

LEFT HAND HEADERS DRAWN

DRILLING FOR CENTRE-BOX.
LEFT HAND HEADERS ONLY.

DRILLING FOR WING-BOX.
R.H. & L.H. HEADERS

21/4/32

NOTE: DEPTH OF TAPPED HOLES IN HEADERS
GIVEN TO POINT OF DRILL.

11 THREADS PER INCH.

HEADERS 4' 3" LONG.

THESE HOLES TO HAVE
BLANK PLUGS.

6 HOLES TAPPED 5/8" WHIT. x 1/4" DEEP.
ON 4 1/2" DIA. P.C.

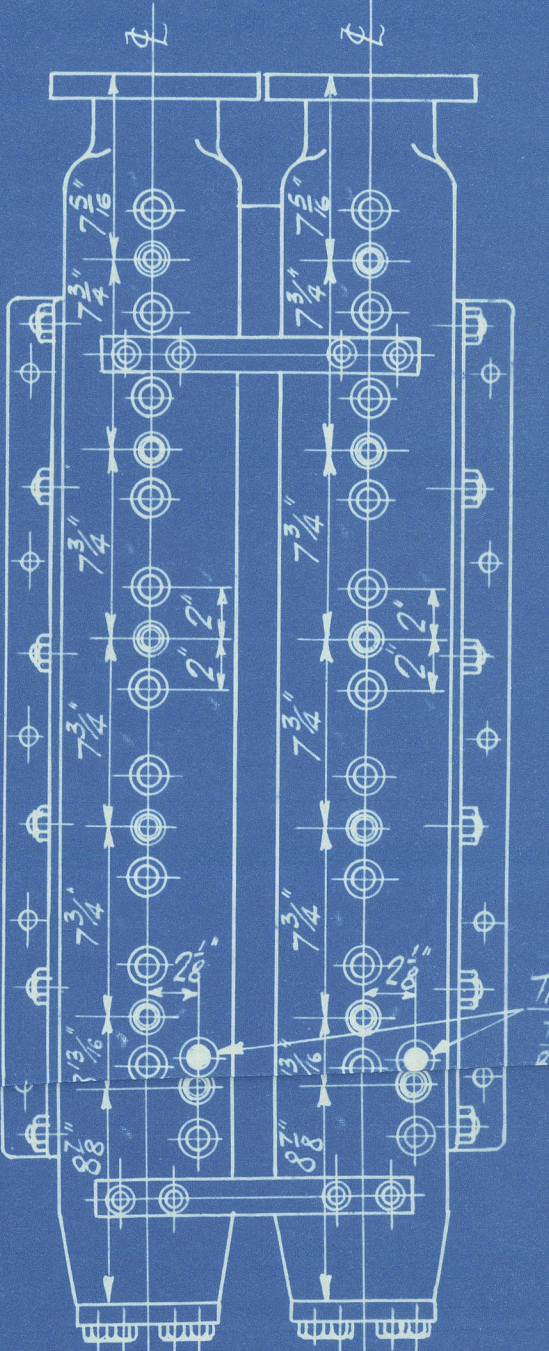
TAPPED 5/8" WHIT.

1 GAS THREAD.

DRILLING FOR BASE.

