

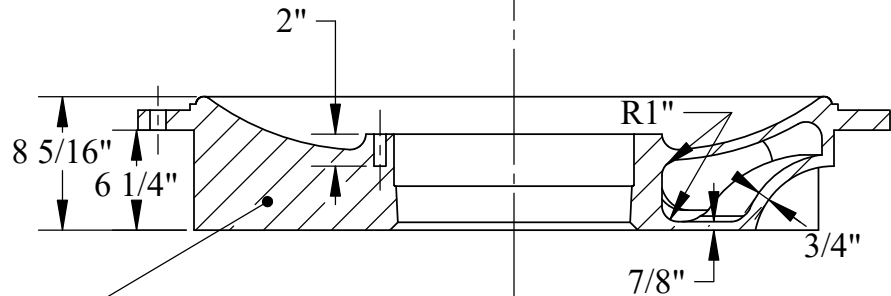
SECTION A-A
SCALE 1 : 4

THIS PROFILE APPLIES TO BOTH CYLINDER HEADS

U.S.S. Monitor Steam Engine

| | | |
|-------------------------|----------------------------------------|-----------------------------------|
| Material Cast Iron | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 835.486 | Description Cylinder Head- Port | |
| Scale 1:4 | | |
| Part # C 4 | | |

SECTION A-A
SEE SHEET 2 OF PORT DWG
