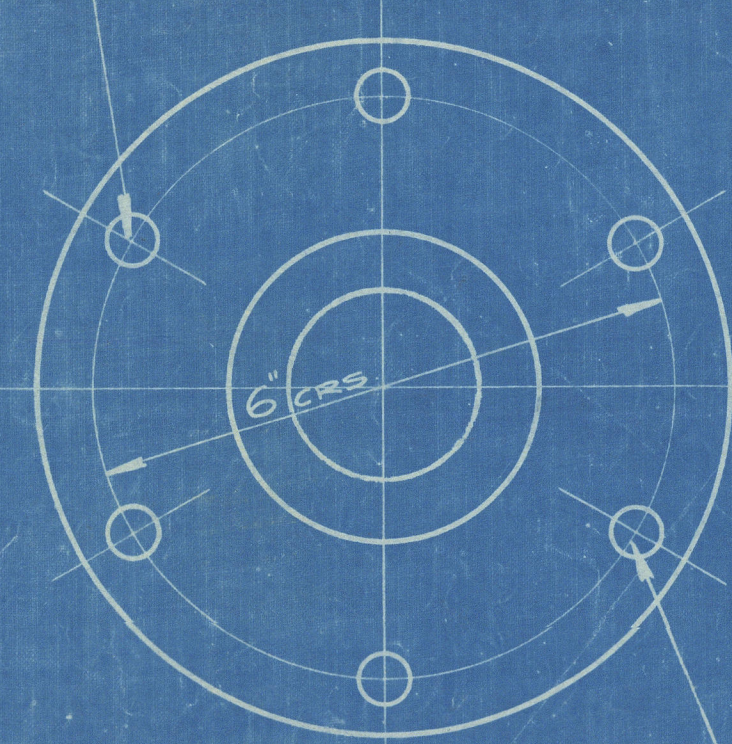


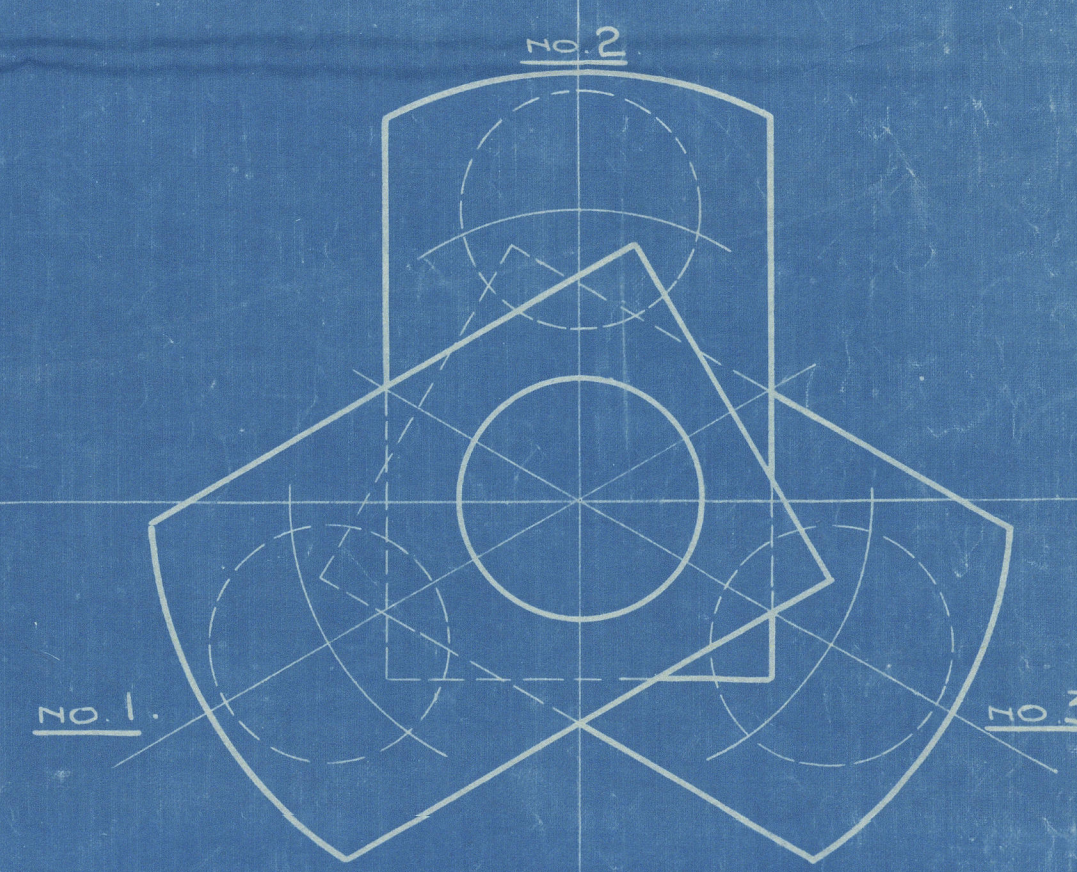
