

5/16 DRILL (BY D.P.C.) FOR
MARINE PROPULSION SETS ONLY
IN LINE WITH C.O. OF NO. 1 CRANK.
REMOVE SHARP EDGE OF HOLE

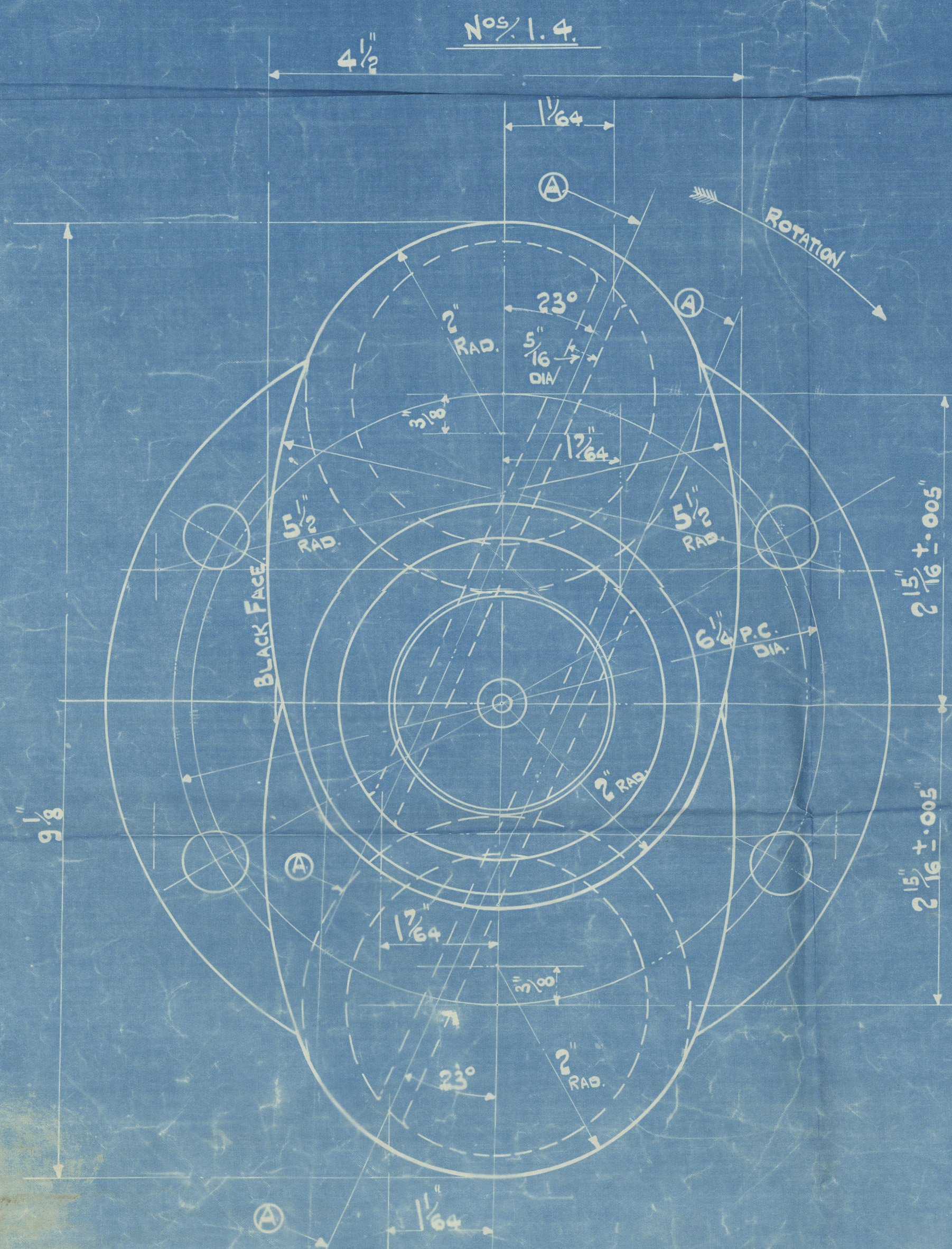
