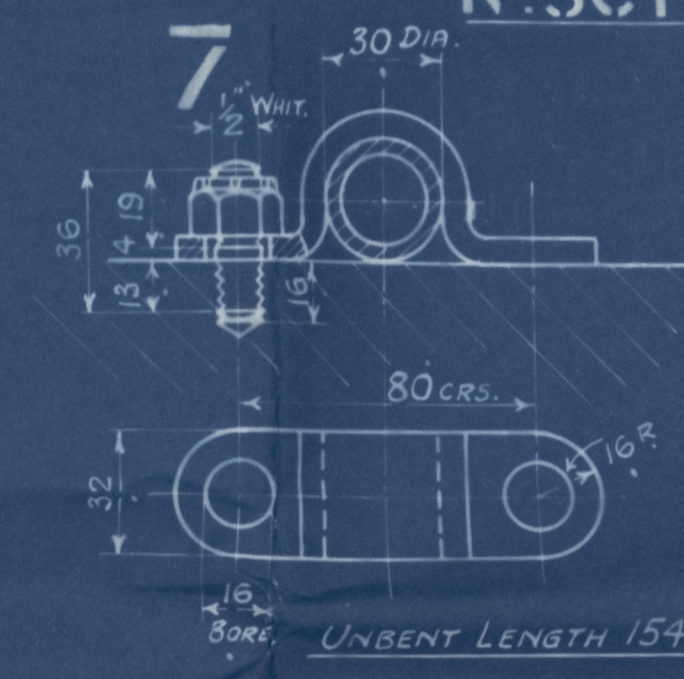
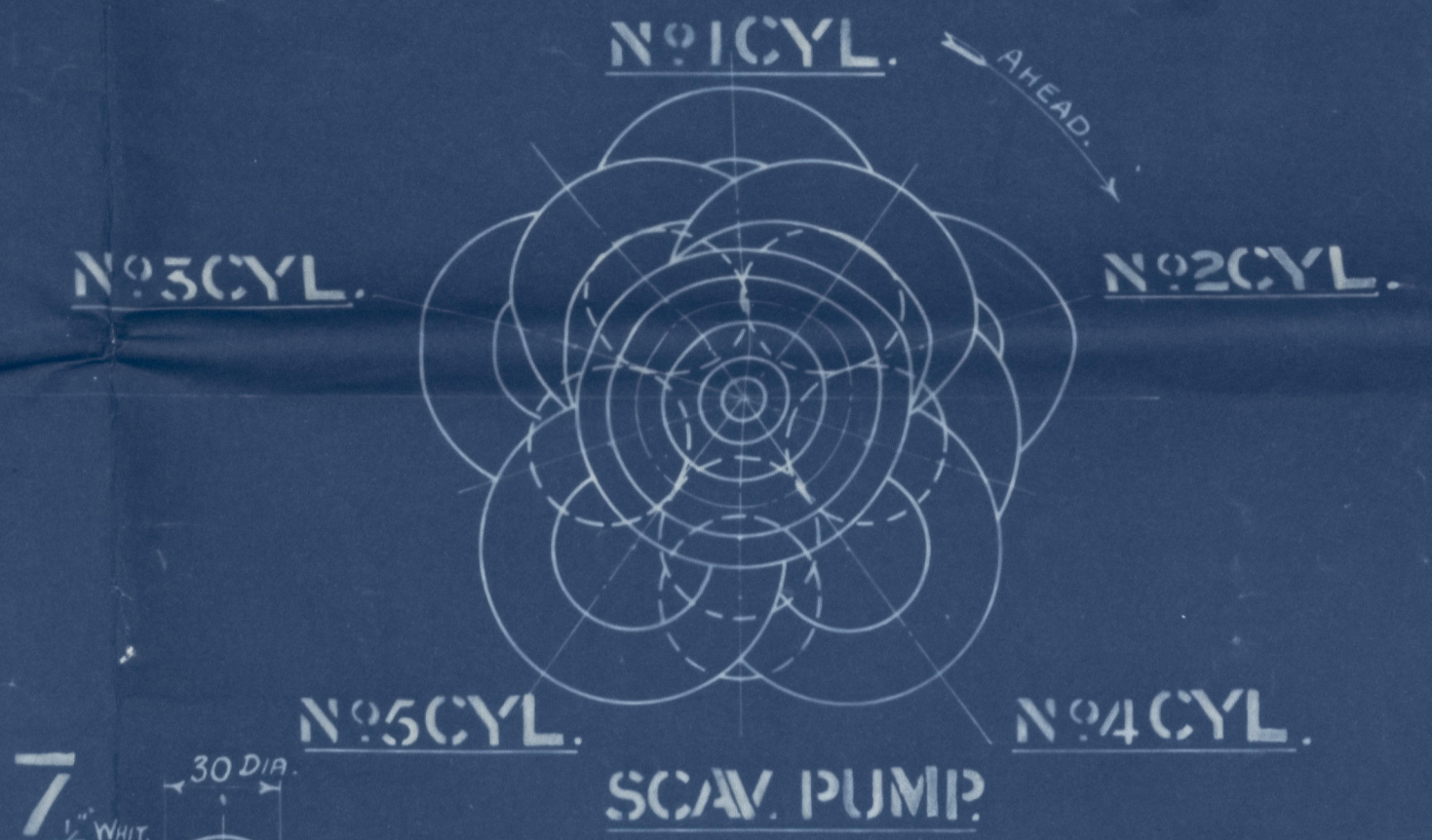


