

# TENSILE STRENGTH OF MATERIALS.

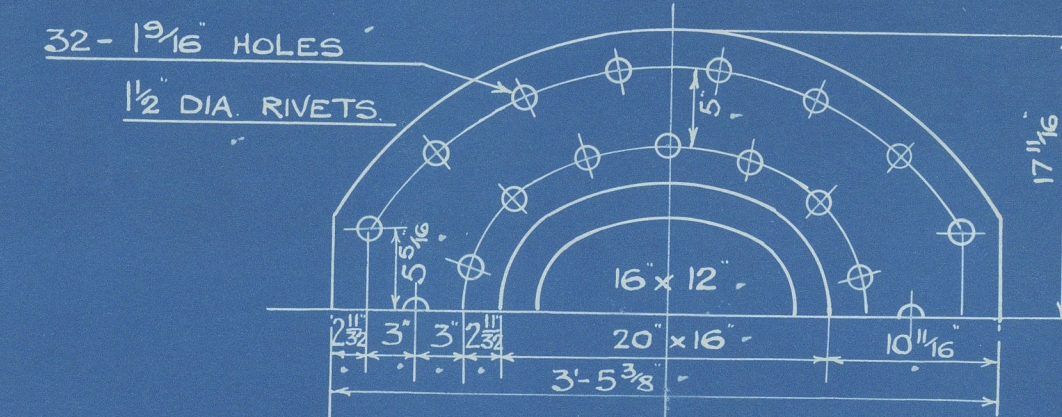
CYL <sup>R</sup> SHELL PLATES & BUTTSTRAPS	— 30 TO 34 TONS/0
GIRDER PLATES	— 28 TO 32
MANHOLE DOUBLINGS	— 27 TO 30
ALL OTHER PLATES & FURNACES	— 26 TO 30
LONG <sup>t</sup> STEEL STAYS	— 28 TO 32
SCREW STAY & RIVET BARS	— 26 TO 30

WORKING PRESSURE = 200 LBS. PER SQUARE INCH.

TEST = 350

ALL PLATES OF STEEL.  
ALL STAYS.  
RIVETS.  
ALL TUBES OF IRON.

SHELL BUTT ENDS  
ELECTRICALLY WELDED.



POSITION OF MANHOLE FIXED LATER.

CIRC<sup>t</sup> JOINT 1 1/8 HOLES 1 3/8 RIVETS 4.588 PITCH.  
(24 PITCHES) PLATE 68.25% RIVET 42.89%

INSIDE BUTTSTRAP SCARPHED TO  
CENTRE LINE OF INNER ROW OF RIVETS.

OUTER BUTTSTRAP 3/32 THICK

INNER 1 3/32

6 - 1 5/8 DIA STAYS SCREWED  
THRO<sup>t</sup> LOWER STRAPS & SHELL.

LONG<sup>t</sup> JOINT 1 3/16 DIA HOLES 1 1/4 DIA RIVETS 5" PITCH.

HYDRAULIC MACHINE RIVETING.

ALL HOLES DRILLED IN PLACE.

