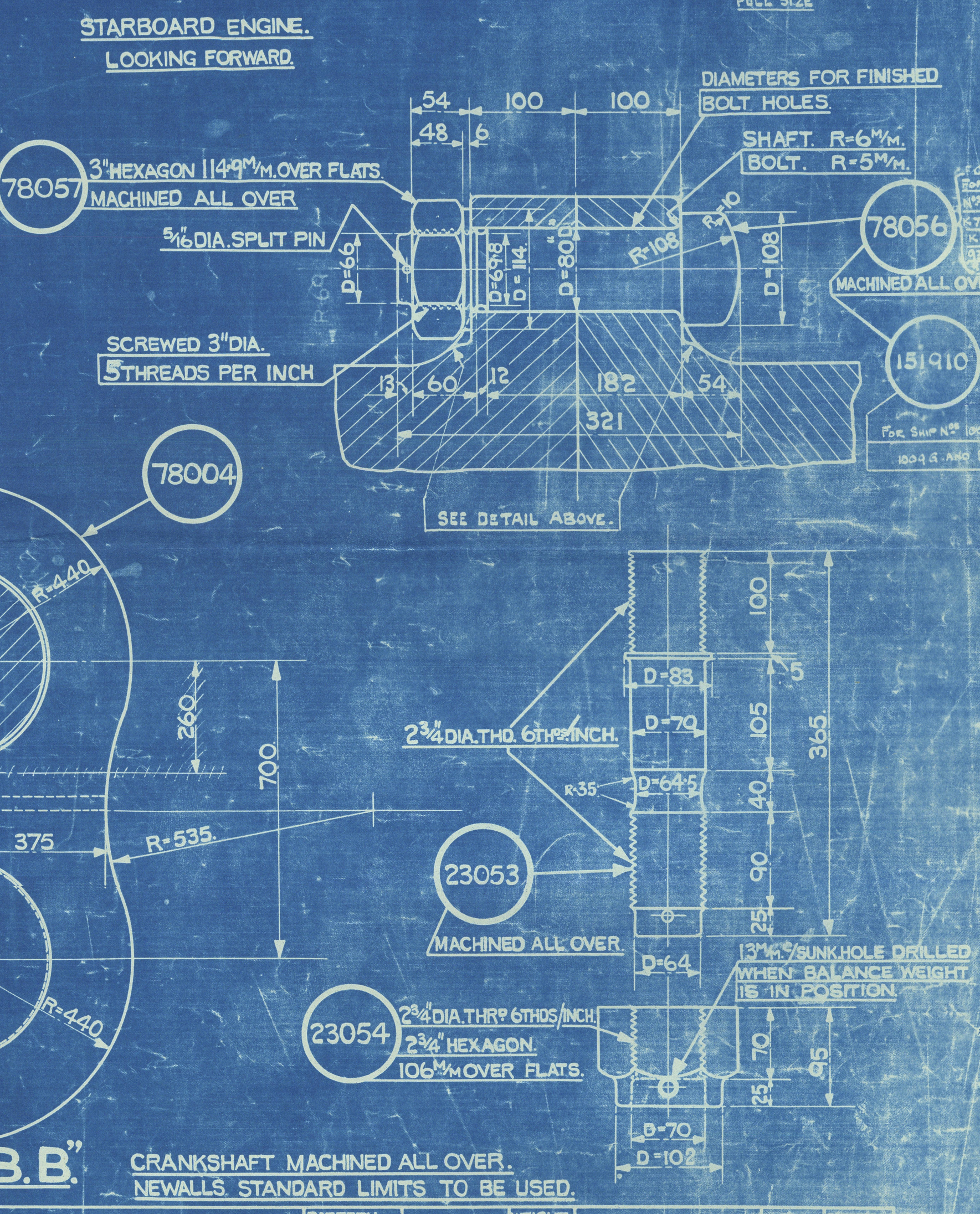