W.M. DOUGLAS & SONS LTD.  
SUNDERLAND.  
To Messrs Lloyd's Register  
of Shipping.

NOTES & ALTERATIONS.  
PER LLOYD'S LETTER  
DATED 1-12-35.  
MINIMUM SPEED.  
CENTRE CRANK PIN  
4.01 1/4 DIA.  
SIDE CRANK PINS &  
JOURNALS 3.94 1/4 DIA.  
SHAFTING.  
FOR LLOYD'S LETTER  
1-12-36.  
INTERMEDIATE SHAFT  
305 M.M.  
SCREW SHAFT.  
334 M.M.

VIEW LOOKING FORWARD  
SHOWING CRANK SEQUENCE.



LOCATION OF WEB & PINS  
TO BE CLEARLY MARKED  
THUS ON ALL SHAPED JOINTS.

INLET & OUTLET LUBRICATION HOLES.  
NOTE! SPECIAL TOOLS ARE TO BE USED TO ENSURE  
THAT LUG HOLES RADIUS ARE CORRECTLY PRODUCED.

1/8" ALLOWANCE TO BE MADE ON  
THESE SURFACES FOR FILING UP.

ALL OIL HOLES TO BE CAREFULLY CLEARED OF CHIPS ETC.  
BEFORE PLUGS ARE INSERTED. PLUGS TO BE TIGHT  
AGAINST TEST PRESSURE OF 50 LBS / IN<sup>2</sup>

