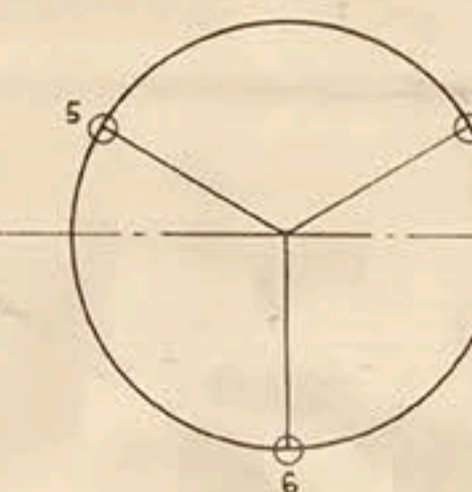


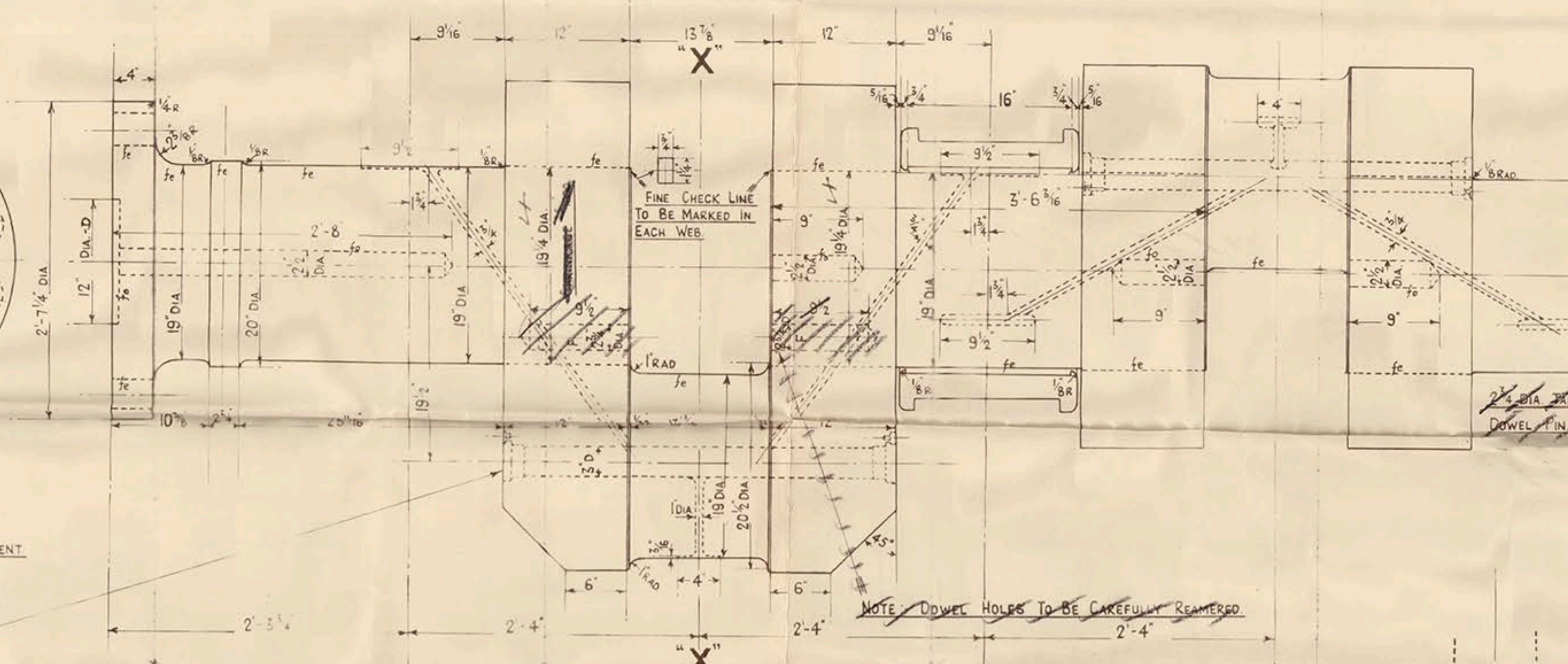