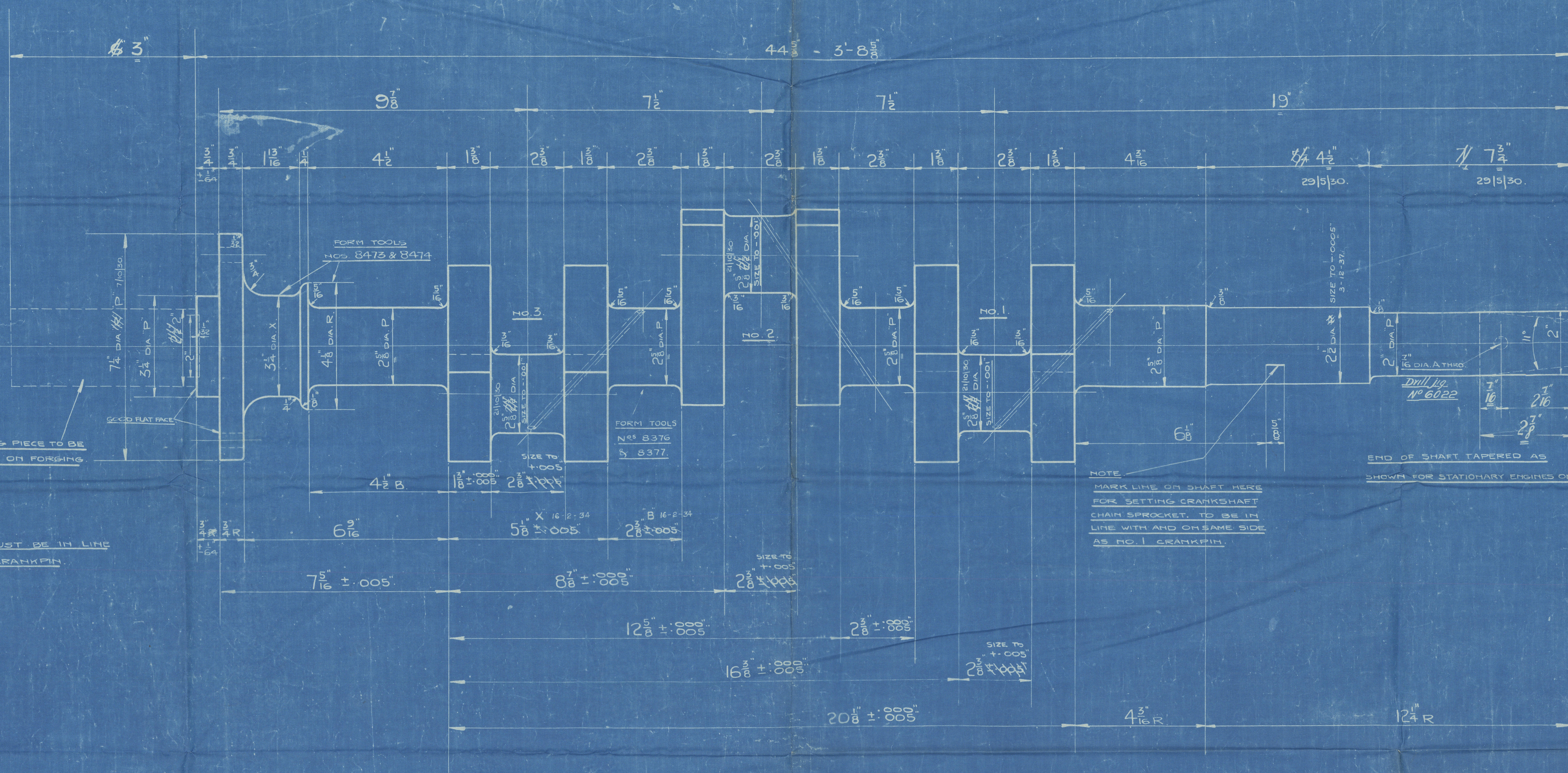
6 HOLES 1/16 DIA "A"
DRILL JIG NO. 8317.