10-83 1/2 DIA. HOLES, PITCHED AS SHOWN

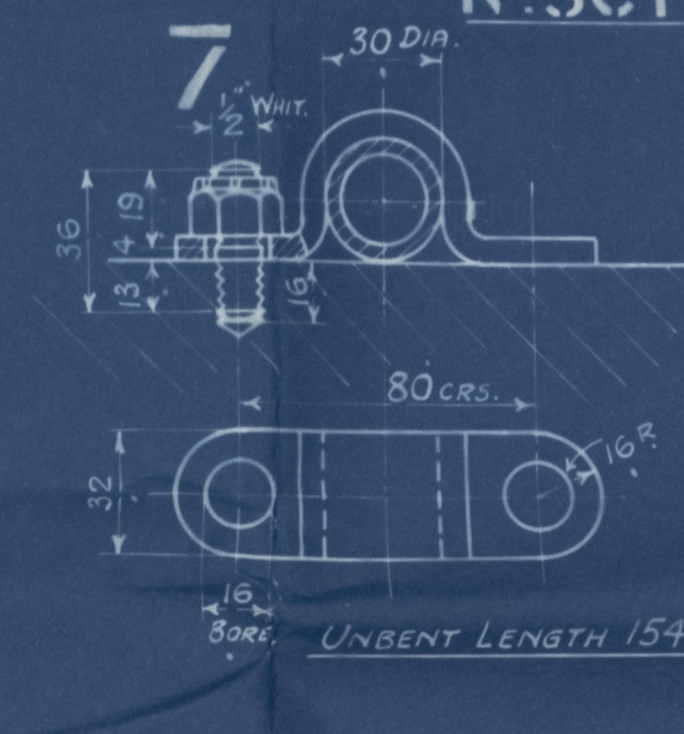
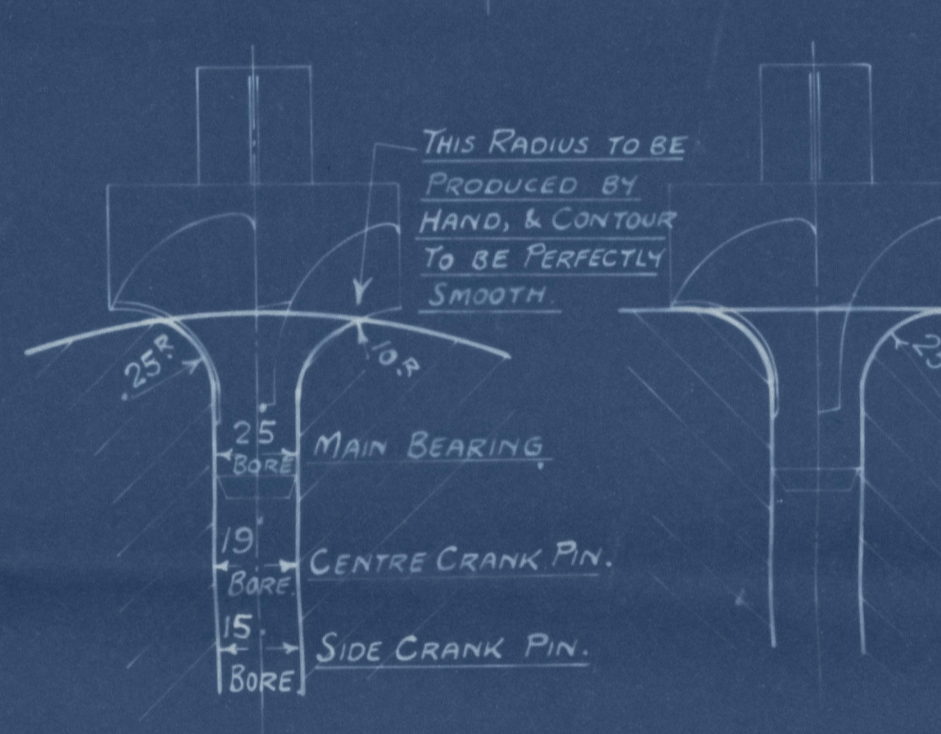
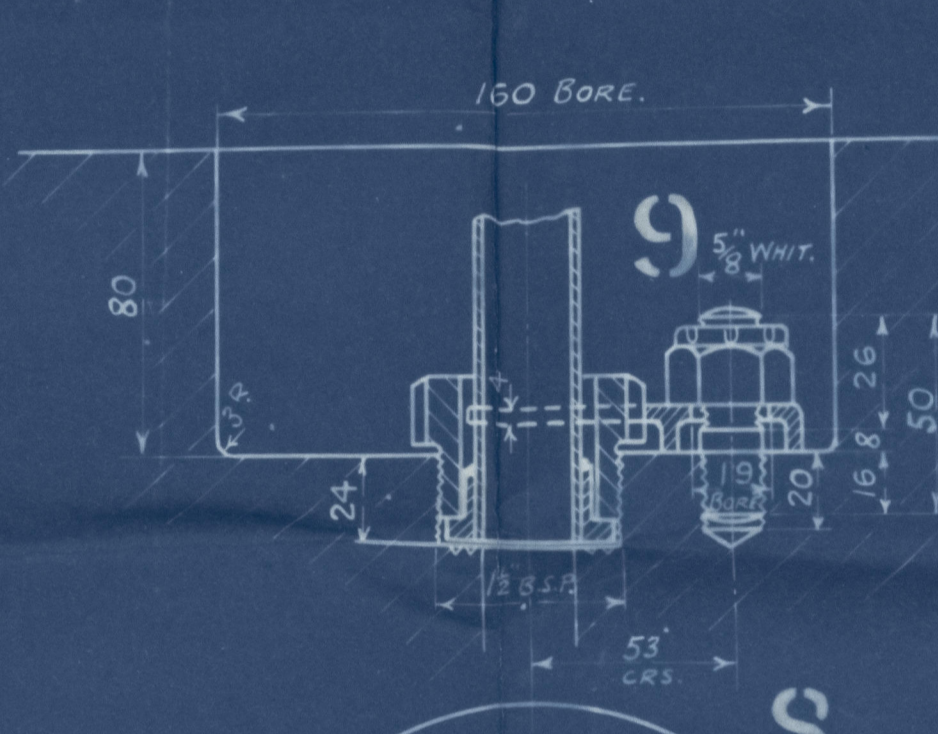
