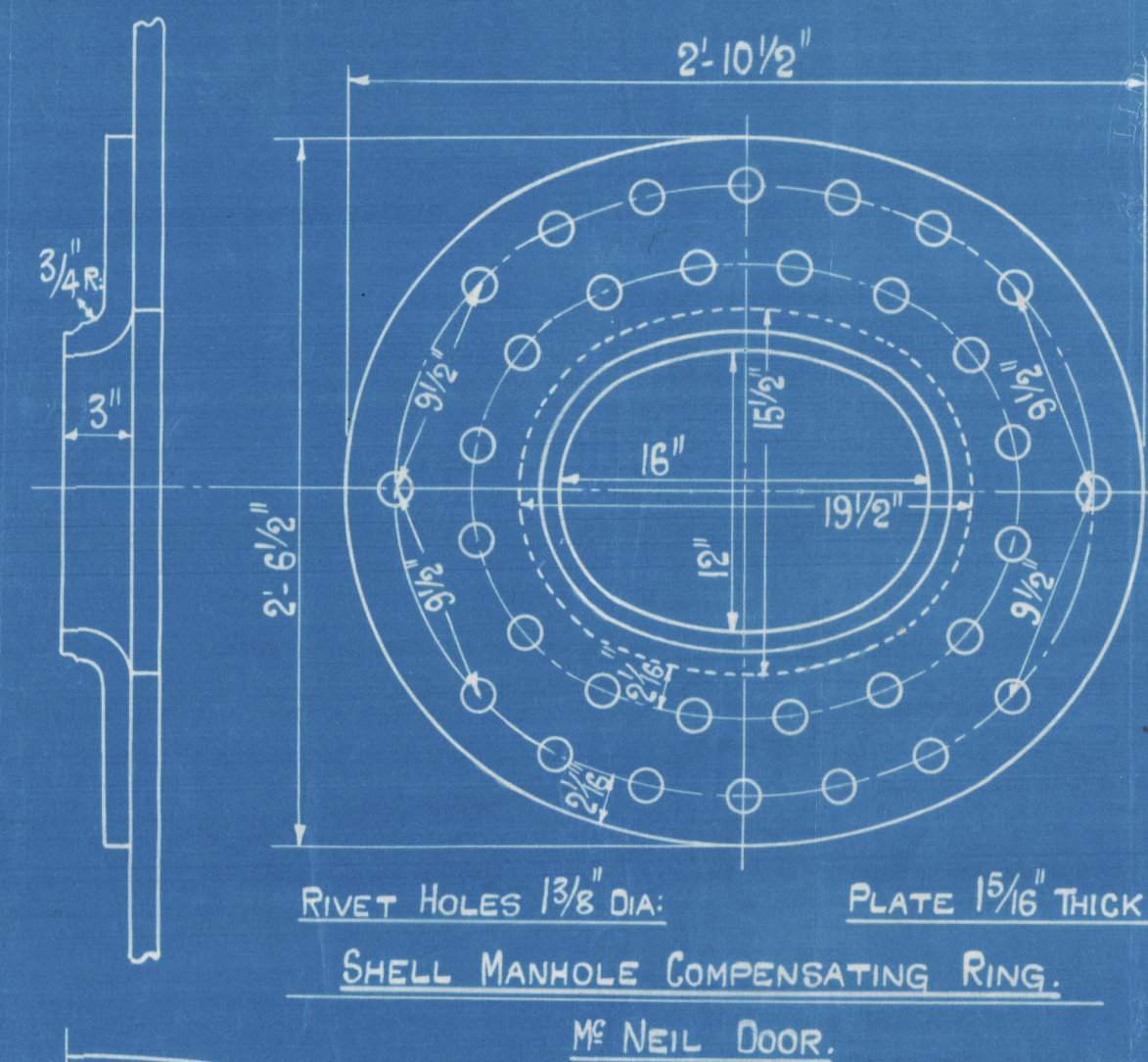
