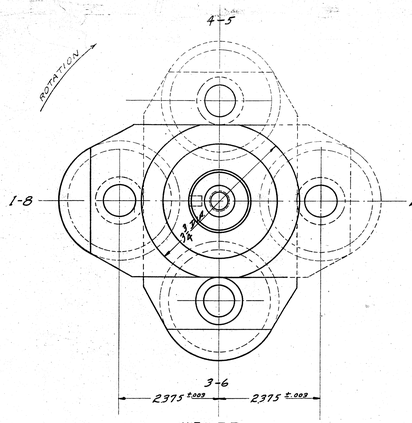
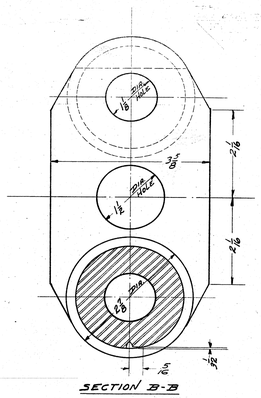
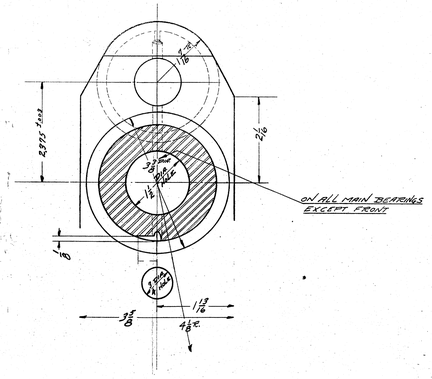


VIEW Z-Z



SECTION B-B



SECTION A-A

MACHINING SPECIFICATIONS

FORGING TO BE PICKLED AND CLEANED OF SCALE BY SAND BLASTING BEFORE MACHING.
SHAFT TO BE FINISHED ALL OVER.
INDEX OF CRANK PINS TO BE WITHIN .010 AT CRANK PIN RADIUS.
SPROCKET STUB TO RUN TRUE WITH JOURNALS WITHIN .001".
BOLT HOLES MUST INDEX WITHIN ±.0005" MEASURED ON BOLT CIRCLE AND MUST BE HELD WITHIN .001" OF RADIUS SHOWN.
ALL SHARP EDGES TO BE ROUNDED WITH FILE OR STONE.
JOURNALS & CRANK PINS TO BE ROUND WITHIN .00025" AND PARALLEL TO ℄ OF SHAFT WITHIN .00025" PER 1".
CENTER AND INTERMEDIATE JOURNALS TO RUN TRUE WITH END JOURNALS WITHIN .002" TOTAL INDICATOR READING.
FINISHED GROUND SURFACES TO BE DEAD SMOOTH & POLISHED & TO BE FREE FROM SCRATCHES, MARKS OR OTHER DEFECTS.
ALL CRANK PIN FACES AND FRONT JOURNAL THRUST FACE TO BE GROUND DEAD SMOOTH.
LONGITUDINAL SPACING OF CRANK PINS AND JOURNALS FROM THRUST FACE AS SHOWN TO BE HELD ±.005.
FINISHED SHAFT MUST BE IN STATIC BALANCE AND IN DYNAMIC BALANCE UP TO 3,000 R.P.M.
ALL OIL HOLES IN JOURNALS & CRANK PINS TO BE ROUNDED SMOOTHLY AFTER GRINDING.

MATERIAL SPECIFICATIONS

CARBON	.38 - .46
MANGANESE	.75 - 1.0
CHROMIUM	.60 - .80
NICKEL	1.25 - 1.75
SUL. MAX.	.04
PHOS. MAX.	.04

USE THIS MATERIAL OR EQUIVALENT TO GET PHYSICAL PROPERTIES SPECIFIED.

