



NACRA SAILING BV

Retrofit Assembly

NACRA 17

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ASSEMBLY MANUAL

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The Netherlands

DOCUMENT NAME : NACRA_17_ASSEMBLY_MANUAL

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DATE REVISION :

PRODUCED BY : R&D - MO

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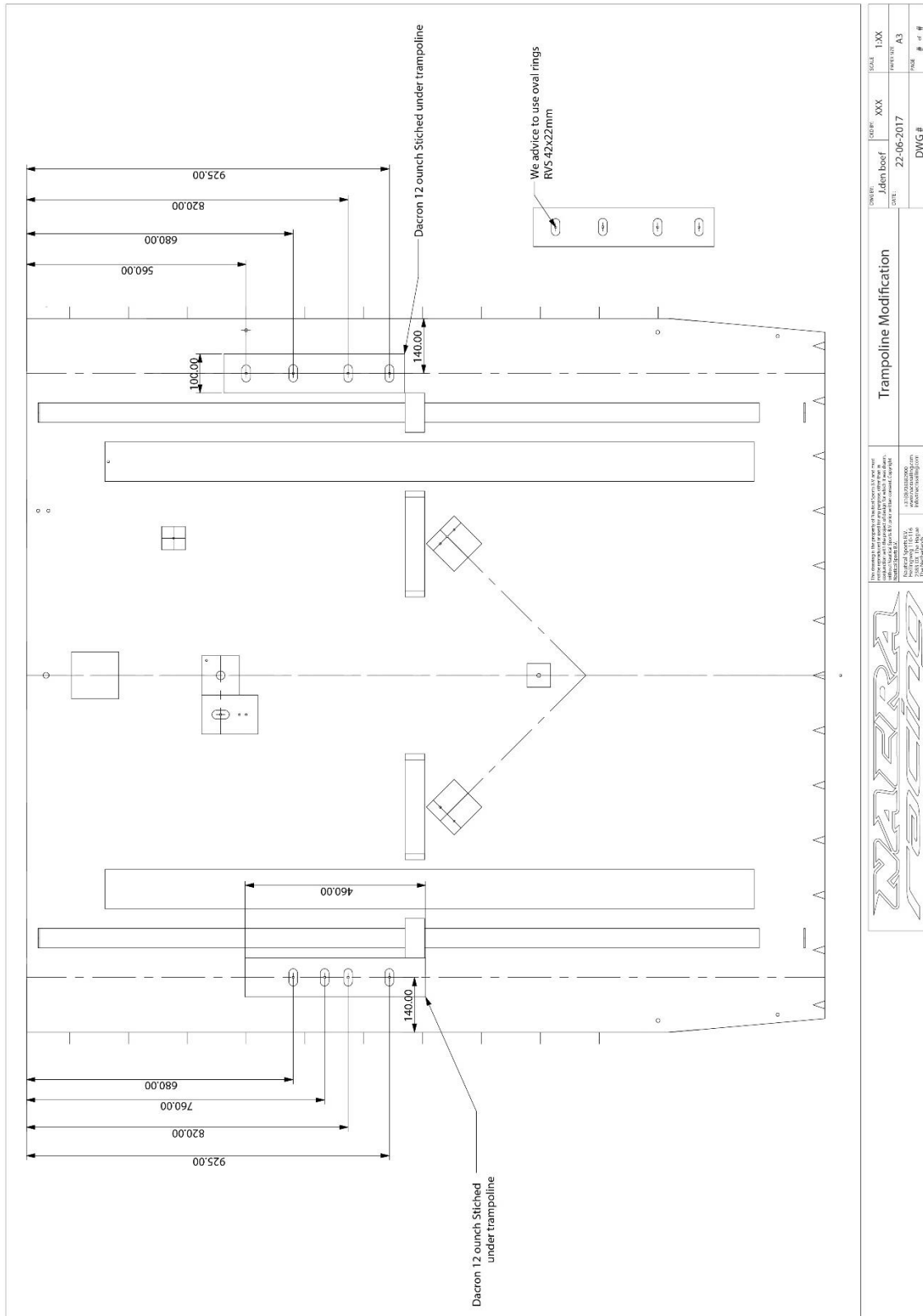
1. PART LIST – NACRA 17 Assembly package

