

LONDON AGENCY: Works Order No. 1400.

Messrs. Vickers-Petters Ltd., Customers Order No. & Date. 1/337 of
Ipswich Works, Ipswich. 23/2/23.

Date entered. 27/2/23.

Forwarded per L.M. & S. Rly. Carriage Paid, home.

Quotation of 12/2/23. Est. 40725.
B. 5019.

Consigned to above address.

Inspection to Lloyds tests requirements & inspection. See under.

Delivery due. 27/3/23.

Standard tested to 400 lbs. per sq. inch. Uncoated.

Lapwelded Mild Steel Air Receivers 24" bore x 9/32" thick complete with dished ends double rivetted in. One end with 14" x 10 1/2" manhole other end with 5 1/4" dia. & 1 1/2" dia. pads.
2 Complete Receivers required.

All to Drawing No. C.273.

24-9/16" o/d. x 7'3" long x 9/32" thick x 24" bore x 14'6" total feet-age.

One end of each tube sized for 6" up and fitted with dished end rivetted in with 2 rows of 1/2" rivets pan head inside, semi-countersunk outside at 2-3/32" pitch staggered, 37 rivets in a row. Dished ends 13/16" thick in body and rivetting flat to be 9/16" thick. This end is bossed centre and fitted with a 14" x 10 1/2" McNeil Type Manhole Door complete with studs and dogs also rubber joint ring 1/8" thick.

Other end sized for 6" up and fitted with dished ends rivetted in with 2 rows of 1/2" rivets, pan head inside semi-countersunk outside 2-3/32" pitch, staggered, 37 rivets in a row. Dished end 3/4" thick in body, and rivetting flat to be 9/16" thick. This end to have M.S. Flat Pad 1/2" thick x 1 1/2" bore x 5 1/4" dia. rivetted on with 4 rivets 1/2" dia., pan heads, inside flush countersunk outside and tapped for 4-1/2" studs a 3/8" P.C. dia. and faced. At position shown on Drawing a M.S. Flat 1/2" thick x 1 1/2" dia. is welded on and tapped for 1/4" B.S.P.

The Dished Ends will be supplied to us for rivetting inside tubes, we to weld on the 1 1/2" dia. pad only.

At position shown on drawing a M.S. Flat Pad 1/2" thick x 1 1/2" dia. is welded on and tapped for 1/4" B.S.P.

All rivets and seams to be thoroughly caulked.

Material tensile ~~24-28~~ ^{minimum tensile 28.6 tons} tons per sq. inch elongation 20% in 8"

Bend plate with Steel-Makers Number & Inspector's stamp on outside and ring with paint before and after bending and rounding prior to despatch.

No acetylene patching is permitted on these tubes.

Tubes to be a good Job and sound at welds.

Welds must be up to thickness free from flats ridges and other imperfections.

Required for Messrs. Camper & Nicholson's Yacht No. 134.
Tubes to be marked C.O. 776/7.

Inspection:- Dished ends and manhole doors will be inspected by Lloyds at our Works before fitting and rivetting to shell.



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