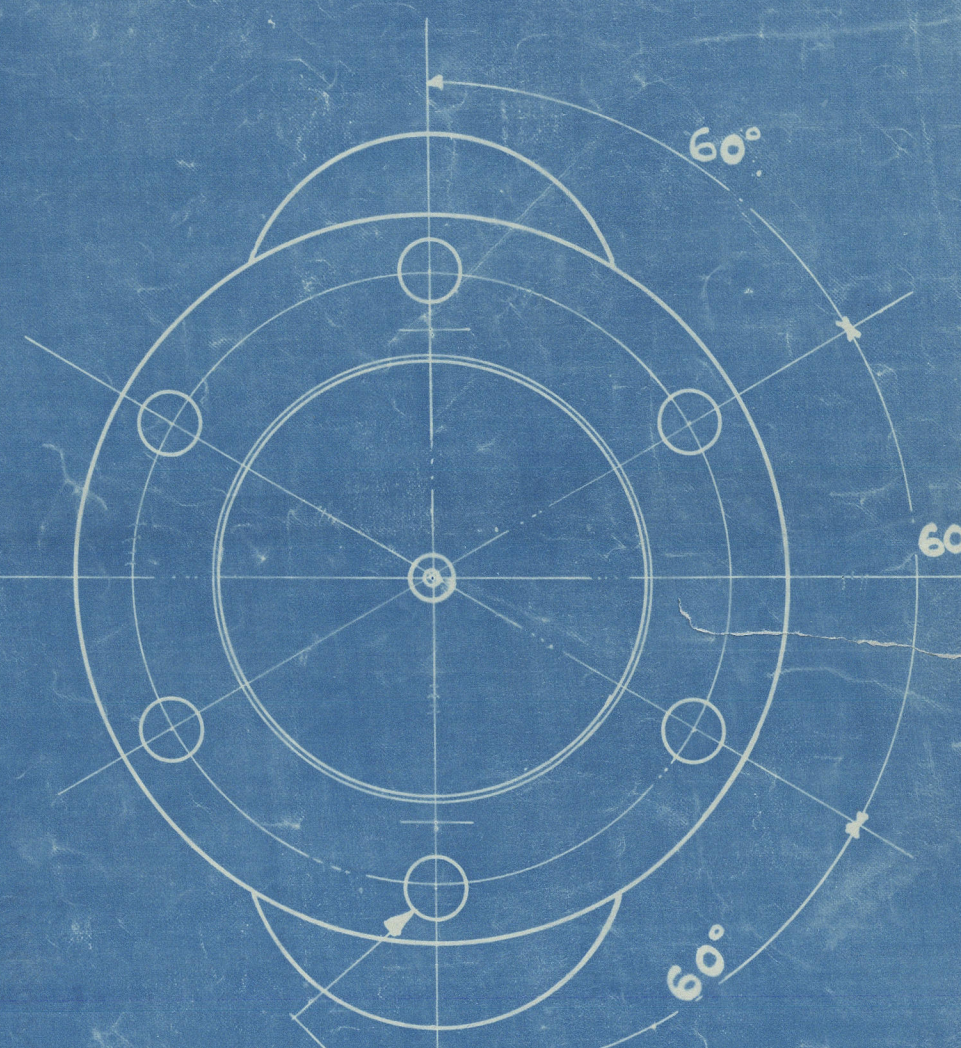
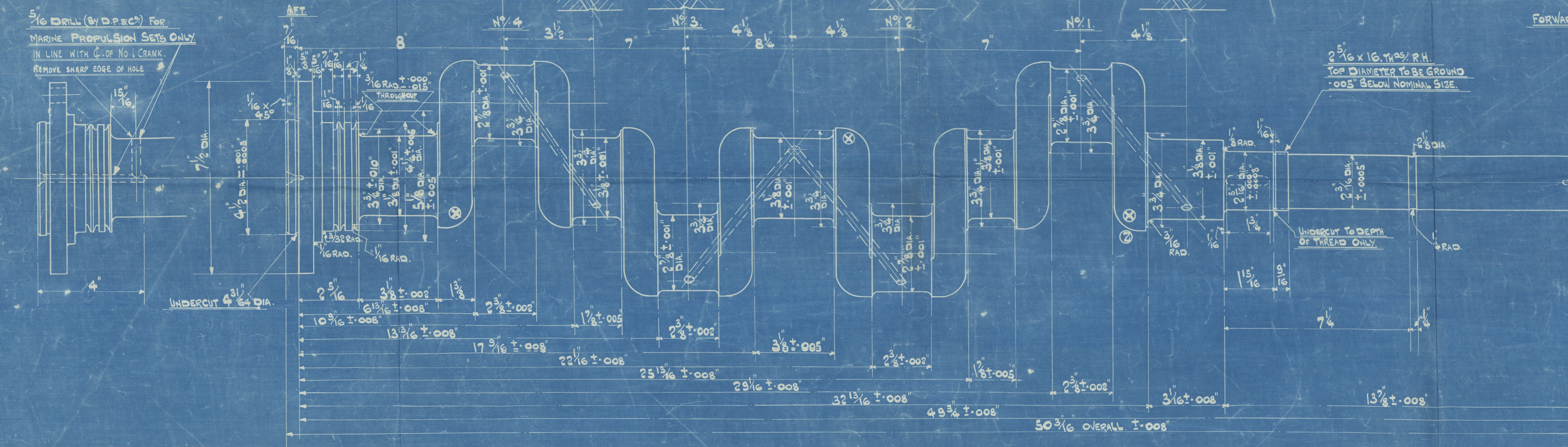
SECTIONS ON (A-A) SHOWING
TRUE ANGLES OF OIL HOLES