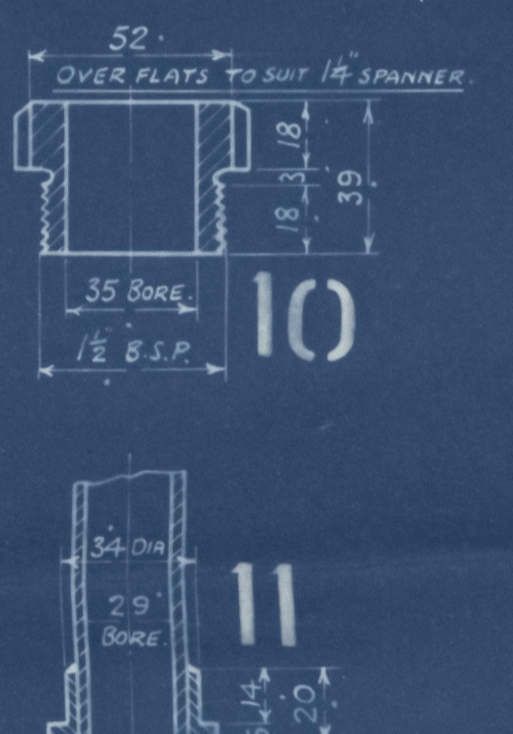
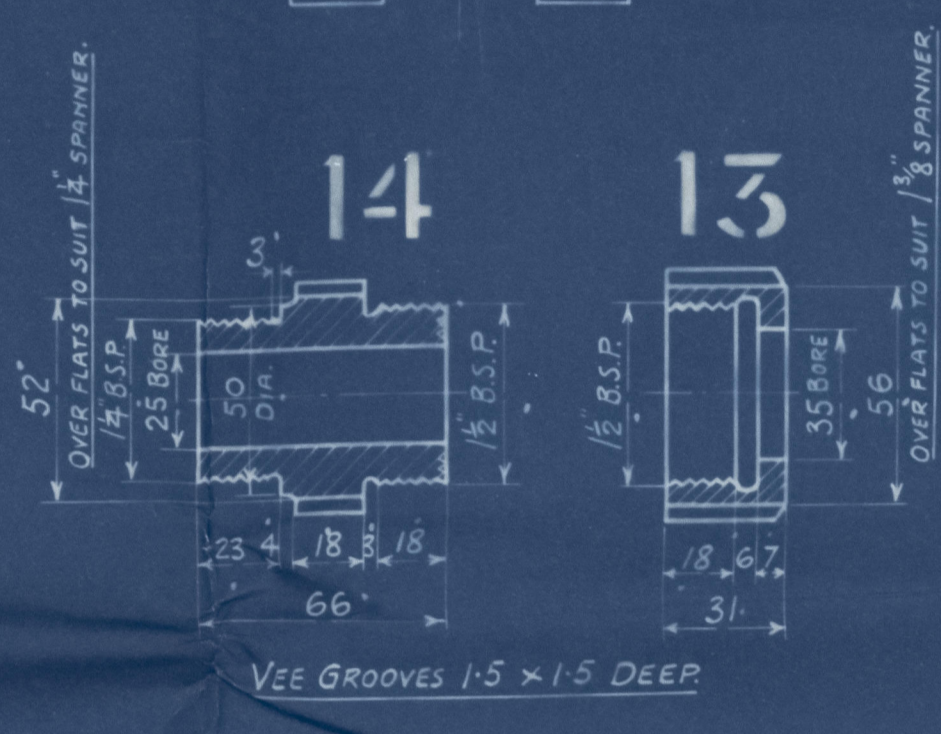
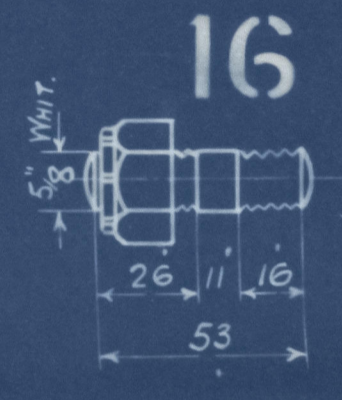
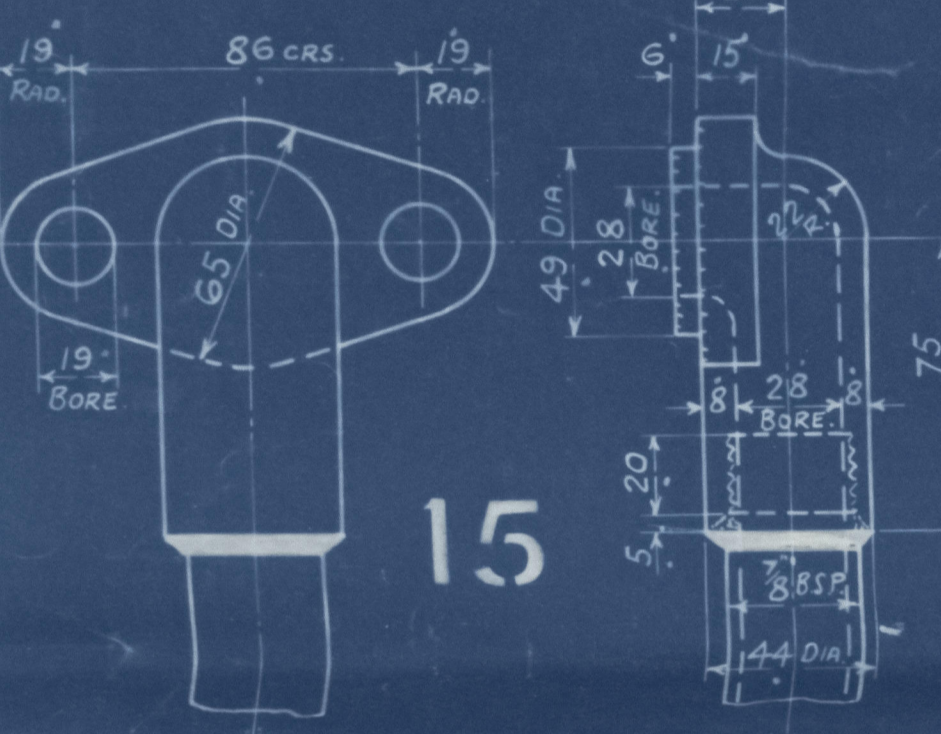
