

**SPECIFICATION FOR DIMENSION LIMITS FOR CRANKSHAFT**  
 THE WEBS INTERCONNECTING THE PINS NEED ONLY BE FINISHED WITH A SMOOTH CUT. THE MEASUREMENTS OF THE CROSS SECTIONS OF THE WEBS MAY DIFFER  $\pm 2\%$ .  
 THE PINS AND JOURNALS TO BE HIGHLY MACHINED, PERFECTLY SMOOTH, AND THE FOLLOWING LIMITS MUST NOT BE EXCEEDED.  $\pm 0.04\%$  IN THE DIAMETER.  
 $\pm 0.03\%$  DEVIATION FROM THE TRUE CIRCULAR CROSS SECTION.  $\pm 0.5\%$  IN SEPARATE LENGTH OF SHAFT.  $\pm 0.1\%$  IN LENGTH OF JOURNALS.  
 $\pm 0.03\%$  IN THE PARALLEL ALIGNMENT OF THE CL OF THE PINS TO THE CL OF CRANKSHAFT.  $\pm 0.5\%$  IN THE STROKE. HOWEVER, EACH PAIR OF SIDE WEBS TO THE RIGHT AND LEFT OF THE CENTRAL THROWS MUST HAVE PRECISELY THE SAME CL. THE STROKE BETWEEN THEM MAY DIFFER  $\pm 0.04\%$ .  $\pm 0.5\%$  IN THE ANGULAR SPACING. HOWEVER, EACH PAIR OF SIDE WEBS TO THE RIGHT AND LEFT OF THE CENTRAL OR MAIN CRANKPINS MUST HAVE THE SAME ANGLE, OR ARK IN THE SAME PLACE, RESPECTIVELY. TWO HAVE THE SAME C.L.

**SCALE** :- FULL.  $\frac{1}{2}$ .  $\frac{1}{5}$ .  $\frac{1}{10}$ . &  $\frac{1}{25}$ .

Part No	DESCRIPTION	No Off	MATERIAL	REMARKS.
18	FOR <sup>ST</sup> SHAFT JOURNAL	1	I.S.	
17	SHAFT JOURNAL	1	I.S.	
16	SPARE STRAIGHT SHAFT	1	I.S.	
15	$\frac{5}{8}$ " WHIT STUDS & CASTLE NUTS	16	MS.	SUPPLIED BY R.W.&C <sup>o</sup>
14	$\frac{1}{2}$ " WHIT STUDS & CASTLE NUTS	16	MS	" " " "
13	1" L.P UNION	8	BR.	" " " "
12	1" L.P SOCKET COUPLING	16	BR.	" " " "
11	SCAVENGE PUMP CRANK SHAFT	1	I.S.	
10	$\frac{3}{8}$ " B.S.P.P.LUGS	10	MS	
9	PIPE CLIP	8	MS	SUPPLIED BY R.W.&C <sup>o</sup>
8	SHORT PIPE $\frac{3}{4}$ " BORE	8	STEEL	" " " "
7	LONG PIPE $\frac{3}{4}$ " BORE	8	STEEL	" " " "
6	CUPLING BOLT NUT & SPLIT PIN.			SEE DRAWING N <sup>o</sup> 16283.
5	DOWEL PINS	32	M.S.	
4	SHAFT JOURNAL	2	I.S.	
3	SIDE PIN WEB	8	I.S.	
2	CENTRE WEB	8	I.S.	
1	CENTRE PIN	4	I.S.	

COMPLETE CRANKSHAFT  
NOTE! PART N° 4 & PART N° 17 ARE SIMILAR EXCEPT IN DRILLING

SURVEYS:- LLOYDS & U.S. DEPARTMENT OF  
COMMERCE REGULATIONS.

**ENG. N° M. 2574.-G.**



Richardson, Westgarth

No. 2574-6

Crank Shaft.

S.S. m/v "Gulfbird"  
MDB. RPT. No. 13338

S.S. m/v "Gulphawk"  
MDB. RPT. No. 13398

S.S. m/v "Gulfwing"  
MDB. RPT. No. 13440



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