

NEWELL STANDARD LIMITS TO BE USED

NO OF PER ENGINE	DESCRIPTION	PATTERN NUMBER	MATERIAL	WT IN KGS	REMARKS	SHOP	SK NO OF JIG
1	LEFT-HAND CRANKSHAFT (FOR PART)	132200	SIEMENS-MARTIN STEEL	43071	MADE FROM PARTS AS ORDERED		
1	RIGHT HAND (FOR PART)	132201	SIEMENS-MARTIN STEEL	43071			
1	CRANKWEB	130472	SIEMENS-MARTIN STEEL	43543			
1	CRANK PIN	130462	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL	130463	SIEMENS-MARTIN STEEL	43071			
1	COUPLING END (AFT)	130464	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130465	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130466	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130467	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130468	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130469	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130470	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130471	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130472	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130473	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130474	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130475	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130476	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130477	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130478	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130479	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130480	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130481	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130482	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130483	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130484	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130485	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130486	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130487	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130488	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130489	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130490	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130491	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130492	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130493	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130494	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130495	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130496	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130497	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130498	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (FOR)	130499	SIEMENS-MARTIN STEEL	43071			
1	CRANK JOURNAL (AFT)	130500	SIEMENS-MARTIN STEEL	43071			

NOTE: BEFORE SHRINKING SHAFT DIA = 510 MM, HOLES DIA = 509.15 MM. EACH WEB TO BE HEATED ONCE ONLY PIN AND JOURNAL TO BE ENTERED SIMULTANEOUSLY. THE HEATING FOR SHRINKING SHOULD BE CARRIED OUT IN AN OVEN AND NOT ON A GASHEATER IN THE SHOP.

CRANKSHAFT TO BE MACHINED ALLOWER MATERIAL:- SIEMENS-MARTIN STEEL 28-32 TONS TENSILE & WEBS - ELONGATION 24-25% TENSILE STRESS & ELONGATION = 57 MINIMUM. THE YIELD POINT OF THE MATERIAL TO BE NOT LESS THAN 14 TONS/IN². SHRINKAGE ALLOWANCE IS 1/100 OF THE DIAMETER. TO THE SURVEY AUTHORITIES' REQUIREMENTS, TESTS & INSPECTION.

CRANK NO 1 LEFT Hb CRANKSHAFT. CRANK NO 8 RIGHT Hb CRANKSHAFT.

SCALE: 1:20

CODE NO 0421

D.A. 8⁶²⁰ 1400 2C.

CRANKSHAFT ASSEMBLY.

6/1/38

SCALE: 1:20

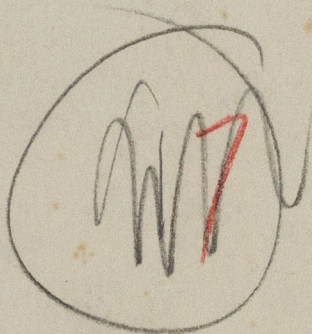
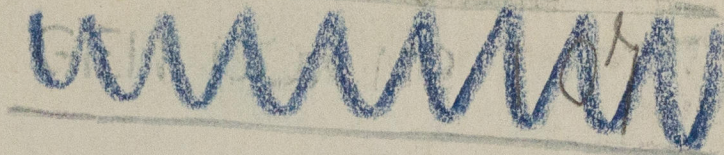
CODE NO 0421

Harland & Wolff Ltd.

Sup 1012/13

u Crankshaft Assembly

Rowallan Castle u



CRANKSHAFT ASSEMBLY

* ROWALLAN *

BEL. F. E. RPT. NC. 12335

ROWALLAN CASTLE

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