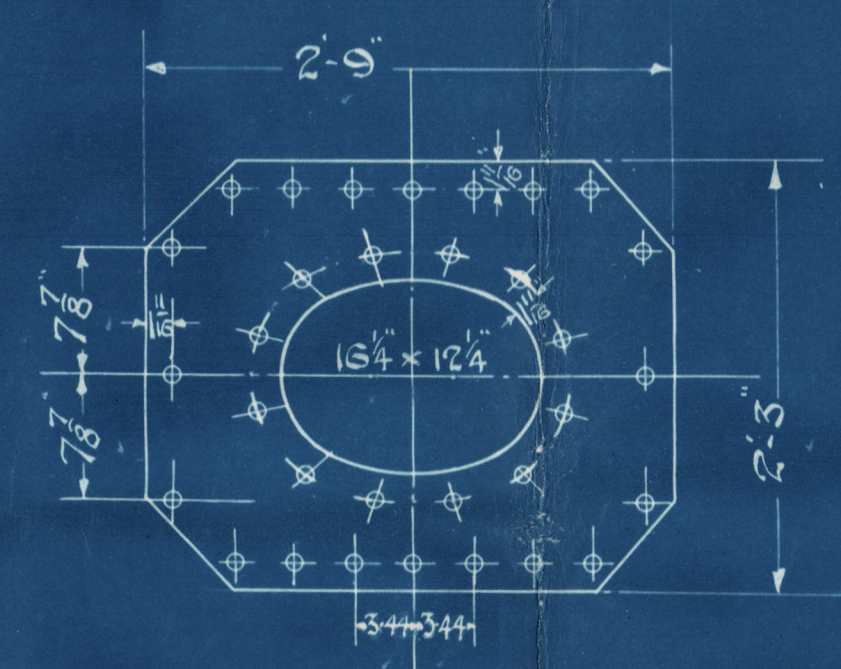
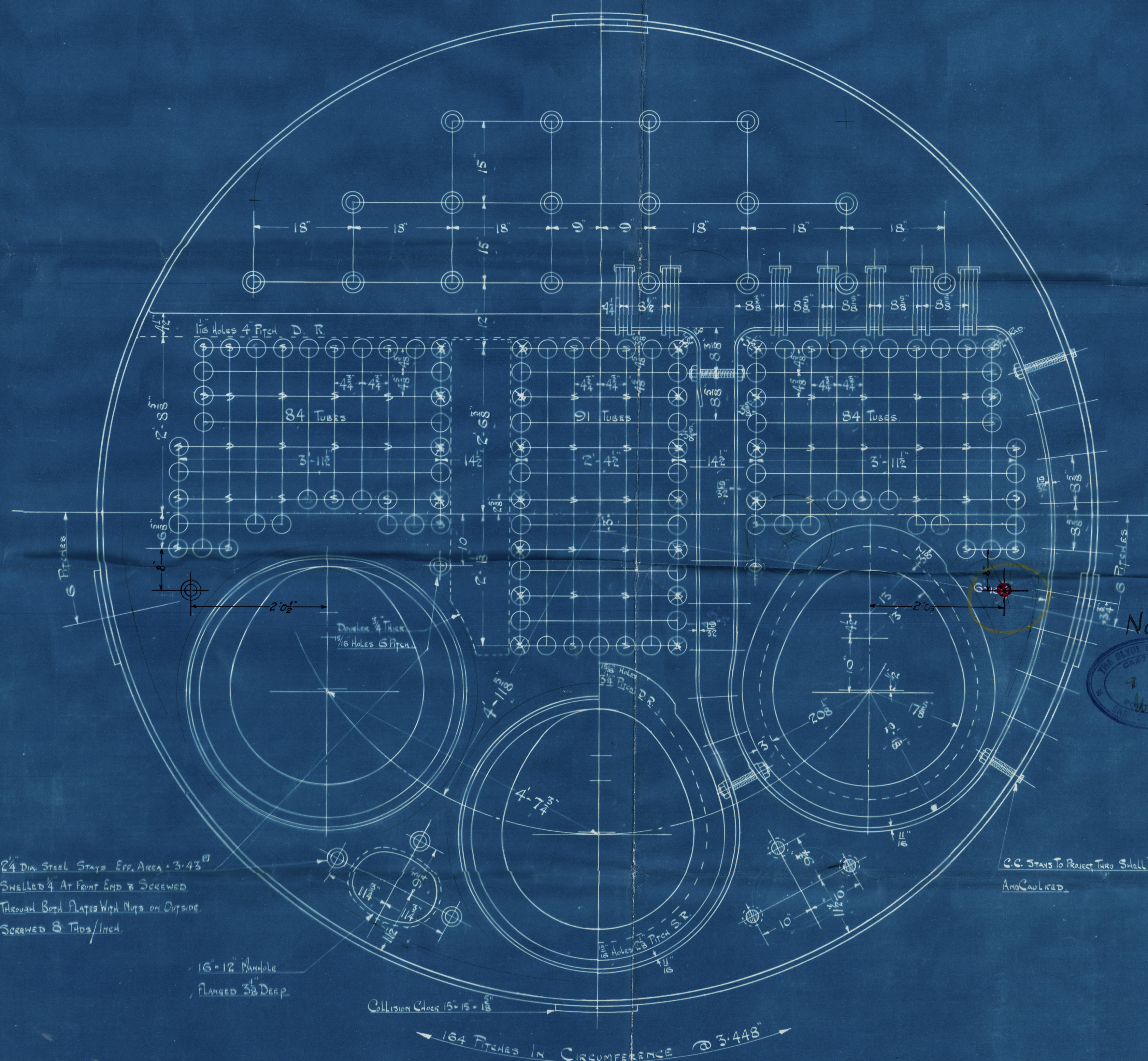