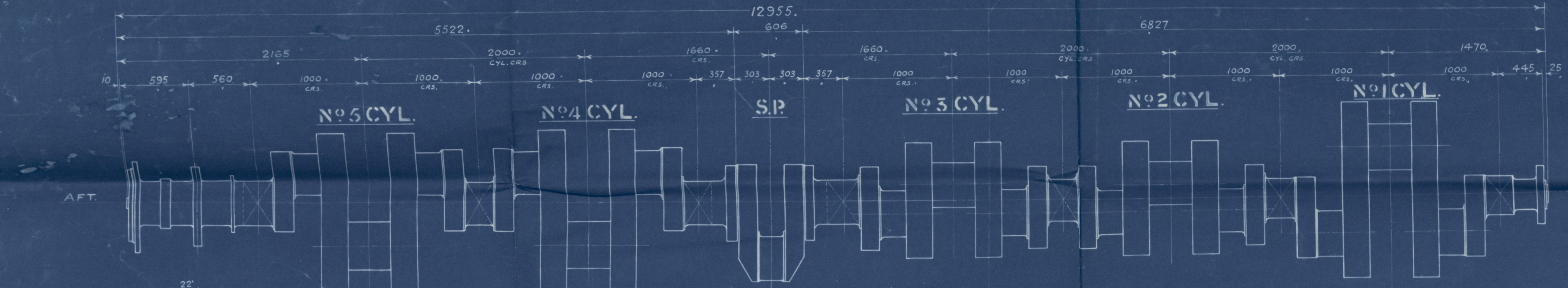
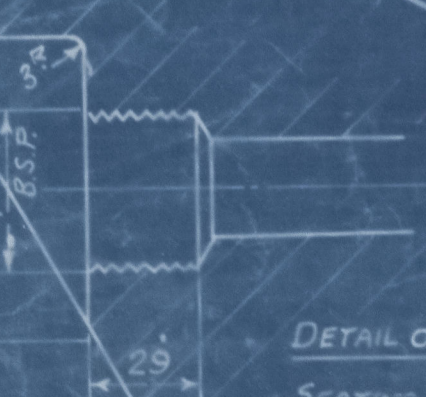
THIS HOLE DRILLED TO SUIT SCAVENGE CRANK  
PINS - TO CONFORM WITH CRANK SEQUENCE

