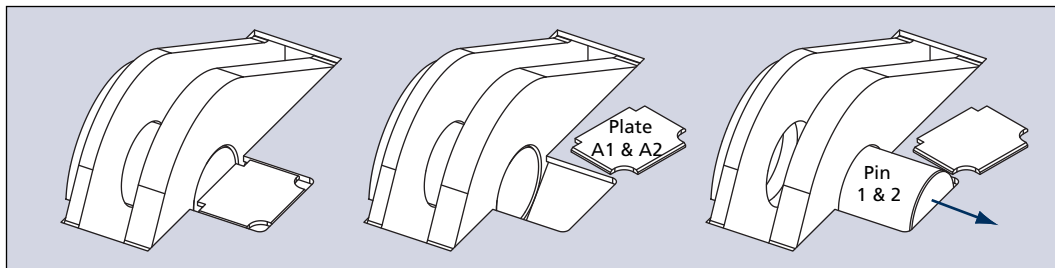
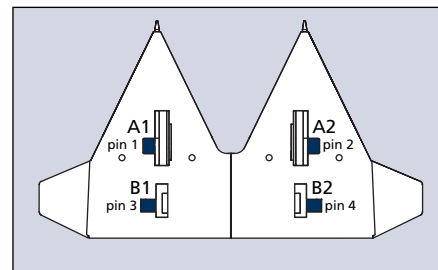


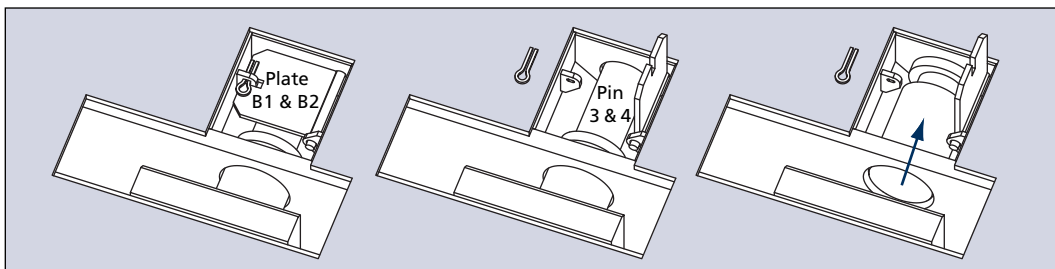
Mounting instructions

Stevpris / Stevshark Mk5



Forward fluke-shank connection

Remove the locking plates A1 and A2 which are tack-welded to the fluke



Aft fluke-shank connection

Move the pins 1 and 2 to the outer side. Remove the split pins and open the locking plates B1 and B2. Move the pins 3 and 4 to the outside.

Mounting instructions

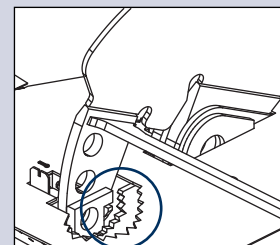
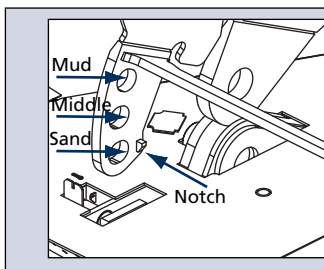
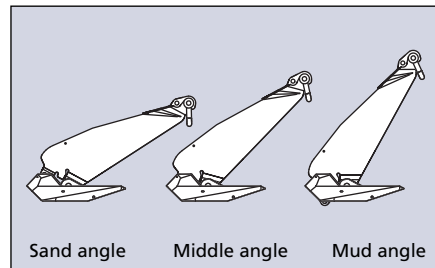
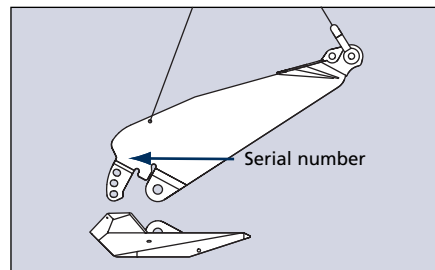
Stevpris / Stevshark Mk5

Fit the rear shank lugs into the fluke by means of a crane. Manoeuvre the rear shank lugs with the notch into the gap in the flukes, as indicated in the figures. When in position, rotate the shank forward to align the front pins with the shank.

Attention

Make sure the serial number of the shank corresponds with the serial number of the fluke for reason of identification and certification.

Align pins 1 and 2 with the forward shank eyes. Move pins 1 and 2 back into position. Place the shank in the sand, middle or mud position. Align pins 3 and 4 with the rear shank lugs. Move pins 3 and 4 back into position. Fit and weld the locking plates A1 and A2 on the fluke. See welding detail below. Close the locking plates B1 and B2 and secure with split pins.



Vryhof recommended welding procedure for locking plates A1 and A2

Fillet weld with electrode acc.AWS.E7018

Welding process SMAW electrode

welding position 2F

material S355J2G3 (St52-2N)

preheat material 50° C

interpass temp max 250° C