6/2/25



Shell Opening 15'-12"
 Manhole Doubling Plates 1 1/2" Thick
 Rivet Holes 1 1/2" Dia.
 M^cNeil's Doors.
 Bottom of Manhole Given Later.

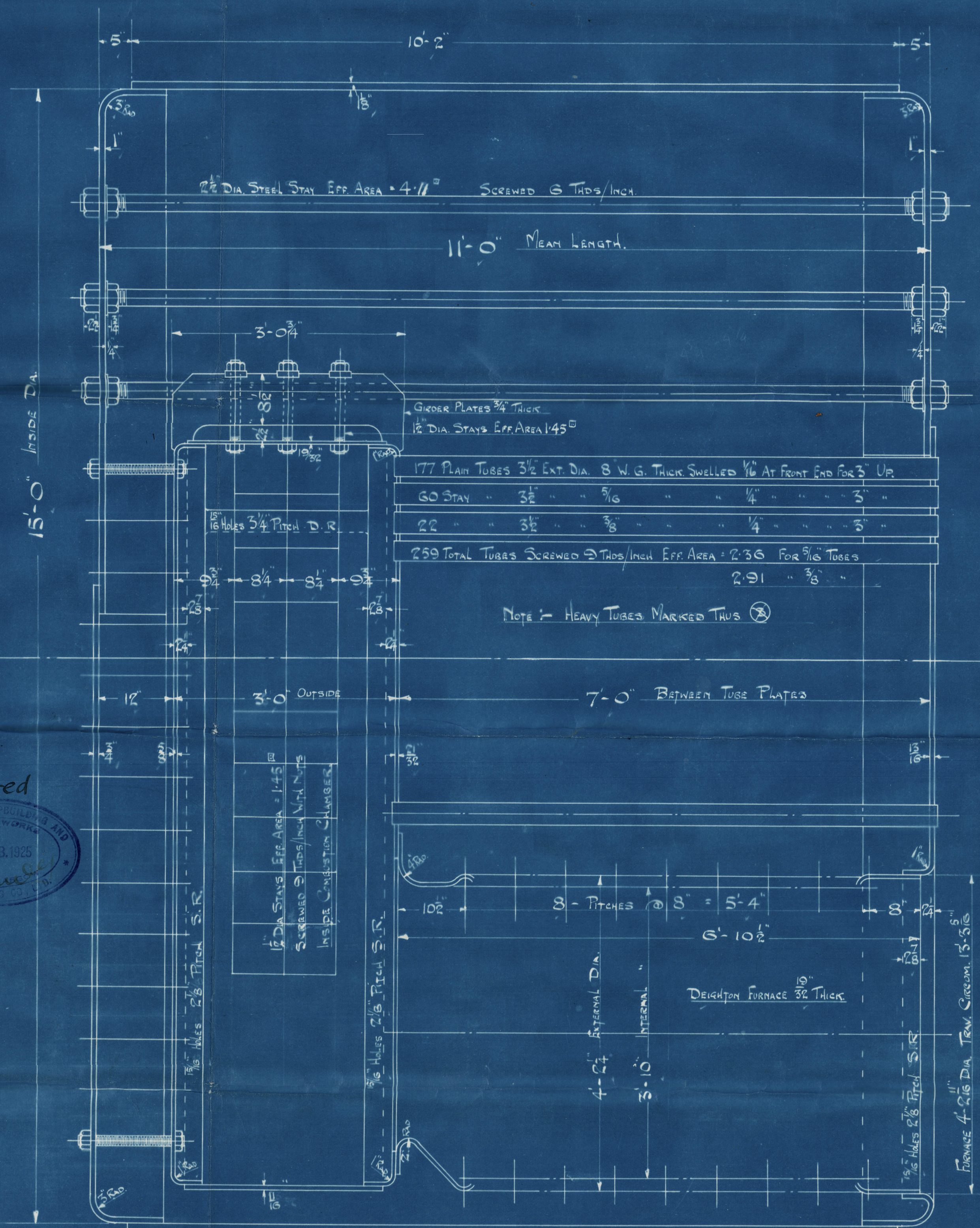


2 1/2" Dia. Steel Stays Eff. Area = 3.43"
 Shelled 4" At Front End & Screwed