VIEW LOOKING IN DIRECTION
OF ARROW "A"

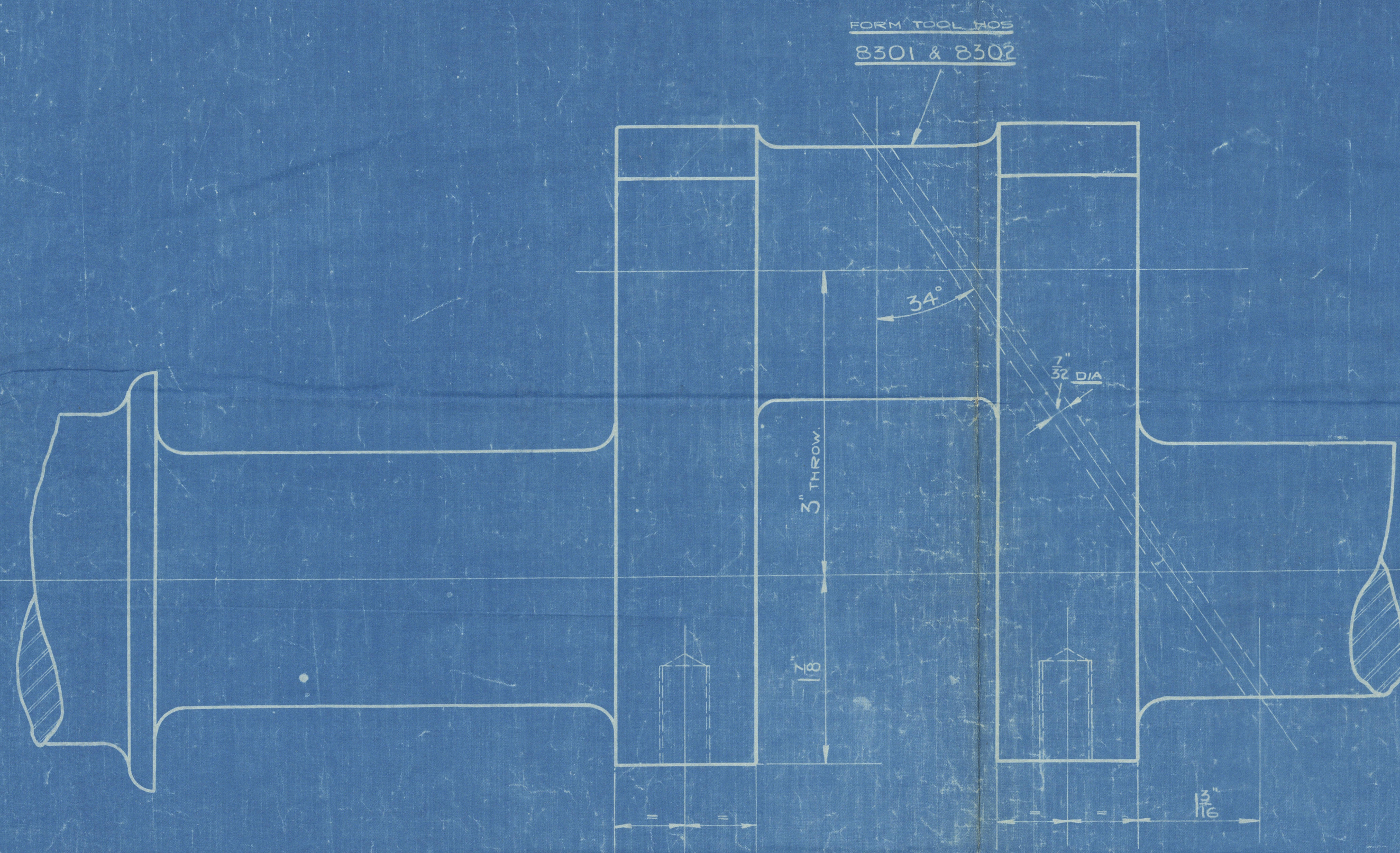
IMPORTANT:
THIS HOLE MUST BE IN LINE
WITH NO. 1 CRANKPIN.

