



## **Instructions for assembly of VARIPROP / RH or LH**

Clean the individual parts thoroughly prior to assembly.

**Fig. 1** Lower housing section (2) with two adjusting grub screws (9).

**Place the inner hub (4) into the lower housing section so that, turned clockwise for right hand rotation prop (RH) or anti-clockwise for a left hand rotation prop (LH), the limit stop of the inner hub is touching the limit stop of the lower housing section.**

**Fig. 2** Place blade no.1 (the numbers are stamped below the gear rim) into the lower housing blade bearing marked no. 1 so that, viewed horizontally, the blade is positioned at an approx. 18°–20° angle. See assembly drawing RH or assembling drawing LH for the position of the blades. (Please note that the straight leading edge must point down/forward towards the bow and the rounded trailing edge must point up/hang towards the stern).

Now repeat this procedure with blades nos. 2 ,3, 4, 5

**Fig. 3** Insert the Seeger circlip rings for the brake (6) so that they are flush with the projection (5mm) above the hub, making sure that the lugs (with two small holes) are positioned between the two stop screws for the brake (12) in the upper housing (10).

**Important : Please note that you must select the smaller distance between the stop screws (12) for placement of the lugs.**

If washers (7) have been used for the particular hub (50 x 58 x 0.3), place these on the circlip rings (6).

**Fig. 4** Now place the upper housing section (10) on the lower housing section (2) so that the locator pin (X) on the upper housing (10) is inserted in the locator hole (X) of the lower section (2).

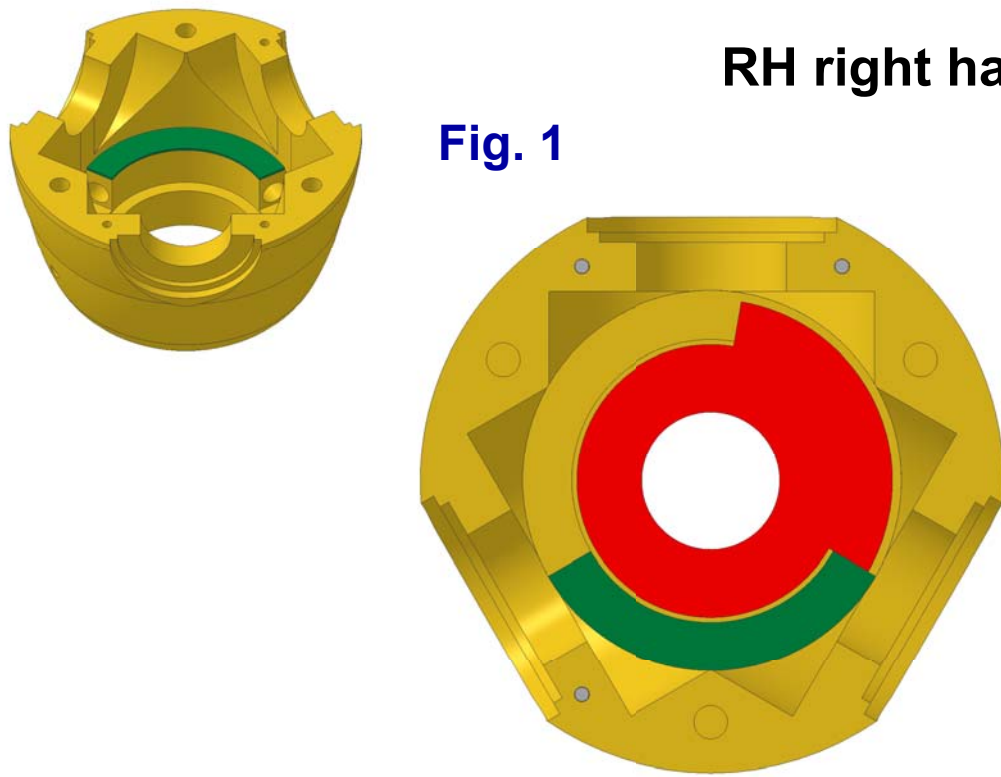
**Tighten the housing screws strongly and secure with Loctite medium (blue). Fill the VARIPROP with the special grease EP/SAL. Turn the blades to remove any surplus grease from the grease nipple borehole.**