 Through Bolt Plates With Nuts on Outside
 Screwed 8 Ties/Inch.

16'-12" Manhole
 Plunged 3 1/2" Deep.

2 1/2" Stays To Rivet Tubes Shell 1/4"
 And Caulked.

Noted
 4 FEB 1935
 H. W. LLOYD



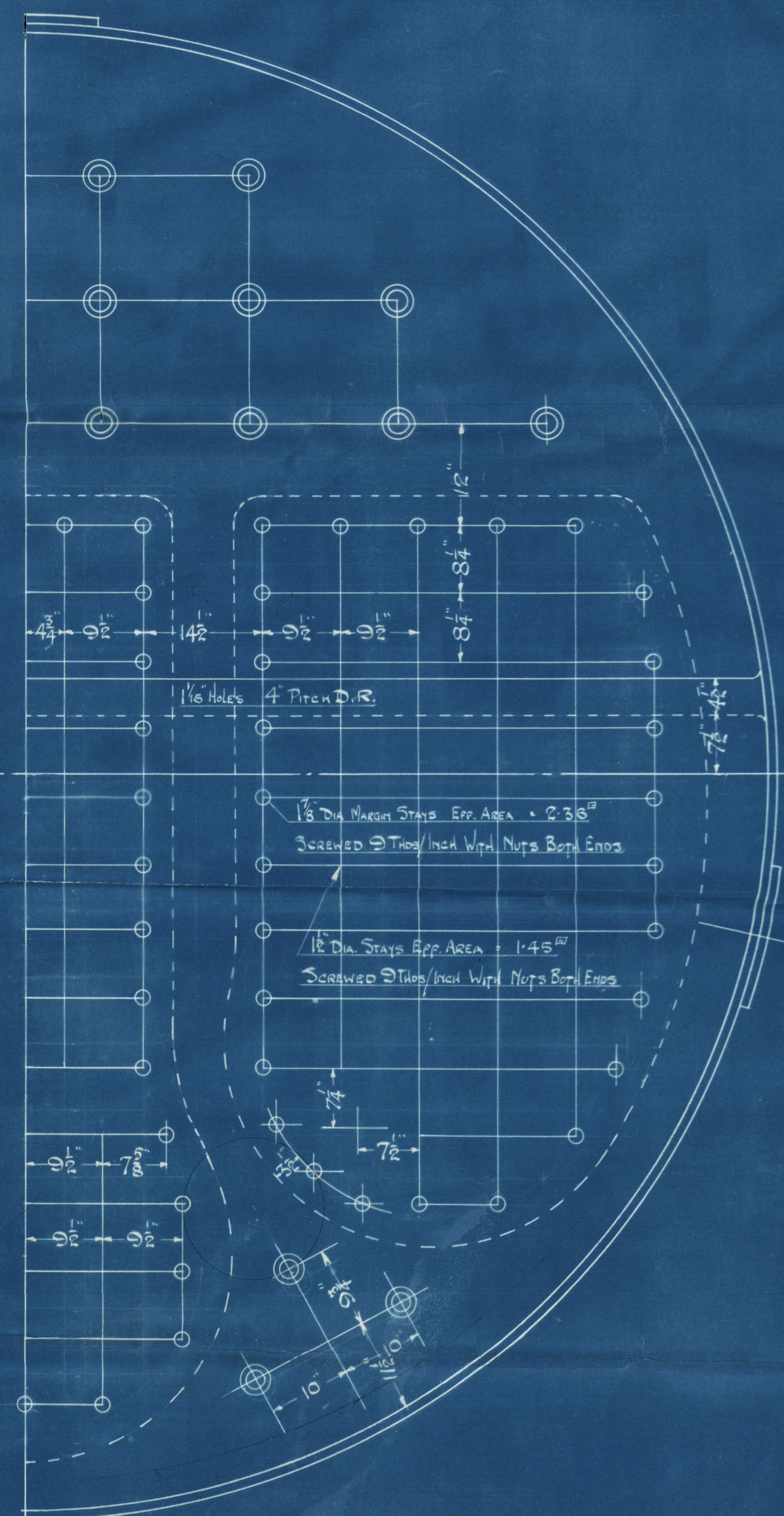
Girders Plates 3/4" Thick
 1 1/2" Dia. Stays Eff. Area 1.45"

