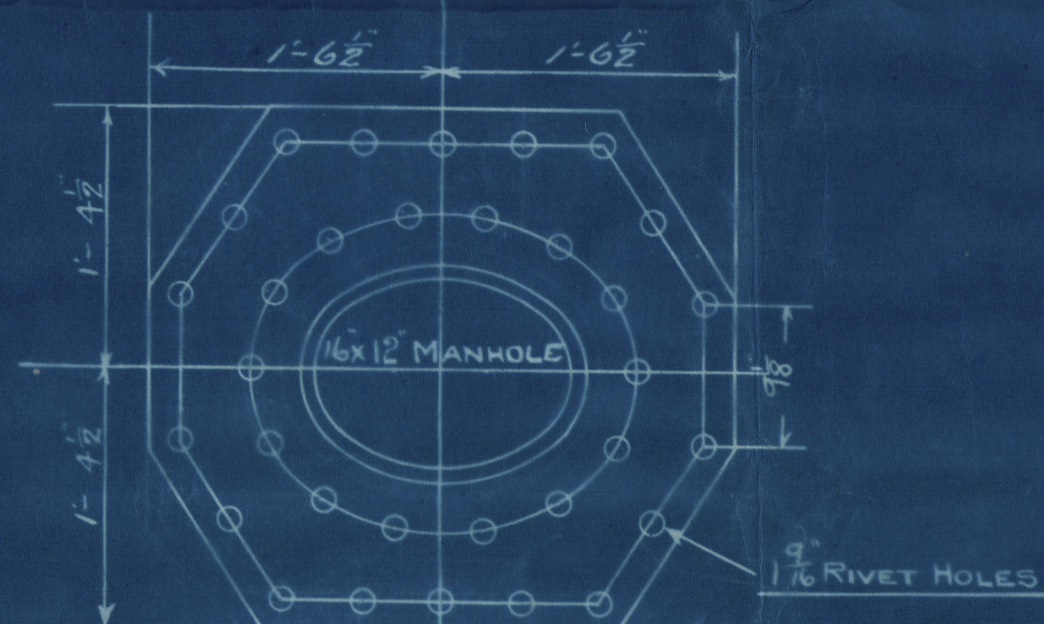


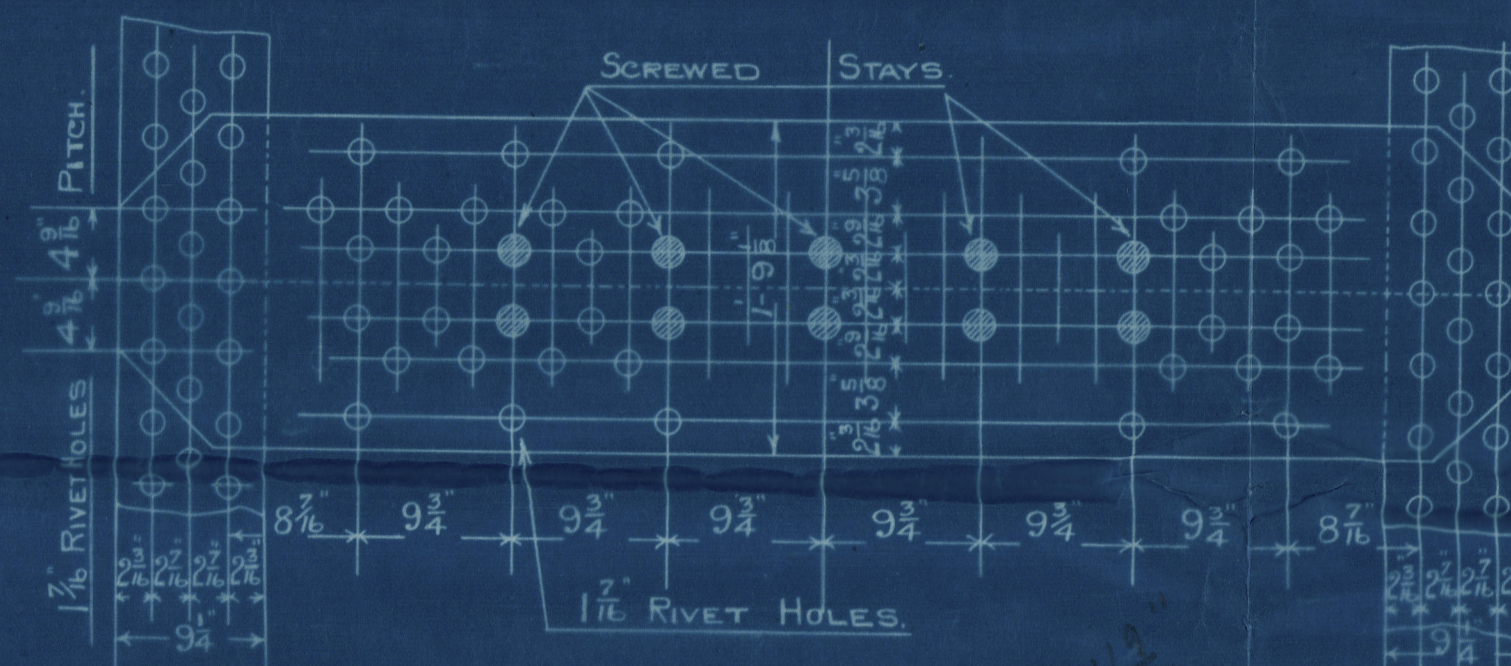