CHUCKING PIECE TO BE
ALLOWED ON FORGING.

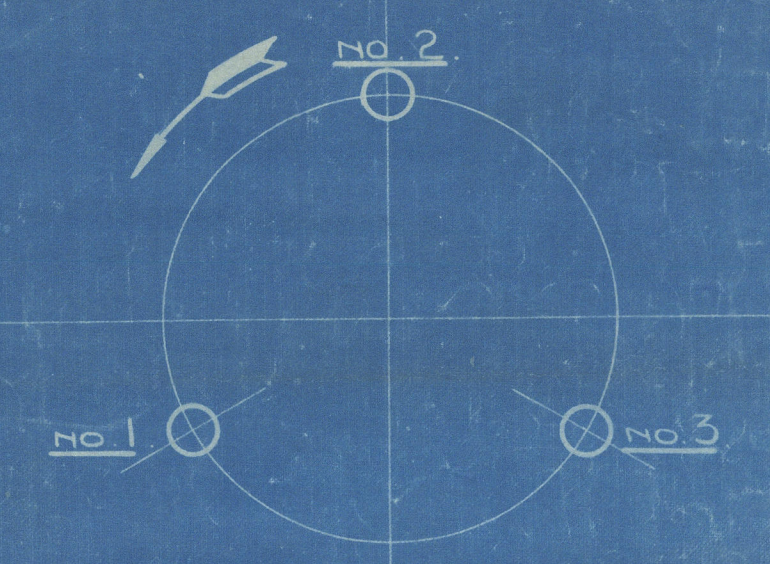
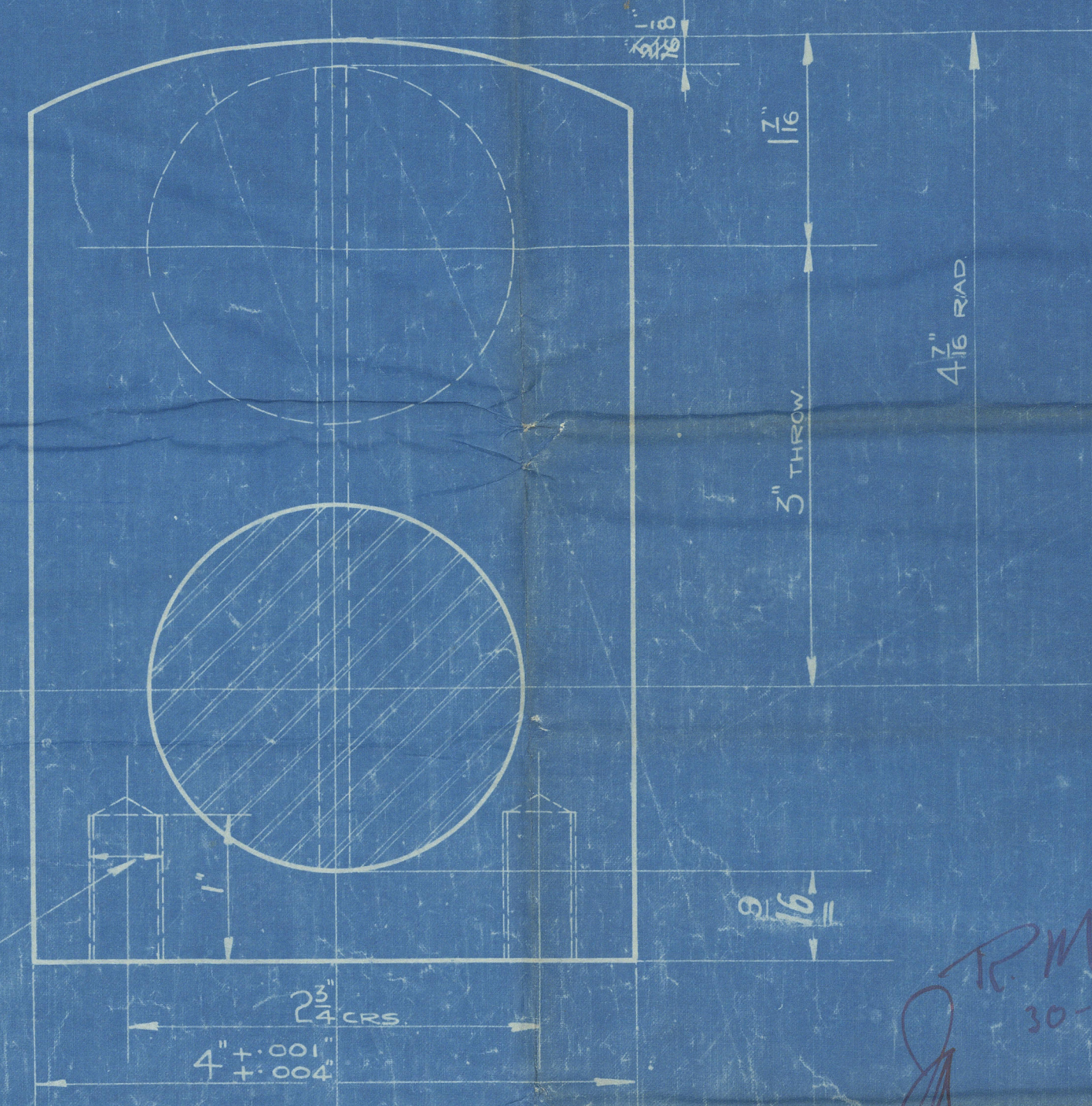