(C 4) FOR DETAILS OF BORE
AND PROFILE

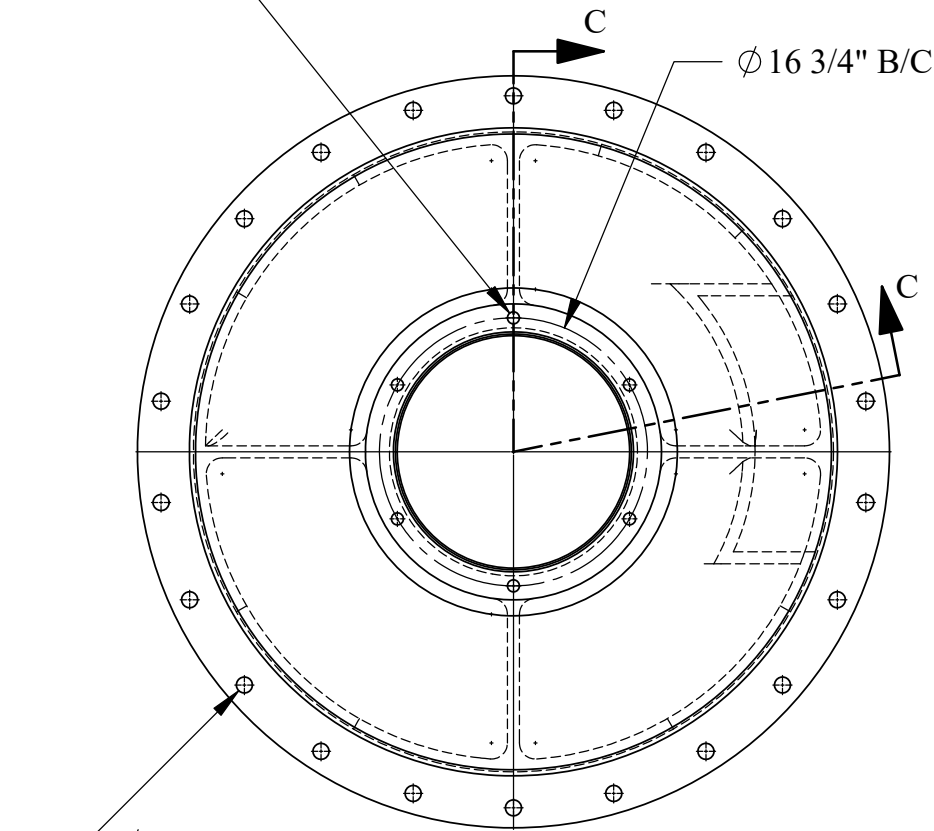


4 INTERNAL
SUPPORT WEBS
7/8" THICK

SECTION C-C

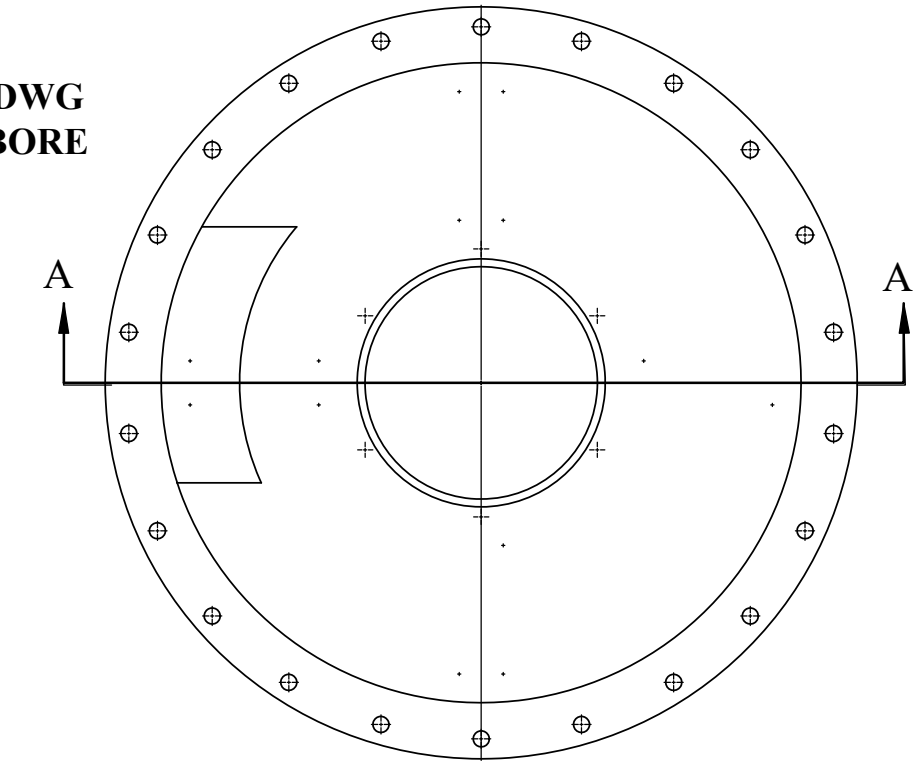
Ø 3/4" TAPPED HOLE - 2" DEEP
6 EQUALLY SPACED ON 16-3/4" B/C
AS SHOWN

CASTING ACCESS PORTS (4)



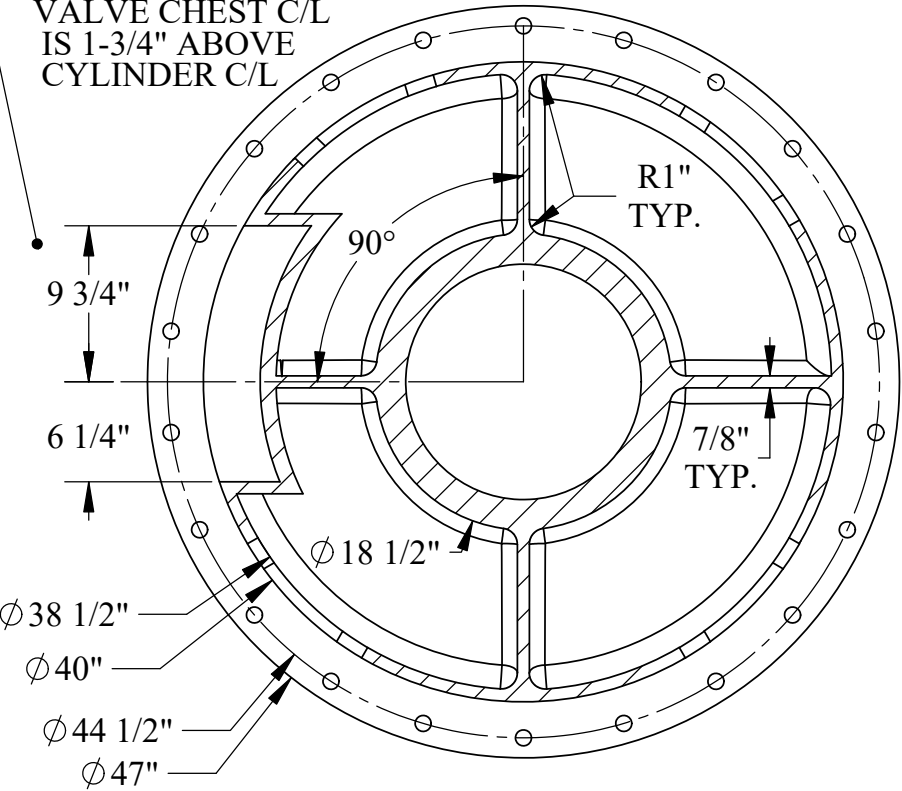
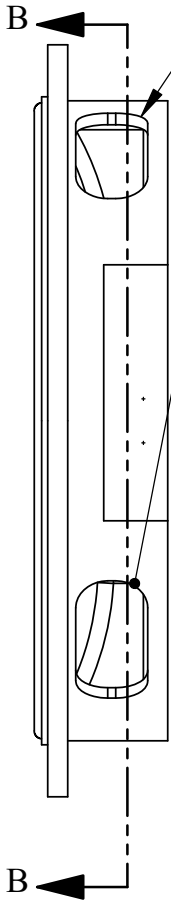
Ø 1"-22 THRU HOLES
EQUALLY SPACED AND
POSITIONED AS SHOWN
ON A 44-1/2" B/C