24/4/19



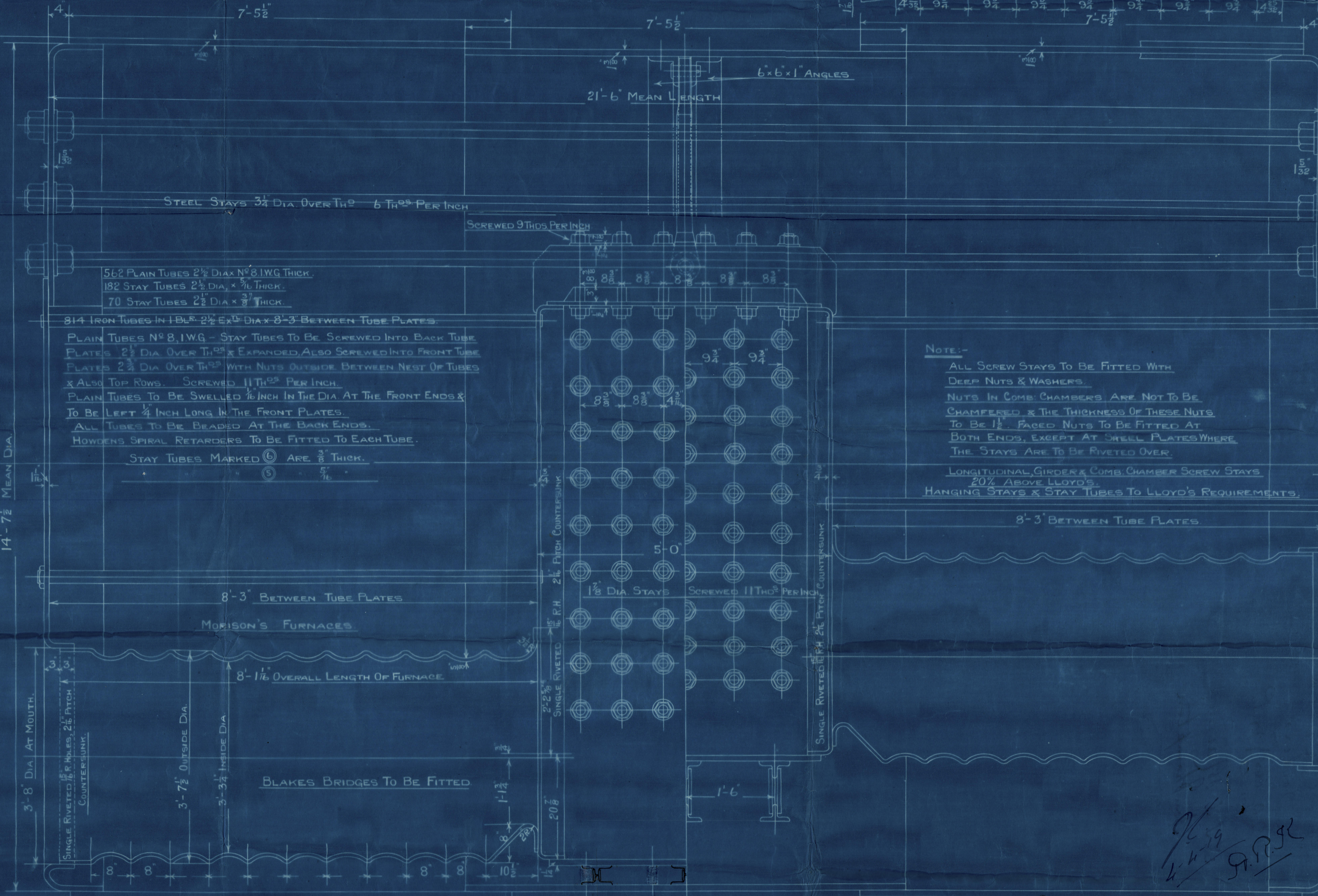
