

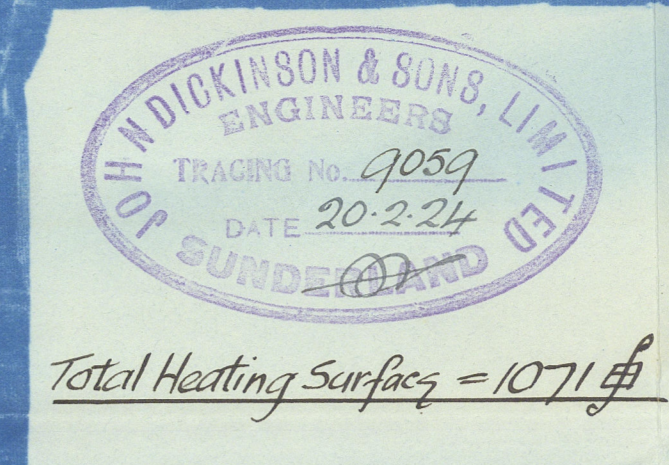
28/2/24

HORIZONTAL DONKEY BOILER

To Lloyds requirements for a working pressure of 180 lbs per Sq. In. Test pressure 320 lbs per Sq. In.

All plates, rivets, stays & girders of steel Tubes of wrought iron

SCALE: ONE INCH = ONE FOOT 25

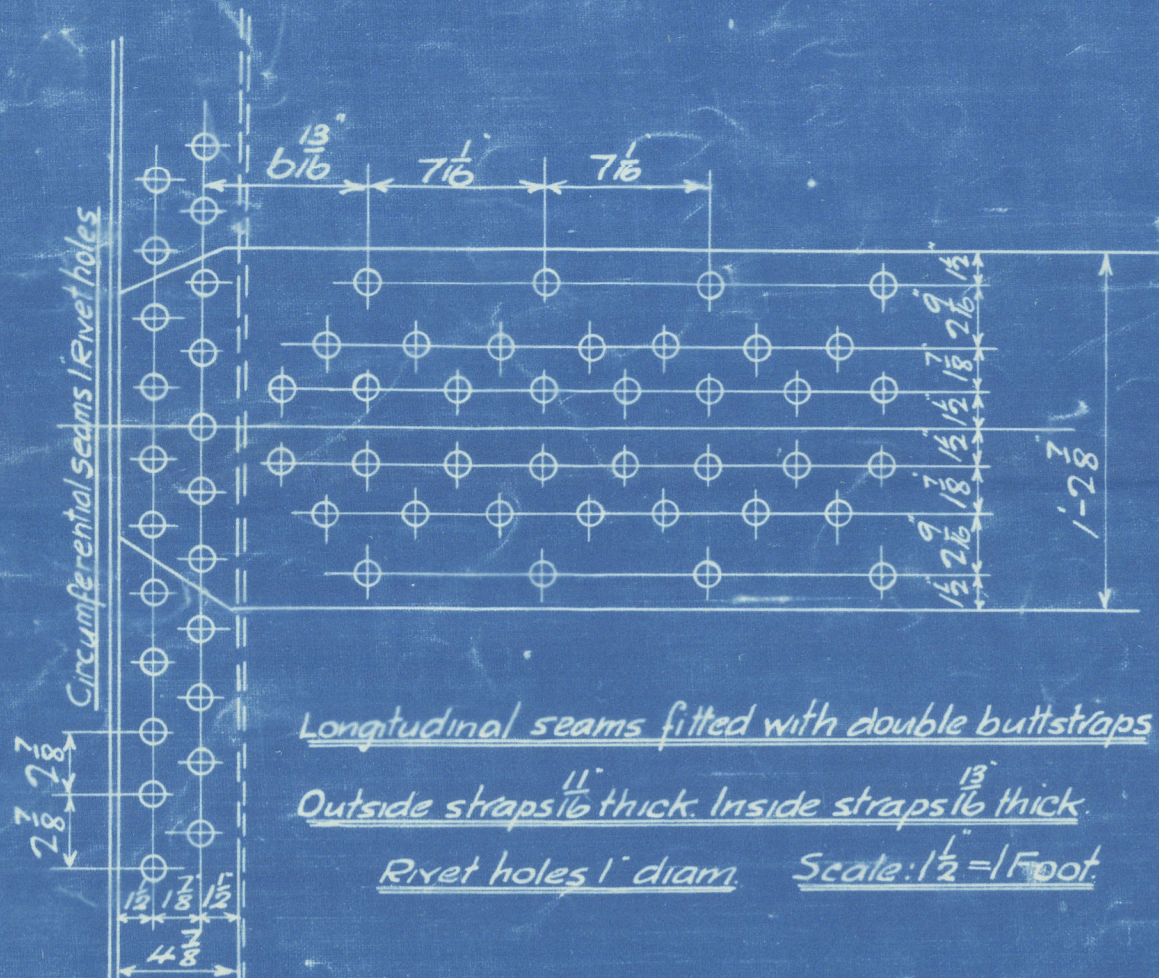


TENSILE STRENGTH

