

MARK	PARTICULAR	MATERIAL	NO REQUIRED	ACTUAL WT	REMARKS
A	CRANK SHAFT	SIEMENS MARTIN STEEL	1	PIECE TOTAL	

FINISH DEGREE	DESCRIPTION
②	ROUGH MACHINING
③a	NORMAL FINISH
④	FINE FINISH

- NUMBER OF FORGINGS ARE FOR ONE ENGINE.
- DIMENSIONS GIVEN IN DRAWING ARE FOR FINISHED SIZE.
- FORGINGS TO BE ACCURATELY FINISHED TO THE DIMENSIONS IN ANY OF ALL JOURNALS OR FORGINGS.
- MATERIAL TO BE ANNEALED AFTER FORGING.
- FORGING MUST BE SOUND WHEN MACHINED.
- SECTIONAL AREA OF INGOT FOR SHAFT MUST EXCEED FIVE TIMES THE SECTIONAL AREA WHERE MARKED. Δ IN ANY OF ALL JOURNALS OR FORGINGS.
- TESTING METHOD, DIMENSION OF TEST PIECES AND NUMBERS, DIRECTION AND POSITION FROM WHERE THE TEST PIECES ARE TAKEN FROM THE FORGING, MUST COMPLY WITH BRITISH LLOYD'S RULE UNLESS OTHERWISE SPECIFIED.

MATERIAL: — SIEMENS MARTIN STEEL —

STRENGTH FOR CRANK SHAFT.

- MAX TENSILE STRENGTH. 28-32 TONS/IN²
- ELONGATION ON THE BRITISH LLOYD'S STANDARD TEST PIECE. NOT LESS THAN 29 % FOR STRH. 28 TONS/IN². NOT LESS THAN 25 % FOR STRH. 32 TONS/IN².
- BENDING TEST ANGLE. 180° AT INTERNAL RADIUS $\geq 1/4$ "
- SUM OF MAX. TENSILE STRENGTH AND CORRESPONDING ELONGATION NOT TO BE LESS THAN 57.