Part Description	Quantity
upgrade kit to MK II foiling version	1
Z-foil NACRA 17 PORT	1
Z-foil NACRA 17 STBD	1
Z-foil bearing system incl up/down w/out bolts PORT	1
Z-foil bearing system incl up/down w/out bolts STBD	1
Rudder blade NACRA 17 w/elevator	2
Rudder system NACRA 17 PORT	1
Rudder system NACRA 17 STBD	1
Tiller tie bar extrusion NACRA 17	1
Rudder gudgeon set NACRA 17 PORT	1
Rudder gudgeon set NACRA 17 STBD	1
Progrip set NACRA 17	1
Z-foil trim kit fore/aft NACRA 17 1 hull	2
Daggerboard case insert rear	2
Carbon stern plate w/holes PORT	1
Carbon stern plate w/holes STBD	1
Glassplate 5mm for stern reinforcement	2
Bolts/pieces for retrofit kit NACRA 17	1
Chinook footstrap plug	

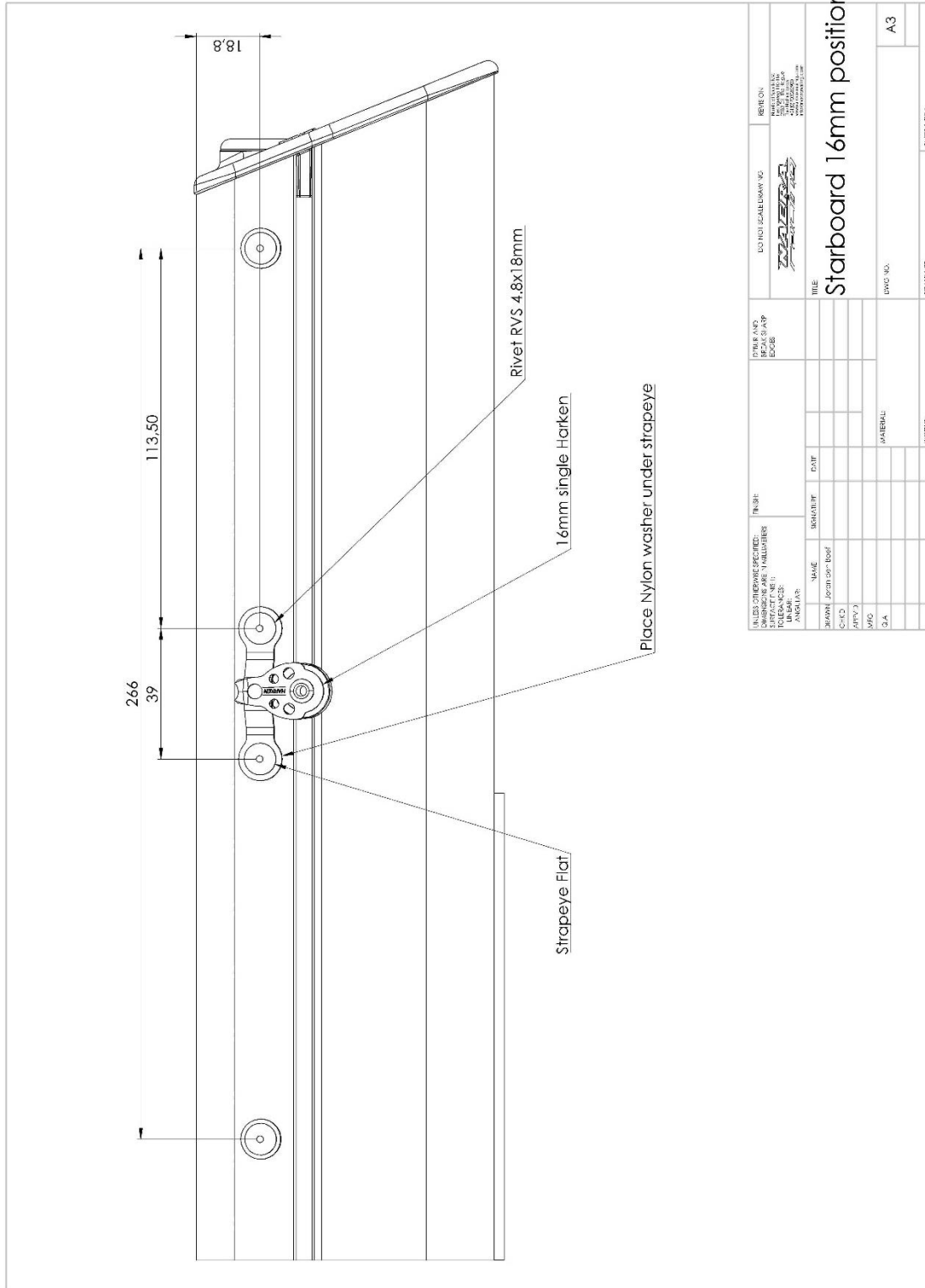
1.1 Bolts/pieces

Part Description	Purpose	quantity
bolt countersunk 1/4 x 1" 1/2 SOCKET	Keel bearing	8
bolt cylinderhead 1/4 x1.1/4 SOCKET	Deck bearing	12
Nut nylock 1/4 UNC	Deck bearing front	4
Washer ss 6,4 standard	Deck bearing front	4
rivet washer nylon	Spi pole strap eyes mounting	6
bolt pan head M5x16mm SOCKET	Spi pole strap eyes mounting	6
nut nylock M5	Spi pole strap eyes mounting	6
washer ss 5,3 standard	Spi pole strap eyes mounting	6
screw panhead 4,2x13mm	Spi pole endcap	1
bolt countersunk M6x35mm TORX	Rudder Gudgeon	24
nut nylock M6	Rudder Gudgeon	24
washer ss 6,4 standard	Rudder Gudgeon	24
main foil trimsticker base NACRA 17 (deck)	Deck	2
traveler cleat base ss NACRA 17	Rear beam	1
harken traveler delrin set screw	Traveller plastic screw replacement	2
ronstan strap eye w/ring medium	Cleat	1
rivet 4.8x18mm Avinox	Traveller base/Harken cleat on bracket/beam insert	7
harken strap eye low	Front beam STBD side	1
rivet 4.8x14mm Avinox	Traveller cleat base	2
