



## Service Bulletin

Bulletin No: SB-0008-18-315-SW    Effective Date: 11-11-2018    Type: Installation

**Subject: Use of Loctite® 243 during assembly of SW350/353 turbines**

### Scope

This service bulletin provides instructions for the use of Loctite® 243 during assembly of SW350 and SW353 turbines.

### Background

There have been reports of the installation hardware in some SW350 and SW353 turbine units loosening during operation. The purpose of this service bulletin is to prevent such occurrences by the application of a small amount of blue Loctite® 243 threadlocker to the threads of key assembly screws and bolts that do not have a previously installed TUFLOK coating or where the applied coating has worn away and is in need of renewal.

Prior to the application of Loctite® 243 threadlocker, ensure all bolt threads are clean and free of grease, residue or any other contaminate that may degrade performance of the product.

### Mounting of the wind vane

Before inserting the two socket cap screws (M8 x 20) used to fasten the wind vane to the rear of the turbine, apply a small amount of Loctite® 243 to the threads of the screws, insert and torque to 30 Nm (see figure 1).

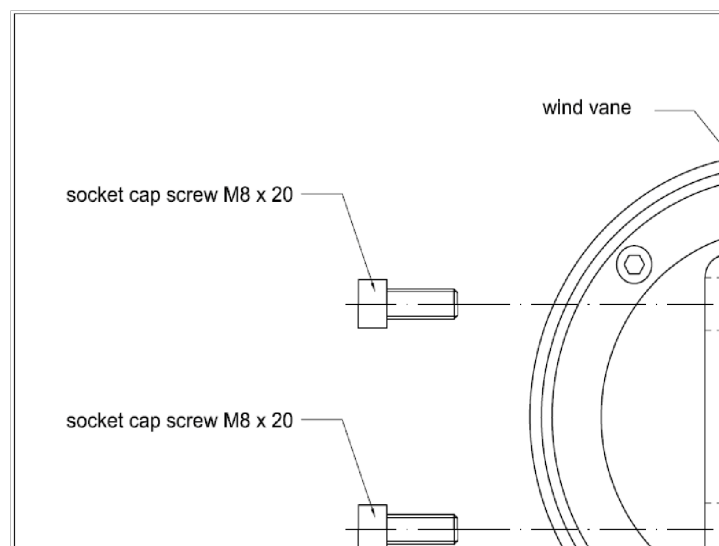


Figure 1

### Mounting the hub to the generator shaft

Before inserting the socket cap screw (M8 x 90) apply a small amount of Loctite® 243 onto the threads. Next insert the socket cap screw through the hub, tighten it until there is no axial play, then torque to 18 Nm (see figure 2).

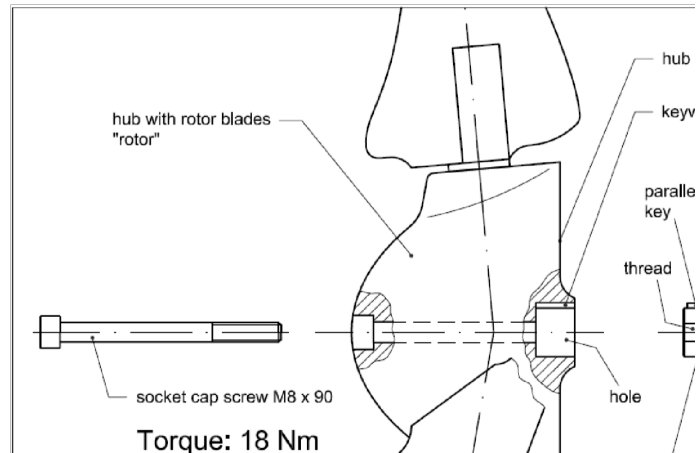


Figure 2

### Bushing / Turbine Assembly

After installing the bushing being used (stainless steel, Delrin®, etc) onto the turbine yaw, place a small amount of Loctite® 243 onto the threads of the provided bushing mounting screws, insert each and tighten securely.

### Mounting the turbine to the mast

After inserting the turbine/bushing assembly in the appropriately sized mast pipe, line the drilled holes of the pipe with the taped holes of the bushing used (stainless steel, Delrin®, etc). Next apply a small amount of Loctite® 243 to the threads of the mounting screws, insert and torque to 15 Nm (see figure 3).

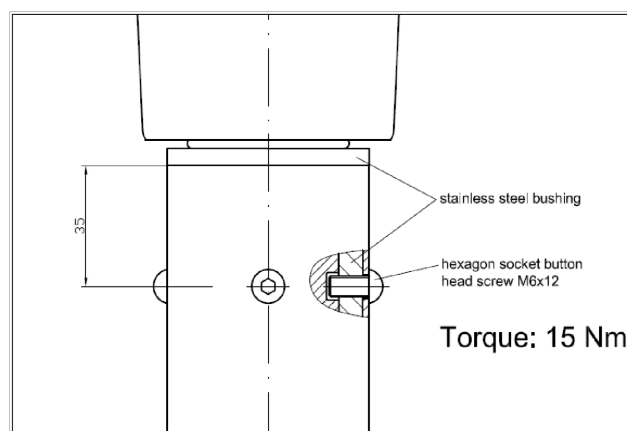


Figure 3



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