Plate	Tens. per Sq. Inch
Shell plates, buttstraps	28 to 32
Manhole stiffening Rings	28 to 32
Comb. Chamber Girders	28 to 32
All other plates	26 to 30

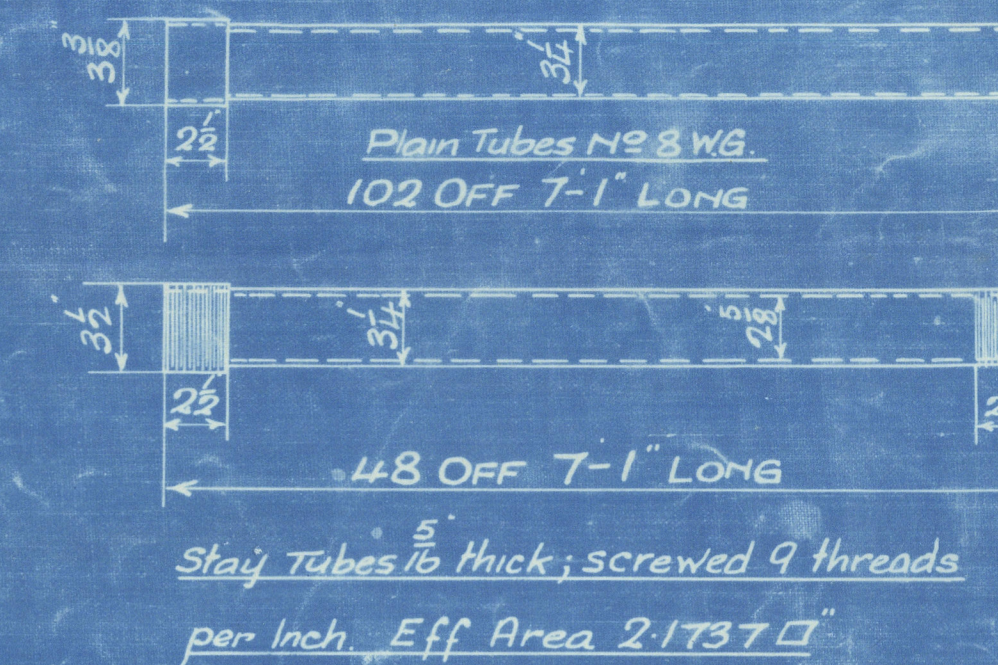
RIVETING

Position	Riveting	Quantity	Plate	Lap
Comb. chamber longitudinal seams	Single	15	2 1/2	2 1/2
Comb. chamber & Furnace seams	Single	16	2 1/2	2 1/2