OUTSIDE VIEW



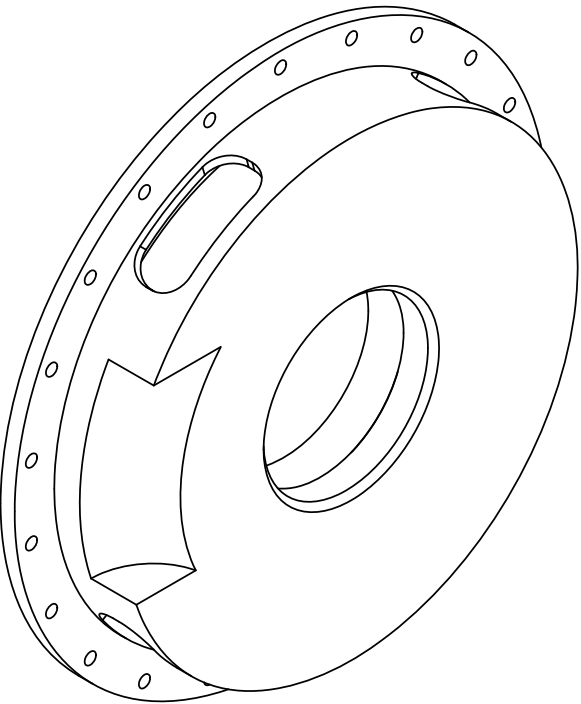
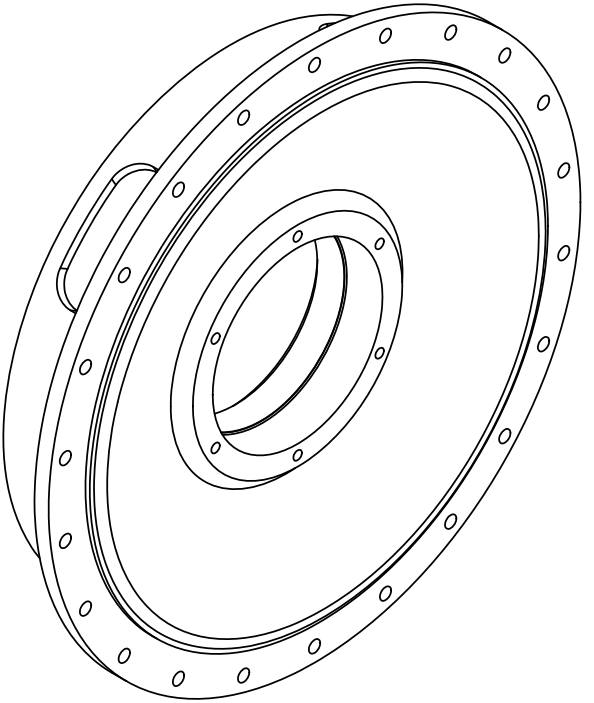
INSIDE VIEW

NOTE:
VALVE CHEST C/L
IS 1-3/4" ABOVE
CYLINDER C/L



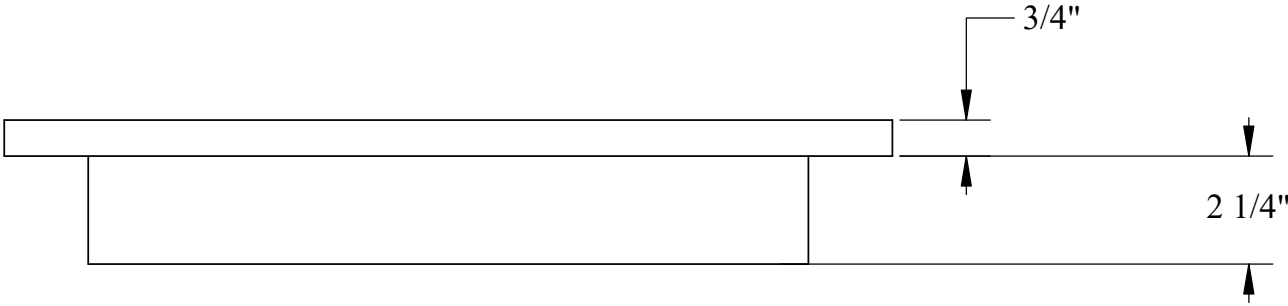
SECTION B-B

SHOWING PROBABLE 4 WEB LOCATION-
THICKNESS CALL OUTS AND ACCESS PORTS
REFERENCED IN PASSIC DRAWING 2-3-33
AS VIEWED FROM INSIDE CYLINDER