rivet washer nylon	Under rivet for fixing beam insert	2
16mm single	Front beam STBD	1

2. Trampoline



3. Front Crossbar



UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS SURFACE FINISH: TOLERANCES: ANGLES:		FINISH:		FORM AND FIT AS AP- PROCESSED		DO NOT SCALE DRAWING		REVISION: DATE: 2017-06-29 BY: [Signature] CHECKED BY: [Signature] APPROVED BY: [Signature]	
NAME	NUMBER	DATE	TITLE						
BEWAAR (part one) part			Starboard 16mm position						
CH-0			DWG NO.						
APP-1			SCALE						
MFG			A3						
CA			SHEET NO.						
			SHEET TOTAL						

4. Rear Crossbar

4.1 Traveller



A. Remove the traveller from the rear beam



B. Use a small flat screwdriver to release the black stopper on the side. Be gentle, these are easy to ruin. When broken, use a drill 4mm and a needle to peel out the plastic



C. remove the lock pin



D. When the pin is salty and stuck, spray WD-40 en wait 5 minutes



E. take of the top part



F. Remove the screws and take off the bracket.

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G. Screw the 2 screws back in the traveller car. The screws will hold the lock pin in place



H. Unscrew the cleat from the bracket



I.



J. Unscrew the fairlead



K. Mount the cleat on the received bracket. Use the 4.8x18 rivet



L. Screw the fairlead back in place on the cleat.

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A. Drill out the rivet with a 5mm drill



B. Tie a rope around the casting and pull firmly



C. Clean the surface and put sikaflex or puraflex in front of the hole for the beambolt.



D. Slide the insert in the beam and place a pin or use a beambolt for positioning the insert.



Measure if the insert sits straight in the beam.