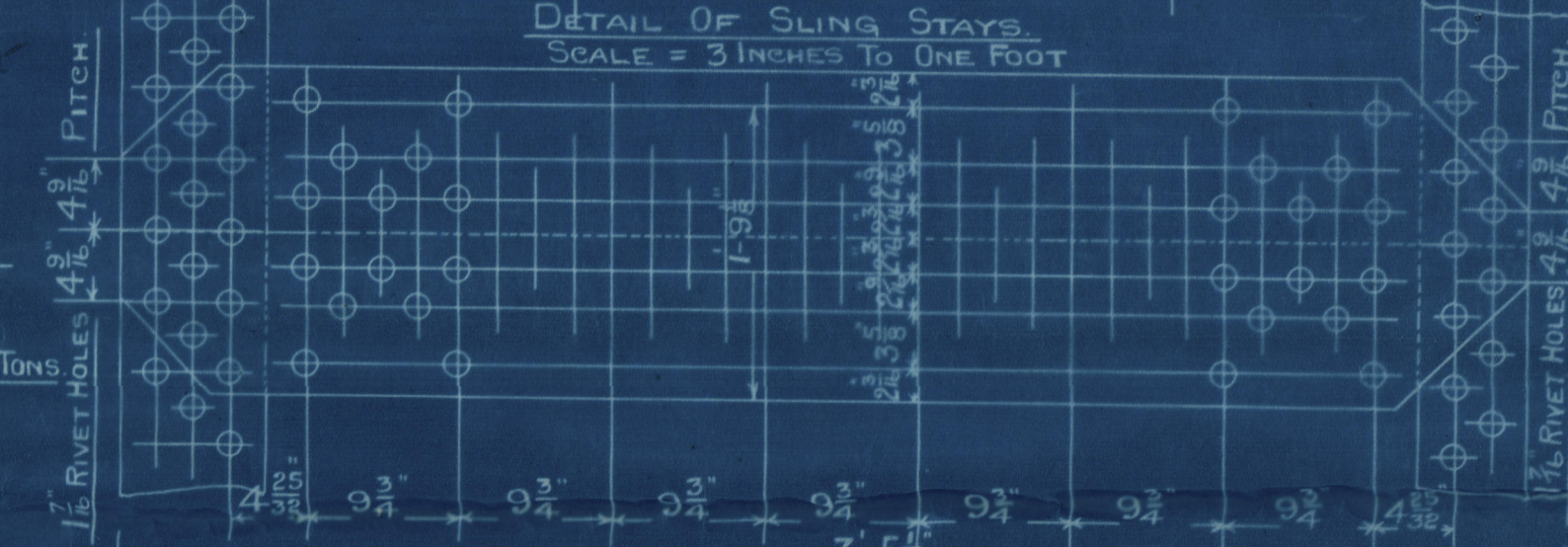