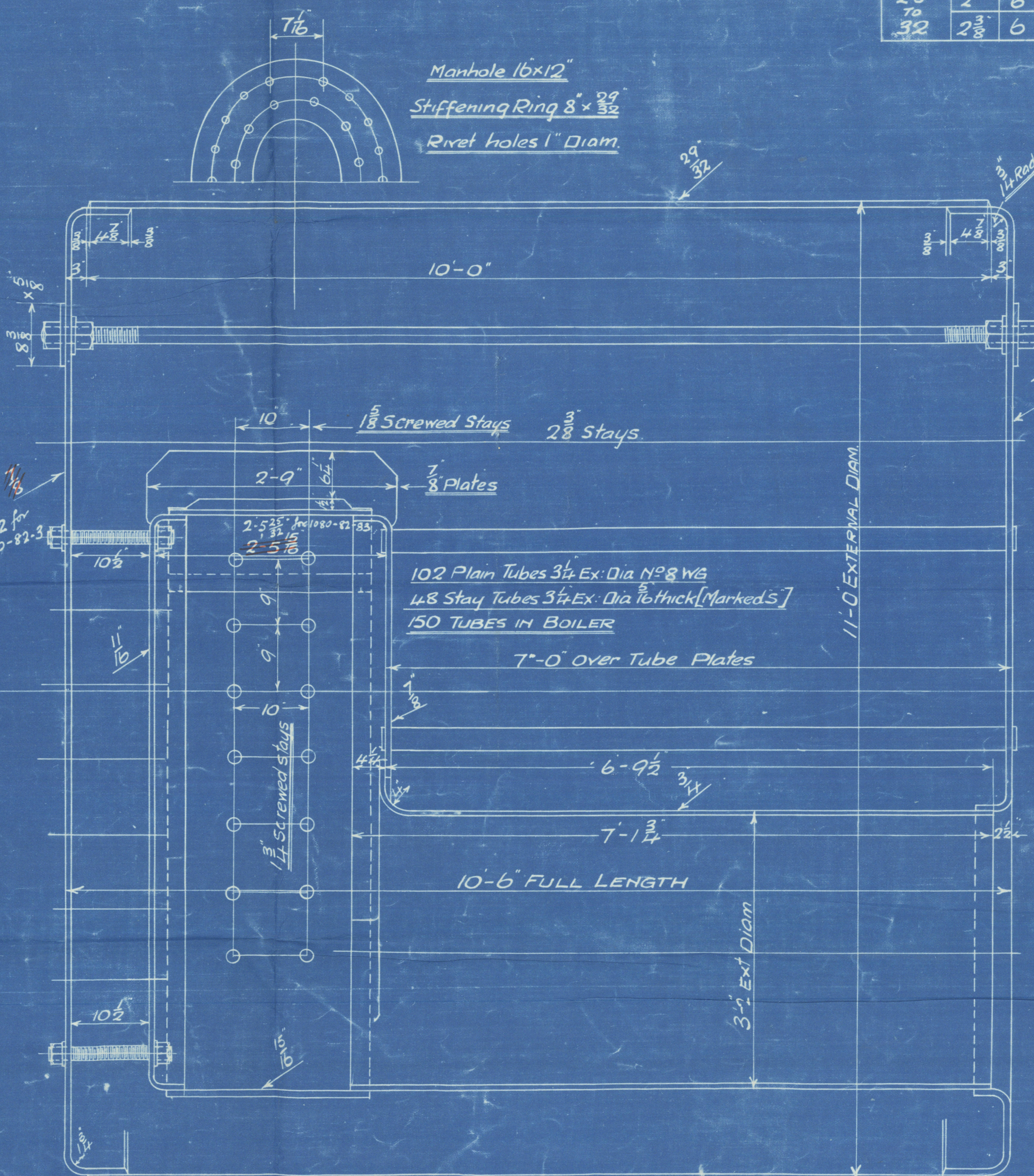