177 Plain Tubes 3 1/2" Ext. Dia. 8 W.G. Thick Swelled 1/8" At Front End For 3" UP
 60 Stay " 3 1/2" " 5/16" " 1/4" " 3"
 22 " " 3 1/2" " 3/8" " 1/4" " 3"
 259 TOTAL TUBES SCREWED @ 8 TIES/INCH EFF. AREA = 2.36 FOR 7 1/2" TUBES
 2.91 " 3/8"

Note: Heavy Tubes Marked Thus ⊗

1 1/2" Dia. Stays Eff. Area = 1.45"
 Screwed @ 8 Ties/Inch With Nuts
 Inside Combustion Chamber.

DEIGHTON FURNACE 30" THICK



1 1/2" Dia. Manhole Stays Eff. Area = 2.36"
 Screwed @ 8 Ties/Inch With Nuts Both Ends
 1 1/2" Dia. Stays Eff. Area = 1.45"
 Screwed @ 8 Ties/Inch With Nuts Both Ends

Material and Tests

NAME OF PART	MATERIAL	TENSILE LIMIT	MINIMUM ELONGATION
Shell, Butt, Straps, Girders	STEEL	28,750 LBS	20% on Length
Comb. Chambers, Furnaces, Flanged Plates	"	28,300 "	25% " "
Other Plates	"	28,300 "	20% " "
Longitudinal Stays	"	28,300 "	20% on Surface B
Comb. Chamber "	"	28,300 "	25% " "
Rivet Bars	"	28,300 "	25% " "
Tubes	IRON		

