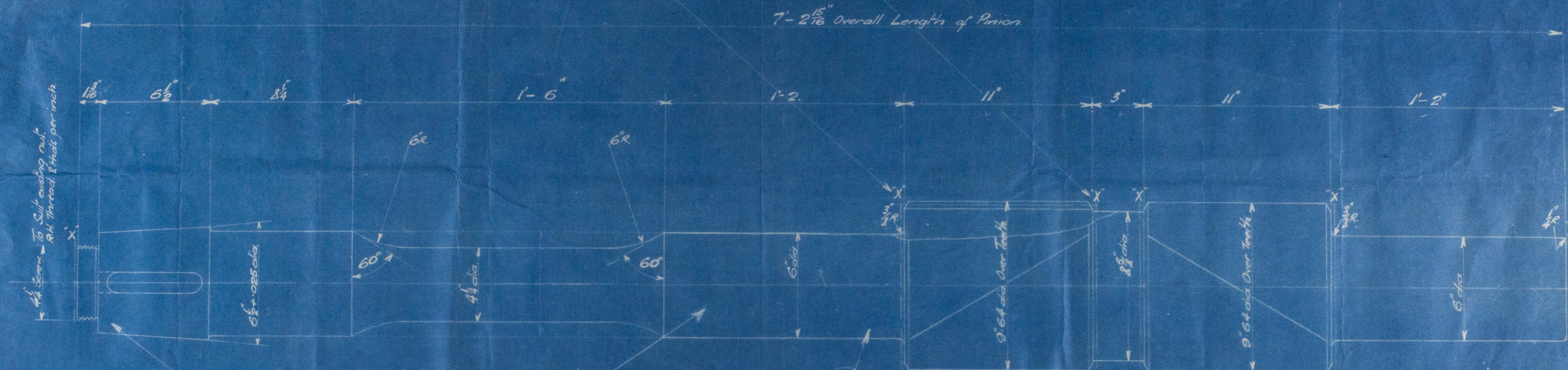


IMPORTANT:-

$\frac{1}{8}$ " To be left on all side faces of pinion at "X" for trueing up after teeth have been cut and the exact position of helices have been determined from the pinion returned to these works.

BILL OF MATERIALS					
Item	Qty	Reqd	Description	Matl	Remarks
1	1	1	High Speed Pinion Forging SK 4.4/146	F.S.	1020
2	1	1	Feather Key (1.5/16" x 1/2" x 1/4")	SS 18	1230
3	1	1	Gib Head Key (0.5/16" x 1/2" x 1/4")	Forged	SK 4.4/146, 1230



This end of Pinion to be machined after cutting of teeth. Exact sizes and position of coupling cone, size of keyways, diameters of bearings, to be determined from the pinion returned to these works.

Above pinion is duplicate of pinion supplied by Messrs. Swan Hunters to their dng T.131, modified to MV Sketch #412559.

(Metro-Vick Dng #E.20543)

40Z5. OF CLEAN TURNINGS OF ABOVE PINION
TO BE SENT TO CHEMICAL DEPT.

$\frac{1}{32}$ " Radius Draw file on full width of teeth of Pinion.

PARTICULARS OF GEARS.		PINION
No. of Teeth		43
Pitch Circle Diameter		9" 269
Dia. over Teeth		9" 640
Face Width		22"
Circular Pitch		6.74212
Spiral Angle		30° 35' 24"
Lead per Tooth		55.48
Hob		1/2 Single Lead

Metropolitan Vickers Electrical Co Ltd.
Manchester - England.

- DETAIL OF HIGH SPEED PINION -
- S.S. "MIDDLESEX" -

Scale = 3" = 1 Foot.
S.O. 140094/1

B.368691



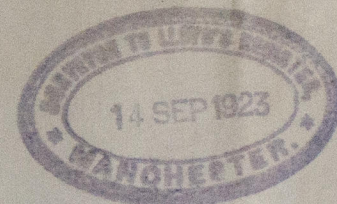
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1	Date 6/9/23 Checked M.G. Design	2	Date 7/9/23 Checked M.G. Design
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Distance between Coupling Head and Bearing was 6" diameter parallel.

Subject to Lloyds Survey.



Hugh Spud Pinner
55. Middleton
Antar. Vickers Elec. Co.
Registration 2
140094/1.

W53- 0155