VIEW LOOKING FORWARD

4-2 3/4 TAPPED HOLES 6 TH/INCH FOR BALANCE WEIGHT STUDS.



DETAIL OF L.P. PIPE CONNECTION  
SEATING IN SCAVENGE CRANK



PARTY	DESCRIPTION	N° OF	MATERIAL	REMARKS
17	SCAVENGE PUMP CRANK	1	I.S.	
16	3/8 WHIT STUDS & CASTLE NUTS	20	M.S.	
15	FLANGED PIPE CONNECTION	10	BRASS	
14	UNION NIPPLE	4	"	
13	COUPLING NUT	4	"	
12	WHITEMETAL WASHER FOR REF 11	14	W.M.	
11	TAIL FOR L.P. CONNECTION	14	METAL	
10	SOCKET NUT	10	M.S.	
9	3/8 WHIT STUDS & CASTLE NUTS FOR REF 10	10	M.S.	
8	LOCKING PLATE FOR REF 10	10	BRASS	
7	3/8 WHIT STUDS & CASTLE NUTS FOR REF 6	20	M.S.	
6	PIPE CLIPS	10	M.S.	
5	3/8 B.S.P. PLUGS	42	"	
4	3/8 BORE PIPE (SHORT)	2	STEEL	
3	3/8 BORE PIPE (LONG)	10	"	
2	CENTRE CRANKPIN	5	I.S.	
1	CENTRE CRANK WEB	10	I.S.	

W1192-0050<sup>2</sup>/<sub>2</sub>

WM. DOXFORD & SONS LTD.  
SUNDERLAND.

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To Messrs Lloyd's Register  
of Shipping.

Wm. Dorrance & Sons L<sup>ds</sup>.

Contract N<sup>o</sup> 634.

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Copy of app.<sup>d</sup> plan of

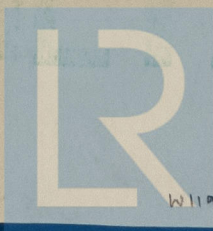
Crank shaft.

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"Pozanica".

SUNDERLAND RPT. NO. 32275.

RETAIN



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Lloyd's Register  
Foundation

W1192-0050