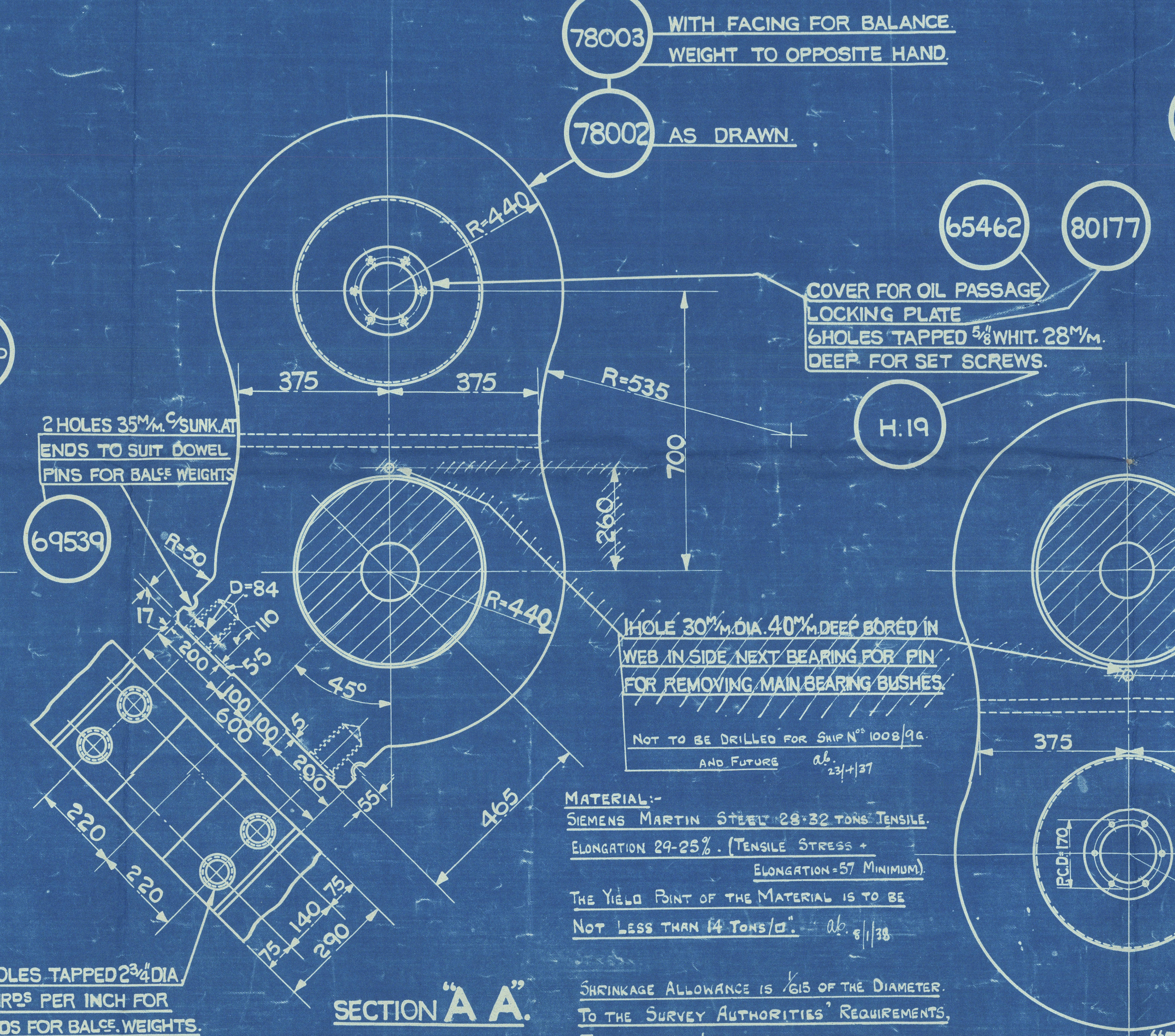
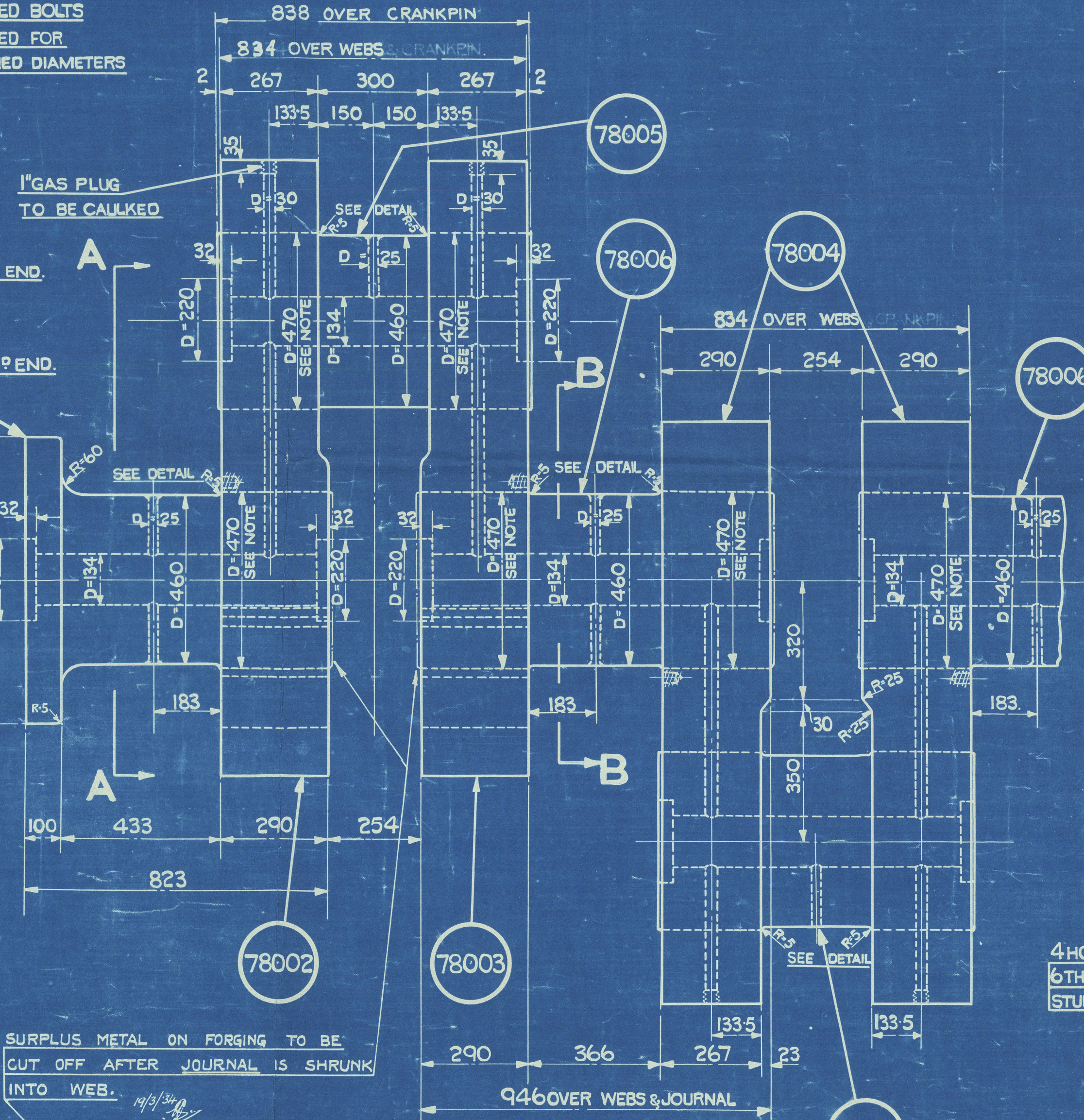