REMOVE SHARP EDGES

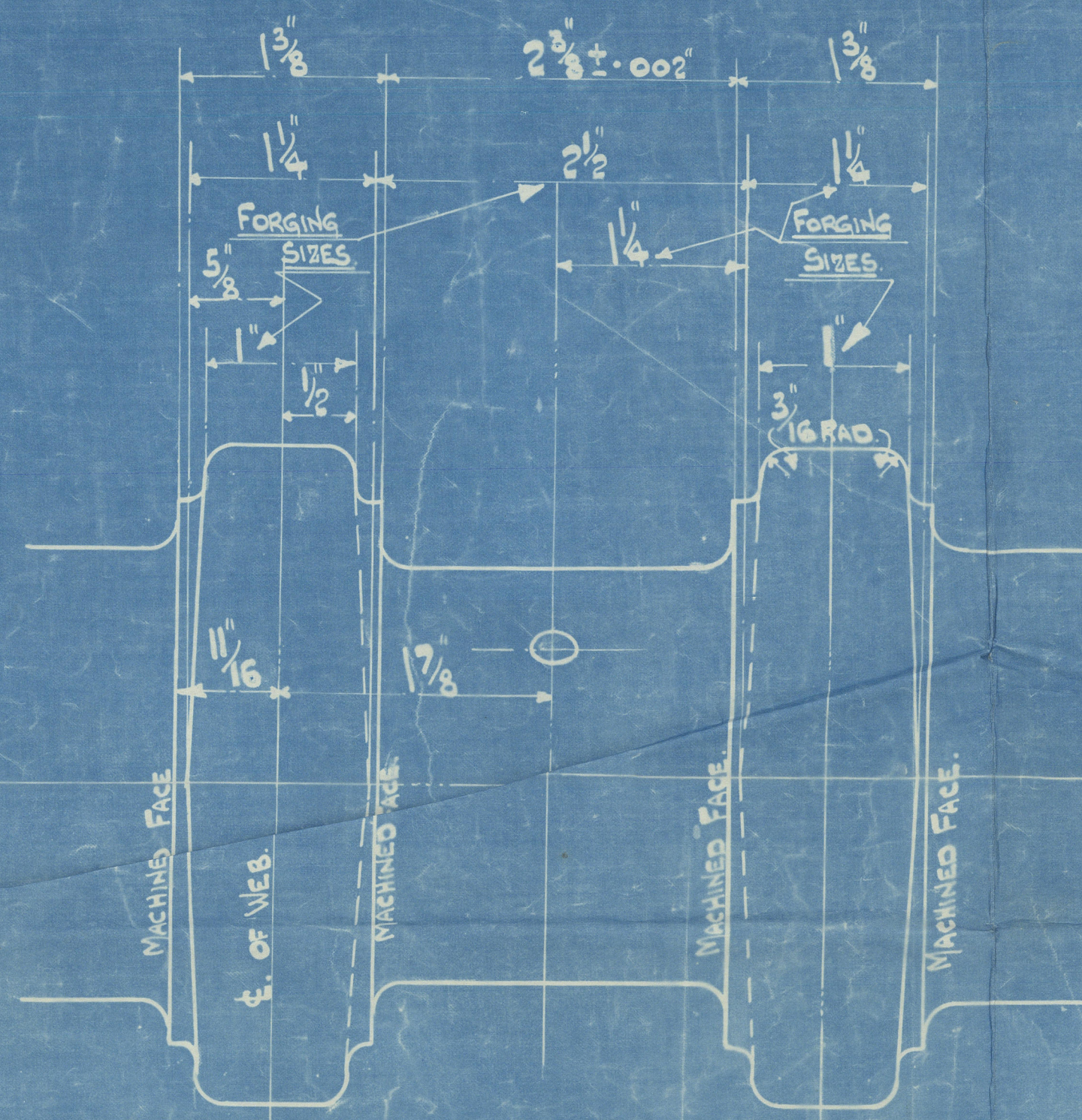
FORWARD

2 5/16 x 16 THRS R.H.
TOP DIAMETER TO BE GROUND