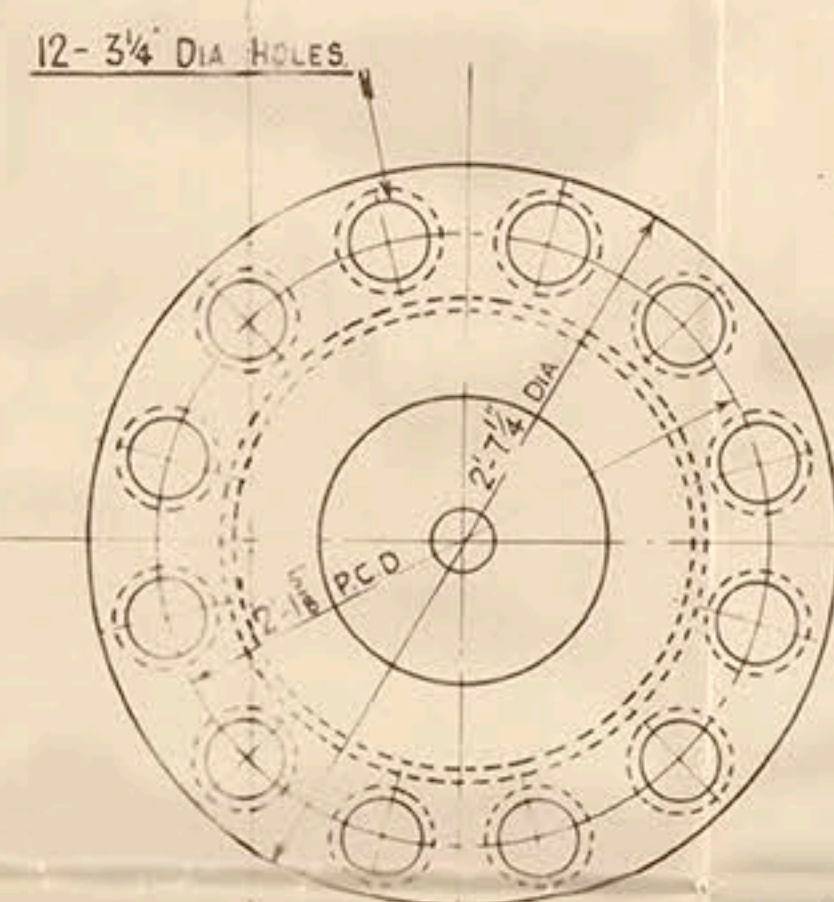
ARRANGEMENT OF MAIN CRANKSHAFT.