PLATE = 85.41%

RIVET = 84.33%

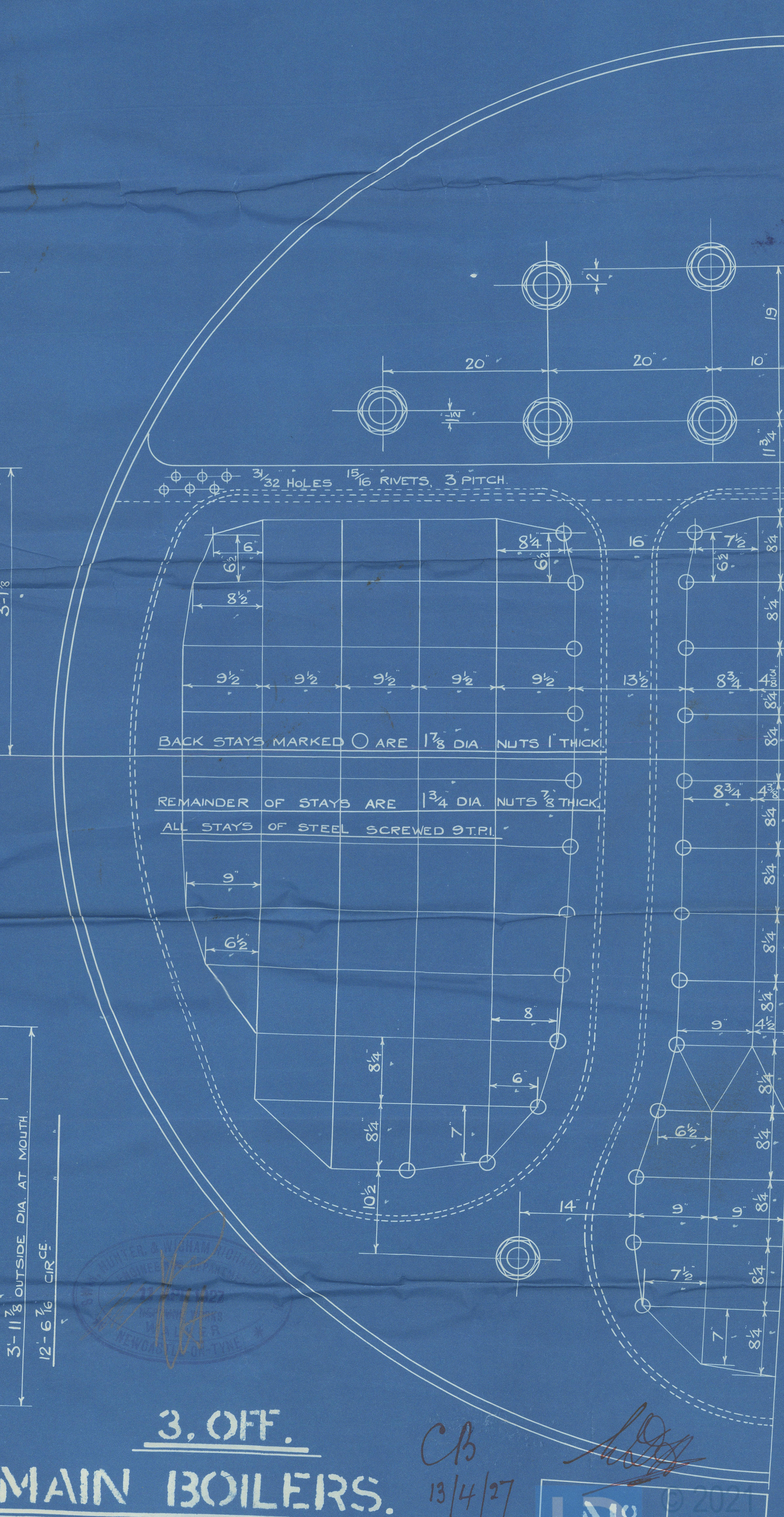