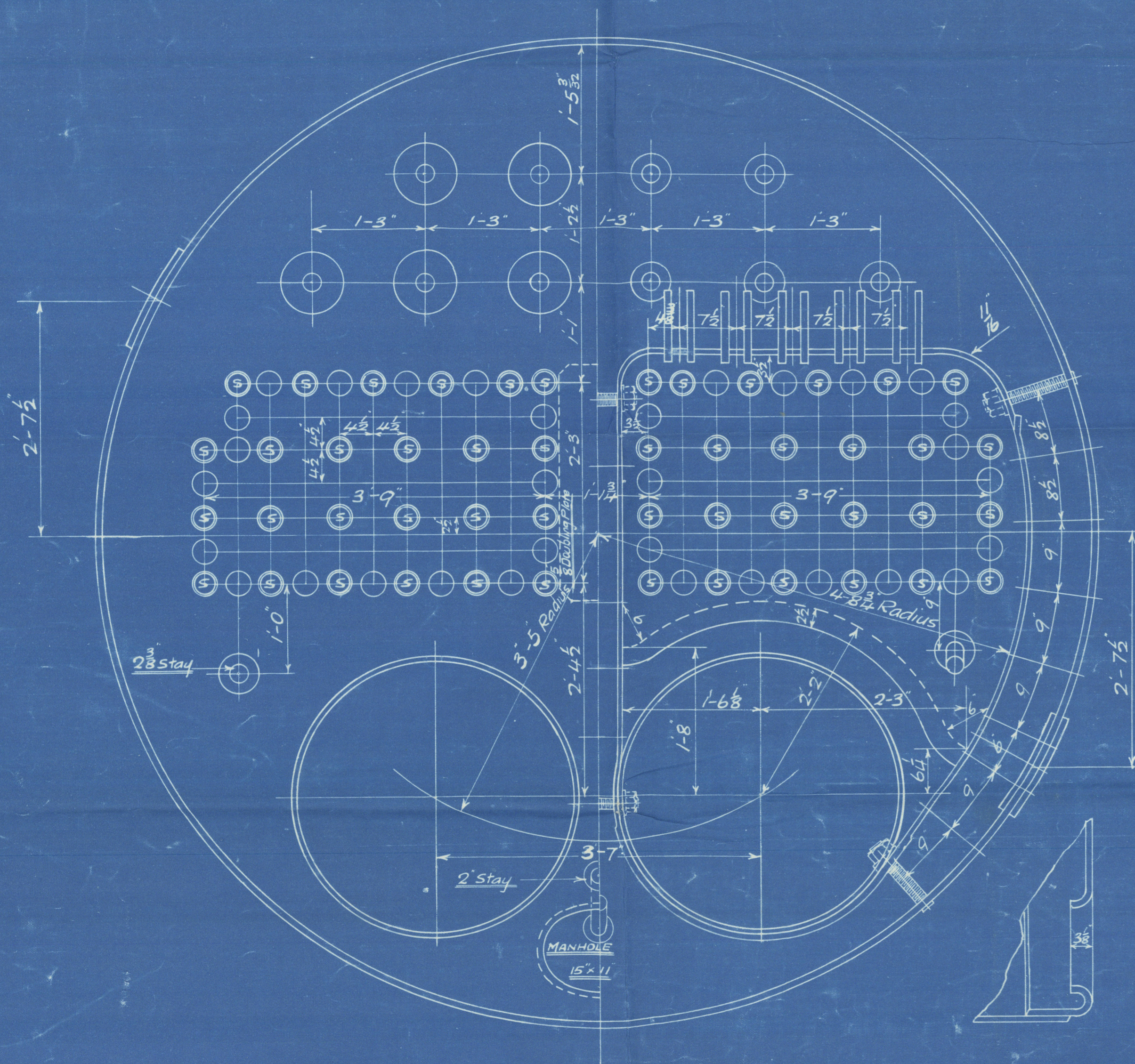


