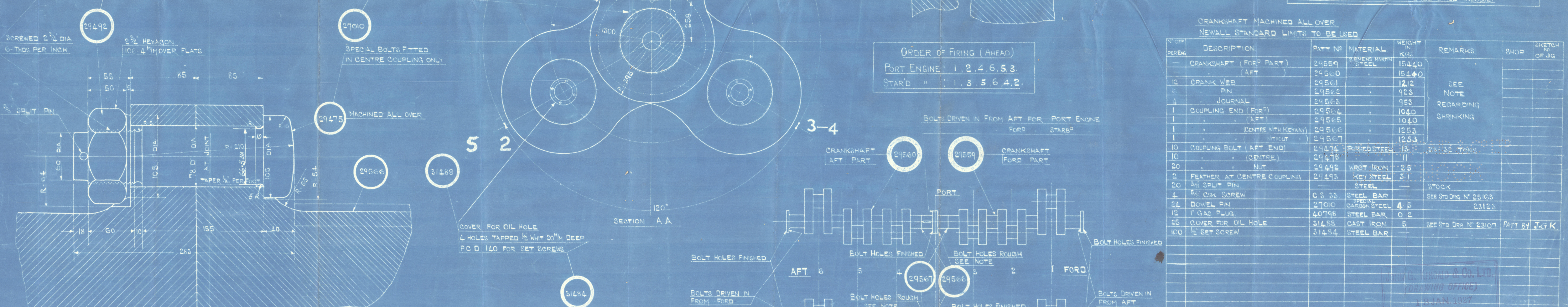
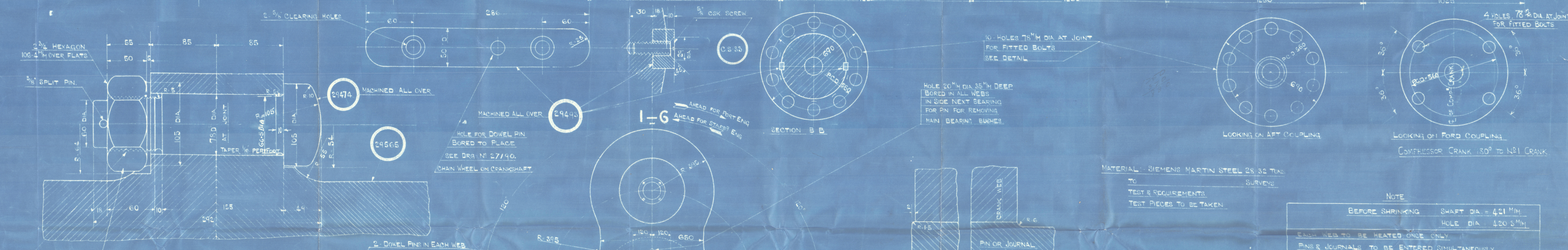
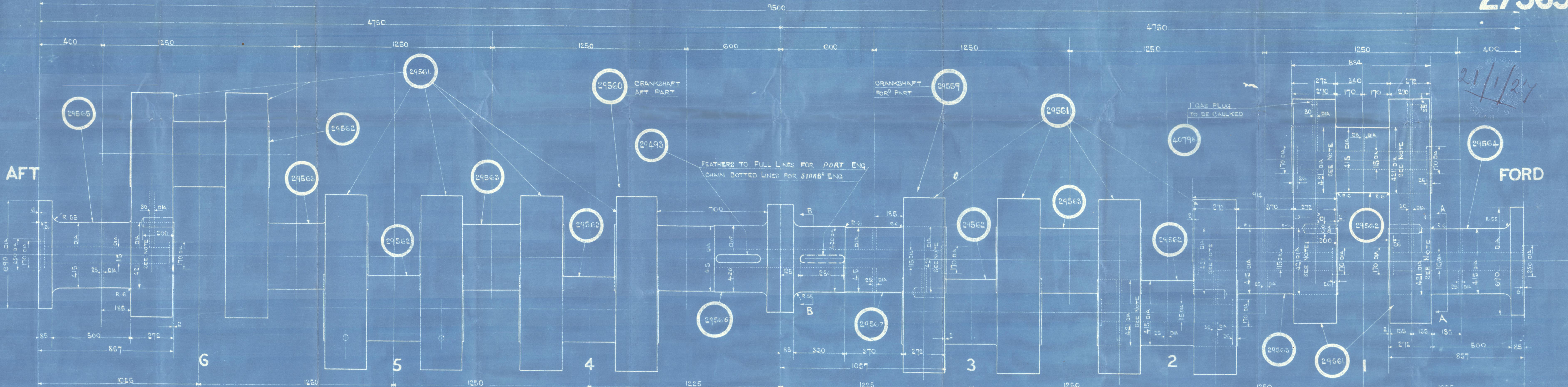


