
**Shipbuilding — Ship screw propellers
— Manufacturing tolerances —**

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

*Construction navale — Hélices de navires — Tolérances de
fabrication —*

Partie 2: Hélices de diamètre compris entre 0,80 et 2,50 m inclus

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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).

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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 484-2:1981), 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*

Introduction

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

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Shipbuilding — Ship screw propellers — Manufacturing tolerances —

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

1 Scope

This part of ISO 484 defines manufacturing tolerances of ship screw propellers of a diameter between 0,80 m and 2,50 m.

NOTE Some deviations for the tolerance are permitted in certain cases subject to the discretion of the customer or of the designer and the customer.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1302, *Geometrical Product Specifications (GPS) — Indication of surface texture in technical product documentation*

ISO 1940-1:2003, *Mechanical vibration — Balance quality requirements for rotors in a constant (rigid) state — Part 1: Specification and verification of balance tolerances*

3 Field of application

This part of ISO 484 applies to monobloc, built-up, and controllable pitch propellers.

4 Methods of measuring pitch

4.1 The principle of one method of measurement consists in setting out along a helicoidal line of radius, r , a certain length, PQ, corresponding to the desired angle, α , and in measuring the difference, h , in the heights of the points P and Q with respect to a reference plane (see [Figure 1](#)).

The length PQ shall be set out using one of the methods described in [4.1.1](#), [4.1.2](#) or [4.1.3](#).

NOTE Other methods giving the required accuracy may be used if necessary.

4.1.1 Use of marking gauges

The length PQ shall be set out by means of marking gauges.

4.1.2 Method with a graduated ring

The length PQ shall be set out by means of angle, α , on a part of a graduated ring of suitable radius (see [Figure 1](#)).