WALKERITE
JOINT RING
1/16" THICK

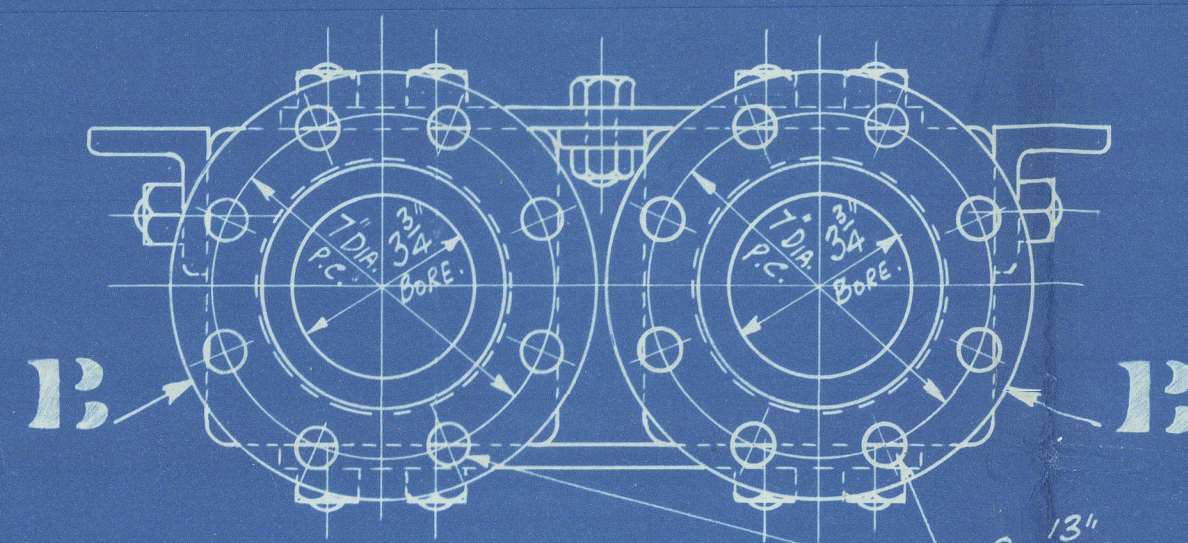
DETAIL OF SUPERHEATER ELEMENT JOINT.
FULL SIZE.



DRILLING FOR CENTRE-BOX.
RIGHT HAND HEADERS ONLY.
SCALE 1/2" = 1 FOOT.

LIST OF MATERIAL FOR ONE BOILER.

| MARK. | DESCRIPTION. | NO OF MATERIAL | REMARKS. |
|-------|--------------------|----------------|---------------------------------------|
| A. | HEADERS. | 4. | STEEL FORGINGS. |
| B. | FLANGES. | 4. | M.S. 8 3/4" DIA x 1 1/2" THICK. |
| C. | STRAPS. | 8. | STEEL. DRG. NO. M.M. 190. |
| D. | BASE PLATES. | 4. | M.S. " " M.M. 203. |
| E. | ANGLE SUPPORTS. | 4. | M.S. 2 1/2" x 3" x 3/8" x 3' 0" LONG. |
| F. | BAFFLE PLATES. | 2. | STEEL. DRG. NO. M.D. 210. |
| G. | 3/4" WHIT STUDS. | 56. | M.S. " " M.D. 290. |
| H. | 5/8" BOLTS. | 24. | M.S. " " M.D. 290. |
| J. | 3/4" NUTS. | 56. | STEEL. " " M.D. 290. |
| K. | 1/4" COLLAR STUDS. | 76. | M.S. " " M.D. 280A. |
| L. | 7/8" WHIT. NUTS. | 76. | STEEL. " " M.D. 280. |
| M. | 4" DOGS. | 76. | PROF. FORGINGS. " " M.C. 260. |
| N. | 5/8" WHIT. NUTS. | 4. | STEEL. " " M.E. 61. |
| O. | JOINT RINGS. | 152. | WALKERITE " " M.F. 121. |
| P. | 5/8" WHIT. BOLTS. | 4. | BLACK STEEL " " M.D. 291. |
| - | BLANK PLUGS. | 4. | M.S. " " M.D. 270. |



8 - 13/16" DIA. HOLES ON 7" DIA. P.C.

DETAIL OF ANGLE SUPPORTS.

EACH PAIR OF HEADERS TO HAVE "HAND"
PAINTED ON (WHITE) TO DENOTE POSITION IN BOILER.
SEE ARRANGEMENT DRG. NO. M.N. 7680.

TO PASS LLOYDS SURVEY.

WORKING PRESSURE 180 LBS PER SQ. INCH.

TEST 540 " " " "

SCALE
3" = ONE FOOT

DRAWN BY TCD/ACK

15/4/32

THE SUPERHEATER CO LTD
BUSH HOUSE LONDON W.C.2

TITLE HEADERS

ORDER NOS REF CKD DRAWING NOS
6083M 6083M 1/14/32 MA 5640

JOHN DICKINSON & SONS LTD

CONTRACT No 253.

S.S. CATHNESS

Lloyd's Register Foundation

W 574-0027

J. DICKINSON, SONS.
S/S. "CAITHNESS"

HEADERS.

DUNDEE RPT. NO. 30958

WS14-0027



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