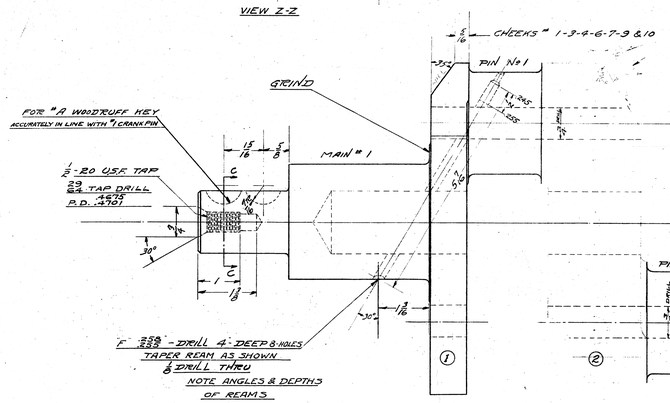
PHYSICAL PROPERTIES

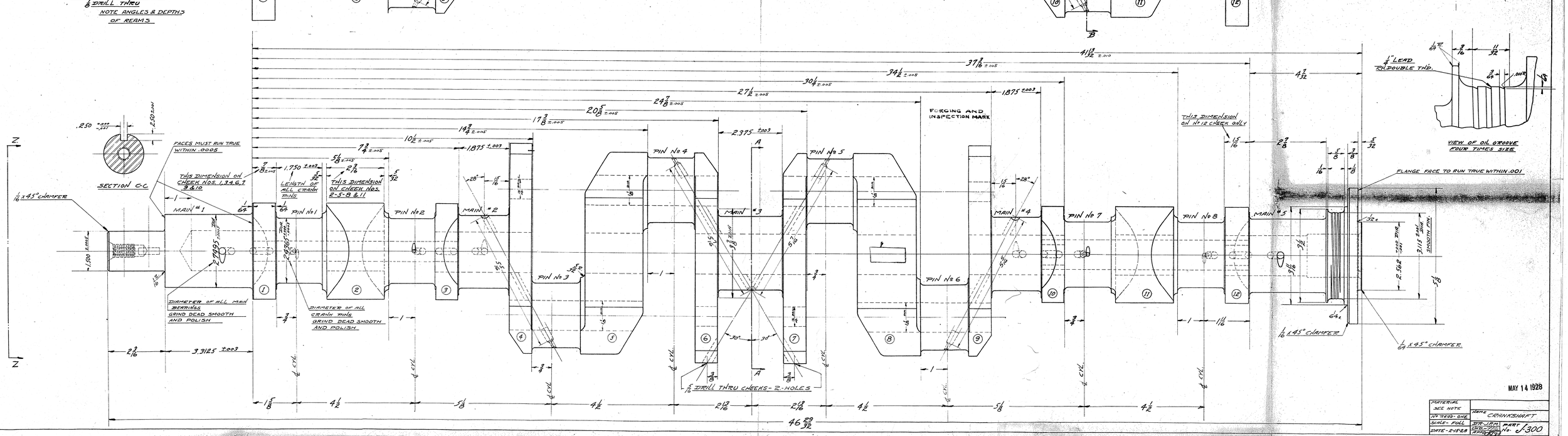
ELASTIC LIMIT	120,000# PER SQ.IN. MINIMUM.
ULTIMATE STRENGTH	140,000# " " "
REDUCTION OF AREA	50% MINIMUM
ELONGATION IN 2"	18% "
BRINELL HARDNESS	285 TO 321
IZOD IMPACT	50 FT. LBS. MINIMUM.

FORGING SPECIFICATIONS

TRIM FLASH CLOSE & REMOVE EXCESS METAL WHERE POSSIBLE.
STRAIGHTEN FORGING
ENDS OF FORGING TO BE SQUARE & FLAT FOR CENTERING
CENTERS TO BE TRUE WITH BEARINGS & CHEEKS WITHIN 32
LIMITS ON DIAMETERS +1/16 − 0
CRANK PINS TO BE IN PLANES GIVEN WITHIN ½°
PROVIDE ⅜ PIN AT ONE END ONLY (SEE NOTE 5)
TURN & MACHINE PADS A & B IN JIG OR AS A FINISH PIN SIDE 2 FACES OF CHEEKS AND ⅜ PIN ON CRANK NO. 6

REAM .434 ±.0005 18 HOLES
BEFORE ASSEMBLY 64 CHAMFER BOTH SIDES.
REAM 4.375 +.2005 −.0005 12 HOLES
AT ASSEMBLY WITH FLYWHEEL





VIEW OF OIL GROOVE FOUR TIMES SIZE

MAY 14 1928

MATERIAL SEE NOTE	NAME CRANKSHAFT
NºREQD- ONE	
SCALE- FULL	STR. 1ST. PART Nº 1300
DATE- 2-16-28	