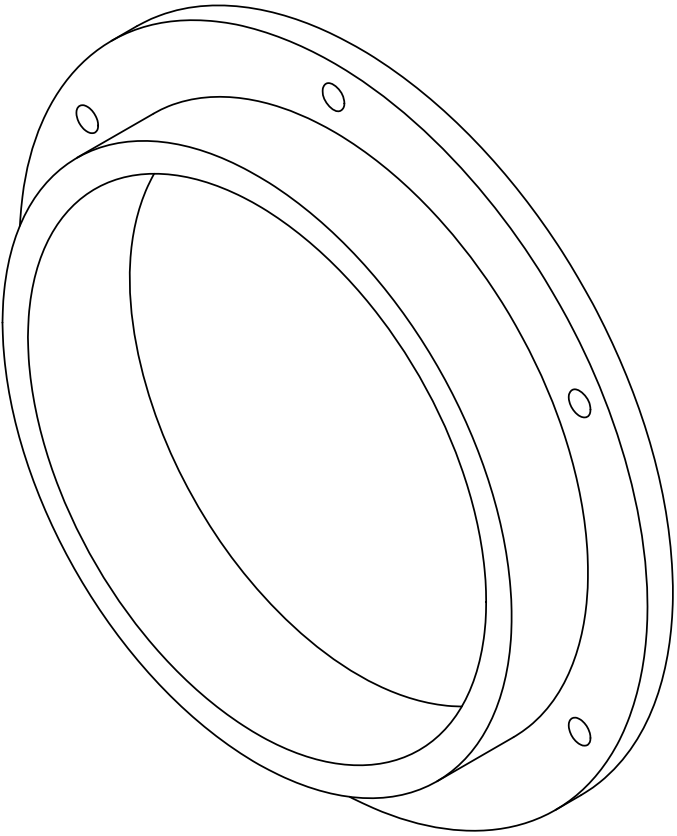
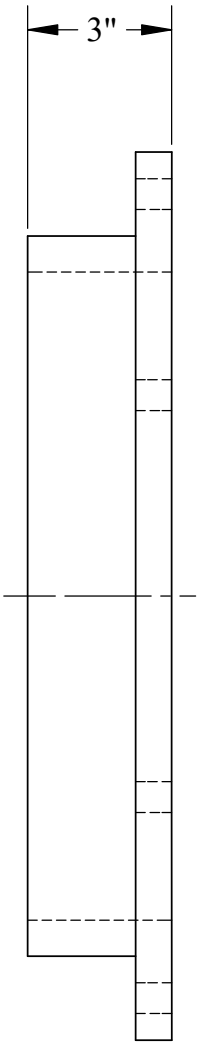
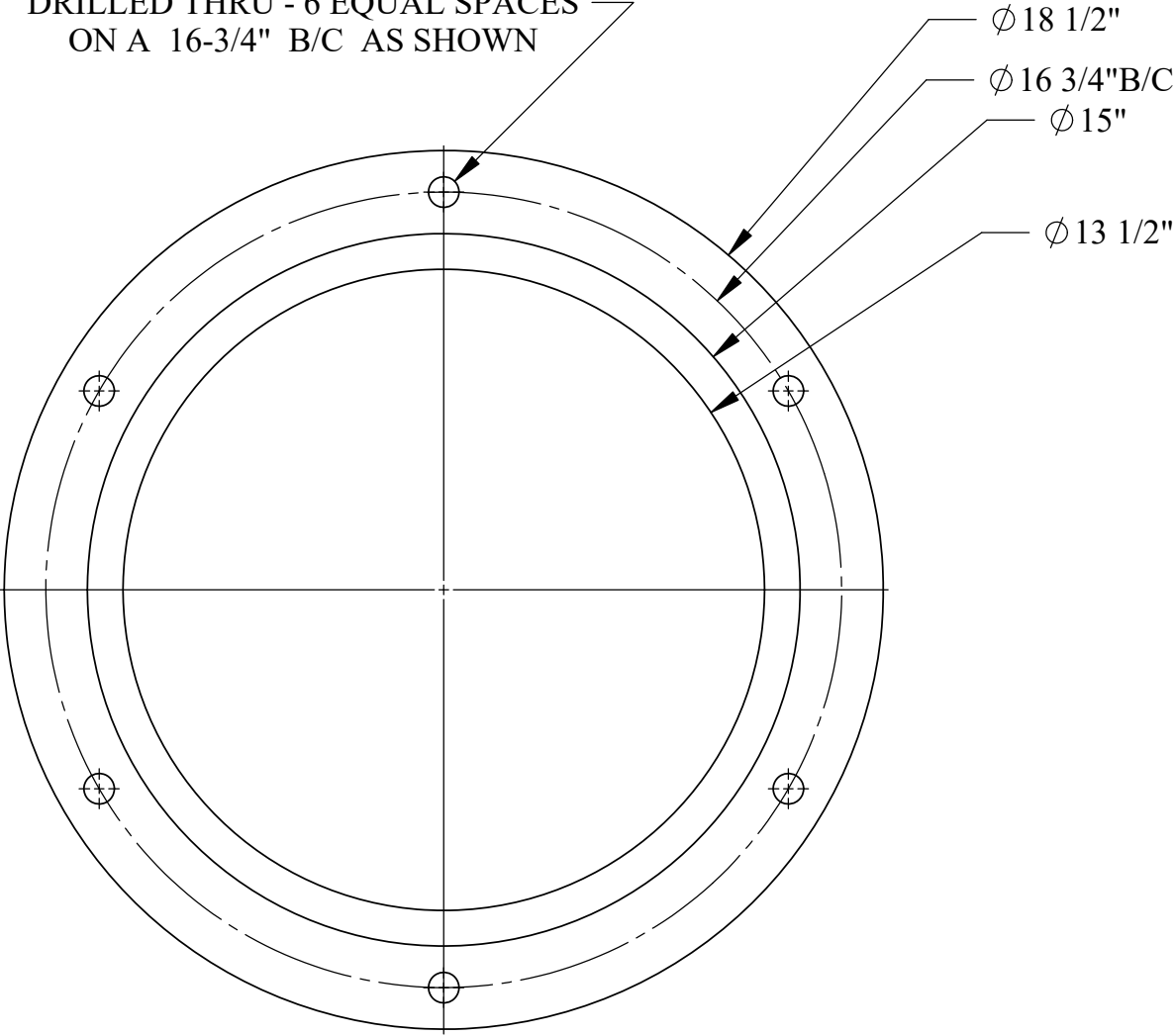


U.S.S. Monitor Steam Engine

| | | |
|------------------------|--------------------------------|-----------------------------------|
| Material Cast Iron | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 834.32 | Cylinder Head- Starboard | |
| Scale 1:12 | | |
| Part # C 5 | | |