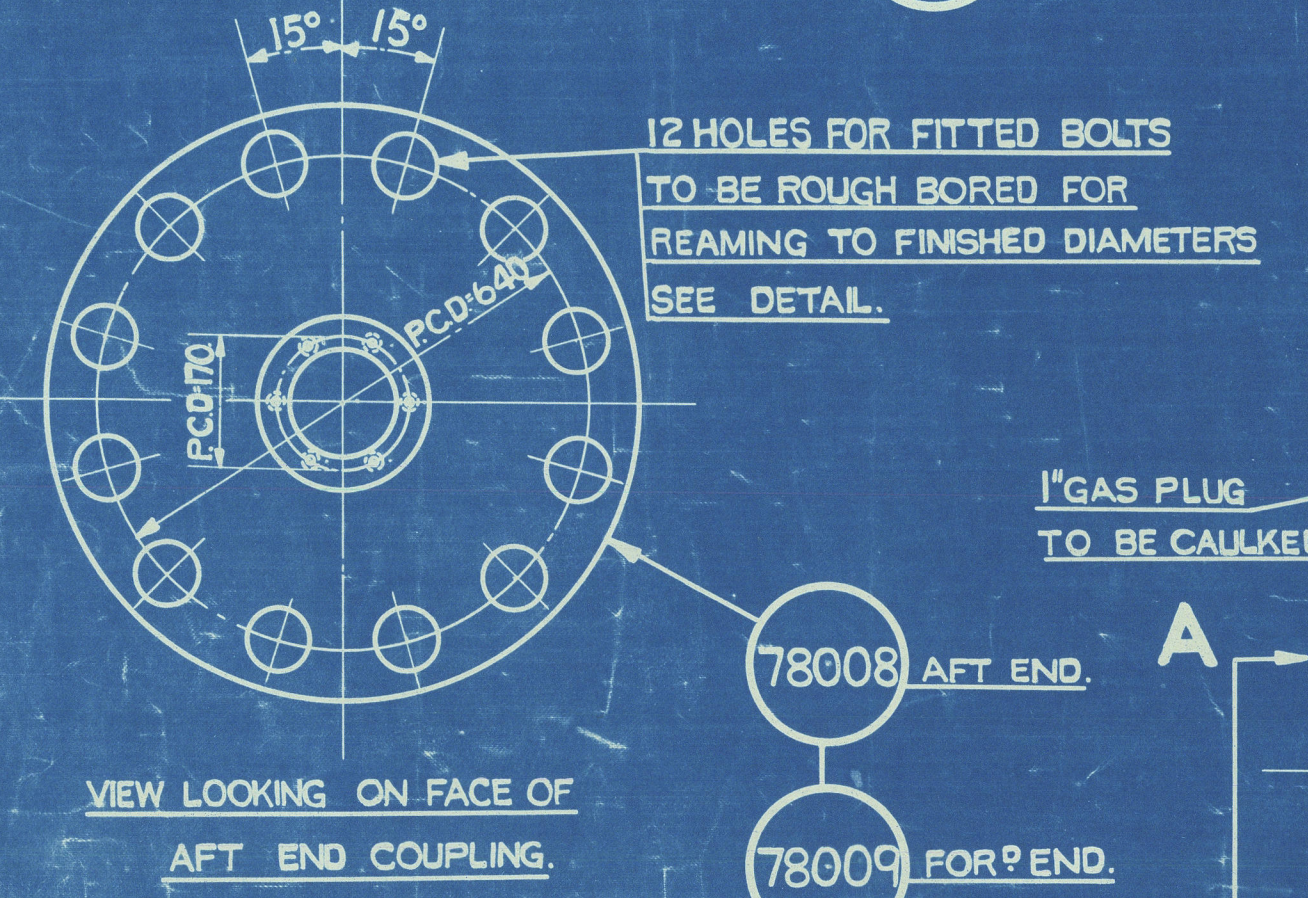


