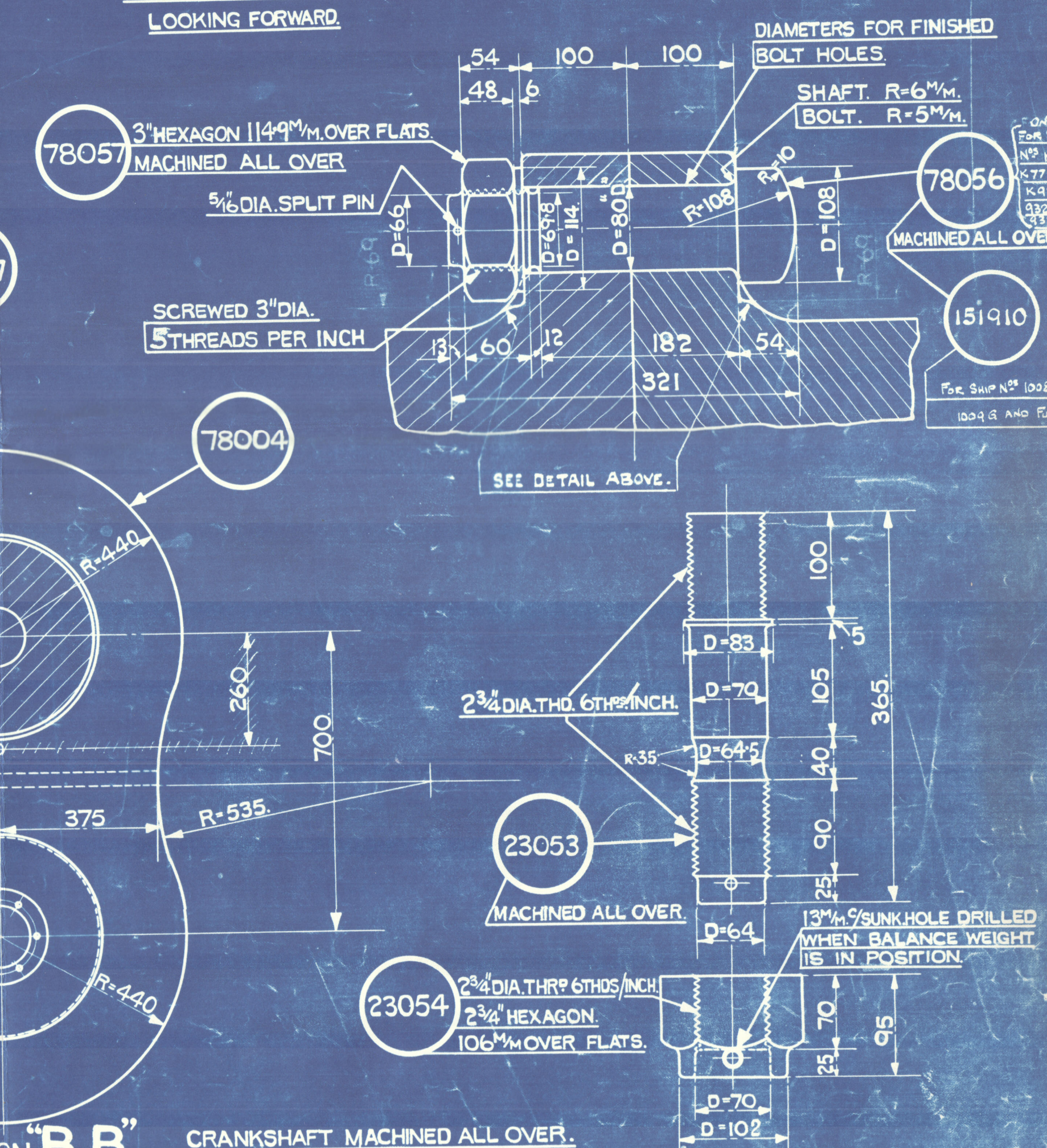
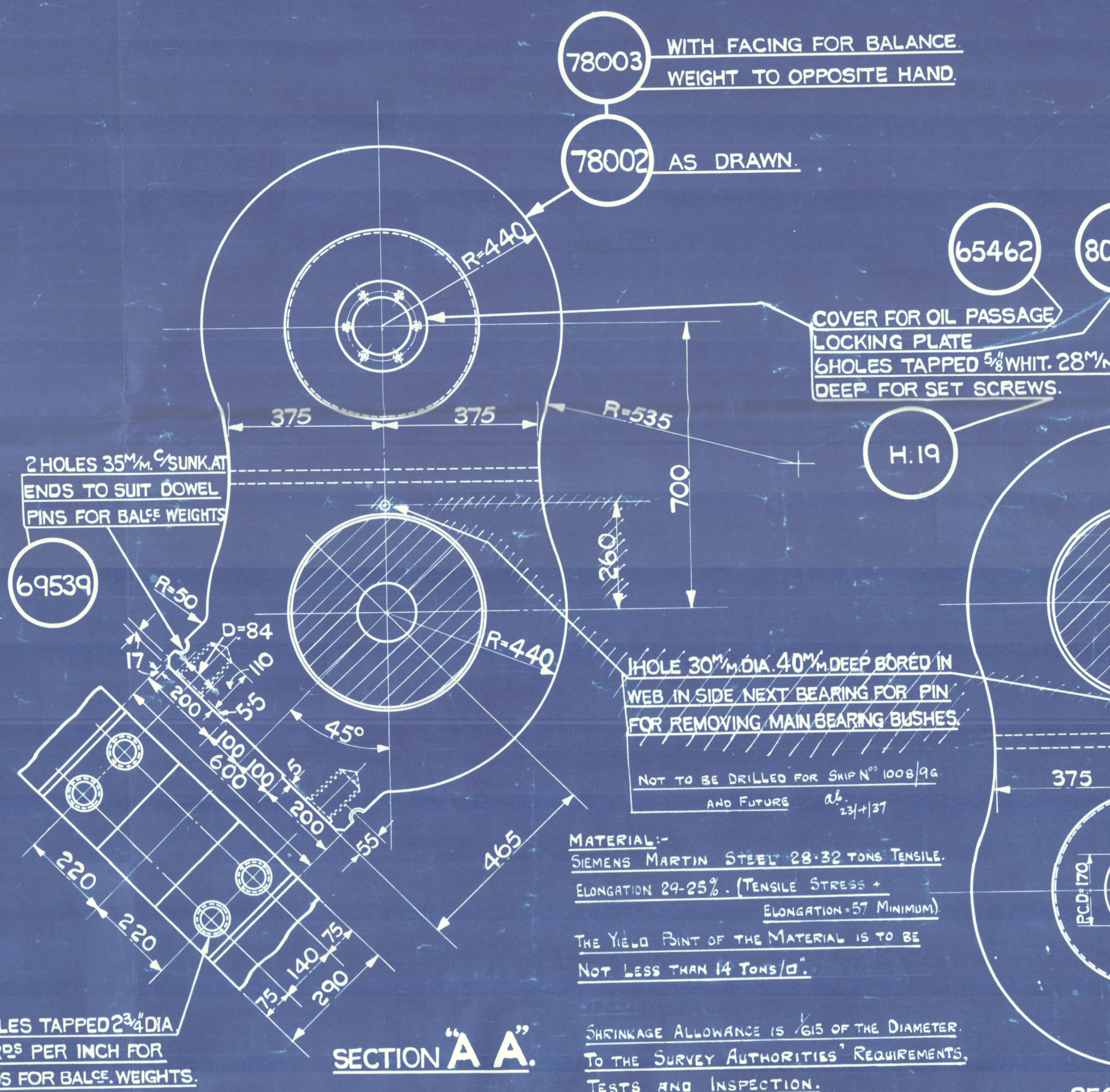


