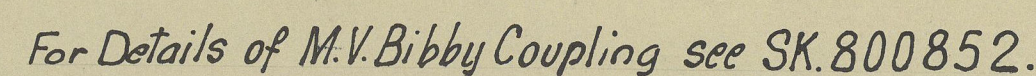
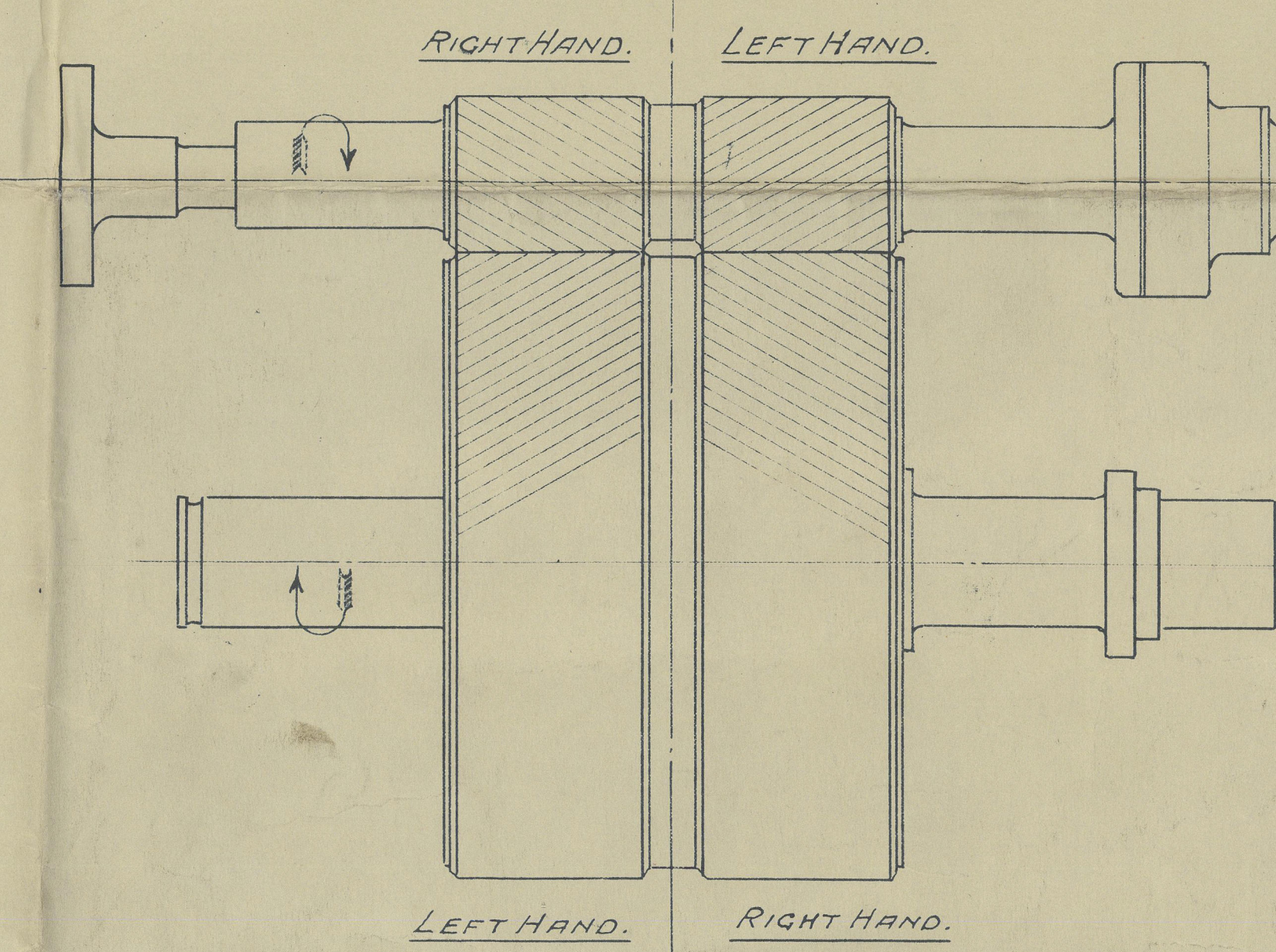
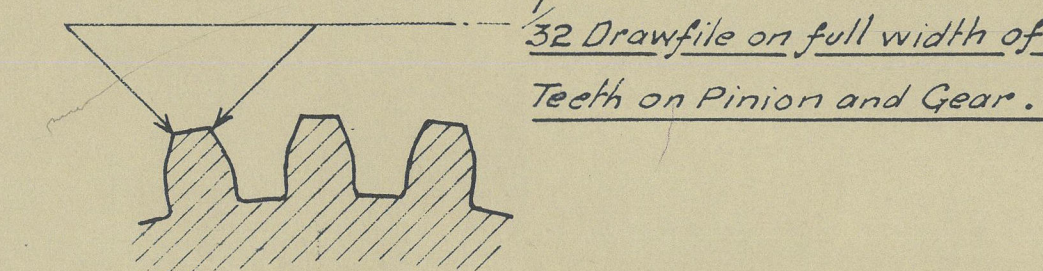


Collar Item #20 to be always in position, whilst the assembled pinion is being lifted or lying about out of Gear Case.