DRAWN FOR STARBOARD ENGINE.



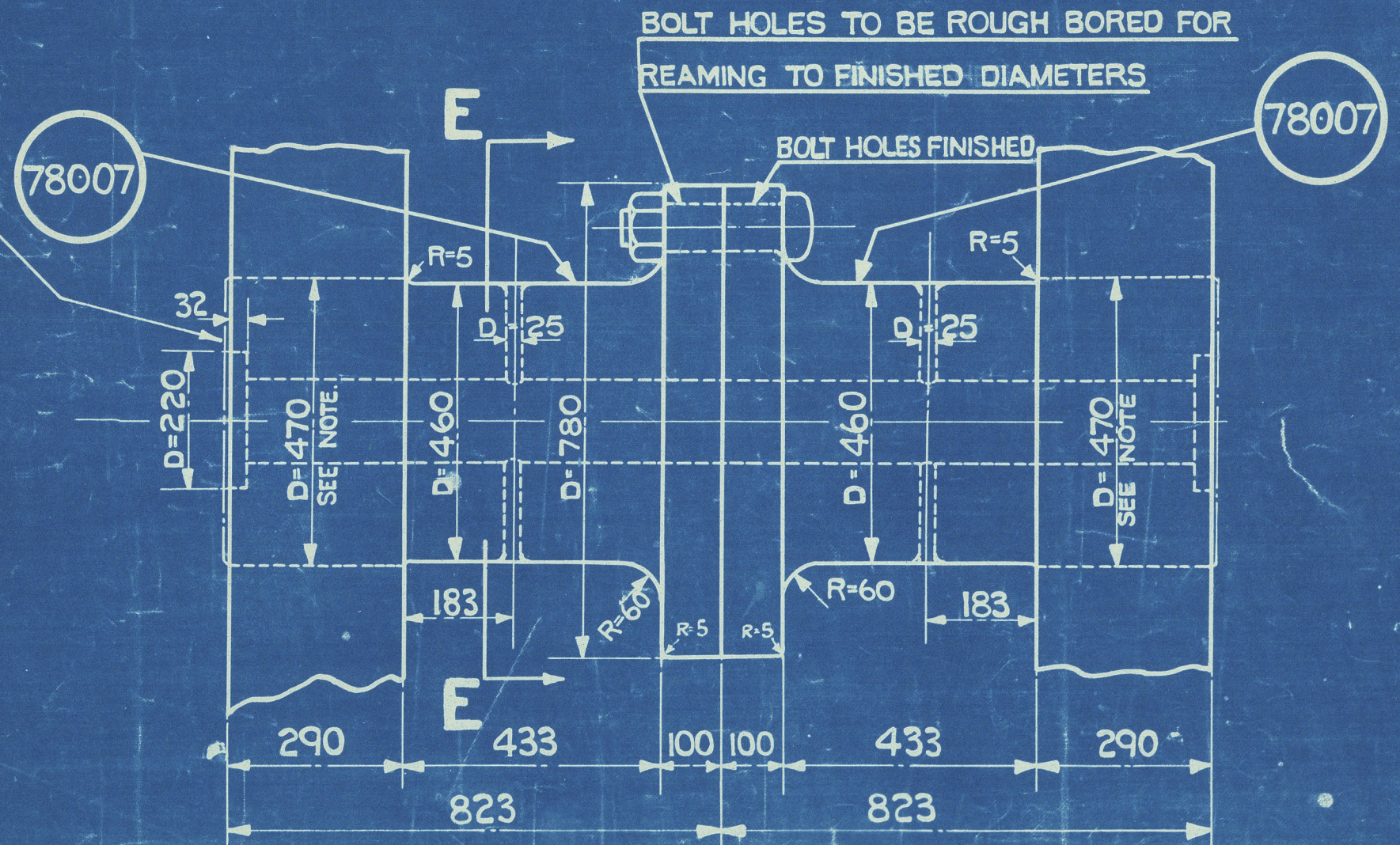
SECTION "A.A."

