BS ISO 484-1:2015

BSI Standards Publication

Shipbuilding — Ship screw propellers — Manufacturing tolerances

Part 1: Propellers of diameter greater than 2,50 m

bsi.

...making excellence a habit.™

Document Sharing Hub

National foreword

This British Standard is the UK implementation of ISO 484-1:2015.

The UK participation in its preparation was entrusted to Technical Committee SME/32, Ships and marine technology - Steering committee.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

© The British Standards Institution 2015.
Published by BSI Standards Limited 2015

ISBN 978 0 580 89428 2

ICS 47.020.20

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 December 2015.

Amendments/corrigenda issued since publication

Date	Text affected

Documents
Document Sharing Hub

Full document details: BS ISO 484-1:2015

INTERNATIONAL STANDARD

ISO 484-1

Second edition
2015-12-01

Shipbuilding — Ship screw propellers — Manufacturing tolerances —

Part 1: Propellers of diameter greater than 2,50 m

Construction navale — Hélices de navires — Tolérances de fabrication —

Partie 1: Hélice de diamètre supérieur à 2,50 m

Reference number
ISO 484-1:2015(E)

Documents
Document Sharing Hub

© ISO 2015

Full document details: BS ISO 484-1:2015

COPYRIGHT PROTECTED DOCUMENT

© ISO 2015, Published in Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

© ISO 2015 – All rights reserved

Documents
Document Sharing Hub

Full document details: BS ISO 484-1:2015

Contents

Page

Foreword ..... **iv**
Introduction ..... **v**
1 Scope **1**
2 Normative references **1**
3 Field of application **1**
4 Methods for measuring pitch **1**
4.1.1 Use of marking gauges 1
4.1.2 Method with a graduated ring 1
4.1.3 Method using coordinate measuring machine 1
5 Methods for measuring the thickness of the section **2**
6 Accuracy classes **3**
7 Tolerances on the pitch **4**
8 Tolerances on the extreme radius of the screw propeller **5**
9 Tolerances on the thickness of the blade section **5**
10 Checking and tolerances of the form of blade sections **5**
11 Tolerances on the length of the blade sections **8**
12 Tolerances on the location of blades, reference lines, and blade contours **8**
12.1 Marking of lines of reference 8
12.2 Tolerances on the contour of the leading edge 9
12.3 Tolerances on the angular deviation between two consecutive blades 10
13 Tolerances on rake, axial position, and relative axial position of consecutive blades **10**
14 Surface finish **11**
15 Static balancing **11**
16 Measuring equipment **12**
Bibliography **13**

© ISO 2015 – All rights reserved

Documents
Document Sharing Hub
Full document details: BS ISO 484-1:2015

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 8, *Ships and marine technology*, Subcommittee SC 3, *Piping and machinery*.

This second edition cancels and replaces the first edition (ISO 484-1:1981), which has been technically revised.

ISO 484 consists of the following parts, under the general title *Shipbuilding — Ship screw propellers — Manufacturing tolerances*:

— *Part 1: Propellers of diameter greater than 2,50 m*

— *Part 2: Propellers of diameter between 0,80 m and 2,50 m inclusive*

© ISO 2015 – All rights reserved
Documents
Document Sharing Hub
Full document details: BS ISO 484-1:2015

Introduction

The propeller manufacturer is at liberty to use any equipment and method that enables the tolerances to be verified to the required accuracy.

© ISO 2015 – All rights reserved

Documents
Document Sharing Hub
Full document details: BS ISO 484-1:2015

Documents
Document Sharing Hub

Full document details: BS ISO 484-1:2015