.005" BELOW NOMINAL SIZE

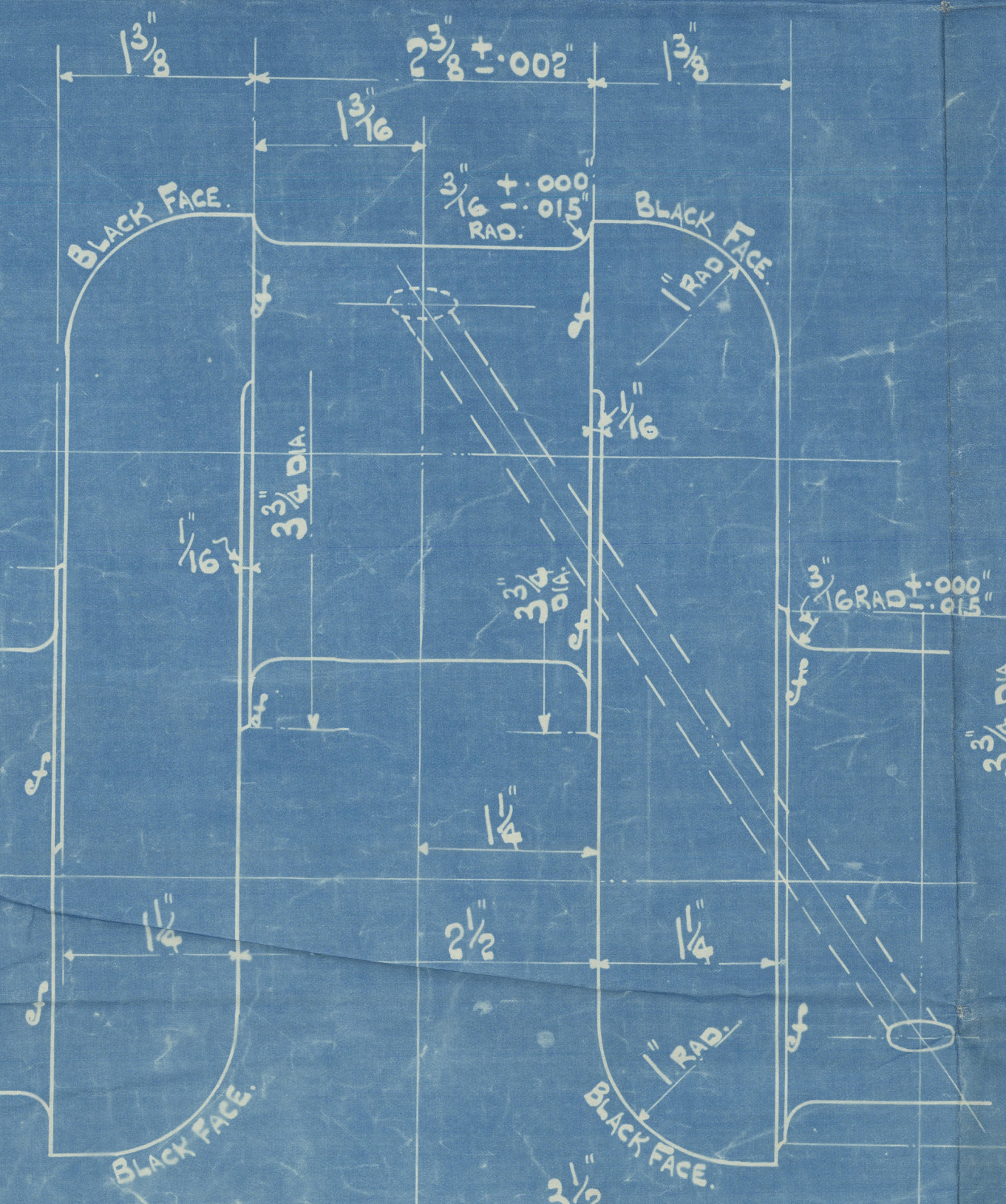
SIX 5/8 REAMED HOLES
(BY D.P. & C.)