<https://spw-gmbh.de/en/support-specs/videos>

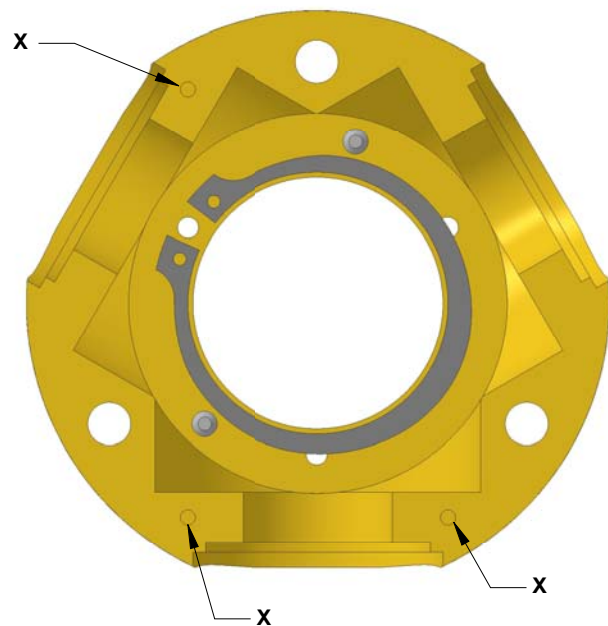
**Note: For part numbers refer to the exploded parts list and assembly view.**