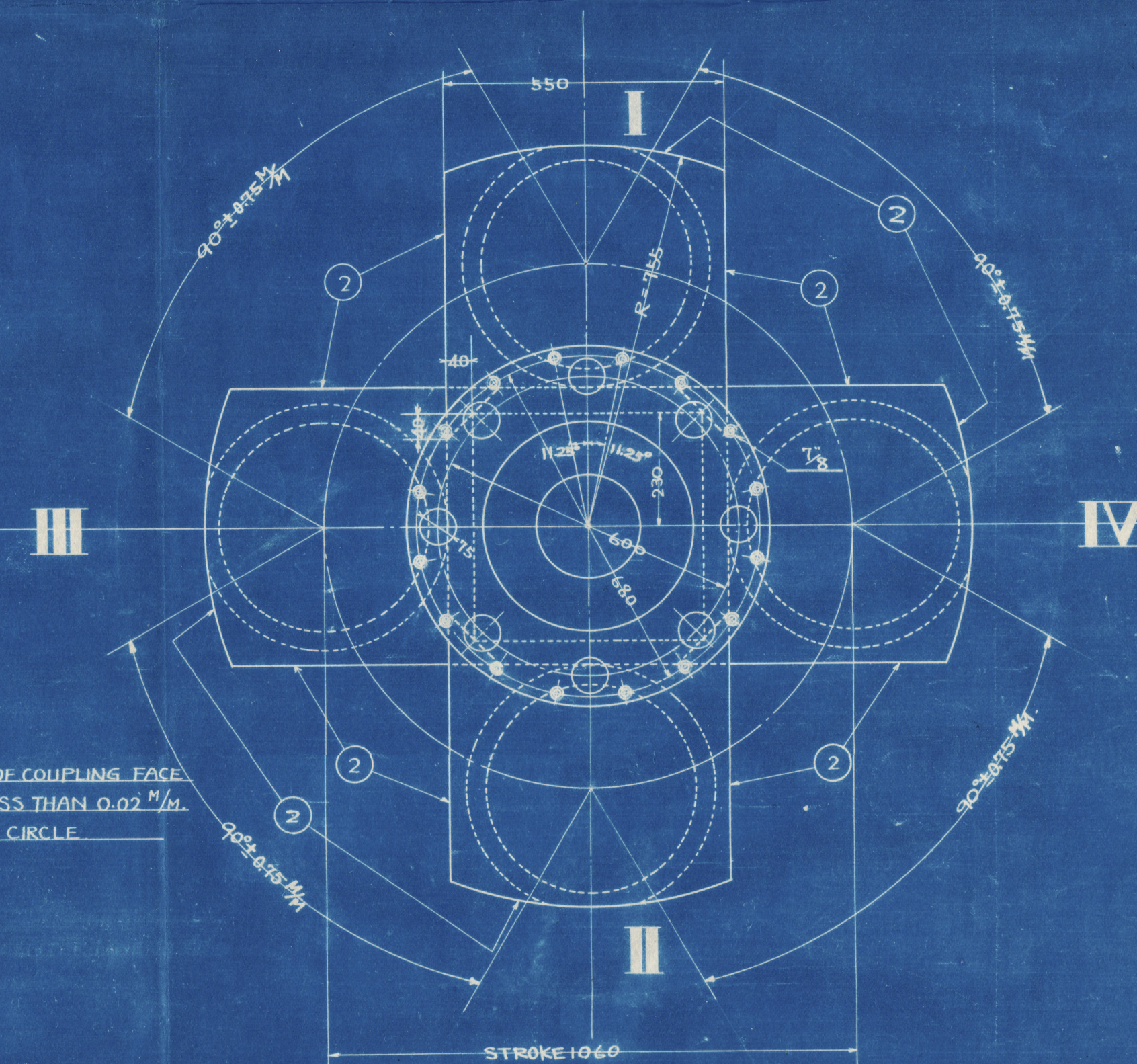
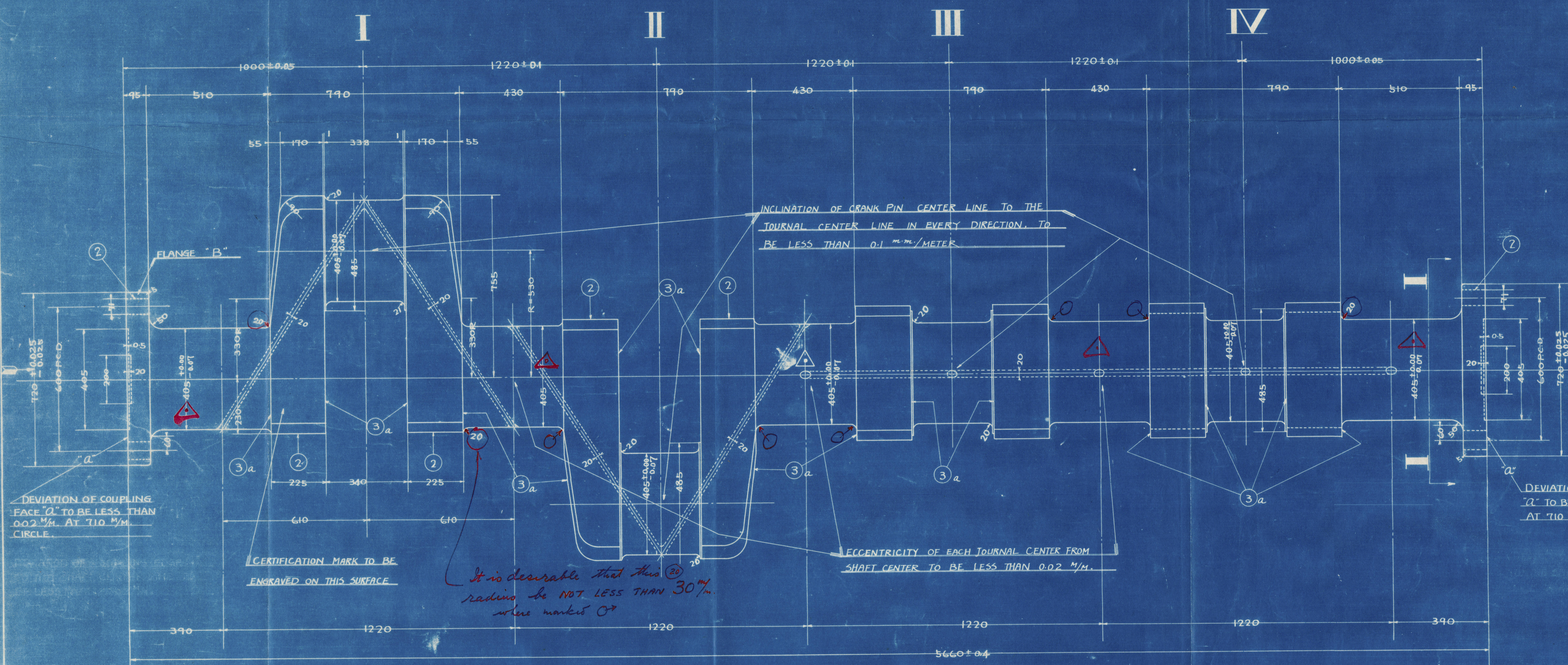
1-OFF PER ENGINE