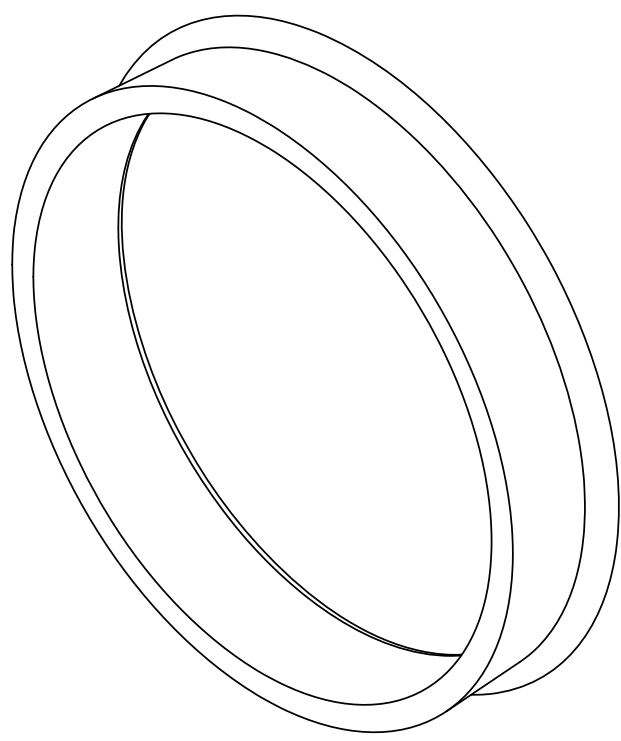
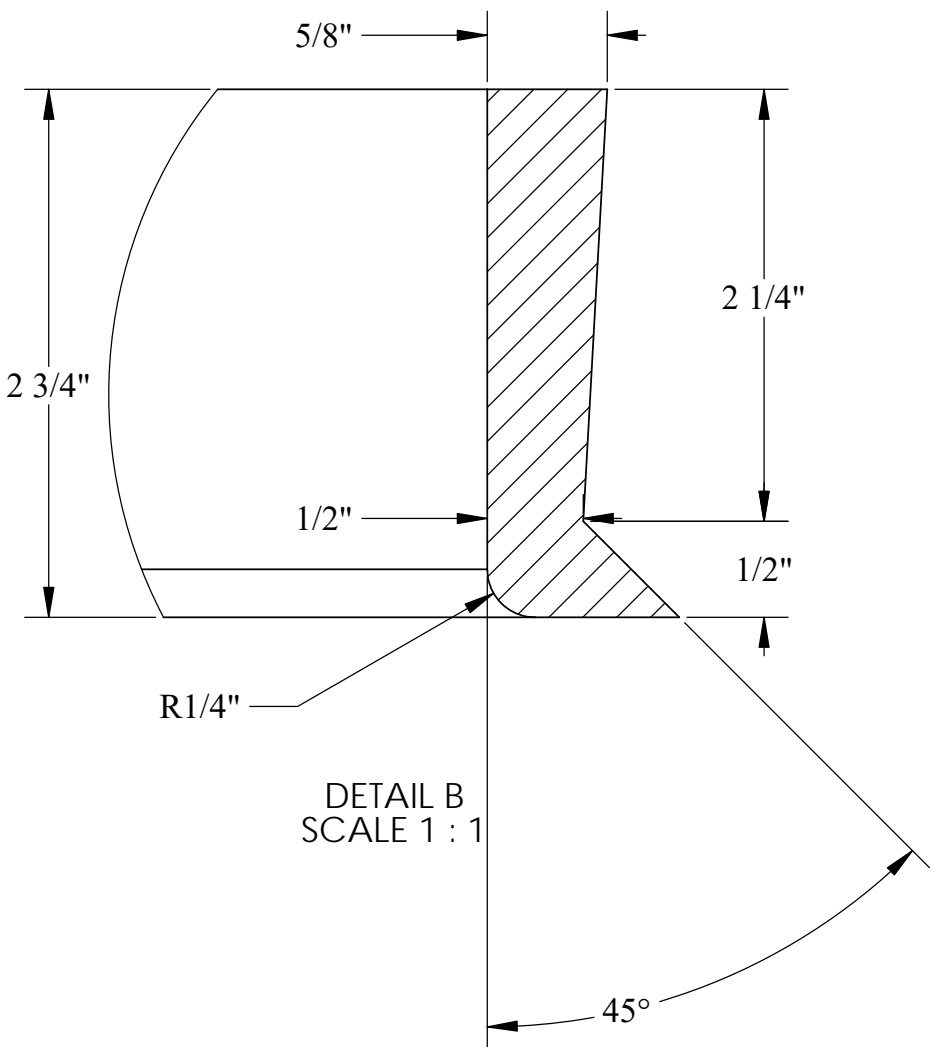