SECTION "B.B."

CRANKSHAFT MACHINED ALL OVER. NEWALLS STANDARD LIMITS TO BE USED.

NO. OFF PER ENG	DESCRIPTION	PATTERN NUMBER	MATERIAL	WEIGHT IN KGS.	REMARKS	SHOP NO. OF JIG
1	CRANKSHAFT (FORD PART)	78000	SIEMENS MARTIN	25062	BUILT FROM PARTS ORDERED	
2	CRANKWEB WITH FACING FOR BALANCE WEIGHT	78002	"	1002	"	
4	CRANKWEB WITHOUT	78003	"	1802	"	
8	CRANKPIN	78004	"	1064	"	
2	CRANK JOURNAL	78006	"	1156	"	
2	CRANK JOURNAL WITH COUPLING	78007	"	1200	"	
2	"	78008	"	1194	"	
2	"	78009	"	1250	"	
16	DOWEL PIN	69539	MILD STEEL	2-2	STD. DRG. NO. 27769	
12	COUPLING BOLT 28-32 TONS TENSILE	78056	FORGED STEEL	14	"	
12	NUT FOR COUPLING BOLT	78057	WROT IRON	4	"	
34	COVER FOR OIL PASSAGE	65462	CAST IRON	6	STD. DRG. NO. 23107	
1024	LOCKING PLATE	80177	SOFT IRON	"	"	
204	5/8" SCREWS	H.19	STEEL BAR	"	"	
16	"GAS PLUG	"	"	"	"	
12	5/16" DIA. SPLIT PIN	"	"	"	"	
32	STUD FOR BALANCE WEIGHT	23053	FORGED STEEL	11	"	
32	NUT	23054	WROT IRON	4	"	
12	COUPLING BOLT	151910	3" MOD. STEEL	14	"	

NOTE:-
BEFORE SHRINKING. SHAFT DIA. = 470MM.
HOLE = 469.25MM.
EACH WEB TO BE HEATED ONCE ONLY.
PIN AND JOURNAL TO BE ENTERED SIMULTANEOUSLY.



SECTION "E.E."

S.A. 8650 A.I. P.I.
CRANKSHAFT.

SCALE: 1:20 1:10 1:4



W1181-0184

HARLAND & WOLFF LTD.
BELFAST

No. 2086/18

TITLE. Crankshaft

DATE APPROVED. 13.11.39

"Empire Steel."

Lin. 115811.

RETAINED



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Lloyd's Register
Foundation