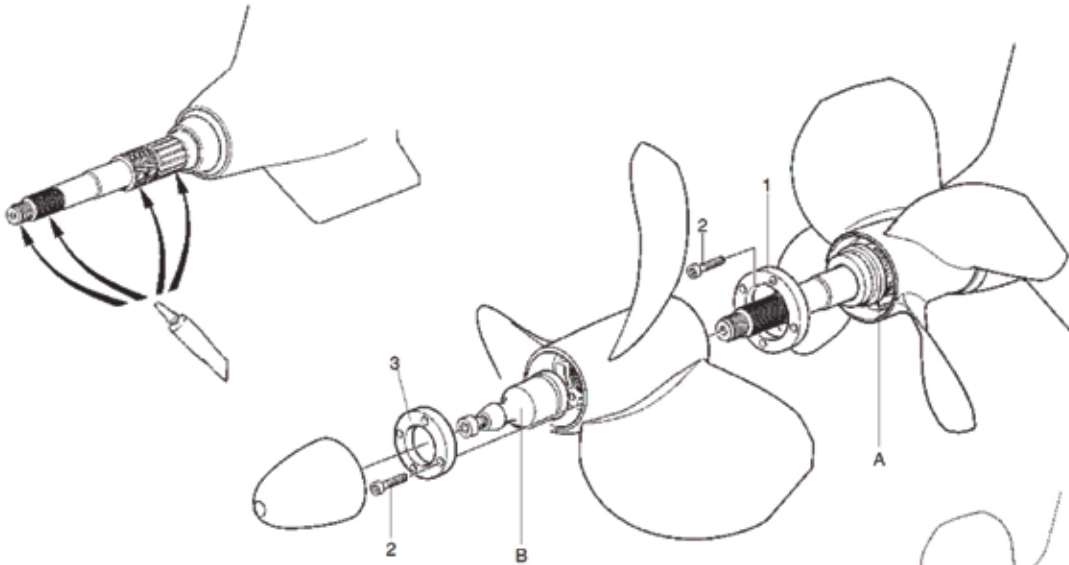


Torque to 25 +/- 3 Nm (15.5 +/- 2.2 lb-ft).



Install cone.

Propeller installation



1. Remove nuts (A) and (B).

2. Apply water-resistant grease, Volvo Penta part no. 828250 to the splines and the threads on the aft propeller shaft. Also grease all screw threads.

3. Install the aft propeller. Then install the aft nut (A) and tighten it by hand until it bottoms. Install locking ring (1). Tighten the locking ring using special tool **3863070**, a torque wrench and four socket cap screws (2).

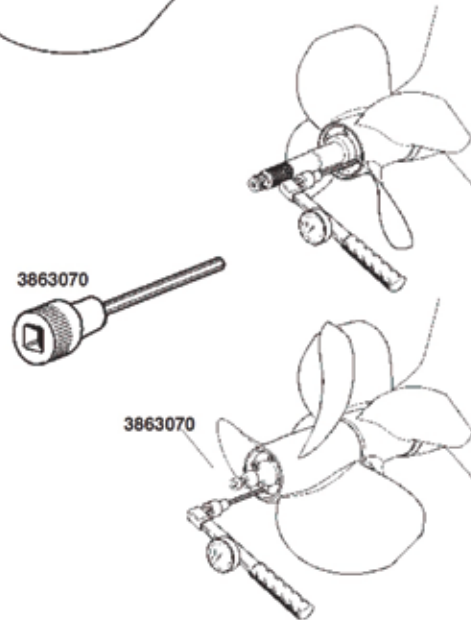
Tightening torque: **25±3 Nm (18.5±2.2 lbf ft)**.

4. Apply water-resistant grease, Volvo Penta part no. 828250 to the splines and the threads on the forward propeller shaft.

5. Install the forward propeller on the propeller shaft. Install nut (B) and locking ring (3). Tighten the locking ring using special tool **3863070**, a torque wrench and four socket cap screws (2).

Tightening torque: **25±3 Nm (18.5±2.2 lbf ft)**.

6. Install the rubber cone.



NOTE! The propeller surface finish may differ between propeller sizes due to different suppliers.