E. Dill a 5 mm hole in the insert. Use a 4.8x18 rivet

4.2 Rear crossbar insert replacement



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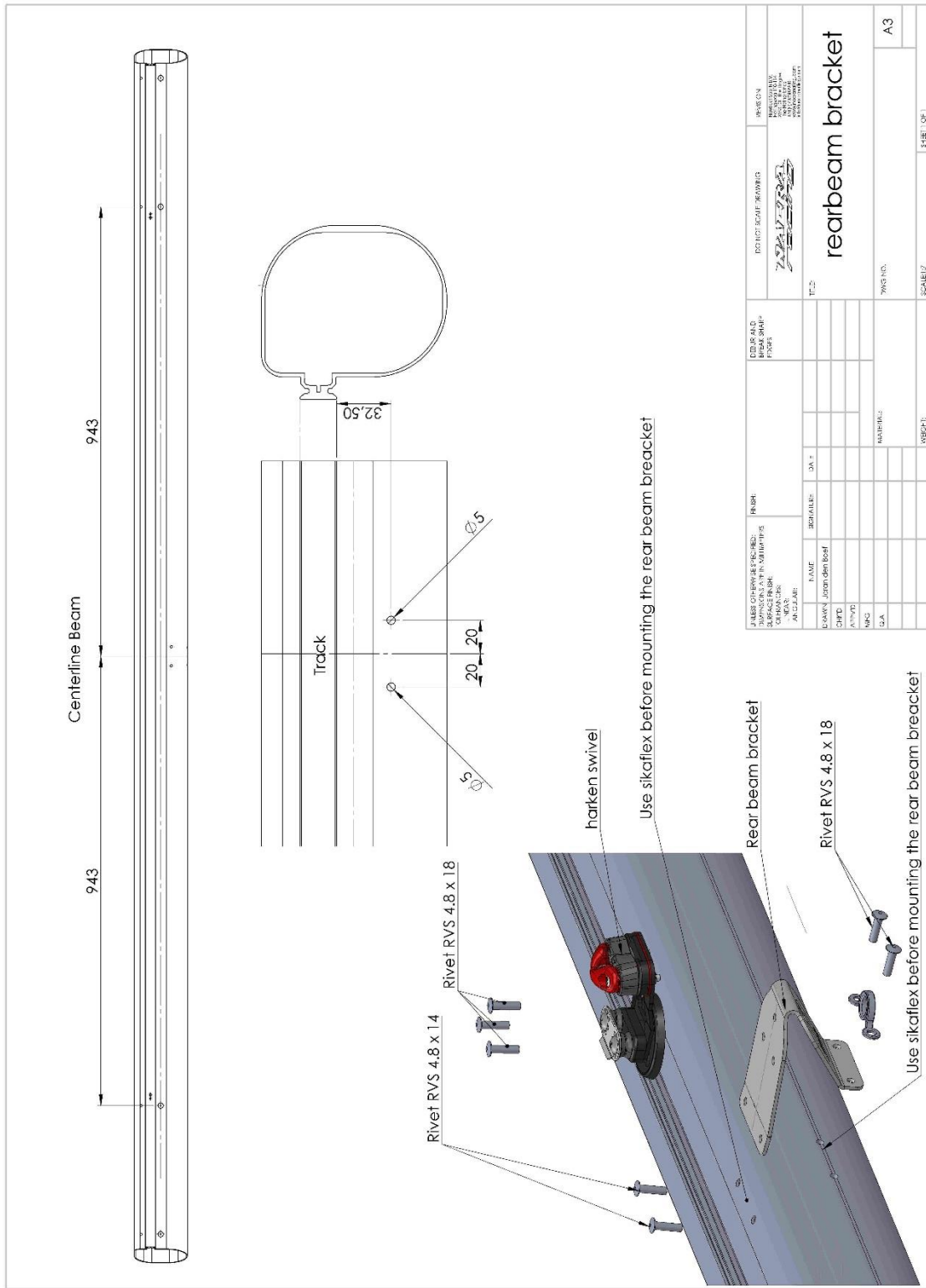
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JULES CHEVREAU SCHAIP (DEUR) A.M.B. VAN NACRA 17			TO HOÏT SCHAIP (DEUR) A.M.B. VAN NACRA 17			REGIO EN A.M.B. VAN NACRA 17		
NAME	SCHUWELLE	DA. T.	DEUR A.M.B.	TO HOÏT SCHAIP	REGIO EN A.M.B.			
LOWA / JONON / BOEF			FRANKRIJK		FRANKRIJK			
DHFD								
NFG								
USA								
MATERIAL:			T.C.S.			rearbeam bracket		
WBCH.F:			TWS.ND.			A3		
SCALE:1/1			SCALE:1/1			SHEET 1 OF 1		



