"A"

6 HOLES $\frac{9}{16}$" DIA A
DRILL JIG NO. 8317.

VIEW LOOKING IN DIRECTION OF ARROW A

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

"B"

VIEW LOOKING IN DIRECTION OF ARROW B

CHUCKING PIECE TO BE ALLOWED ON FORGING

FORM TOOLS Nos. 8473 & 8474

FORM TOOLS Nos 8376 & 8377.

NOTE.
MARK LINE ON SHAFT HERE FOR SETTING CRANKSHAFT CHAIN SPROCKET. TO BE IN LINE WITH AND ON SAME SIDE AS NO. 1 CRANKPIN.

END OF SHAFT TAPERED AS SHOWN FOR STATIONARY ENGINES ONLY.

Drill Jig No 6022

ALTERATIONS
25/5/35 (Inst. 1608) LIMIT ON WIDTH OF CRANKPINS MODIFIED

FORM TOOL NOS 8301 & 8302

$\frac{1}{2}$"-16 THDS TO BE TAPPED SQUARE TO FACE
DRILL JIG No 8434.

ALL CRANKSHAFTS MADE TO THIS MATERIAL SPECIFICATION TO BE STAMPED Z 31 TO 36.

34/38 TONS STEEL
TENSILE TESTS.
TEST PIECES MACHINED TO BRITISH STANDARD TEST PIECE "C"
ULTIMATE STRESS — BETWEEN 34 & 38 TONS PER Sq. In.
YIELD POINT — NOT LESS THAN 50% OF ULTIMATE STRESS
ELONGATION — NOT LESS THAN 25%
REDUCTION OF AREA — NOT LESS THAN 50%
IMPACT — NOT LESS THAN 10 FT/LBS
BEND TEST — NO CRACKS
ALL TESTS TO BE WITNESSED BY LLOYDS INSPECTOR

MATERIAL	3M/A10 STEEL
	28/32 TONS/□"
	TO BOTTOM INSPECTION TEST
DATE	3.7.28.

MACHINED	ALL OVER
JIG Nos	Rowledge 595

SUPERSEDES	
SUPERSEDED BY	
DRAWN BY	
TRACED BY	
CHECKED BY	

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

30-5-39

Crankshaft Bed Reamer

Approved Jan 1084/0

20 MAY 1939

OFFICE PATRICROFT

DWG No	7818
TYPE	3L2 ENGINE
DESCRIPTION	CRANKSHAFT
SCALE	HALF & FULL SIZE

L. GARDNER & SONS, LTD. PATRICROFT.

DWG No 7818

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