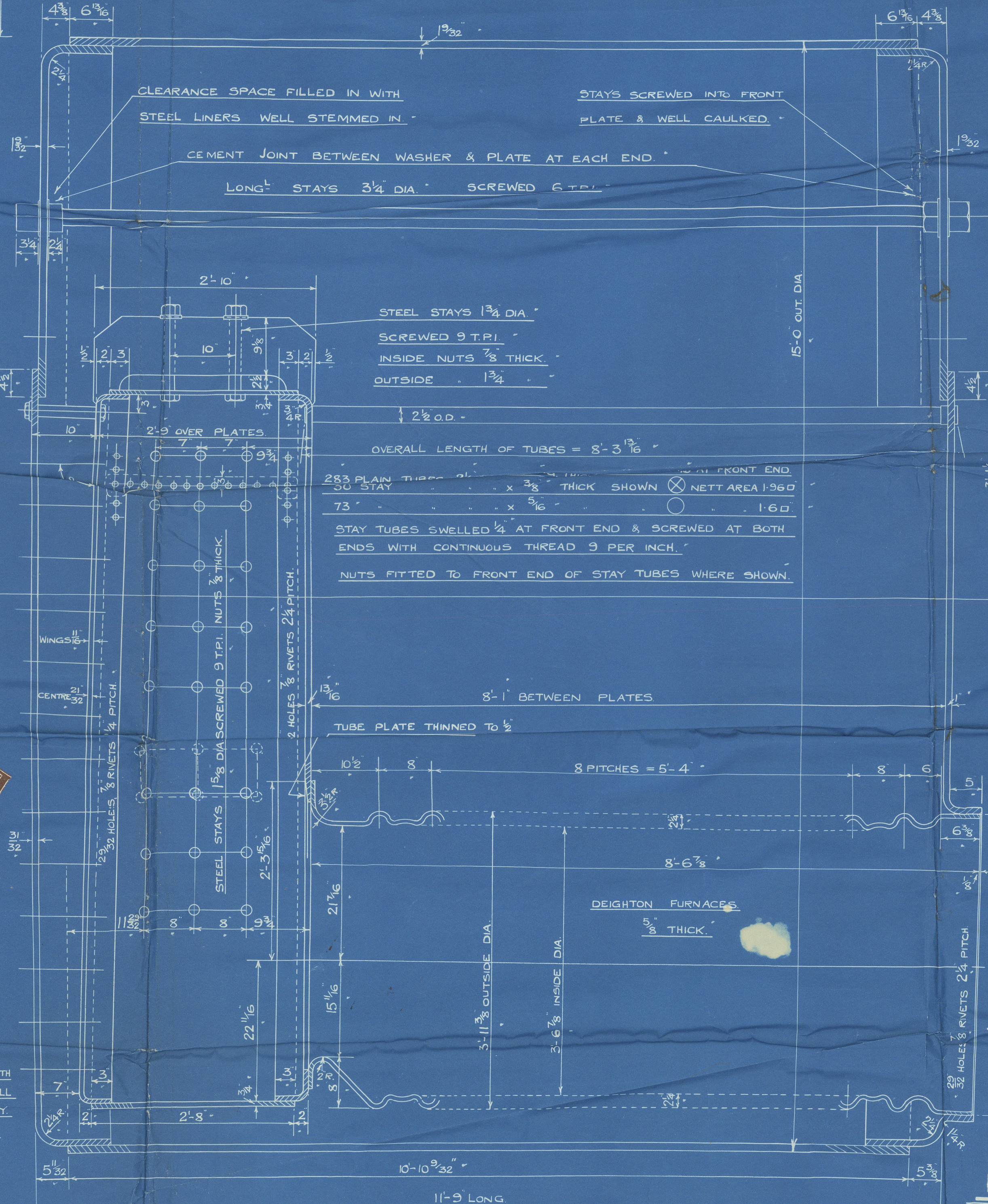
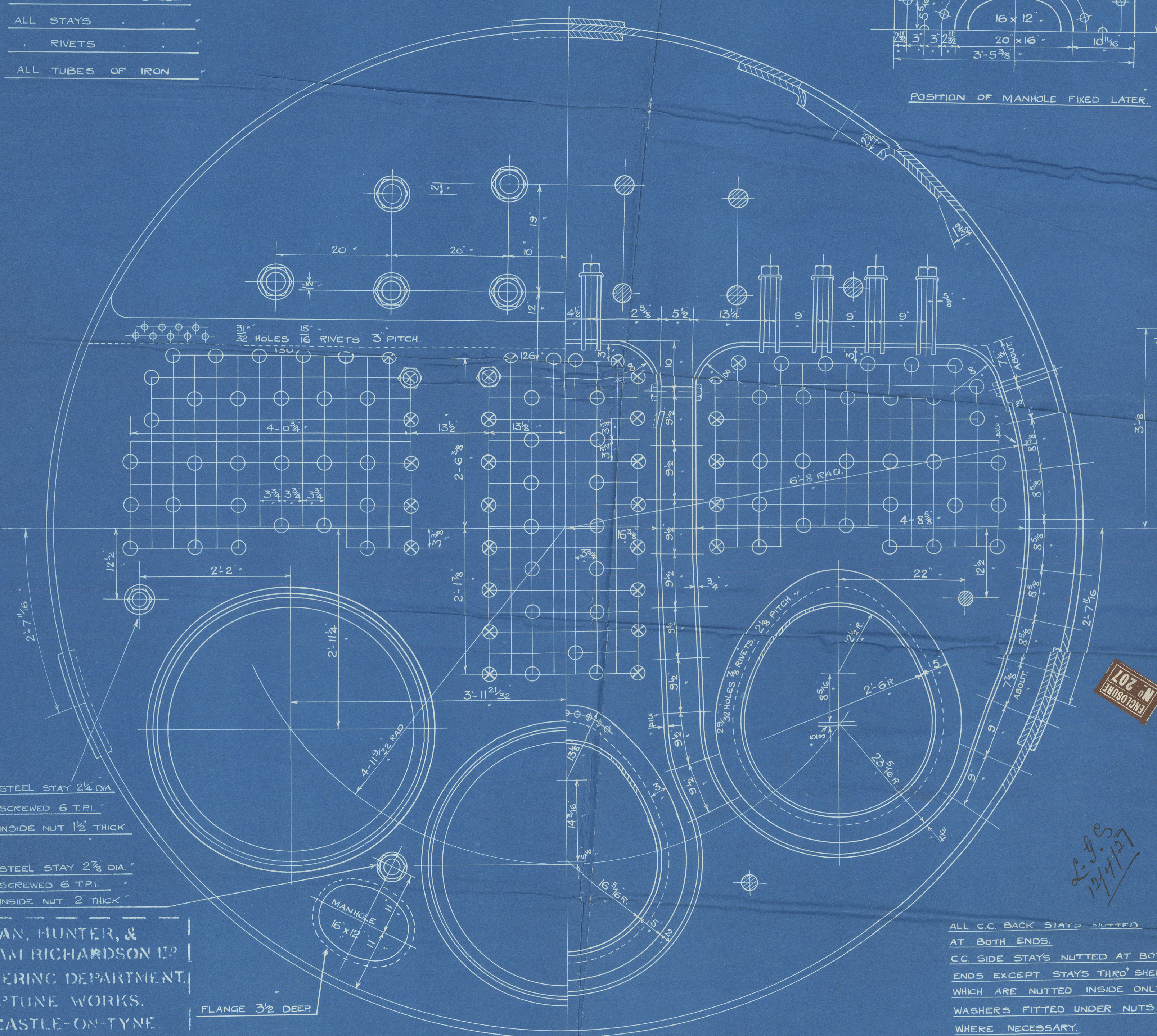
COMBINED = 87.69%