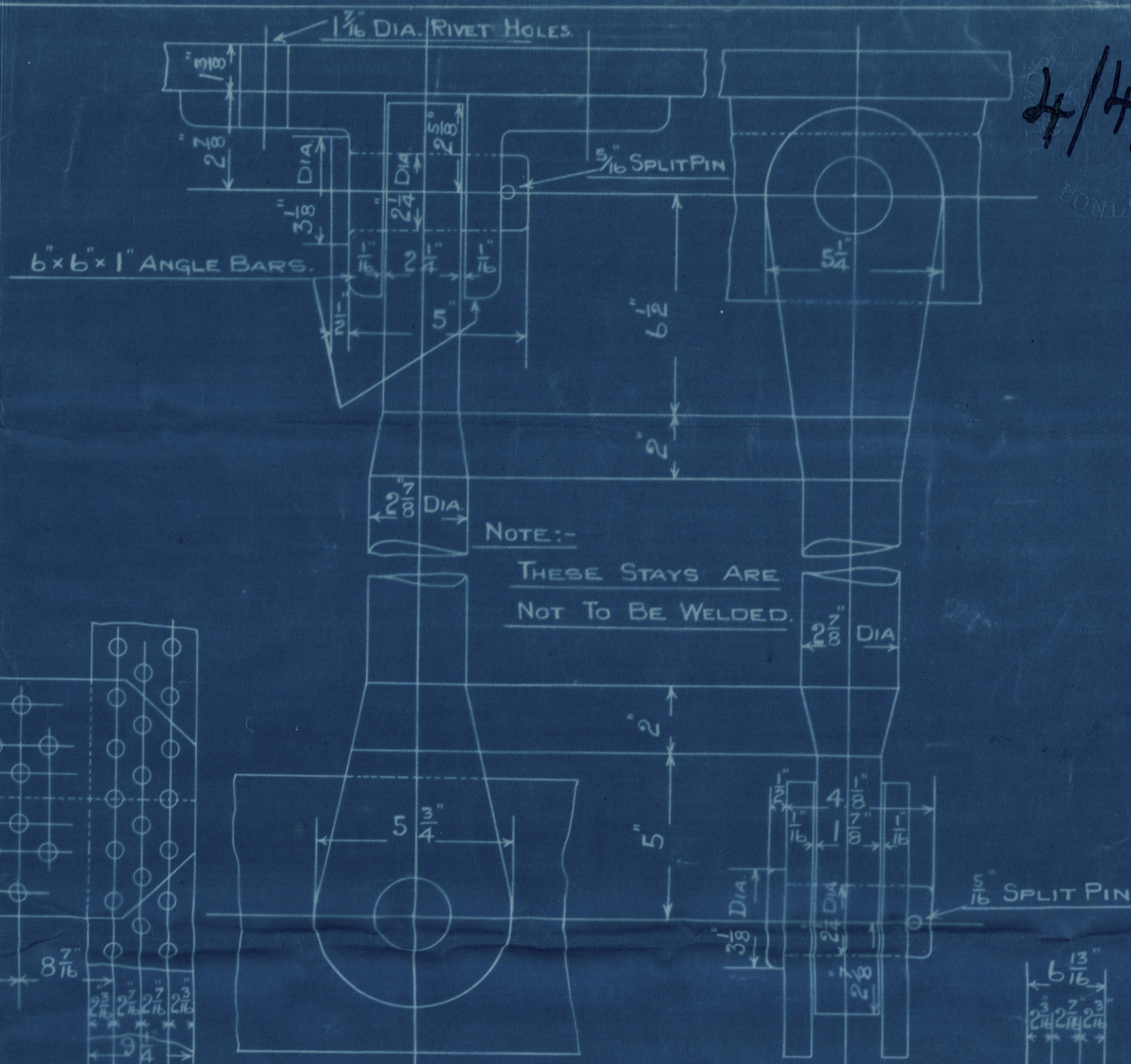
HEATING SURFACE OF DOUBLE ENDED BOILERS.