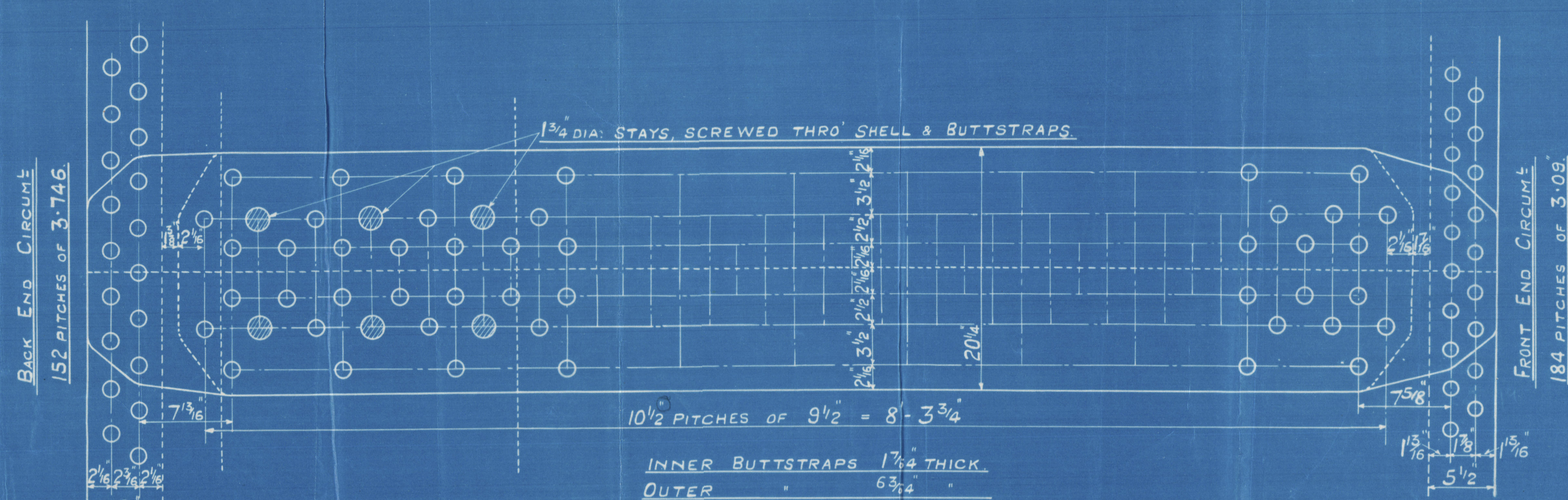


