



Marine Installation Recommendation Engine Mounting

The marine engine mounting system must adequately support the engine and marine gear without overstressing any part of the engine-gear structure, and at the same time, hold proper alignment with the drive line components. Also, it is one of the principal factors to be considered in any program to reduce in-boat noise levels.

The recommendations in this bulletin provide a guide to obtaining a satisfactory mounting system. To obtain Customer's concurrence to an installation, the mountings must accomplish the following:

1. The mounting system must be constructed so that the supporting structure deflections do not over-stress the engine castings.
2. The engine must be installed so that the static bending moment at the point where the flywheel housing is attached to the engine does not exceed the maximum value given on the particular engine data sheet.
3. Engine movement must be restrained sufficiently to prevent damage from physical contact between the engine components and adjoining structures; and the movement must not exceed the flexural limits of connecting systems.

Engine Foundation

The typical hull structure consists of a series of longitudinally placed members or stringers supported by transverse web frames and bulkheads. The primary purpose of this structure is to support the vessel shell and deck, and stiffen the hull against stresses. The engine is mounted on an engine bed that is part of the longitudinal stringer system. The engine bed provides the attachment points for the engine and marine transmission to the vessel framework. The weight of the engine and marine transmission is distributed throughout the hull by the stringers. The entire mounting system, engine bed, stringers, and frames must be rigid enough to resist excessive flexing in any part of the hull and must securely hold the engine when subjected to rolling, pitching, pounding and propeller thrust. The marine transmission and shafting must be held in alignment to prevent damage to the drive system. The engine bed must provide flat, parallel surfaces to use as the engine attachment points, and must allow a space for alignment spacer plates, chocks, and shims.

Fixed or Solid Engine Mounting

A fixed mounting is solidly attached to the engine bed with spacer plates, chocks, or shims used for alignment.

Most work boats use the fixed mounting system, because it is the easiest to install and align and does not require maintenance. Solid mounts are simple, durable and inexpensive, but have some disadvantages. Close tolerances must be held on all mounting holes, and the engine may be subjected to severe shock and stress from the hull. If the engine block, flywheel housing or front gear cover are over-stressed by the mounting system, they may crack and fail. Unless the mounting locations are quite rigid, relative motion between the brackets and engine bed can cause fretting corrosion. A fixed mounting system will transmit

more noise and vibration to the hull structure than a resilient mounting arrangement, making it less desirable in pleasure boats and passenger boats.

Some of the objections to solid mountings can be overcome by the use of Fabreka type washers and pads (Figure 1). This material, which is layers of rubber impregnated canvas vulcanized together, will provide some flexibility for minor misalignments, increase the tolerance for hull flexure, and give a degree of protection to the engine from shock loading. Its spring rate is too high to provide isolation of the hull from engine vibrations, however.

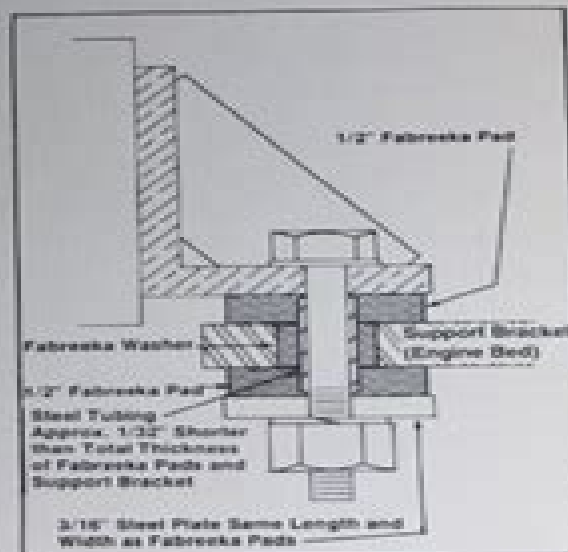


Figure 1

EXHAUST
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FUEL
SYSTEM

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