# RH right hand propeller Ref.01\_2023

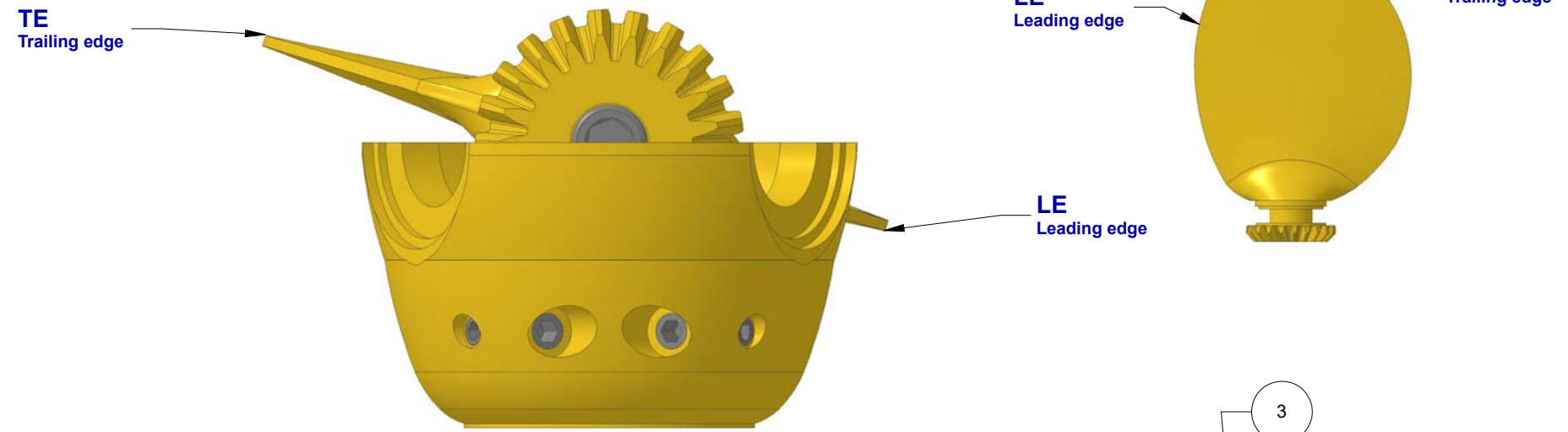
**Fig. 1**



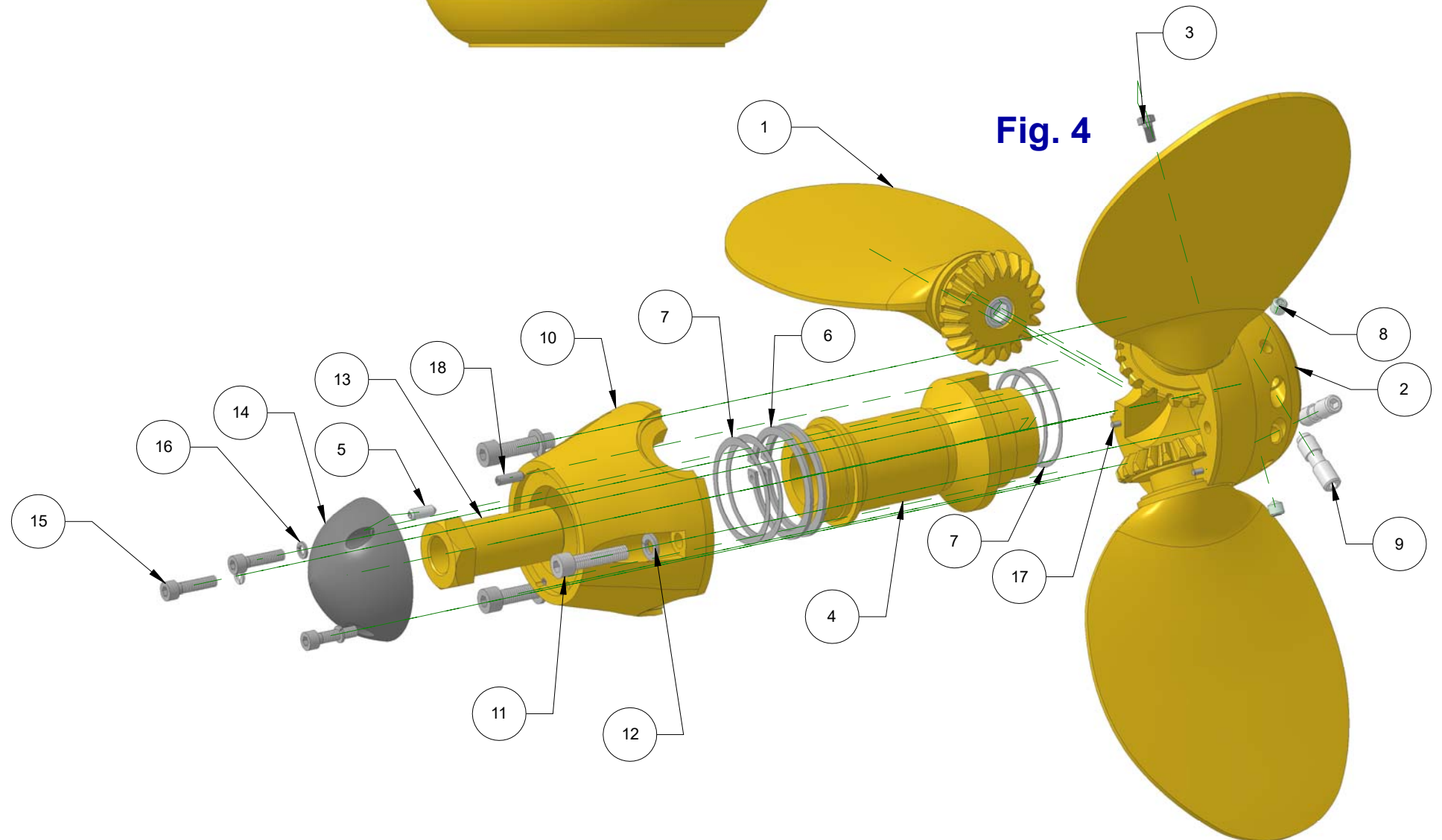
**Fig. 3**



**Fig. 2**

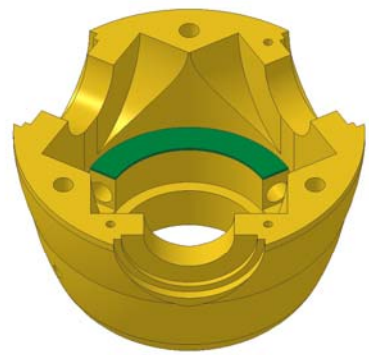


**Fig. 4**

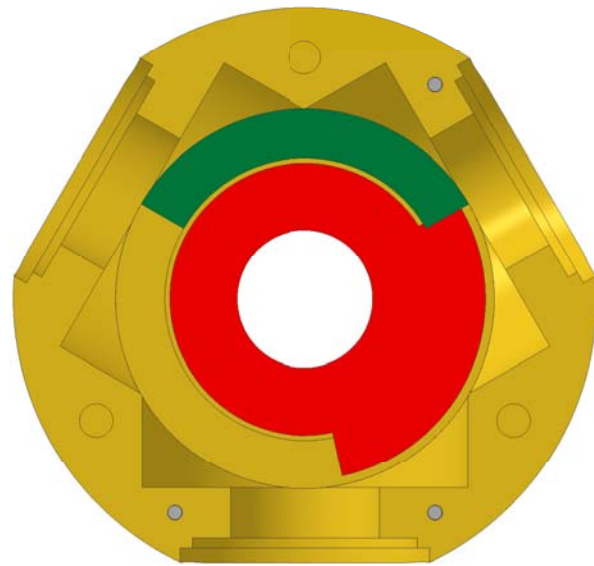


(Verwendungsbereich)				(Zul. Abw.)	(Oberfl.)	Maßstab	(Gewicht)
						(Werkstoff, Halbzeug) (Rohteil-Nr) (Modell- oder Gesenk-Nr)	
				Datum	Name	Variprop Zusammenbau RH	
			Bearb.	08.23	D.S		
			Gepr.				
			Norm				
						Blatt	
						Blätter	
Zust.	Änderung	Datum	Name	Ursprung	Ersatz für:		Ersatz durch:

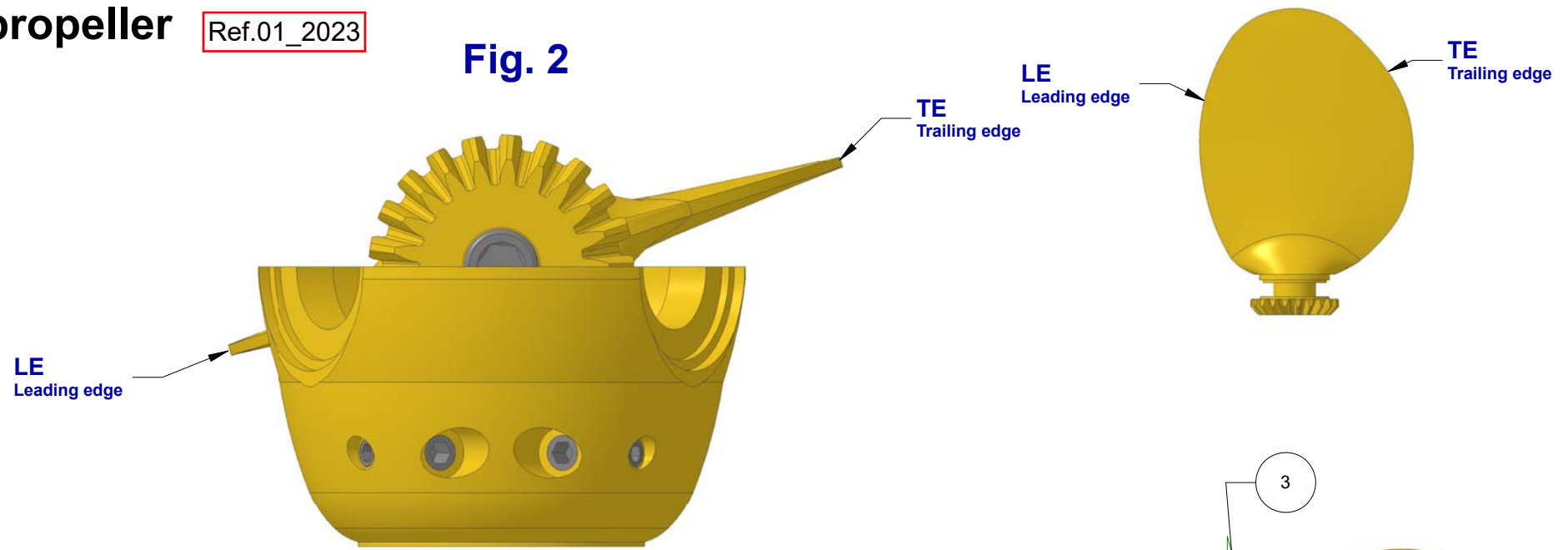
# LH left hand propeller Ref.01\_2023



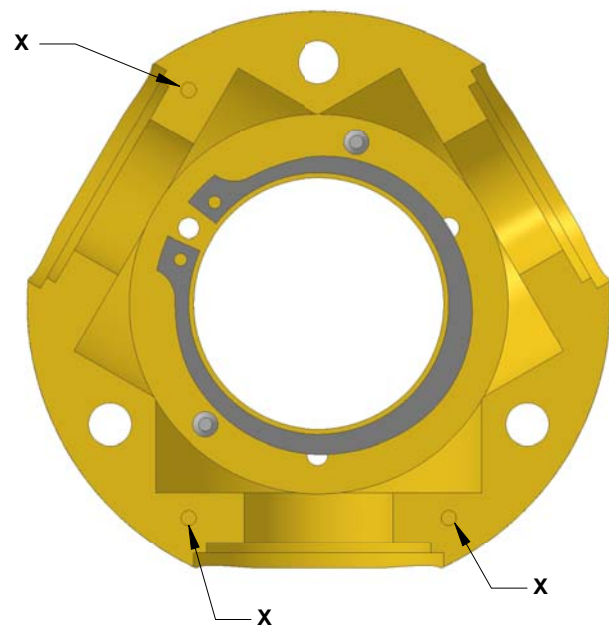
**Fig. 1**



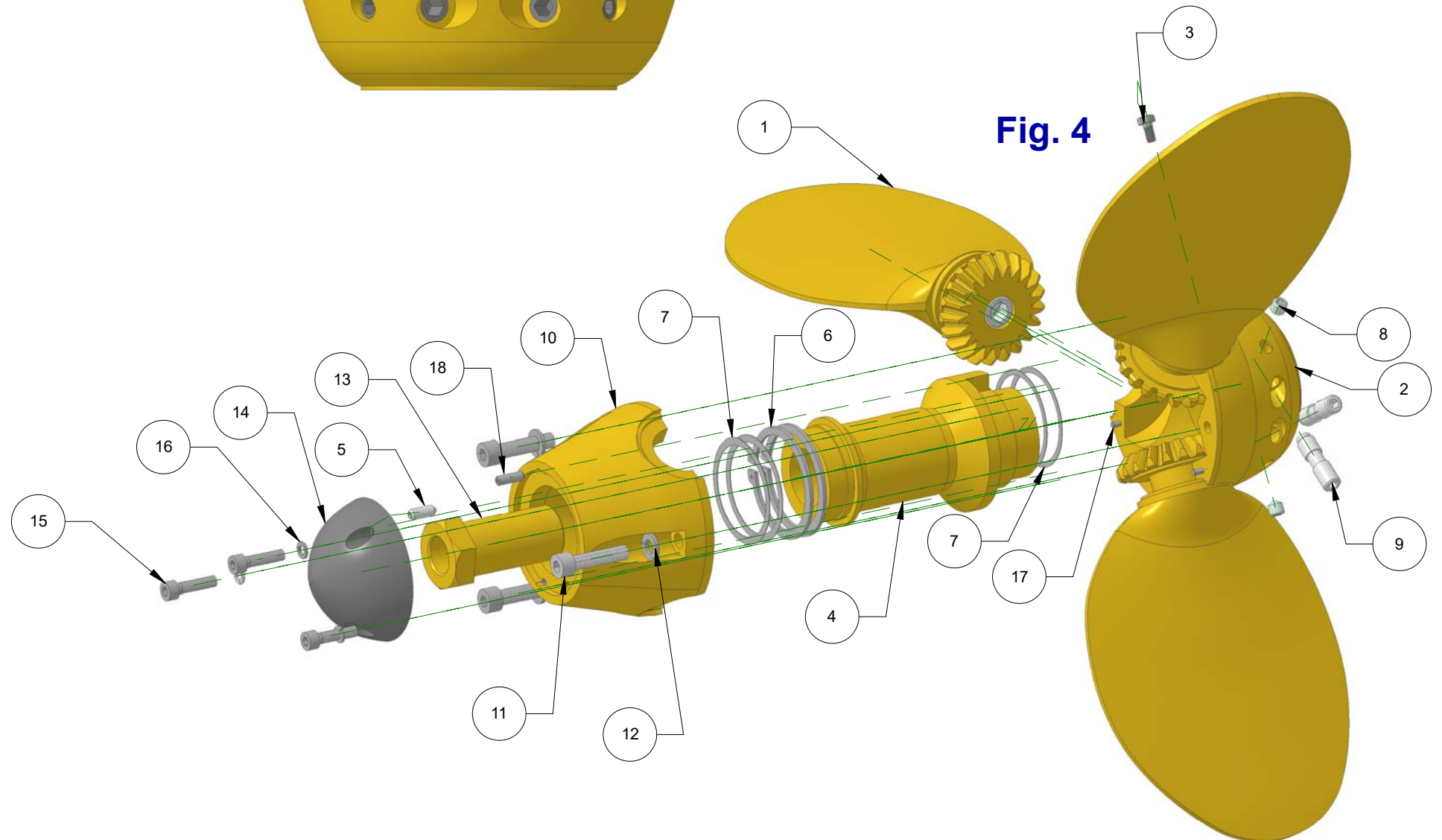