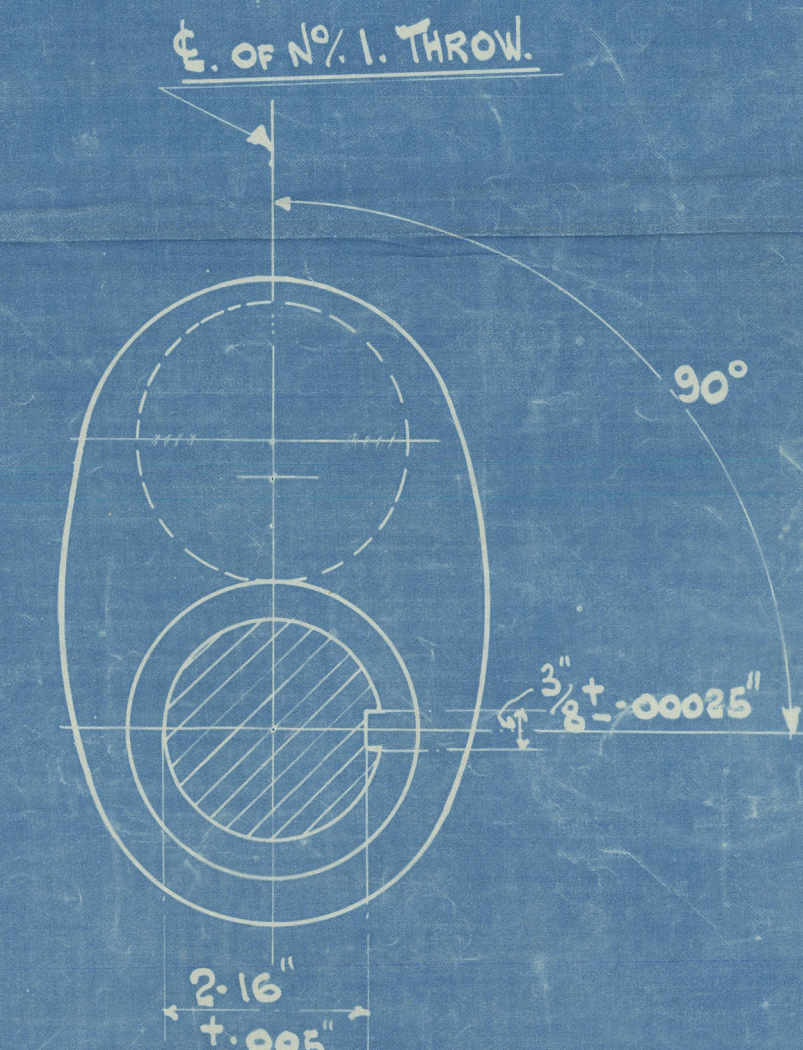
END VIEW FROM FORWARD



PLAN OF ANY ONE THROW



FULL SIZE VIEW OF ONE THROW
(NO. 4)



SECTION IN WAY OF FEATHERWAY
FROM FORWARD

CRANK
MAKERS
INITIALS AND
NUMBER

IDENTIFICATION MARK
TO BE STAMPED ON END
FACE OF WEB AT (2)

LLOYD'S TESTS

WHEN REQUIRED THESE TO COMPRISE TENSILE &
BEND ONLY & NOT IMPACT TESTS

TESTS AT THE THREE POINTS (X) BY D.P.C.
BRINELL NUMBERS TO LIE BETWEEN 174 & 228
AND ON ANY ONE SHAFY THEY ARE NOT TO
DIFFER BY MORE THAN 35 UNITS
PERMISSIBLE QUALITY ON ANY PIN OR JOURNAL .0005

TO BE BALANCED AS A FINAL OPERATION (AFTER BALANCE WEIGHTS HAVE BEEN FITTED)
PERMISSIBLE OUT OF BALANCE OUNCES AT CRANK RADIUS

MACHINED ALL OVER EXCEPT WHERE MARKED ON WEBS

DRAWN BY	CHECKED BY	CWSS	DROP	FORGING	DATE	ALTERATION	BY	DATE	REMARKS
OR. N° 963, 965, 970									

22 Machine
OR. N° 963, 965, 970
4 RR. OIL ENGINE

4-CYL
CRANKSHAFT
REGISTERED
FOUNDATION

Barclay, Burke
Yd No. 666

Davey, Paxman
4 RQ Aug. Eng.

Crankschaft

Motorship El Madama

205

W240-0109

(8)



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