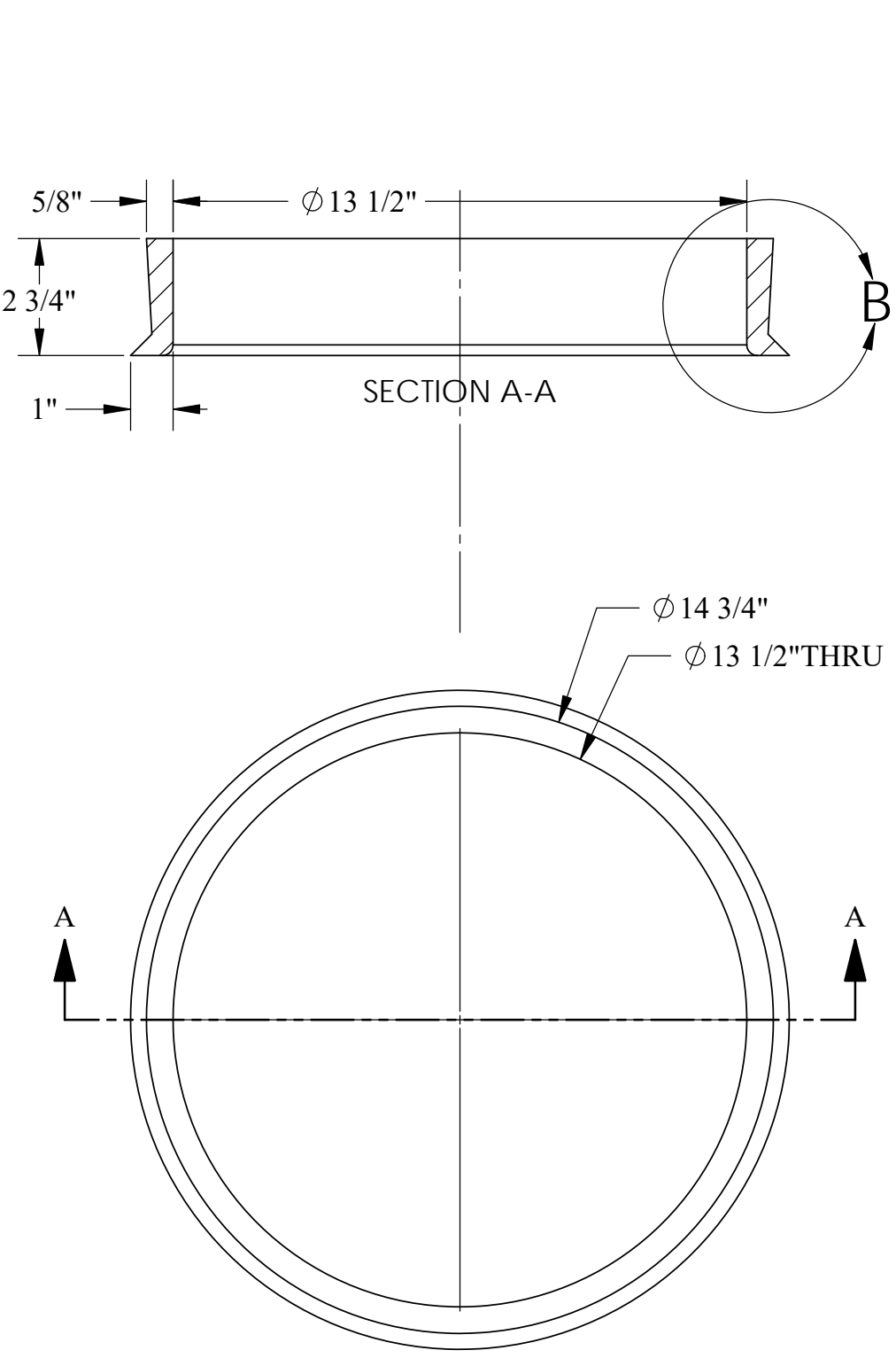


