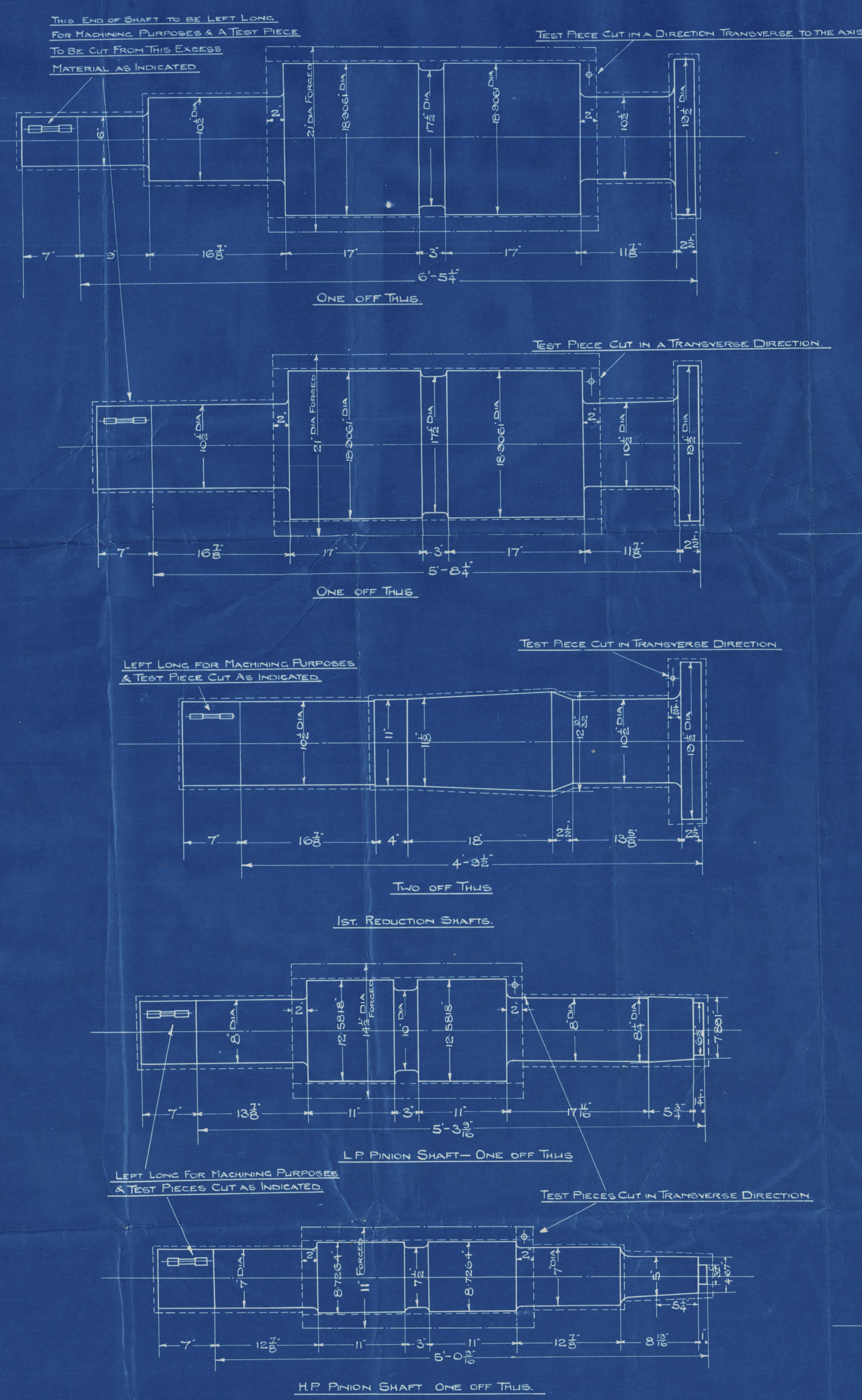


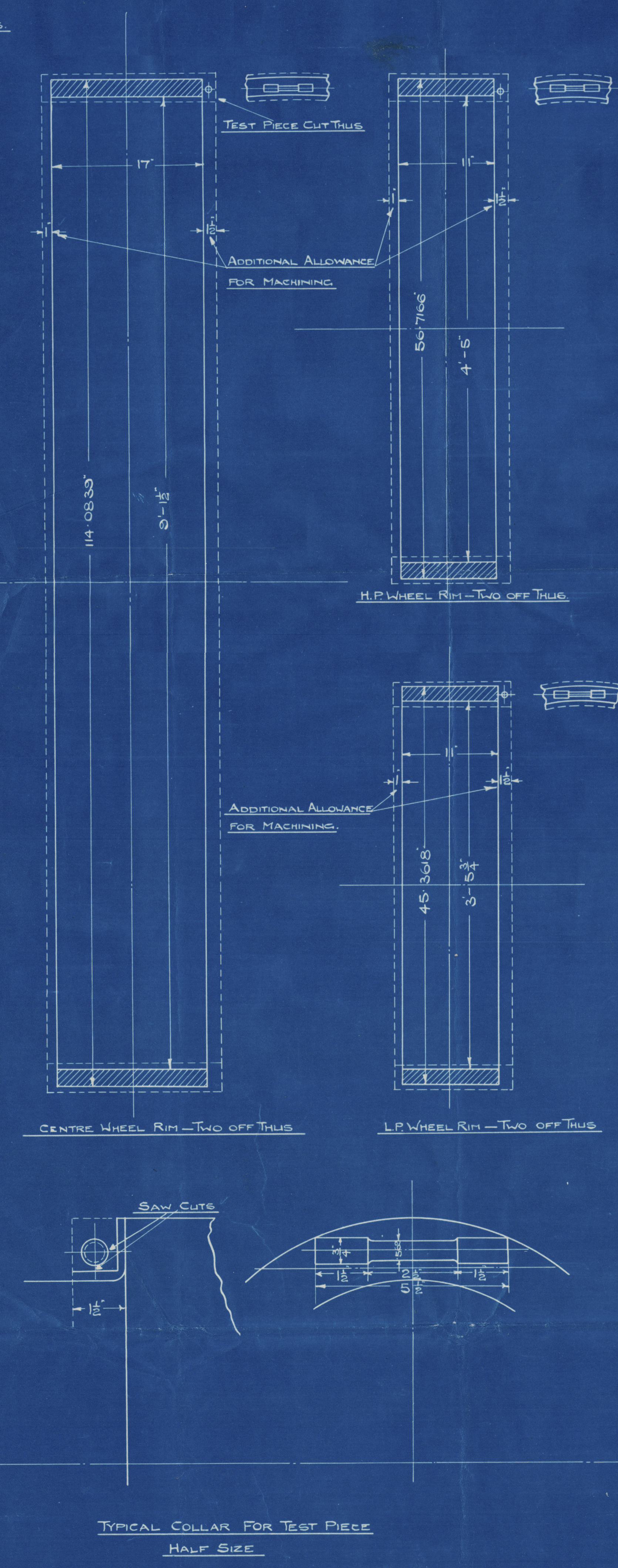
SURVEY BOT & LLOYDS

FORCINGS FOR CENTRE SHAFT, NUTS & KEYS M226G.

DRAWN BY *AS-TRADE MARK M226G*
 TRACED BY *6/11/20*
 CHECKED BY *13/5/19*
 DATE



SCALE 1 1/2" = ONE FOOT.



TYPICAL COLLAR FOR TEST PIECE
 HALF SIZE

SURVEY:- B.O.T. & LLOYDS.

SPECIFICATION OF MATERIAL.

PINIONS & SHAFTS.

THE SHAFTS AND PINIONS TO BE NICKEL STEEL CONTAINING NOT LESS THAN 3 1/2% AND NOT MORE THAN 5% NICKEL WITH CARBON CONTENT FROM .25% TO .32% PHOSPHORUS AND SULPHUR NOT TO EXCEED .045% EVERY PRECAUTION TO BE TAKEN TO EXCLUDE OXYGEN, NO CONSTITUENTS BEING ADDED SUBSEQUENT TO THE FINAL DECARBIDISATION OF THE BATH MANGANESE NOT TO EXCEED .7%

TEST PIECES WHEN CUT IN A DIRECTION TRANSVERSE TO THE AXIS TO FULFIL THE FOLLOWING REQUIREMENTS:-

TENSILE STRENGTH.	40-45 TONS PER SQUARE INCH
ELASTIC LIMIT.	26 TONS PER SQUARE INCH
ELONGATION.	16-20% IN TWO INCHES
BENDING TEST	TEST PIECE 3/4" WIDE AND 3/4" THICK TO BE BENT OVER A 3/4" RADIUS THROUGH 180° WITHOUT FRACTURE