VIEW LOOKING IN DIRECTION OF ARROW "B"

ALTERATIONS
25/5/35 (Inst 1605) LIMIT ON WIDTH OF CRANKPINS MODIFIED



1/16 THDS
TO BE TAPPED
SQUARE TO FACE.
DRILL JIG
NO 8434.



DIRECTION OF ROTATION FOR
STARBOARD ENGINE LOOKING ON
GEAR END.

ORDER OF FIRING

STARBOARD ENGINE 1, 3, 2

PORT OR REVERSE ROTATION ENGINE 1, 2, 3

Ben Ham 20 MAY 1939

DWG No
7818

L. GARDNER & SONS, LTD.
PATRICROFT.

TYPE 3L2 ENGINE
DESCRIPTION CRANKSHAFT
SCALE HALF & FULL SIZE

34/38 TONS STEEL
TENSILE TESTS
TEST PIECES MACHINED TO BRITISH STANDARD TEST PIECE "C"
ULTIMATE STRESS BETWEEN 34.5 AND 38.5 TONS PER SQ. IN.
YIELD POINT BETWEEN 24 AND 28 TONS PER SQ. IN.
ELONGATION BETWEEN 18% AND 22%
REDUCTION OF AREA BETWEEN 40% AND 50%
2000 LB. TEST PIECES

MATERIAL
34/38 TONS STEEL
28/32 TONS STEEL
DATE 9.7.29

MACHINED
ALL OVER
JIG NO.
DRAWN BY
TRACED BY
CHECKED BY

SUPERSEDES
SUPERSEDED BY
DRAWN BY
TRACED BY
CHECKED BY

DWG No
7818
Lloyd's Register
Foundation