WEIGHT PER ONE OFF. 12000 Kg.

NUMBER OF FORGING TO BE ORDERED

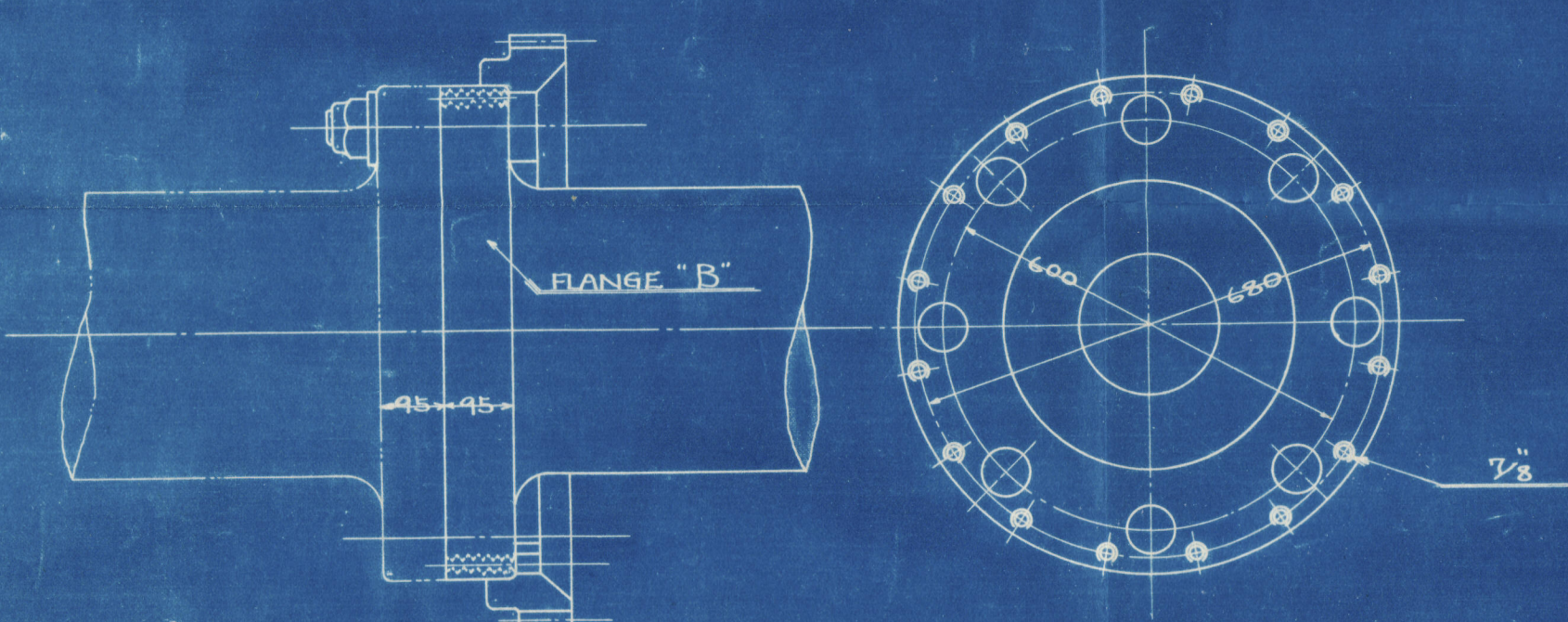
1-OFF

VIEW IN THE DIRECTION OF ARROW.