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5. DB rake trim



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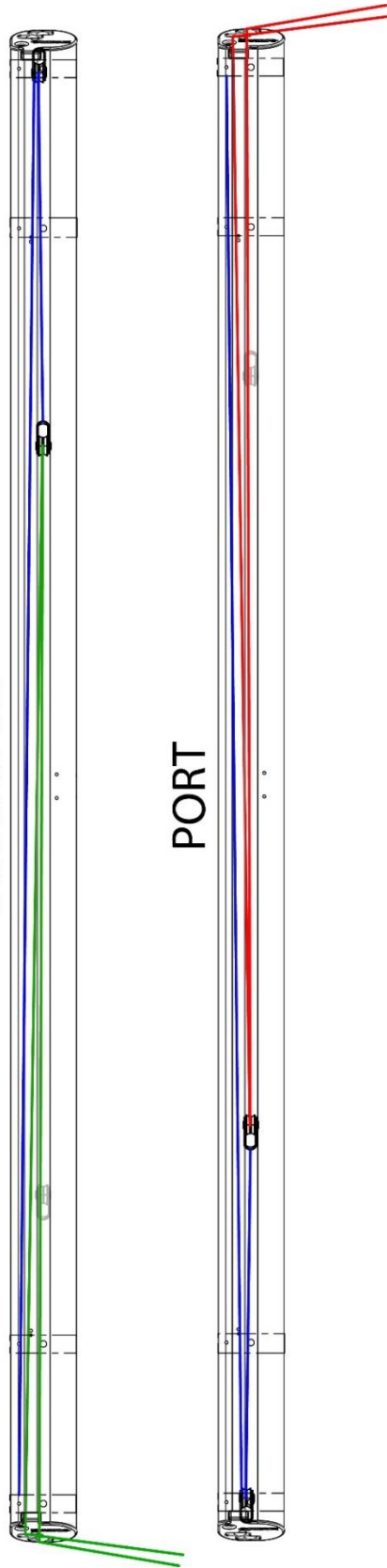
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- 4 mm shockcord - 2x 2.4m
- 5 mm Swiftcord - 1 x 10m + 0.4m split
- 5 mm Swiftcord - 1 x 10m + 0.4m split
- 16mm Harken 4x

STARBOARD

PORT





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6. Bottom bearing



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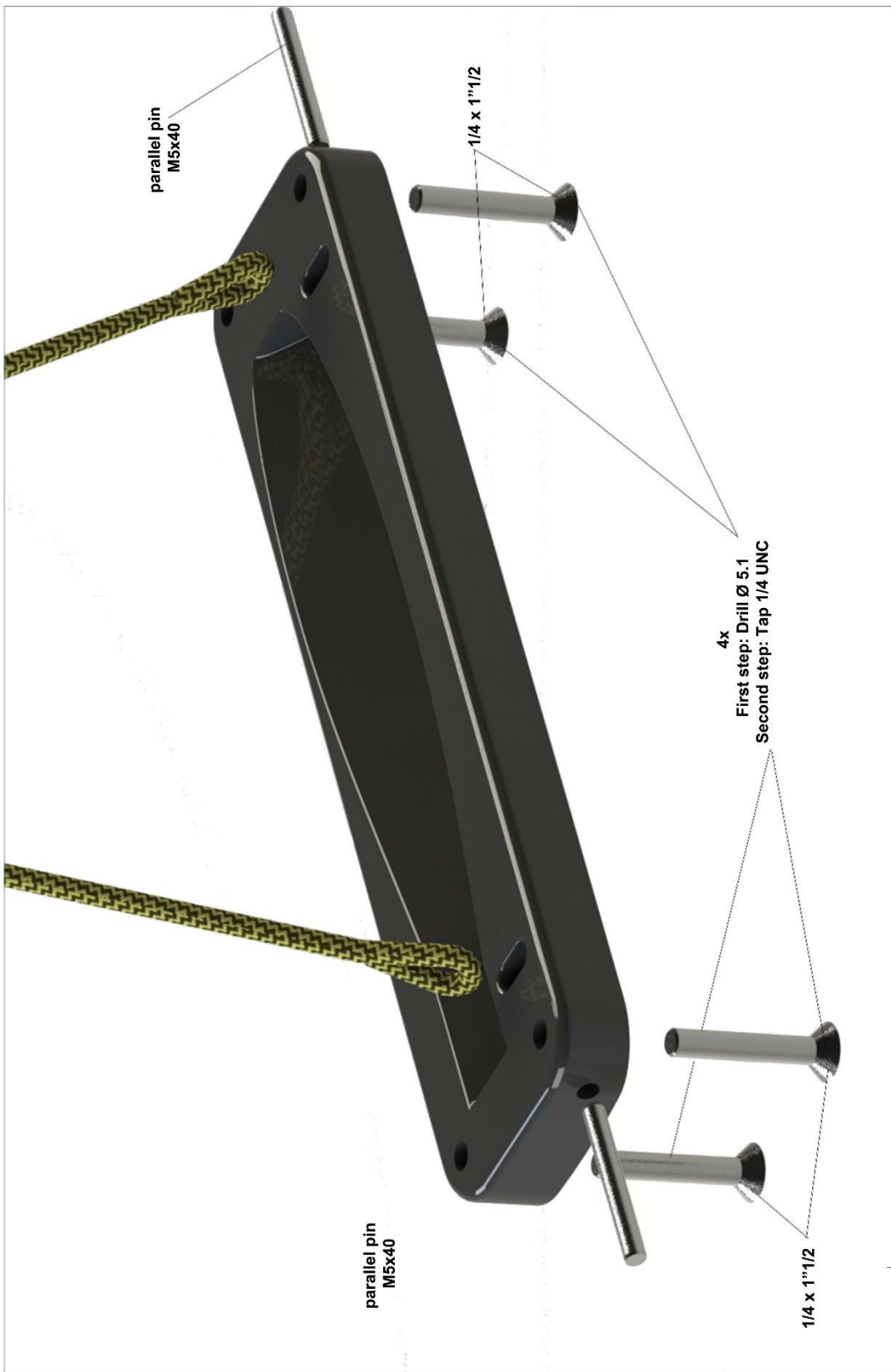
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	<small> J. den Boef M. Oord DATE: 06-06-2017 DWG 1.0 </small>	<small> bottom bearing </small>	<small> 1-XX A3 # of # </small>



