

## **Yaquina Boat Equipment**

### **Models #2469 & #3333 Machining instructions for Stainless Steel and Bronze Alloy\* Sheaves**

Sheaves surfaces are machined at an angle of 2-3/4 degrees or 0.048 inch of taper per inch of travel. A 1/16 (.0625) inch raised surface is maintained at the hub / shim contact surface.

Sheaves are directional and are turned as a mirror image with the inside sheave being cut from the outside in while the outside sheave is cut from the inside out. This produces matched spiral surfaces that draws the line in under pressure and reduces the twisting that is produced by turning both sheaves in the same direction.

Final cut is made at 84 RPM with a CNMG 432 carbide insert or equivalent 1/32" radius tool edge profile. Cross feed rate is 0.010 inch per revolution.

Polish at 200-300 RPM with 80 grit emery cloth to remove the sharp surface on the ridges in order to reduce line wear while still providing a groove to grip the line.

**IMPORTANT:** #2469 8 hole sheaves that are used on Yaquina model PB1 pot haulers (powered by a Char-Lynn 10,000 hydraulic motor) should be ***removed from service*** when they reach 5/8 inch thickness at the center bore.

Similarly, model #3333 16 hole sheaves used on Yaquina model PB2 pot haulers (driven by a KYB piston motor) should be ***removed from service*** when they reach 3/4 inch thickness at the center bore.

*\*Bronze Alloy sheaves are available in both models and should be used any time that a flat fiber type line is used such as Manline, American Blue Steel, etc as these types of line used in stainless steel sheaves have a tendency to pop out of the sheave when under extreme pressure and can cause injury.*

For technical assistance call Doug Alldridge toll free at 1-800-923-3625