**Fig. 2**



**Fig. 3**



**Fig. 4**



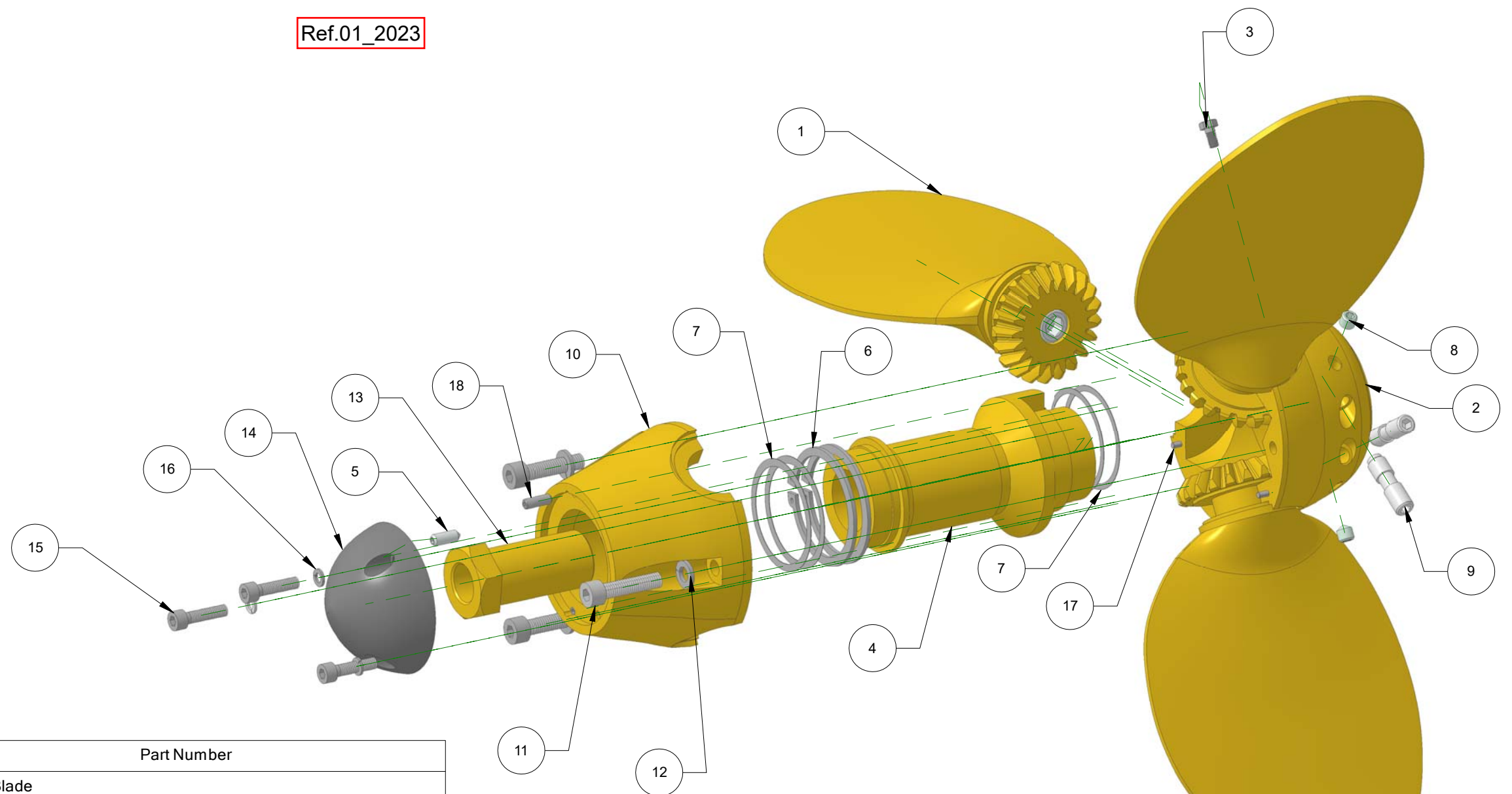
N:\Zeichnungen\_N\alibre\SPW Migration\VARIPROP\DF-107-GP\Zusammenbau RH + LH (Zeichnungen)