TUBES	814 x 2 1/2" DIA x 8'-3" =	4400 #
FURNACES		326
COMBUSTION CHAMBERS		259
BACK TUBE PLATES		76
FRONT		66
TOTAL, 1 BOILER =		5127
	2	= 10254

WORKING PRESSURE 220 LBS PER SQ IN LLOYD'S
TEST 440 " " " " SURVEY
GRATE AREA 5'-6" BARS = 222.8 # FOR 2 BOILERS



SHELL RIVETING
DOUBLE BUTT STRAP JOINTS.
SHELL PLATES 1 1/2" BUTT STRAPS 1 1/2"
RIVET HOLES 1 1/2" DIA GREATEST PITCH 9 3/4"
PLATE SECTION 85-2% RIVET SECTION 90-25% LLOYD'S
TENSILE STRENGTH OF SHELL PLATE 29 TO 33 TONS.
FURNACES & COMB. CHAMBER PL = 26 TO 30 TONS
GIRDER 28 TO 32 TONS
MANHOLE RING 26 TO 30 TONS



562 PLAIN TUBES 2 1/2" DIA x 8' 1 1/2" THICK
182 STAY TUBES 2 1/2" DIA x 1/2" THICK
70 STAY TUBES 2 1/2" DIA x 3/4" THICK

814 IRON TUBES IN 1 BLUR 2 1/2" DIA x 8'-3" BETWEEN TUBE PLATES.
PLAIN TUBES NO 8, 1 W.G. - STAY TUBES TO BE SCREWED INTO BACK TUBE PLATES 2 1/2" DIA OVER THOSE EXPANDED ALSO SCREWED INTO FRONT TUBE PLATES 2 1/2" DIA OVER THOSE WITH NUTS OUTSIDE BETWEEN NEST OF TUBES & ALSO TOP ROWS. SCREWED 11 THICK PER INCH.
PLAIN TUBES TO BE SWELLED 1/8 INCH IN THE DIA AT THE FRONT ENDS & TO BE LEFT 1/4 INCH LONG IN THE FRONT PLATES.
ALL TUBES TO BE BEADED AT THE BACK ENDS.
HOWDEN'S SPIRAL RETARDERS TO BE FITTED TO EACH TUBE.
STAY TUBES MARKED (C) ARE 3/4" THICK.

NOTE:-
ALL SCREW STAYS TO BE FITTED WITH DEEP NUTS & WASHERS.
NUTS IN COMB CHAMBERS ARE NOT TO BE CHAMFERED & THE THICKNESS OF THESE NUTS TO BE 1 1/2" FACED NUTS TO BE FITTED AT BOTH ENDS, EXCEPT AT SHELL PLATES WHERE THE STAYS ARE TO BE RIVETED OVER.
LONGITUDINAL GIRDER & COMB CHAMBER SCREW STAYS 20% ABOVE LLOYD'S.
HANGING STAYS & STAY TUBES TO LLOYD'S REQUIREMENTS.
8'-3" BETWEEN TUBE PLATES

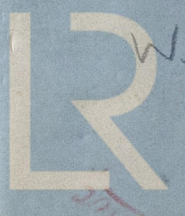
Palmer's Co Ltd
No 873
Double Ended
Boilers

220 lb } W.P.
per sq ft

J. S. S. Maimoa
Southampton

S. S. MAIMO A.
NEWCASTLE ON TYNE.

Report No. 79667.



© 2019
W54-0133

Lloyd's Register
Foundation