SCALE: 3/4" = 1 FOOT.



MACHINING REFERENCES	FIT REFERENCES
1. ROUGH.	1. CORRECT SIZE MACHINED TO GAUGE.
10. ORDINARY FINISH TO DIMENSIONS GIVEN.	2. EASY RUNNING FIT.
11. SMOOTH FINISH TO DIMENSIONS GIVEN.	3. GOOD RUNNING FIT.
12. SMOOTH FINISH TO EXACT DIMENSIONS GIVEN NO TOLERANCE.	4. VERY CLOSE RUNNING FIT.
13. GROUND JOINT.	5. PUSH FIT (BY HAND).
14. GROUND TO EXACT DIMENSIONS.	6. DRIVING FIT.
	7. PRESS FIT.
	8. (HYDRAULIC HEAVY HAMMER OR SHOCKING.)

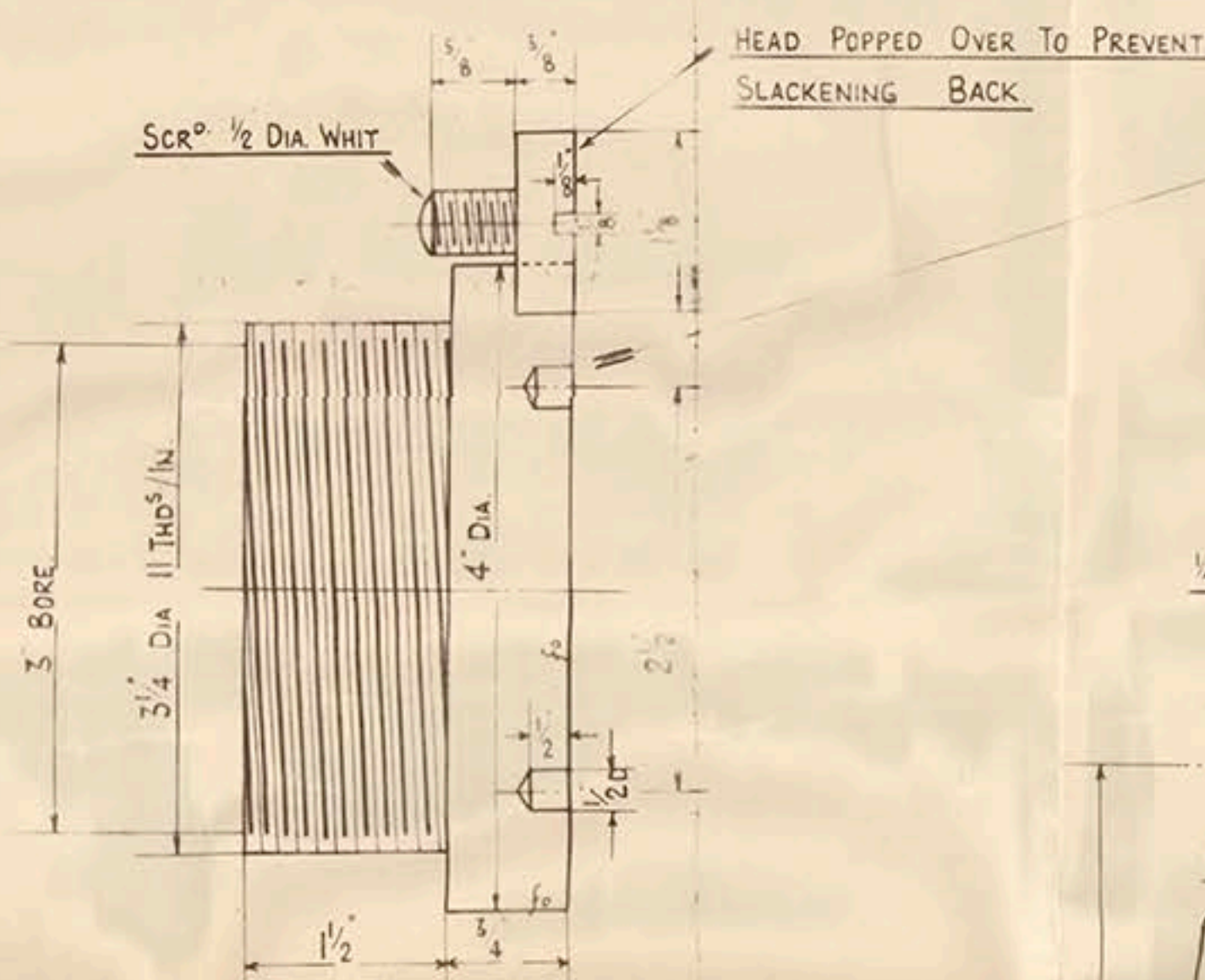
S.O. N° 4954 (603) 2-11-38.
NO DOWEL PINS TO BE FITTED.
SHRINKAGE ALLOWANCE ON 1 1/4" DIA.
= .001 MARK V
SHRINKAGE: .0018 TO .002 PER INCH OF DIAMETER.



DETAIL OF MAIN CRANKSHAFT

SCALE: 1 1/2" = 1 FOOT.

SECTION THRO "X" "X"