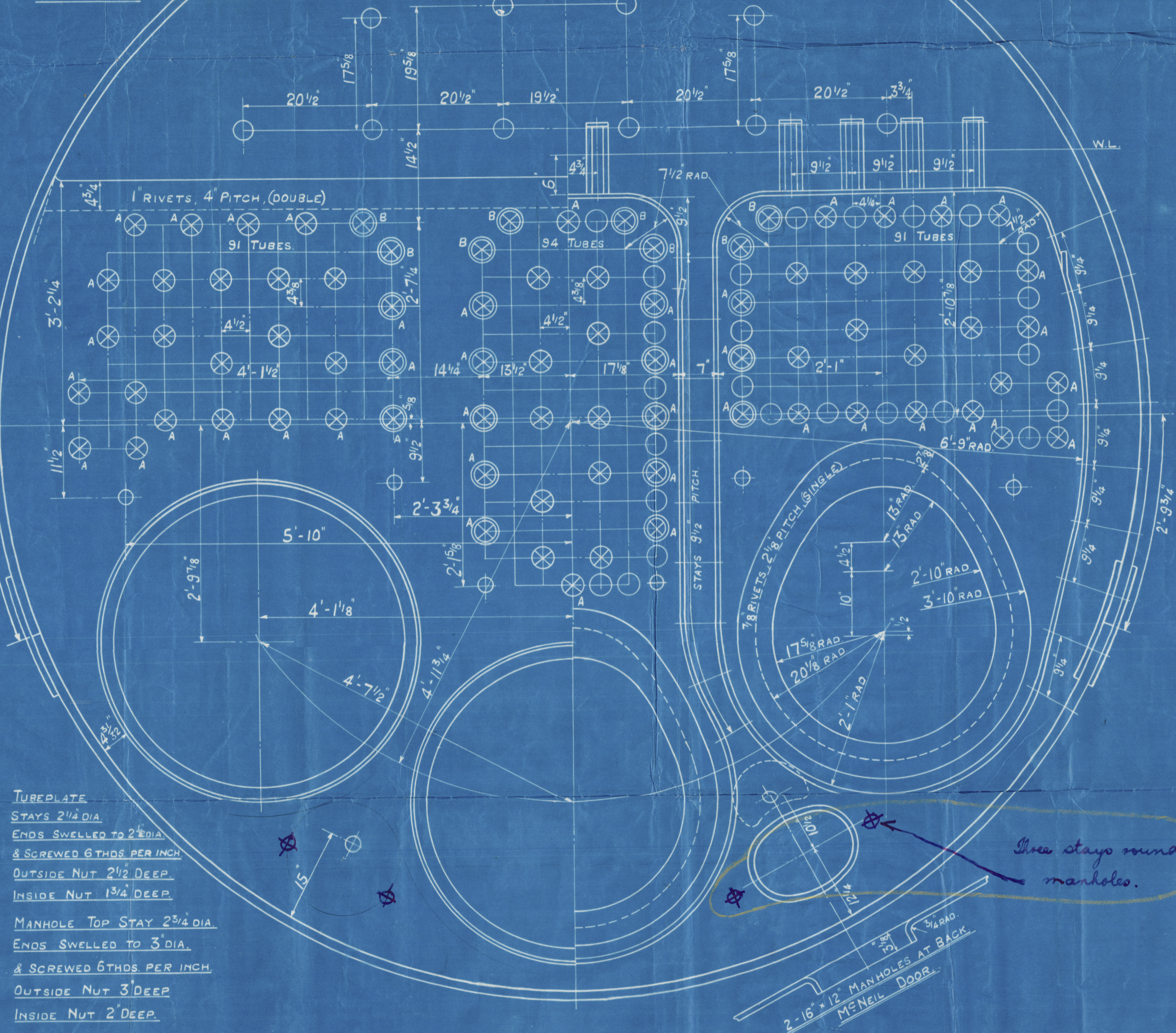
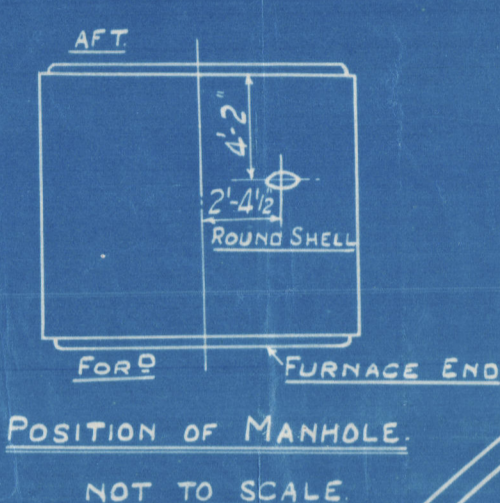
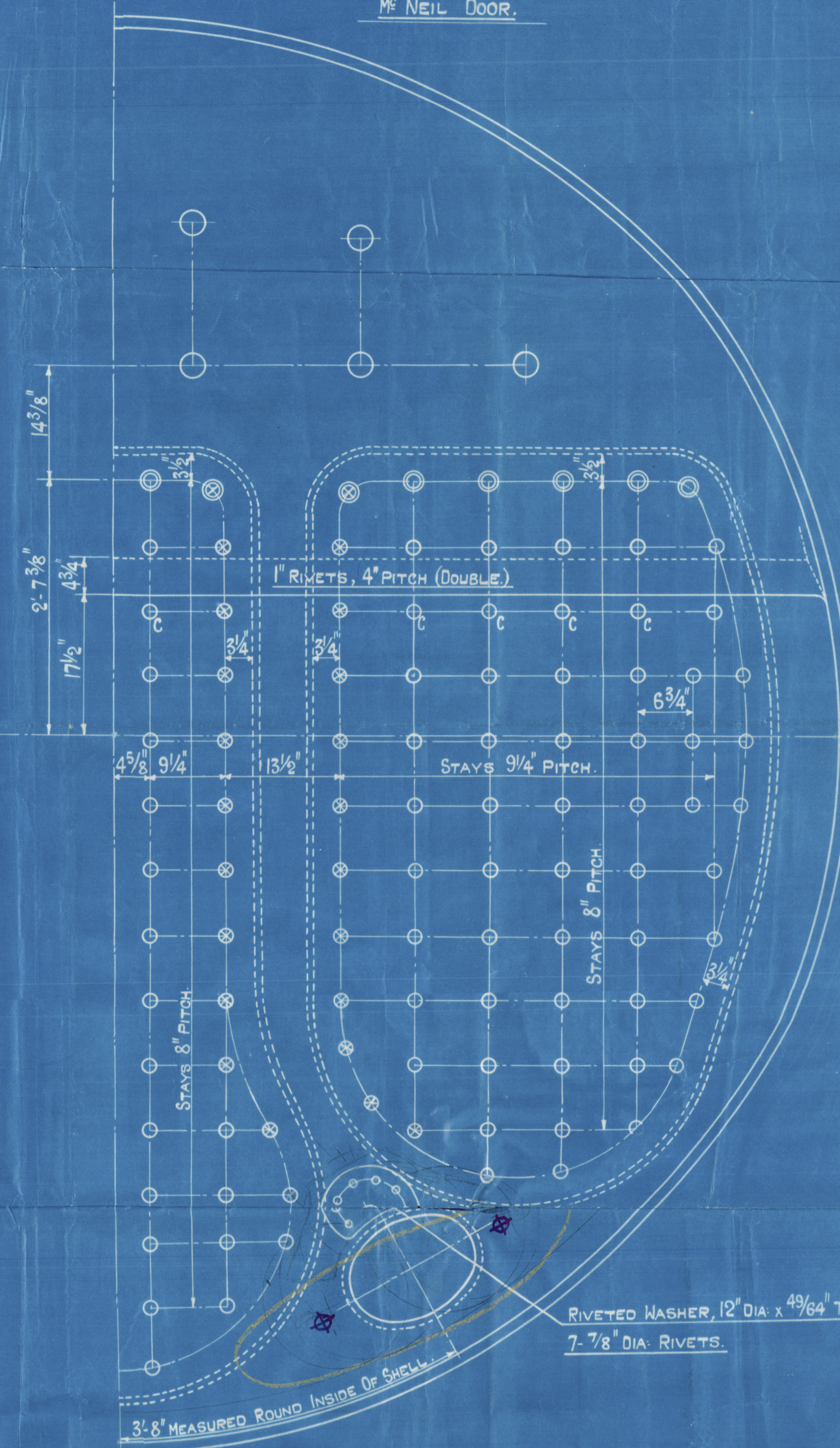
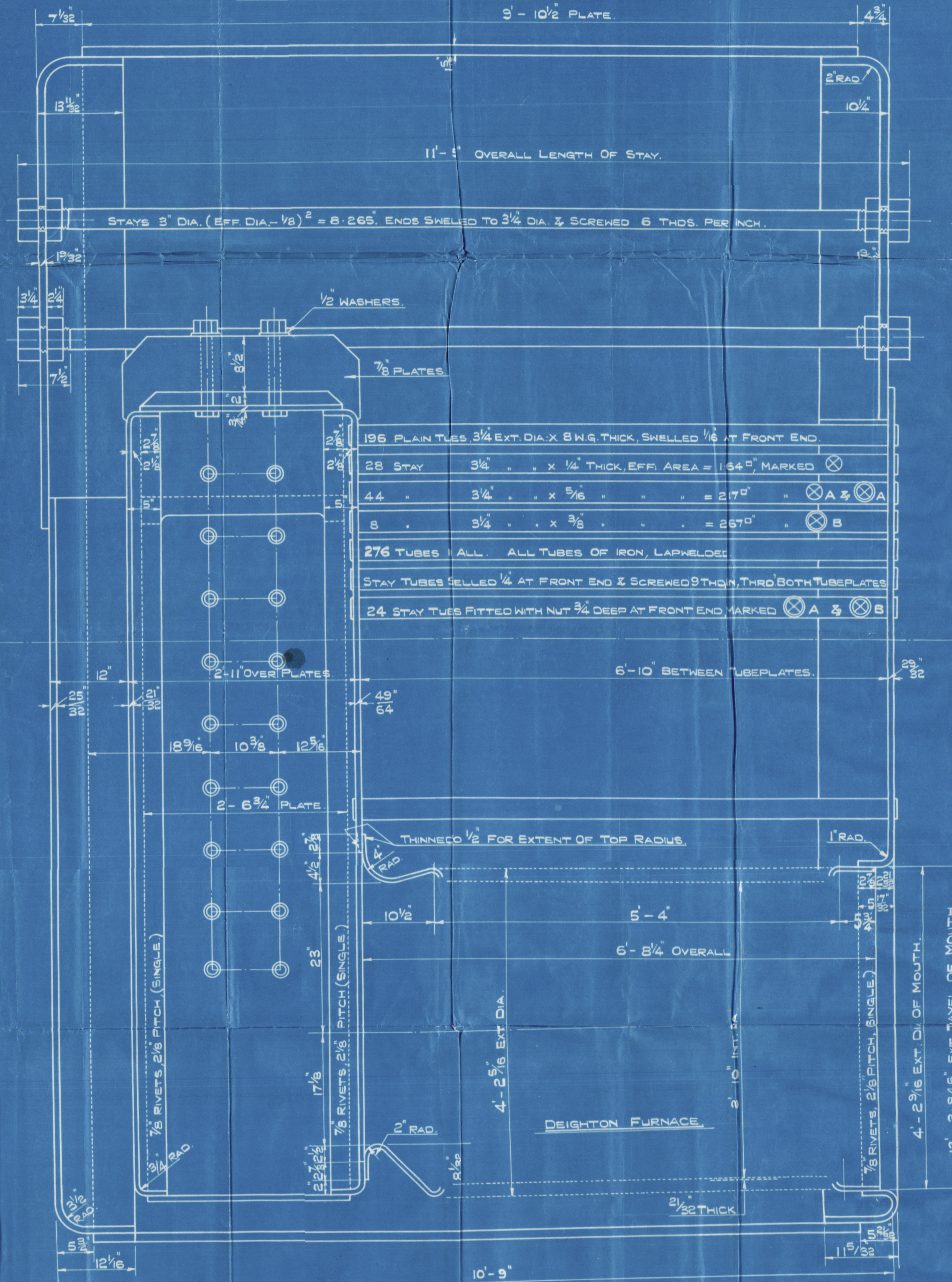
SURFACES	ONE BOILER
TUBES	1603
FIREBOX TOP AND SIDES	145
BACK	79
TUBEPLATE	51
FURNACES	143
TOTAL HEATING SURFACE	2021
GRATE AREA (5" O BARS)	57 1/2
TUBE AREA	12.25
WATER AREA	141
STEAM SPACE	404
GRATE AREA : HEATING SURFACE	1 : 35.1
STEAM SPACE : TUBE	1 : 27.87
STEAM SPACE : WATER	4.69 : 1
STEAM SPACE : STEAM SPACE	1 : 2.45
STEAM SPACE : WATER	1 : 7.02
% BOILER ABOVE FIREBOX	30.2
WEIGHT OF WATER	24 TONS

