

DRAWN BY THE  
TRACED BY K.R.  
CHECKED BY G.E.D.  
APPROVED BY *[Signature]*  
DATE 2.20.11

CRANKPINS TO BE PARALLEL  
WITH CRKSHAFT AXIS TO WITHIN .001

# CRANKSHAFT

SCALE  $1\frac{1}{2} = 1$  FOOT.

PART. № 12154	DRG. № 125
------------------	---------------

V.N.6.M



DRAWN BY J.E.  
 TRACED BY K.H.  
 CHECKED BY J.G.D.  
 APPROVED BY J.M.  
 DATE 2.20.20

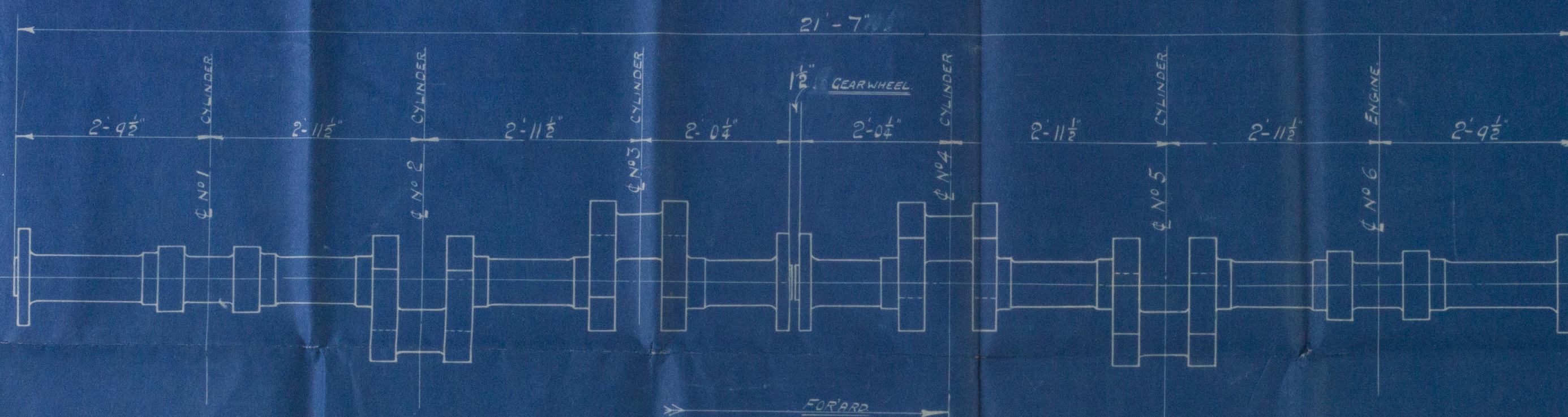
10-9 1/2" OVERALL LENGTH OF EACH CRANKSHAFT SECTION

8 HOLES FOR  
 1/2" DIA FITTING BOLTS  
 DRILL IN JIG NO 1835

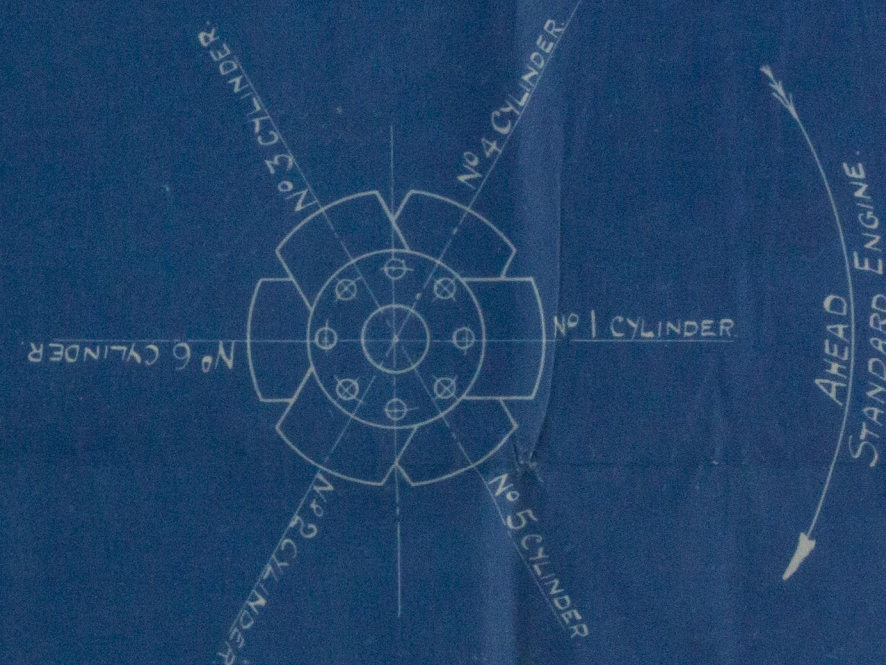
8 HOLES FOR  
 1/2" DIA FITTING BOLTS  
 DRILL IN JIG NO 1835

CRANKPINS TO BE PARALLEL  
 WITH CRANKSHAFT AXIS TO WITHIN .001"