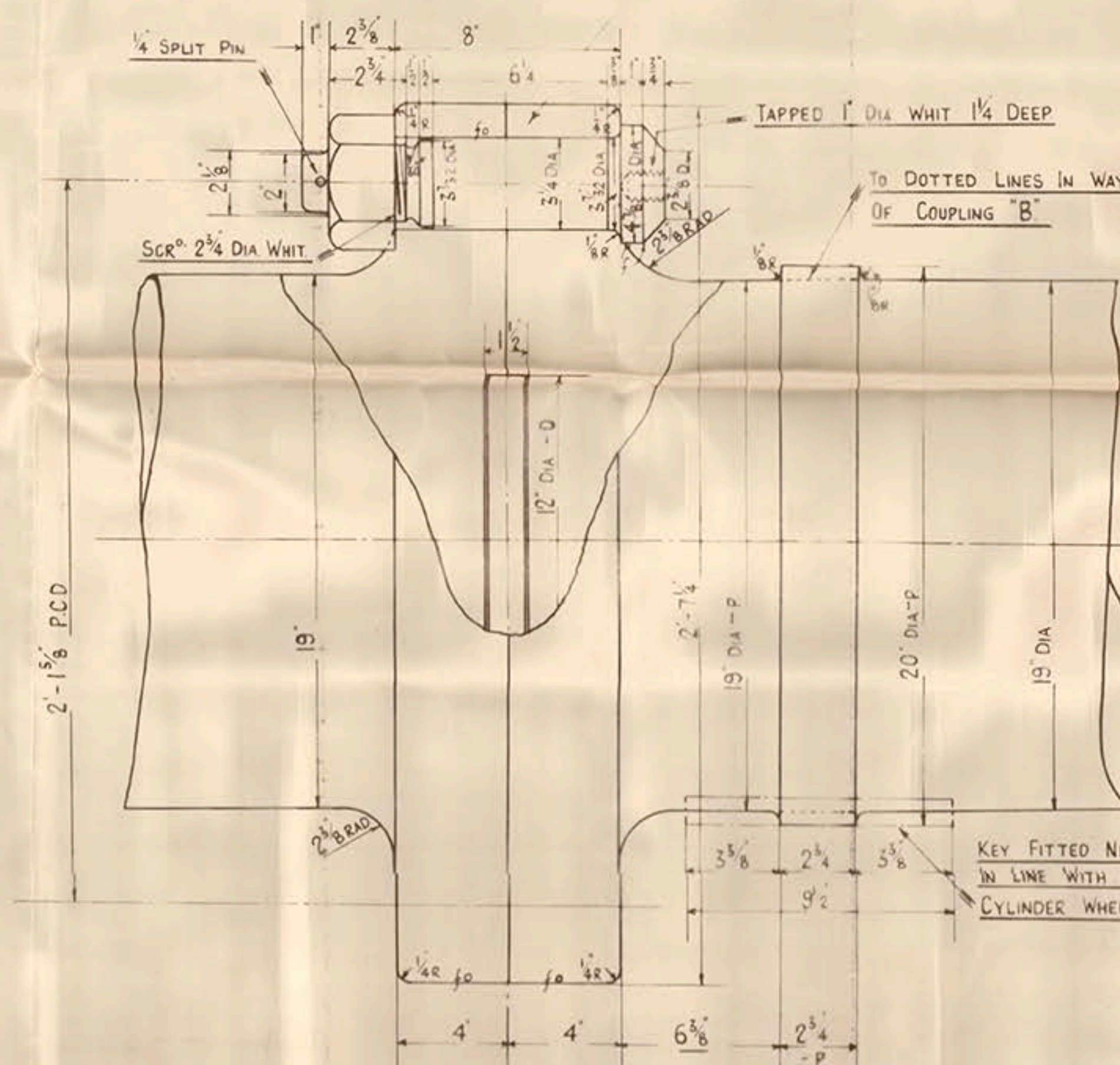
DETAIL OF PLUGS

SCALE: FULL SIZE



DETAIL OF KEY FOR VERT SHAFT SKEW WHEEL ON MAIN CRANKSHAFT

SCALE: 3" = 1 FOOT

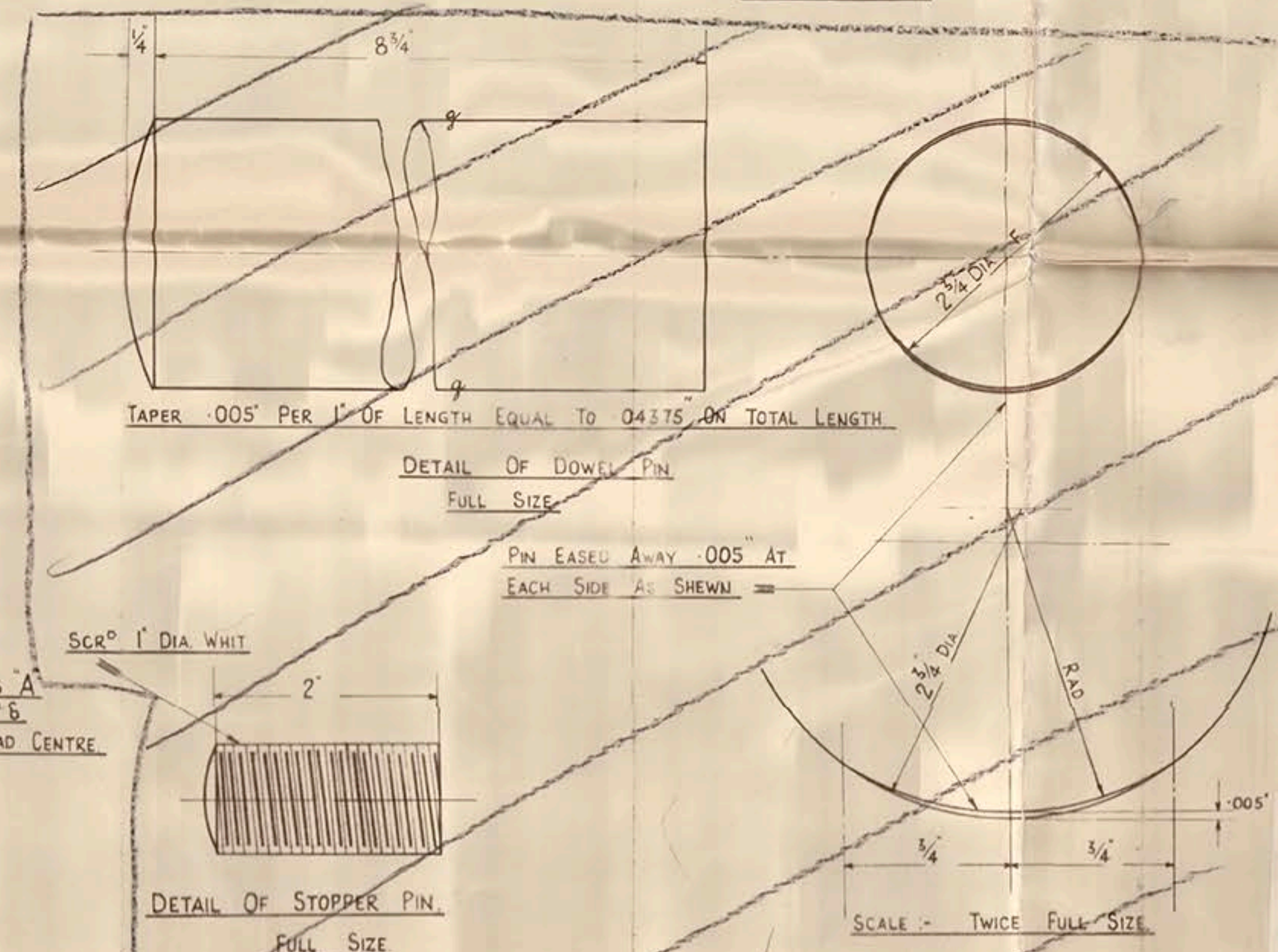


DETAIL OF COUPLINGS "A" & "B"

SCALE: 3" = 1 FOOT

DETAIL OF OIL GROOVES

SCALE: FULL SIZE



DETAIL OF DOWEL PIN

FULL SIZE

PIN EASED AWAY .005 AT EACH SIDE AS SHOWN

DETAIL OF STOPPER PIN

FULL SIZE

FAIRFIELD ENGINE WORKS
GOVAN, GLASGOW
CHECKED 29-10-38
TO 28
DEPARTMENT
PRINTED BY
C.P.O.S. 128-10-38
BOT
OFFICE
STORE
FINISHED

ONE SPARE HALF CRANKSHAFT
FINISHED COMPLETE
HOLES FOR COUPLING BOLTS
3/4" DIA TO JIG