RIVETING	LONG	BACK END CIRC	FRONT END CIRC
RIVET HOLE DIA	1 3/8	1 3/8	1 3/8
PITCH	9 1/2	3.746	3.08
% PLATE	85.5	63.2	61.5
% RIVET	88.1	48	42.9
% COMBINED	88.7	-	-

LIMITS OF TENSILE STRENGTH & MATERIAL	
SHELL & BUTTSTRAPS	23 TO 33 TONS
GIRDERS	23 TO 33
OTHER PLATES	26 TO 30
FURNACES	26 TO 30
MAIN STAYS	28 TO 32
SCREWED STAYS	26 TO 30
RIVET BARS	26 TO 30

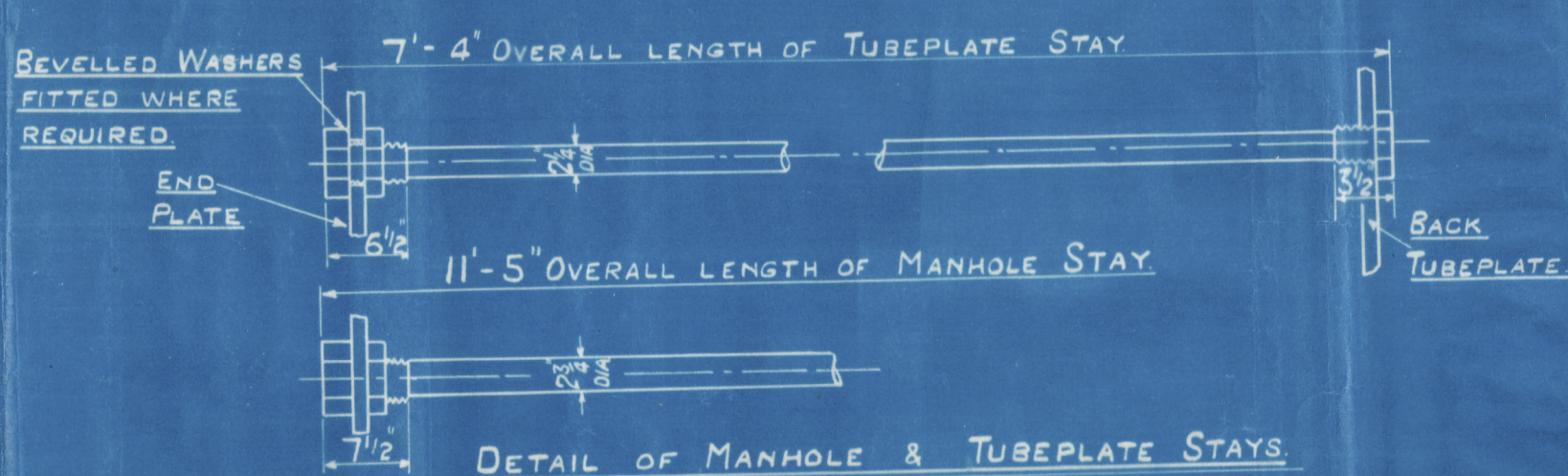


ALL RIVET HOLES DRILLED IN PLACE.
MAIN STAYS SWELLED AT ENDS BY
HYDRAULIC PRESSURE & ANNEALED.



TUBEPLATE
STAYS 2 1/4 DIA.
ENDS SWELLED TO 2 3/4 DIA.
& SCREWED 6 THDS PER INCH.
OUTSIDE NUT 2 1/2 DEEP.
INSIDE NUT 1 3/4 DEEP.

MANHOLE TOP STAY 2 3/4 DIA.
ENDS SWELLED TO 3 DIA.
& SCREWED 6 THDS PER INCH.
OUTSIDE NUT 3 DEEP.
INSIDE NUT 2 DEEP.



ALL FIREBOX STAYS SCREWED THRO' BOTH PLATES, & NUT FITTED AT EACH END EXCEPT STAYS FROM WING FIREBOX TO SHELL & STAYS MARKED 'C' IN BACK BOTTOM END, WHICH PROJECT 3/8 AND ARE CAULKED. ALL 1 7/8 & 2" NUTS, 1" DEEP EXCEPT ON GIRDER TOPS WHERE THE OUTSIDE NUTS ARE 1 7/8 DEEP. ALL 1 5/8 & 1 3/4 NUTS, 7/8 DEEP.

POSITION	MARK	DIA	(QA-267)	SCREWED THDS/INCH
BACK	○	1 5/8	1.844	9
" WIDE SPACE	⊗	1 3/4	2.199	9
" TOP ROW, TOP SIDES	⊙	1 7/8	2.585	9
" CORNER	⊗	2"	3.003	9

WDA 9/9/29.

330

WHEELAY, DUNN & CO. LTD.
2-SEP-1929
GLASGOW

MAIN BOILER N° AILSA 10.
15'-0" INT. DIA. x 10'-9" MEAN LENGTH TO PASS LLOYD'S SURVEY & REQUIREMENTS.
WORKING PRESSURE 200 LBS/D.
TEST 350 LBS/D.
1- OFF REQUIRED.

DATE	DRAWN BY	TRACED BY	CHECKED BY	ISSUE TO	MAN. BY
2nd Sep 1929	WDA	R.J. S.F.G.	WDA		

12/11/42-0048

Worth Aika No. 10.

By Barclay Curle & Co

for

Aika Shipbuilding Co.

Sp. No. 414

their Eng. No. 149.



No 18570.

LLOYD'S TEST

350 lb.

WP. 200. lb.

26-12-29 HS

GLASGOW REPORT No 50028

The Emperor

GLASGOW REPORT No 50170

W1142-0046



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Foundation