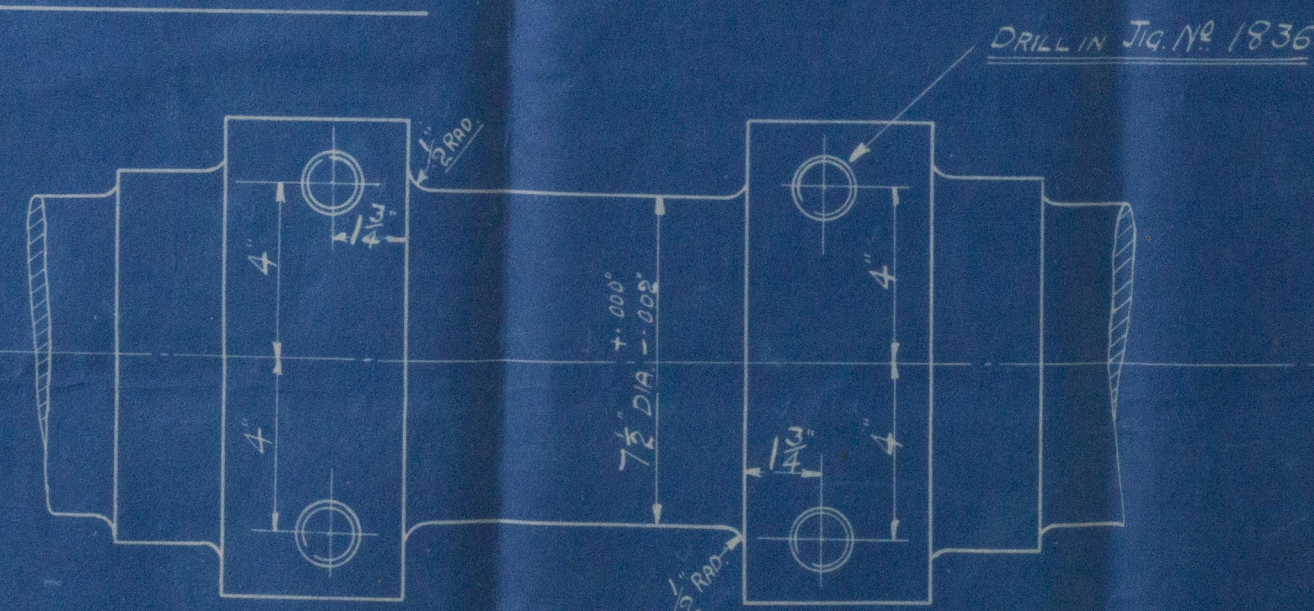
ALL WEBS DRILLED ALIKE FOR  
 CENTRIFUGAL OILER



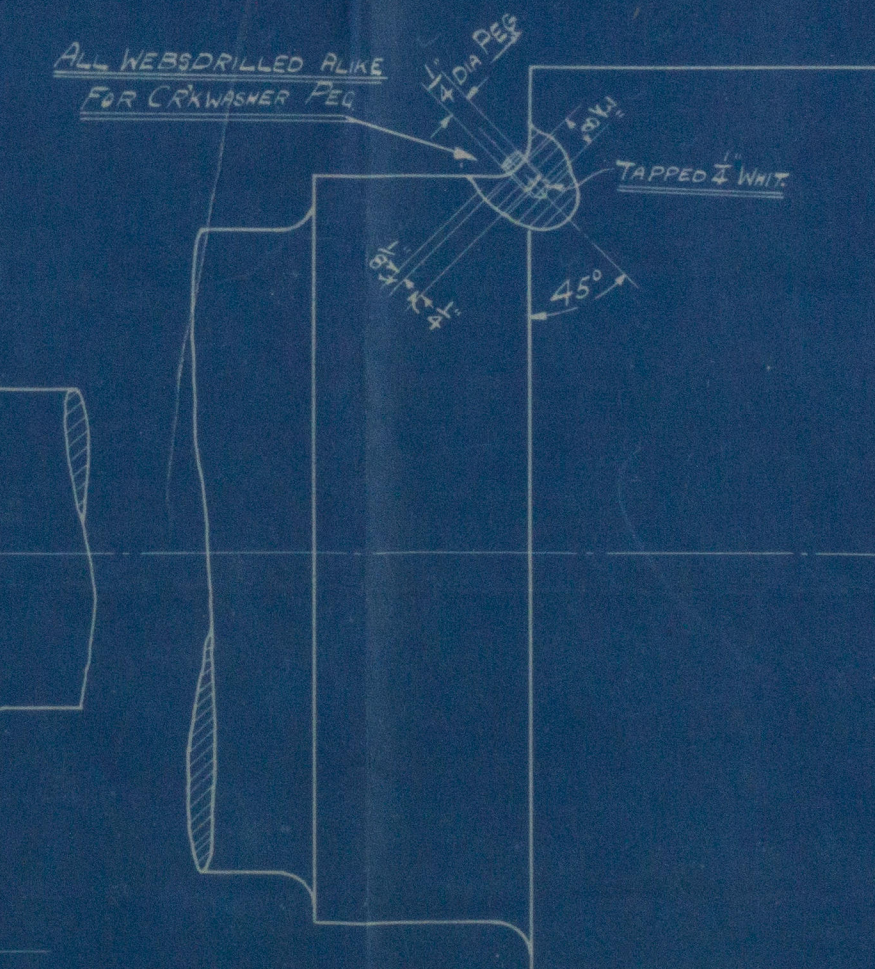
COMPLETE CRANKSHAFT FORMED OF TWO SIMILAR SECTIONS  
 SCALE: 3/4" = 1 FOOT



IMPORTANT: THIS SHAFT TO BE MADE TO  
 LLOYDS REQUIREMENTS.



DRILL OIL HOLES  
 IN JIG NO 1405



# CRANKSHAFT

2 OFF PER ENGINE

SIEMENS-MARTIN ACID STEEL

MACHINED ALL OVER

SCALE 1/2" = 1 FOOT

From VICKERS-PETTERS, Ltd.  
 IPSWICH.

FOR ENCLOSURE TO

M. Brown for  
 Lloyd's Register of  
 Shipping  
 Date 4.8.20  
 W319-0172(2/2)

PART NO  
 134

DRG. NO  
 125

VN.6.M



Vickers-Petters Ltd

Engines 251-2

Grant Shaft

London Rpt 85486.  
"Sona"

Son. 11316

W319-0172

Grant Shaft



© 2019

Lloyd's Register  
Foundation