TEST PIECES WHEN CUT IN A LONGITUDINAL DIRECTION TO FULFIL THE FOLLOWING REQUIREMENTS:-

TENSILE STRENGTH	40 TONS PER SQUARE INCH
ELONGATION	25% IN TWO INCHES
BENDING TEST	TEST PIECE 1" SQUARE TO BE BENT OVER A 3/4" RADIUS THROUGH 180° WITHOUT FRACTURE

WHEEL RIMS.

THE RIMS TO BE HOLLOW FORGED STEEL

TEST PIECES TO FULFIL THE FOLLOWING REQUIREMENTS

TENSILE STRENGTH.	31-35 TONS PER SQUARE INCH
ELONGATION	20% IN TWO INCHES
BENDING	TEST PIECE 1" SQ. TO BE BENT OVER A 3/4" RADIUS THROUGH 180° WITHOUT FRACTURE

NOTE.

TEST PIECES TO BE CLEARLY STAMPED IN THE PRESENCE, AND TO THE SATISFACTION OF THE B.O.T. & LLOYDS SURVEYORS, AND ARE THEN TO BE SAWN OFF AS INDICATED AFTER THE ROUGH MACHINED FORGINGS HAVE BEEN OIL QUENCHED AND ANNEALED.

METHOD OF PREPARING FORGINGS & TEST PIECES.

FULL LINES SHOW OUTLINE OF FORGINGS AS 'FINISHED MACHINED'
 DOTTED - - - - - 'ROUGH MACHINED'
 CHAIN DOTTED - - - - - 'ROUGH FORGINGS'

ALL TEST PIECES MUST BE CUT BEFORE FORGINGS ARE ROUGH MACHINED THE RIMS ARE TO BE ROUGH MACHINED TO DOTTED LINES WHICH LEAVE 3/8" ON THE DIAMETER FOR FINISHING AND ON THE LENGTH, 1" ON ONE SIDE FOR CHUCKING PURPOSES AND ON THE OTHER SIDE 1 1/2" FOR TEST PURPOSES.

THE PINION SHAFTS ARE TO BE ROUGH MACHINED, LEAVING 1/4" ON THE DIAMETER AND 3/8" ON ALL END SURFACES FOR FINISHING EXCEPT THE ENDS OF THE PINION PARTS OF THE SHAFTS WHERE 1/4" MUST BE LEFT ON.

ALL THE SHAFTS AFTER ROUGH MACHINING TO BE OIL QUENCHED AND ANNEALED. SPECIAL PRECAUTIONS TO BE TAKEN TO SECURE UNIFORM MATERIAL IN THE NEIGHBOURHOOD OF THE TEETH.

ALL FORGINGS TO BE PERFECTLY SOUND AND FREE FROM ALL FLAWS, AND IN ADDITION TO PASSING THE SURVEYS MENTIONED, TO BE TO OUR, AND OWNERS ENTIRE SATISFACTION.

TO BE DELIVERED AT OUR HARTLEPOOL WORKS.

See HPL Letter 15/1/20
 12/1/20
 10/1/20
 8/1/20

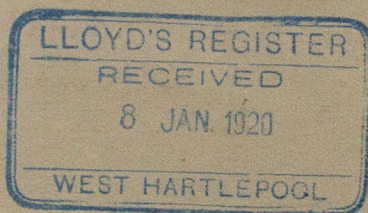
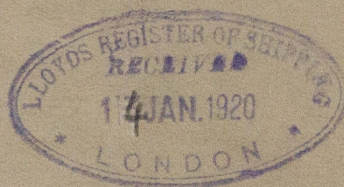
14248

Pickard & Co. Whitby & Co.

T 192 - Year shipping
for

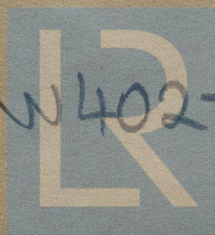
Dr R. Dixon & Co. 596 ^{1/2} road

RETAIN



"St. Hurmuzi"
MIDDLESBRO' 10931.

RETAIN



© 2020

W402-0155

Lloyd's Register
Foundation