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7. Deck bearing



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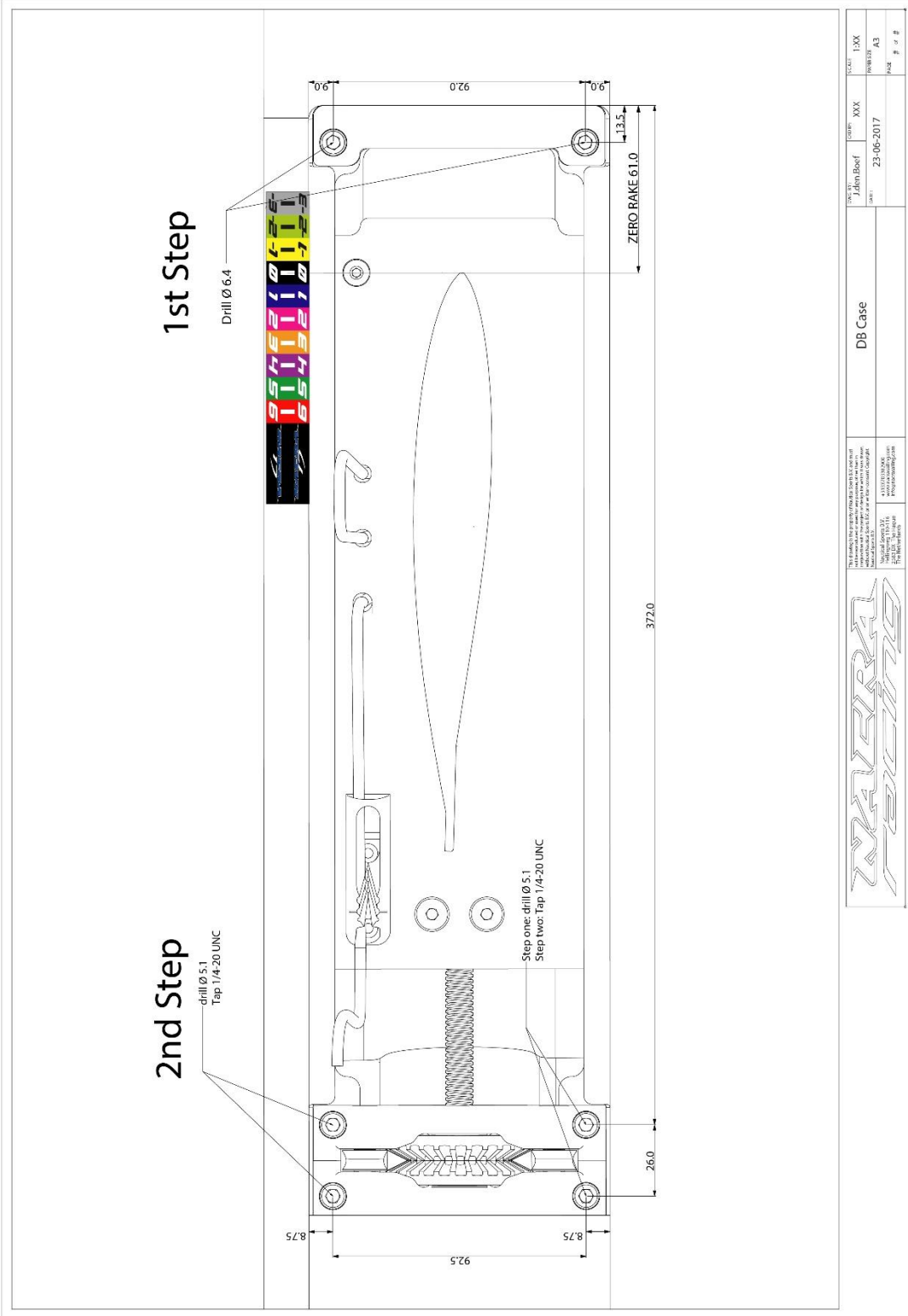
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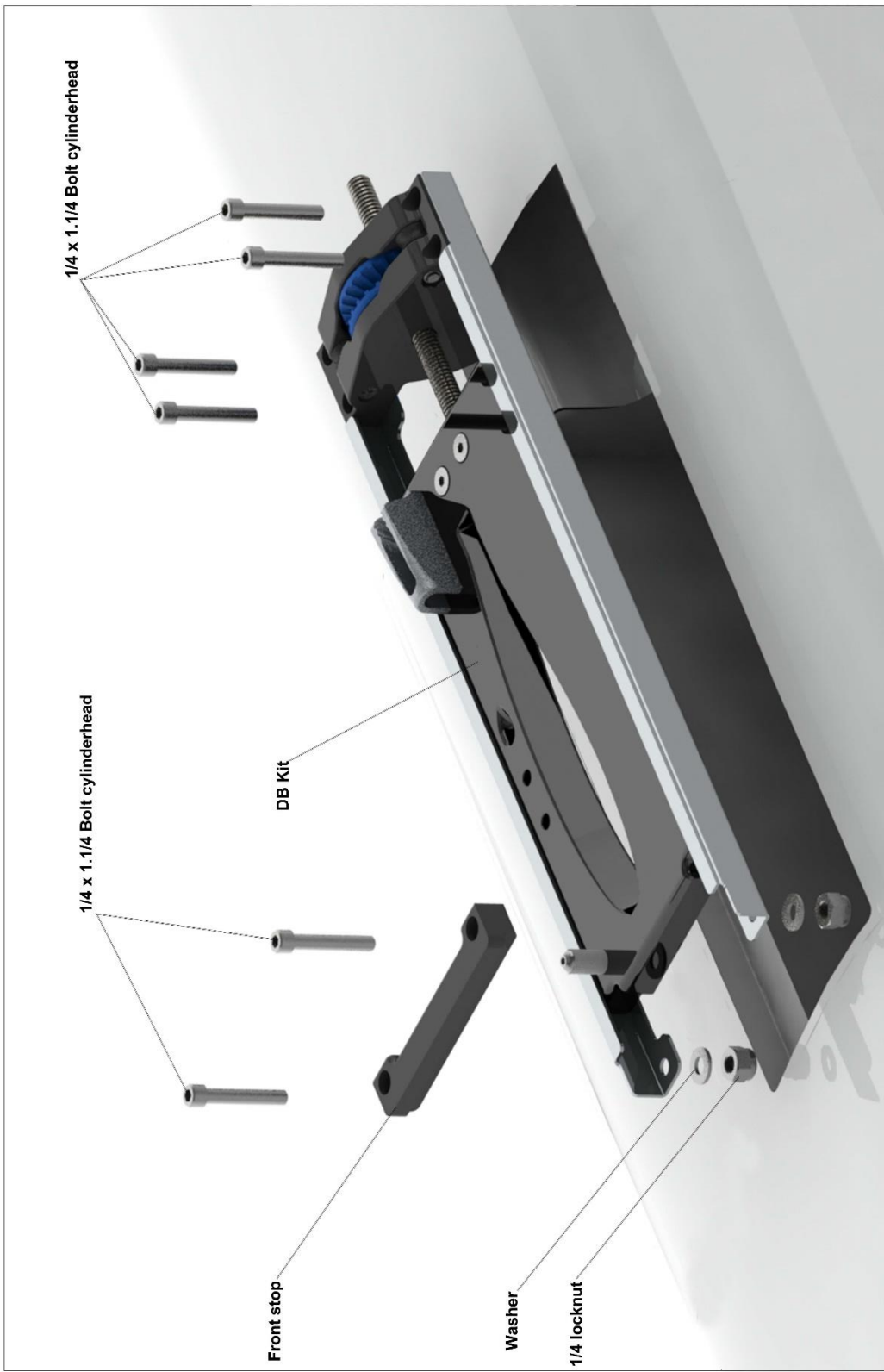
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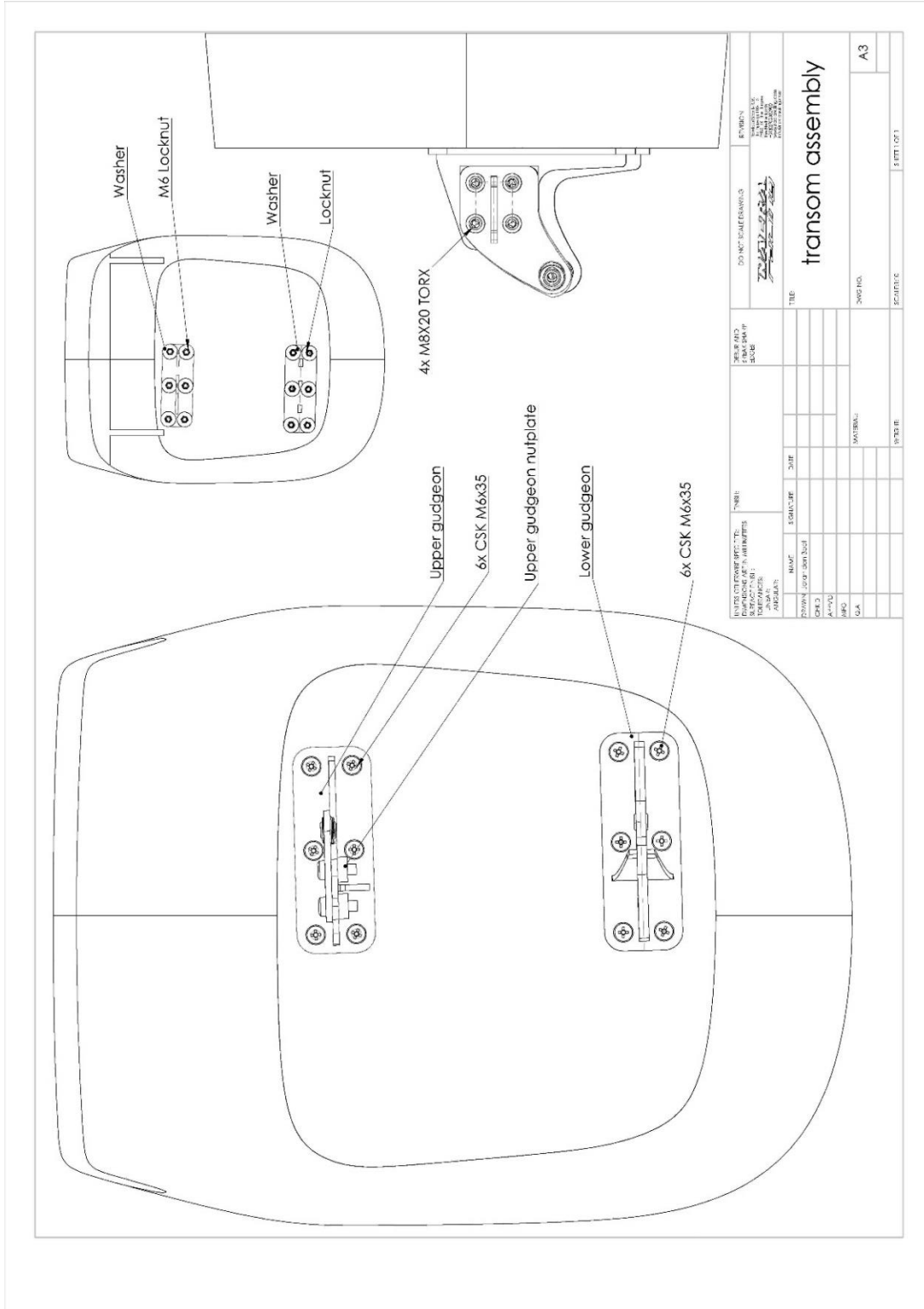
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<p>Deck bearing</p>		<p>Assembly</p>		



8. Transom Fit out



- Put Sikaflex or puraflex in between the gudgeons and the stern before mounting



- Set the M6 x 35 at 12Nm on the torque wrench

9. Rudderstock fit out





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The rudder will be pre-assembled when delivered



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10. Spi pole

11. Quality control check

#	Action	✓
1	12 ounc dacron reinforcement stiched in tramp!	
2	Stainless rings used in tramp!	
3	Nylon washers used under low strapeye front crossbar!	
4	Replaced the 2 screws in the traveller car!	
5	Insert in rear crossbar sits straight	
6	Nylon washer used under rivet for fixing the rear crossbar insert!	
7	bolt cylinderhead 1/4 x1.1/4 in front crossbar mounted with Nylock + Washer	
8	Sikaflex/Puraflex used under rudder gudgeons	
9	M6 bolts for gudgeon set at 12Nm	
10	M5 x20 & M5 lock nut & washer used for strapeye mounting for spipole	