M:\Variprop\Installation - Demontage (PDF)

(Verwendungsbereich)				(Zul. Abw.)	(Oberfl.)	Maßstab	(Gewicht)
						(Werkstoff, Halbzeug) (Rohteil-Nr) (Modell- oder Gesenk-Nr)	
				Datum	Name	Variprop Zusammenbau LH	
			Bearb.	08.23	D.S		
			Gepr.				
			Norm				
							Blatt
							Blätter
Zust.	Änderung	Datum	Name	Ursprung	Ersatz für:		Ersatz durch:



Ref.01\_2023



Item Number	Quantity	Part Number
1	3	Flügel / Blade
2	1	Gehäuse Unterteil / Lower housing
3	1	Verschlusschraube für Schmiernippel / screw plug for grease nipple
4	1	Nabe / Hub
5	1	Sicherungsschraube für Befestigungsmutter / Shaft nut locking screw
6	2	Bremsringe / Shock absorber
7	2	Distanzscheibe / Distance Disk
8	2	Sicherungsschraube für Steigungsverstellungsschraube / locking screw
9	2	Steigungsverstellungsschraube / Pitch adjustment screw
10	1	Gehäuse Oberteil / Upper housing
11	3	Gehäuse Schrauben / Housing screws
12	3	Unterlegscheiben / Washer
13	1	Befestigungsmutter / Shaft nut
14	1	Anode
15	3	Anoden Schrauben / Screws
16	3	Unterlegscheiben / Washer (Anode)
17	3	Positionsstift / Locater pin
18	2	Stop Schraube für Bremsringe / Stop screw for brake

N:\Zeichnungen\_N\alibre\SPW Migration\VARIPROP\DF-107-GP\Zusammenbau RH + LH (Zeichnungen)

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(Verwendungsbereich)		(Zul. Abw.)	(Oberfl.)	Maßstab	(Gewicht)
				(Werkstoff, Halbzeug) (Rohteil-Nr) (Modell- oder Gesenk-Nr)	
			Datum	Name	Variprop Stückliste
			Bearb. 08.23	D.S	
			Gepr.		
			Norm		
Zust.	Änderung	Datum	Name	Ursprung	Ersatz für:
					Ersatz durch:



Blatt  
Blätter