

Installation method A
 where you are able to inject the Sikaflex.

Clean the GRP tube inside with a abrasive fan (rotating sandpaper) in the area where the bearing shall be mounted.

Find the position of the PETP bearing, mark up the "outside grooves" on the inside GRP tube, translate these marks to the outside of the GRP tube. Use a ruler from the top of the tube.

Drill minimum 4pcs 10mm holes in the rudder tube, two holes at each groove.

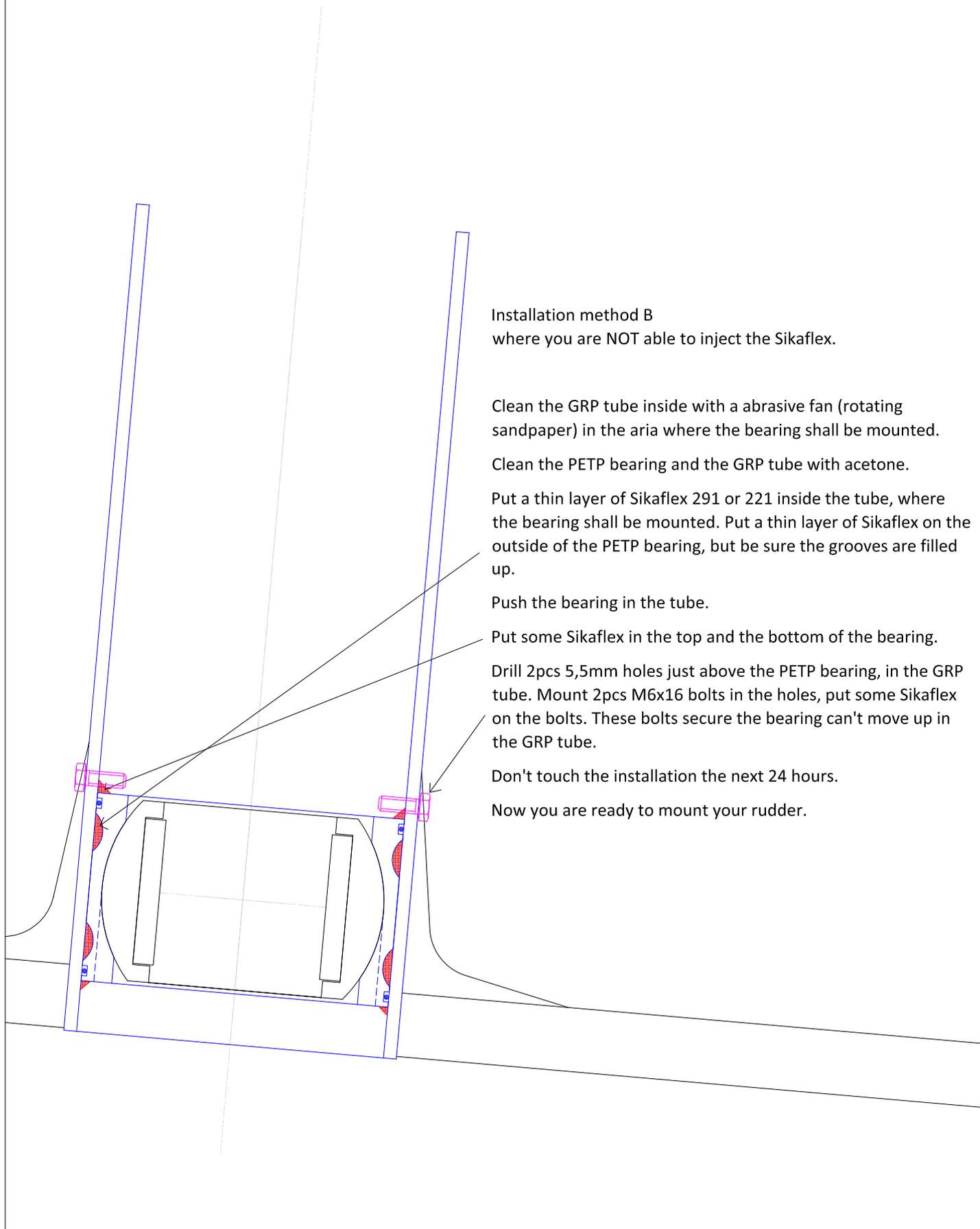
Clean the PETP bearing and the GRP tube with acetone, and mount the bearing in the tube. Make sure the drilled holes are placed where the grooves are.

Inject Sikaflex 291 or 221 via the 10mm holes. Be sure there are Sikaflex all around the bearing. End up the installation with some Sikaflex in the top and bottom of the bearing.

Don't touch the installation the next 24 hours.

Now you are ready to mount your rudder.

Modify date	Project: installation manual "A"		 JEFA MARINE A/S NIMBUSVEJ 2 2670 GREVE, DENMARK Tlf. +45-4615 5210 & Fax +45-4615 5208 E-mail info@jefa.com & WWW.jefa.com
Modify date	6BB rudder bearing		
Modify date	Scale 1:2	Date 2011-05-15	
Modify date	Material —	Drawing no. —	
Modify date	Filename —		
Modify date	Drawn by J.F.		



Installation method B
where you are NOT able to inject the Sikaflex.

Clean the GRP tube inside with a abrasive fan (rotating sandpaper) in the area where the bearing shall be mounted.

Clean the PETP bearing and the GRP tube with acetone.

Put a thin layer of Sikaflex 291 or 221 inside the tube, where the bearing shall be mounted. Put a thin layer of Sikaflex on the outside of the PETP bearing, but be sure the grooves are filled up.

Push the bearing in the tube.

Put some Sikaflex in the top and the bottom of the bearing.

Drill 2pcs 5,5mm holes just above the PETP bearing, in the GRP tube. Mount 2pcs M6x16 bolts in the holes, put some Sikaflex on the bolts. These bolts secure the bearing can't move up in the GRP tube.

Don't touch the installation the next 24 hours.

Now you are ready to mount your rudder.

Modify date	Project: installation manual "B"		 JEFA MARINE A/S NIMBUSVEJ 2 2670 GREVE, DENMARK Tlf. +45-4615 5210 & Fax +45-4615 5208 E-mail info@jefa.com & WWW.jefa.com
Modify date	6BB rudder bearing		
Modify date	Scale 1:2	Date 2011-05-15	
Modify date	Material —	Drawing no. —	
Modify date	Filename (dwg) —		
Modify date	Drawn by J.F.		