For record of this end as fitted on S.S.
"City of Canterbury" on S.O. 115570/2 see:
 SK. 800760 for Item* 5,
 C. 521860 for Item* 14,
 D. 279495 for Item* 15+16.
 Barring Spanner not fitted.

BILL OF MATERIAL.						
Item	Cat	Req	Description.	Mat'l	Dwg No	Note.
1	1		Gear Wheel Centre	Pat't # 17393.	C. I.	B. 578799. Old.
2	1		H.S. Pinion Item #2	Forging SK. 800743.	F.S	C. 521361. P.D. 3000 1020
3	1		Gear Wheel Rim	" #3	"	D. 552075 " " 101
4	1		" " Shaft	" #1	"	D. 521561 " " 1131.
5	1		Flexible Shaft	" #4	"	C. 521857 " " 1100.
6	1		Coupling Claw	" #5	"	B. 573583 " " 1084
7	1		" Sleeve	" #6	"	A. 373586 " " 1083.
8	1		Spindle Looking Collar.		"	B. 370696. —
9	1		Half Split Key. (Long Half)	"	"	D. 652076. —
10	1		" " (Short Half)	"	"	D. 652076 —
11	12		7/8 Whit. Screwed Pags - 2 1/2" A cut off to suit Job.	Blk SH Bar		(Shock, MH)
12	8		Coupling Bolts. (Flat as per Detail Dwg.) Flex. Shaft.	F.S.	B. 279465.	RS. 1335.
13	8		3/4 Hex. Nuts for Item #12.	Blk SH Bar	D. 160002	Stock.
14	1		Oil Catcher for Shaft End. T. 20600.	B. 10.	C. 522782	New
15	1		Coupling Nut. Item #1.	F.S.	D. 655677	"
16	1		Grab Screws for Coupling Nut. Item #2. 1/2 Whitel.	Blk SH Bar	"	D. 655677. Stock.
17	1		Aligning Gauge A = .6209. Item #1.	Tool SH.	D. 523357.	"
18	2		Half Keys. (Flex. Shaft) (Long Halves).	5/8" N. SH.	D. 652077.	"
19	2		" " (") (Short ")	"	D. 652077.	"
20	2		Aligning Collar Half Rings. T. 17451.	C. I.	D. 652086.	"
21	12		Fitted Bolts for Coupling Sleeve.	F.S.	D. 653210.	RS. 1335
22	12		5/8 Fin. Hex. Nuts for Item #21.	B. 5/8 SH Bar.	D. 160002	Stock.
23	12		3/8" x 1" Fin. Hex. Hd. Top Bolts. (Heads drilled for Wire)	"	D. 160199.	"
24	12		1/8" x 1/4" Split Cotter Pins. for Item #21.	Steel.	D. 11909.	"
25	38 SH		3/32 Dia Wire for Item #23.	"	"	"
26	2		3/4 x 7 1/2" S.F. Hex. Hd. Top Bolts for Item #20	Blk SH Bar	D. 160012.	"
27	2		5/8" S.F. Hex. Nuts for Item #26.	Blk SH Bar	D. 160035.	"
28	8		3/16 x 1/4" Split Cotter Pins. for Item #22.	Steel.	D. 11909.	"
29	1		Handle for Aligning Gauge. 3/16 Dia x 19 1/2 Lg Item #2.	Blk SH Bar.	D. 523357.	"
30	1		Feather Key for Item #4 Wheel Seat.	F.S.	D. 652141.	"
31	1		Barring Spanner Item #1.	Std. Sift Steel.	C. 522785.	"
32	1		Lever Item #2.	N. S. Plate.	C. 522785.	"
33	4		5/8" x 1 1/2" S.F. Hex. Hd. Tap Bolts, for Item #31, 32.	Blk. St.	Std. 160912	Stock.



VIEW SHOWING HANDLING OF GEARS.

IMPORTANT:—
COMPLETE GEAR TO BE BALANCED STATICALLY.

PARTICULARS OF GEARS.	PINION	WHEEL
Number of Teeth.	39.	157.
Pitch Circle Diameter.	8.3555.	33.6363.
Diameter over Teeth.	8.7265.	34.007.
P.P.M.	3.00.	750.
Spiral Angle of Teeth.	29° 58' 9."	
Circular Pitch.		" 67306."
Centres.	20.3959.	
Hob.		7/12 Lead."
Machine cut on.		

All Dimensions with Symbols are to be made to Gauges.
Any size between Limits is correct.
Unlimited overall dimensions to be correct within \pm
Unlimited Machining " " " " \pm

METROPOLITAN-VICKERS ELECTRICAL CO. LTD.
MANCHESTER, ENGLAND.
DETAIL ASSEMBLY & GEAR CUTTING
OF ROTATING ELEMENT.

21" S. R. GEAR

S.S. "City of Canterbury" SK.800853.

S.O. 115707/2 { S.S. "City of Venice" }
S.O. 115708/2 { S.S. "City of Florence" }
S.O. 115709/2 { S.S. "City of Salisbury" }
 { S.S. "City of Kimberley" }

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