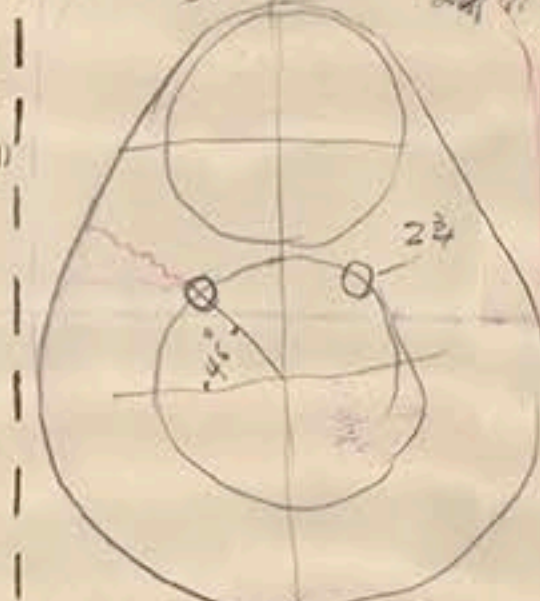
MATERIAL: FORGED INGOT STEEL
TENSILE STRENGTH 81-85 TONS/IN.²
ELONGATION 26%
AORANCE 1

ARRANGEMENT & DETAILS
OF MAIN CRANKSHAFT

S.O. N° 357-17-10-38

S.O. N° 4954 (603) 2-11-38

5 Thru bolts through web & this plan submitted with all details for full size shall after 28/10/38



Copy of plan approved 2/2/39 J.M.S. 16/2/39

ONE SPARE HALF CRANKSHAFT
FINISHED COMPLETE
HOLES FOR COUPLING BOLTS
3/4" DIA TO JIG

MATERIAL: FORGED INGOT STEEL
TENSILE STRENGTH 81-85 TONS/IN.²
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ARRANGEMENT & DETAILS
OF MAIN CRANKSHAFT