TOTAL HEATING SURFACE (3 BOILERS) = 7410

TOTAL GRATE ( ) = 180

FIRE BARS 5'-6" LONG.

TO LLOYDS SURVEY.



SWAN, HUNTER, &  
WIGHAM RICHARDSON LTD  
ENGINEERING DEPARTMENT  
NEPTUNE WORKS.  
NEWCASTLE-ON-TYNE.

DATE

B.554.

NO 8 AD

MA

ALL C.C. BACK STAYS NUTTED  
AT BOTH ENDS.  
C.C. SIDE STAYS NUTTED AT BOTH  
ENDS EXCEPT STAYS THRO<sup>t</sup> SHELL  
WHICH ARE NUTTED INSIDE ONLY.  
WASHERS FITTED UNDER NUTS  
WHERE NECESSARY.

3. OFF.  
MAIN BOILERS.

SCALE 1" = 1 FOOT

1246  
DATE  
11/4/27

1117-0092



Swan Hunter Lighthouse Richardson Ltd

3 main Boilers 1246, scanning similar to 1232 + capt for length  
Submitted to London

12/4/27

approved 13/4/27

St R.N. advised 14/4/27

S. S. PRYUS.

NEWCASTLE ON TYNE.

Report No. 81896.

XL117-0092



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Foundation