AFT

FORD



ORDER OF FIRING (AHEAD)
 PORT ENGINE: 1, 2, 4, 6, 5, 3
 STARBOARD: 1, 3, 5, 6, 4, 2

MATERIAL: SIEMENS MARTIN STEEL 28, 32 TON
 TO TEST & REQUIREMENTS
 TEST PIECES TO BE TAKEN

NOTE

BEFORE SHRINKING	SHAFT DIA = 421 MM
	HOLE DIA = 120.5 MM
EACH NEED TO BE HEATED ONCE ONLY	
PINS & JOURNALS TO BE ENTERED SIMULTANEOUSLY	

CRANKSHAFT MACHINED ALL OVER
 NEWELL STANDARD LIMITS TO BE USED

NO OF PERCENT	DESCRIPTION	PART NO	MATERIAL	WEIGHT KGS	REMARKS	SHOP	SKETCH NO OF JIG
—	CRANKSHAFT (FORD PART)	29559	SIEMENS MARTIN STEEL	15440			
—	CRANKSHAFT (AFT)	29560		15440			
12	CRANK WEB	29561		1212			
6	PIN	29562		923			
1	JOURNAL	29563		953			
1	COUPLING END (FOR?)	29564		1040			
1	(AFT)	29565		1040			
1	(CENTRE WITH KEYWAY)	29566		1253			
1	(WITHOUT)	29567		1253			
10	COUPLING BOLT (AFT END)	29474	FORGED STEEL	13	28, 32 TON		
10	(CENTRE)	29475		11			
20	NUT	29492	WROG IRON	2.5			
2	FEATHER AT CENTRE COUPLING	29493	KEY/STEEL	3.1			
20	3/8 SPLIT PIN				STOCK		
4	5/8 C/SK SCREW	C/S 33	STEEL BAR		SEE STD DRG N° 25163		
24	DOWEL PIN	27010	CARBON STEEL	4.5	23123		
12	1 GAS PLUG	40796	STEEL BAR	0.2			
25	COVER FOR OIL HOLE	31458	CAST IRON	5	SEE STD DRG N° 23107		
100	1/2 SET SCREW	31454	STEEL BAR				

S.A. 630 1300
 CRANKSHAFT.

SCALE: 1:50, 1:10, 1:2

J. Goring
 16/3/26

6 Crankshaft 1300 mm, 1350 mm
 Rev. 1.0. on 14/1/27

Kincaid R. 21
Shifting Crane

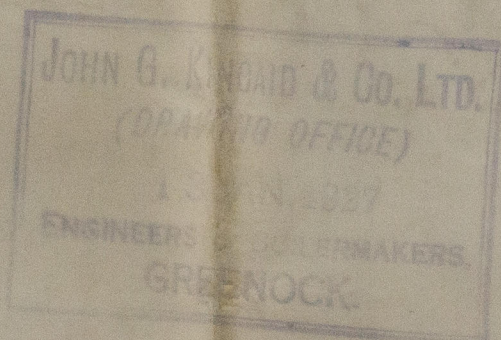
(K. 21) "ATHELQUEEN"

Mdb 13193

Greenock Report No. 18495.



S.S. *Athelqueen*
MDB. RPT. No. 13193



RETAIN



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