Longitudinal seams fitted with double buttstraps
Outside straps 1/8 thick Inside straps 1/8 thick
Rivet holes 1" diam Scale: 1 1/2" = 1 Foot

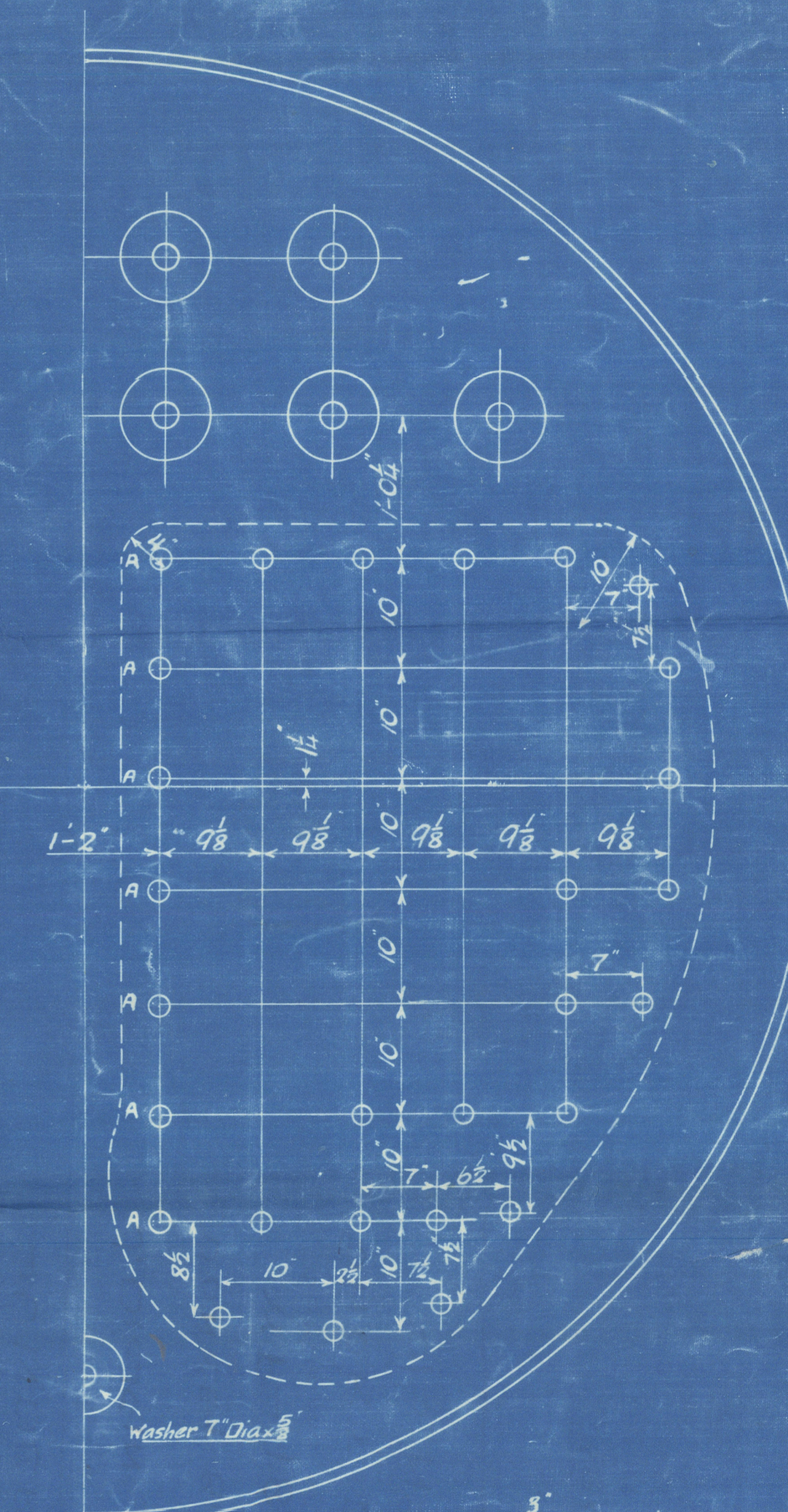
STAYS					
Tensile strength	Diam.	Yield point	Eff. Area	Eff. Area	No. in Boiler
26	1 1/8	9	1.4828	1.73	20
30	1 1/8	9	1.607	2.031	12
28	1 1/8	9	1.7328	2.355	14
32	1 1/8	9	2.1618	3.68	12



Stay Tubes 5/16 thick; screwed 9 threads per inch. Eff Area 2.1737 sq in



For position of angles on back & rolling stays see Arrangement of Mountings



1 1/8" Screwed Stays
1 3/8" Screwed Stays (Marked 'A')

NOTE: Stays between combustion chambers & marginal stays in backs screwed thro' both plates & not fitted to each end.
Stays from combustion chambers to shell & remainder of stays in back to have not fitted on inner end only; & to project 3/8 thro' plate & to be caulked.

DATE	
Nº1080	864
Nº1081	865
Nº1082	867
Nº1083	867



SUNDERLAND

J. DICKINSON & sons^{LD}

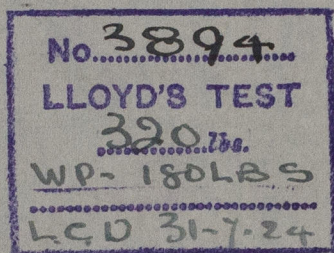
DONKEY BOILER N^o 1083

WP- 180 LBS

DUPLICATE OF N^o 1082

SHORT BROS LTD

S/S N^o 417



SUNDERLAND REG. NO. 28901

RETAILED

Kafuristai

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Lloyd's Register
Foundation