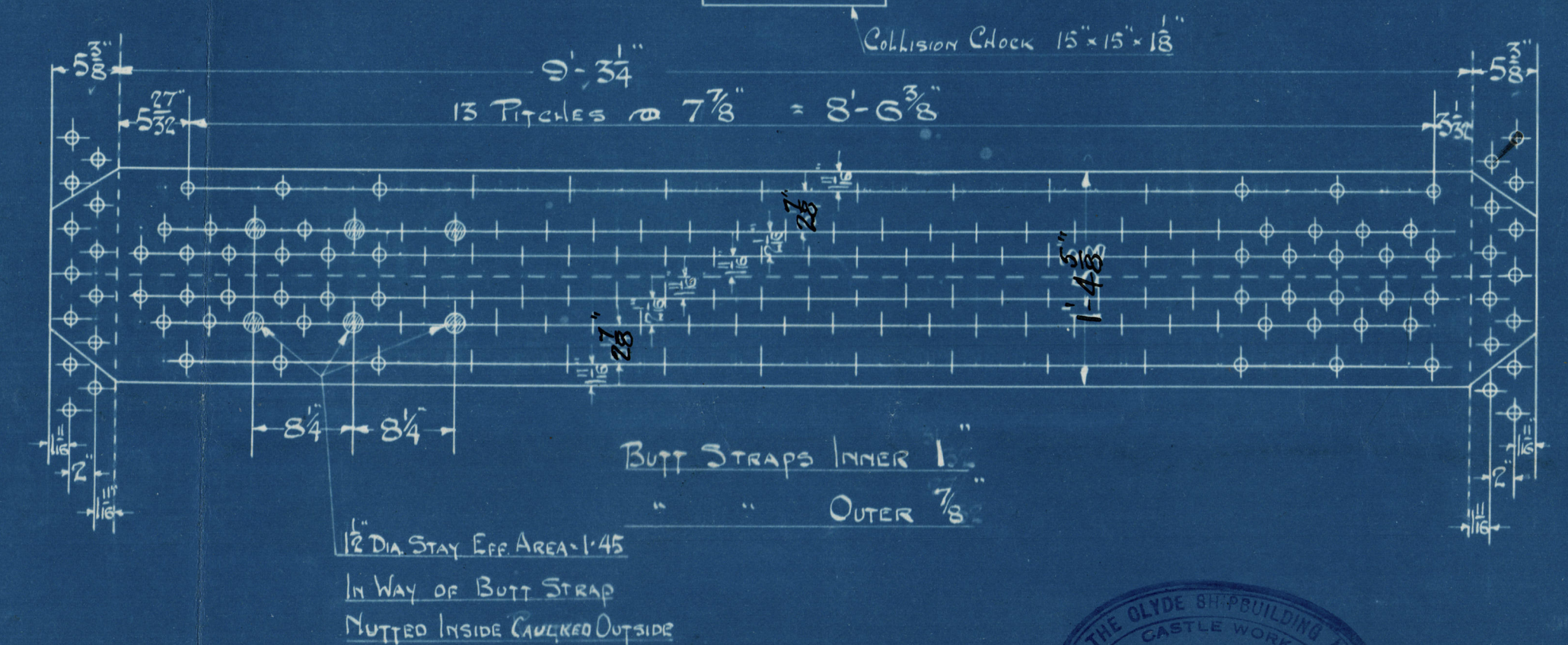
RIVETING

	LONG.	CIRCUM.
Rivet Hole Dia	1 1/2"	1 1/2"
Pitch	7 1/2"	3.448"
% PLATE	85.7	67.5
% RIVET	86.48	42.08
% COMB.	88.75	

SURFACES

PART	SQ FEET
H.S. IN TUBES	1682
" FURNACES	135
" COMB. CHAM.	303
" TOTAL	2100
G.S. 5'-6" BARS	63

Note: All Rivet Holes Drilled In Place, Plates Afterwards Taken Apart and Bars Removed
 To P. H. LLOYD'S SURVEY FOR A WORKING PRESSURE OF 150 LBS/SQ
 TEST PRESSURE 200 LBS/SQ



1 1/2" DIA STAY EFF. AREA 1.45"
 IN WAY OF BUTT STRAP
 NUTTED INSIDE CAULKED OUTSIDE

THE CLYDE STEELWORKS LTD
 27 JAN 1935
 H. W. LLOYD
 ENGINEERING CO. LTD

MAIN BOILER
 SO 918

SCALE 1" = 1'-0"

7571

W 405-0114

RETAIN

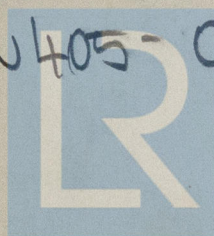
Clyde S B & E Co.
Port Glasgow.
S O 918,
New Boiler for
SS "ACHROITE"

W.P. 160 LBS

Greenock Shipyard No. 18449

RETAIN

W405-01442019



Lloyd's Register
Foundation