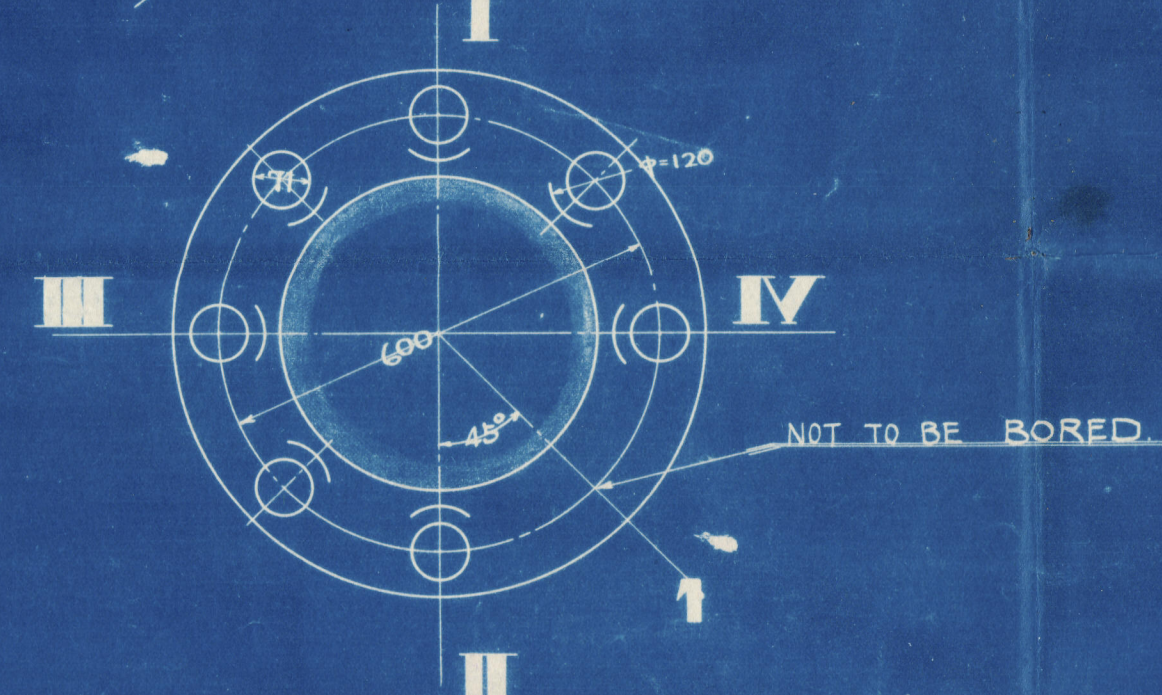
FLY WHEEL SHAFT

CRANK SHAFT FOR WORKING CYLINDER



④ ALL SURFACES TO BE FINISHED TO THE DEGREE ④ EXCEPT THE PORTION MARKED ③a OR ②

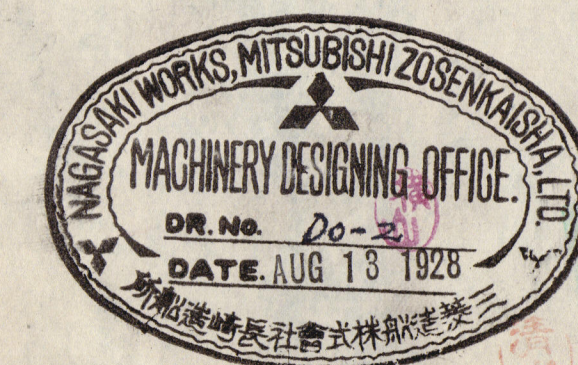
SECTION I-I



4ST-60

主機械用
打物鋼曲軸軸(仕品)
STEEL FORGING
FOR CRANK SHAFT

C-4358



面号 Do-2

製造 製造 製造

納期 年 月 日

工務部	監督部	検査部	印
及日附	監督部	検査部	印

Noted
cm
27/10/28

尺度 10 Do-2

London 9/10/28

Winton 10/10/28

1882

Lloyd's Register Foundation

HINO MARU



箱 3.8.17

W1220-0066

9900-0221M

GEN. BOX NO 141

4ST-60
主機械用
打物鋼曲軸 (仕品)
STEEL FORGING
FOR CRANK SHAFT

工番 C-4358
事番
別事号



圖面号 D0-2

製造數
納期 年 月 日

工番及	監督御査印	関係部	査印

Noted
Cm
27/10/28

W1220-0066