STARBOARD ENGINE.
LOOKING FORWARD.



MATERIAL:-
SIEMENS MARTIN STEEL 28-32 TONS TENSILE.
ELONGATION 24-25% (TENSILE STRESS +
ELONGATION-5% MINIMUM)
THE YIELD POINT OF THE MATERIAL IS TO BE
NOT LESS THAN 14 TONS/SQ."

SHRINKAGE ALLOWANCE IS $\frac{1}{615}$ OF THE DIAMETER
TO THE SURVEY AUTHORITIES' REQUIREMENT
TESTS AND INSPECTION.

SECTION "B.B." CRANKSHAFT MACHINED ALL OVER.
NEWALLS STANDARD LIMITS TO BE USED

NO OF PER ENG	DETAILS STANDARD WEIGHTS TO 100	PART NUMBER	MATERIAL	WEIGHT IN KGS	REMARKS	SHOP	SHEET NO OF JH
STARTS ENGINE							
1	CRANKSHAFT (FORD PART)	78000	STEEL	250.62	BUILT FROM PARTS AS ORDERED		
2	" (AFT)	78001	"	250.06	" " " " " "		
4	CRANKWEB WITH FACING FOR BAISF WGT	78002	"	1902			
4	" " " " " "	78003	"	1902			
8	" WITHOUT " " " "	78004	"	1820	SEE NOTE		
8	CRANKPIN.	78005	"	1064			
8	CRANK JOURNAL	78006	"	1156			
2	" WITH COUPLING	78007	"	1200	REGARDING		
1	" " " " " " (GAST)	78008	"	1194			
1	" " " " " " (GAST)	78009	"	1250	SHRINKING.		
16	DOWEL PIN.	69539	MILD STEEL	2.2	STD. DRG. NO 27766		
12	COUPLING BOLT. 28-32 TONS TENSILE	78056	FORGED STEEL	14	SEE NOTE 23107		
12	NUT FOR COUPLING BOLT	78057	WROT IRON	4			
34	COVER FOR OIL PASSAGE.	65462	CAST IRON	6	STD. DRG. NO 23107		
102	LOCKING PLATE.	80177	SOFT IRON	5	" " " " 23107		
204	2 1/2 SCREWS.	H.19	STEEL BAR	—	" " " " 23940		
16	1" GAS PLUG.	—	STEEL	—	STOCK		
12	3/16 DIA. SPLIT PIN	—	—	—	"		
32	STD. FOR BALANCE WEIGHT @ 28-32 TONS	23053	FORGED STEEL	11			
32	NUT.	23054	WROT IRON	4			
12	COUPLING BOLT	151910	3 1/2 NOVEL STEEL	14			

BEFORE SHRINKING.

SHAFT DIA. = 470^Mm.
HOLE = 469.25^Mm

EACH WEB TO BE HEATED ONCE ONLY.
PIN AND JOURNAL TO BE ENTERED SIMULTANEOUSLY.

BOLT HOLES TO BE ROUGH BORED FOR REAMING TO FINISHED DIAMETERS

BOLT HOLES FINISHED

78007

E

D=230

D=470 SEE NOTE

R-5

D=460

D=780

32

25

183

R-60

R-5

R-5

D=460

D=60

D=470 SEE NOTE

290

433

100

100

433

290

823

823

SECTION "E E."

CRANKSHAFT.

SCALES:-1:20,1:10&1:4

44415

G Glasgow

Harland & Wolff Ltd.

M.V. No 1014

Crank Shaft

GLASGOW REPORT No 60344

•CAIRNDALE•

Bel. 12305

RETAIN



© 2020

Lloyd's Register
Foundation