



**GENERAL NOTES**

Casting to be of Cast Steel - one off.  
 Casting to be Tested to Suit Lloyds latest requirements.  
 Casting to be Clean, Sound, and out of twist, and as free as possible from Blowholes.  
 Contractions or Defects in casting not to be made good by Patching, Burning or Electric Welding.  
 Test Pieces left on casting until after annealing and removed only in Overseers presence.  
 Correct form and section of casting to be taken from moulds which will be supplied by Vickers.  
 Small webs and Fillets to be fitted where considered necessary.  
 Drilling and machining to be done by Vickers. see also note below.  
 The Boss to be formed around shaft centre, remainder of casting to be formed to suit frame.  
 Sections on mould loft floor and as indicated on plan.  
 Fillets in way of ships frames and other angle connections, not to be more than 1/8" thick.  
 Machine to f.  
 The shaft tube is to be tested under a water pressure of 30 lbs. per sq. inch.  
 Rough Bore to be done by Makers of Casting.

**SHIP No 108**  
 CANADIAN VICKERS LIMITED, MONTREAL, P.Q.

**LOWER STERNFRAME AND CENTRE SHAFT BOSSING.**

SCALE 1/2" = 1 FOOT

**PLAN No 26**  
 6th Nov 1928 W. Grant

Lloyd's Register Foundation