



NOTE:-  
BEFORE SHRINKING SHAFT DIA = 495<sup>1</sup>/<sub>16</sub>"  
HOLE DIA = 494<sup>1</sup>/<sub>16</sub>"  
EACH WEB TO BE HEATED ONCE ONLY. PIN & JOURNAL TO BE ENTERED SIMULTANEOUSLY.  
THE HEATING FOR SHRINKAGE SHOULD BE CARRIED OUT IN AN OVEN AND NOT ON A GAS HEATER IN THE SHOP.

1/2 Gas Plug To Be Caulked  
CORNERS OF WEBS TO BE ROUNDED R=3 (APPROX)  
ONE OF THE TWO HOLES IN THE JOURNALS TO BE DRILLED PARALLEL TO THE HOLE IN THE WEB IMMEDIATELY FORWARD.  
THE OTHER HOLE IN THE JOURNALS TO BE DRILLED AT RIGHT ANGLES TO THIS. HOLES IN FORWARD JOURNALS OF CRANKS No 1 & 4 TO BE DRILLED PARALLEL TO HOLES IN AFT JOURNALS OF 1 & 4 RESPECTIVELY.  
OIL HOLES IN CRANK JOURNALS & PINS TO BE ROUNDED TO RAD = 10<sup>1</sup>/<sub>16</sub>" (ABOUT)

ECCENTRIC SHEAVES TO BE MACHINED AFTER ASSEMBLY OF SHAFT.  
SPECIAL CARE TO BE TAKEN TO ENSURE THAT THE TWO SHEAVES FOR EACH CRANK ARE MACHINED PERFECTLY TRUE TO EACH OTHER AND PARALLEL TO THE CRANK JOURNALS.

TO CHAIN DOTTED LINES WITHOUT BAL. WT. FACING  
TO OPPOSITE HAND  
TO OFF HAND WITHOUT BAL. WT. FACING

NEWELL STANDARD LIMITS TO BE USED.		PATTERN		WT IN KGS		REMARKS		SHOP	
NO OFF PER ENGINE	DESCRIPTION	NUMBER	MATERIAL						
1	CRANKSHAFT (FOR PART)	130484	SAE 52100	24975		BUILT FROM PARTS AS ORDERED			
2	CRANKWEB (AFT SIDE CRANKS 1, 2, 3, 4)	130485		2800					
3	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130486		2800					
4	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130487		2800					
5	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130488		2800					
6	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130489		2800					
7	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130490		2800					
8	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130491		2800					
9	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130492		2800					
10	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130493		2800					
11	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130494		2800					
12	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130495		2800					
13	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130496		2800					
14	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130497		2800					
15	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130498		2800					
16	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130499		2800					
17	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130500		2800					
18	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130501		2800					
19	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130502		2800					
20	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130503		2800					
21	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130504		2800					
22	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130505		2800					
23	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130506		2800					
24	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130507		2800					
25	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130508		2800					
26	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130509		2800					
27	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130510		2800					
28	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130511		2800					
29	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130512		2800					
30	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130513		2800					
31	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130514		2800					
32	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130515		2800					
33	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130516		2800					
34	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130517		2800					
35	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130518		2800					
36	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130519		2800					
37	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130520		2800					
38	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130521		2800					
39	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130522		2800					
40	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130523		2800					
41	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130524		2800					
42	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130525		2800					
43	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130526		2800					
44	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130527		2800					
45	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130528		2800					
46	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130529		2800					
47	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130530		2800					
48	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130531		2800					
49	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130532		2800					
50	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130533		2800					
51	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130534		2800					
52	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130535		2800					
53	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130536		2800					
54	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130537		2800					
55	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130538		2800					
56	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130539		2800					
57	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130540		2800					
58	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130541		2800					
59	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130542		2800					
60	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130543		2800					
61	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130544		2800					
62	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130545		2800					
63	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130546		2800					
64	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130547		2800					
65	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130548		2800					
66	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130549		2800					
67	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130550		2800					
68	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130551		2800					
69	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130552		2800					
70	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130553		2800					
71	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130554		2800					
72	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130555		2800					
73	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130556		2800					
74	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130557		2800					
75	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130558		2800					
76	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130559		2800					
77	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130560		2800					
78	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130561		2800					
79	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130562		2800					
80	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130563		2800					
81	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130564		2800					
82	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130565		2800					
83	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130566		2800					
84	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130567		2800					
85	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130568		2800					
86	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130569		2800					
87	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130570		2800					
88	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130571		2800					
89	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130572		2800					
90	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130573		2800					
91	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130574		2800					
92	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130575		2800					
93	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130576		2800					
94	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130577		2800					
95	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130578		2800					
96	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130579		2800					
97	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130580		2800					
98	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130581		2800					
99	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130582		2800					
100	CRANKWEB (FORWARD SIDE CRANKS 1, 2, 3, 4)	130583		2800					

WEIGHTS INCLUDE BALANCE WEIGHTS.  
D. A. 5 620 2 C.  
CRANKSHAFT.  
CODE No 0421  
60902



Glasgow

Harland & Wolff Ltd.

Eng. No. 999 G.

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Crank Shaft

for Right Hand Propeller.

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Amended Plan

Lochavon.

GLASGOW REPORT NO 60050

RETAIN



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Lloyd's Register  
Foundation

W500-0123