Ø 5/8" CLEARANCE HOLES
DRILLED THRU - 6 EQUAL SPACES
ON A 16-3/4" B/C AS SHOWN



U.S.S. Monitor Steam Engine

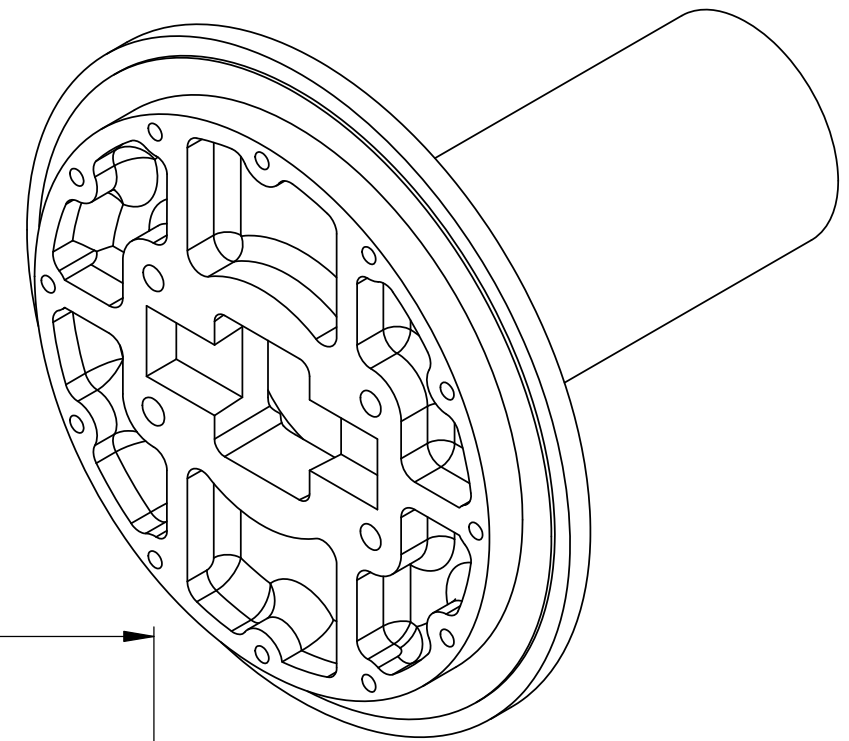
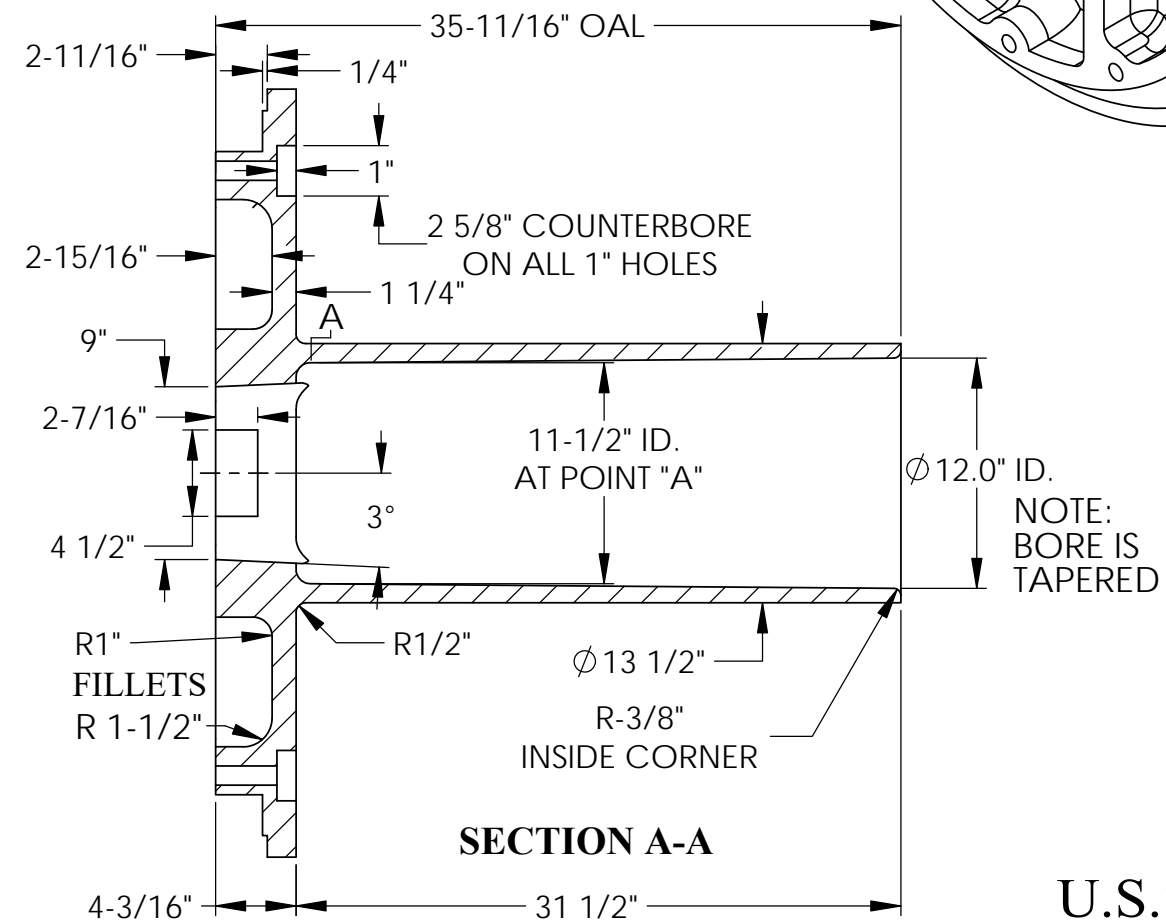
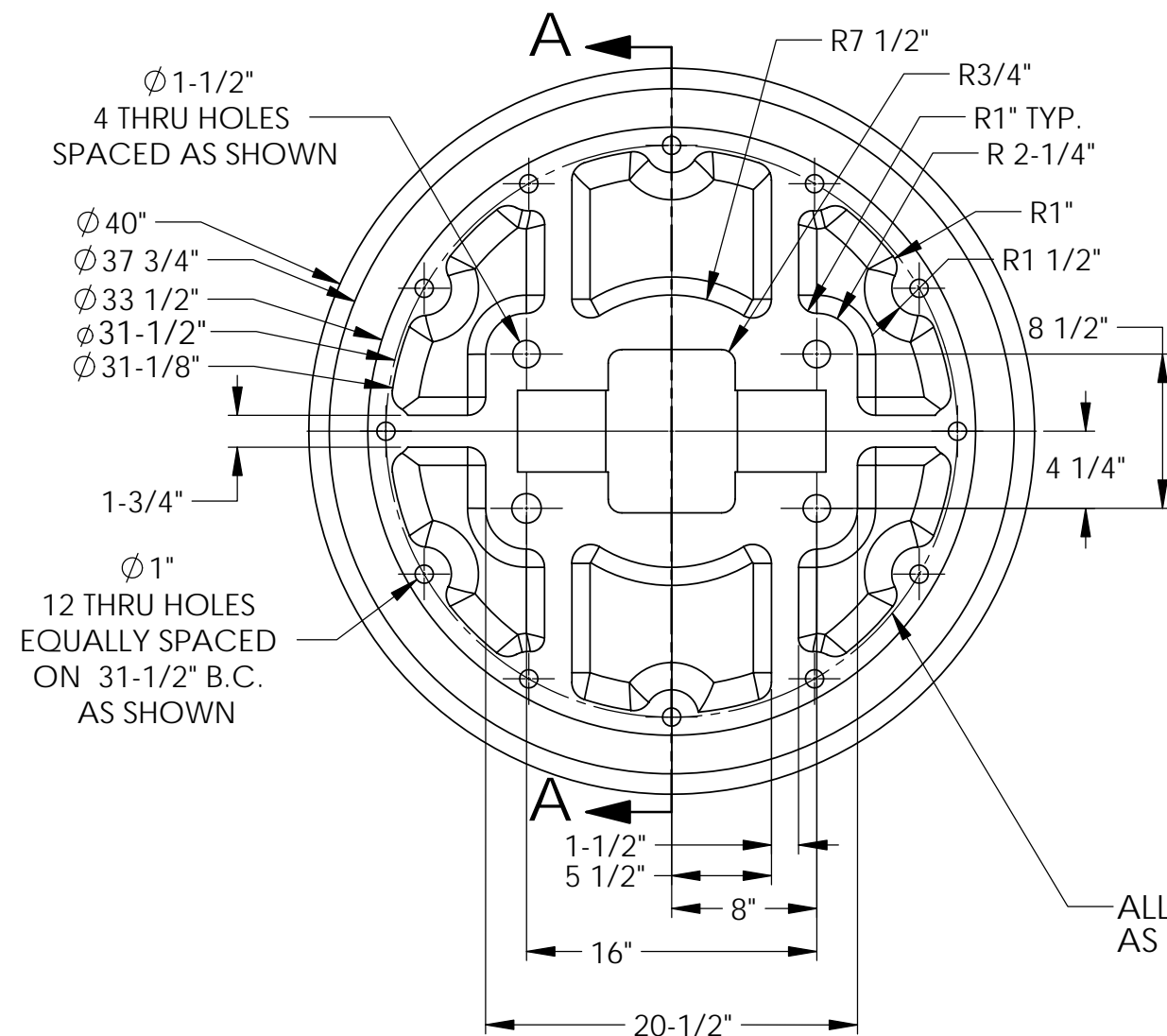
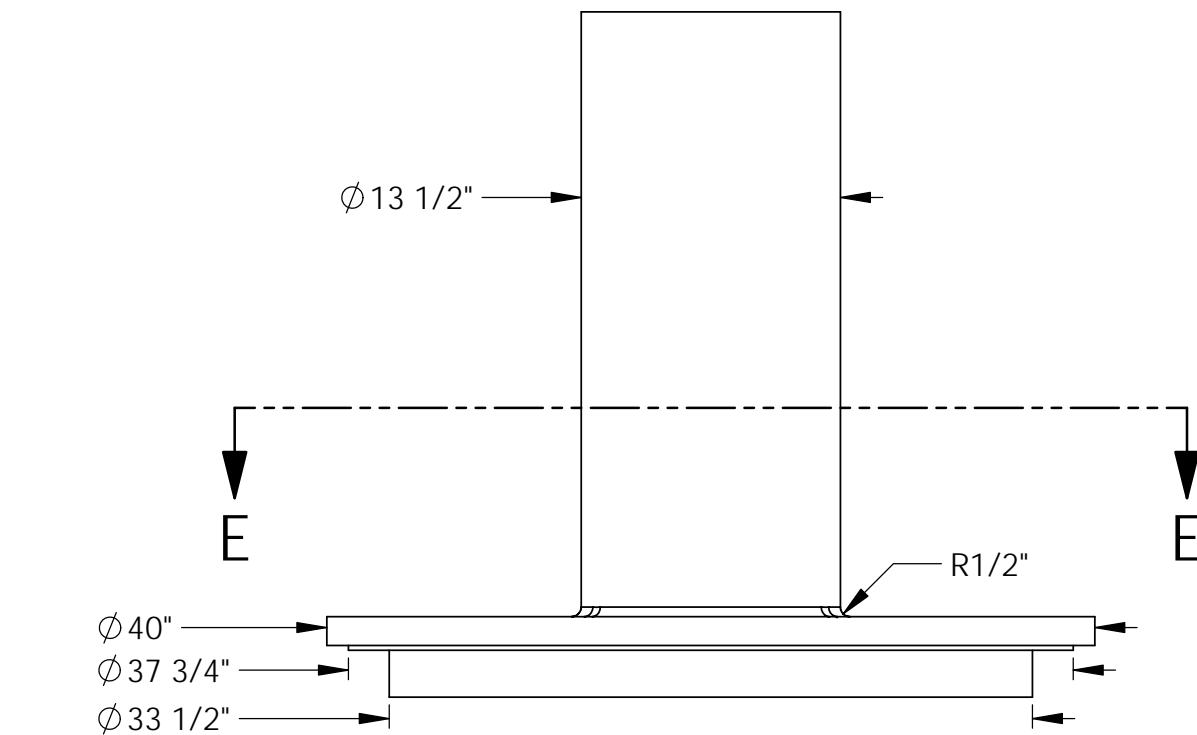
| | | |
|------------------------|--------------------------------|-----------------------------------|
| Material Bronze | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 50.477 | Description Packing Gland | |
| Scale 1:4 | | |
| Part # C 6 | | |



NOTE:
THIS RING IS CAST IN THE CYLINDER HEAD
WITH THE TRUNK OR A FIXTURE IN PLACE
AND THEN HAND FITTED/TRIMED TO THESE
DIMENSIONS . THE "ANGLE" IS A LOCK TO
KEEP THIS BEARING (AND SEAL !) IN PLACE

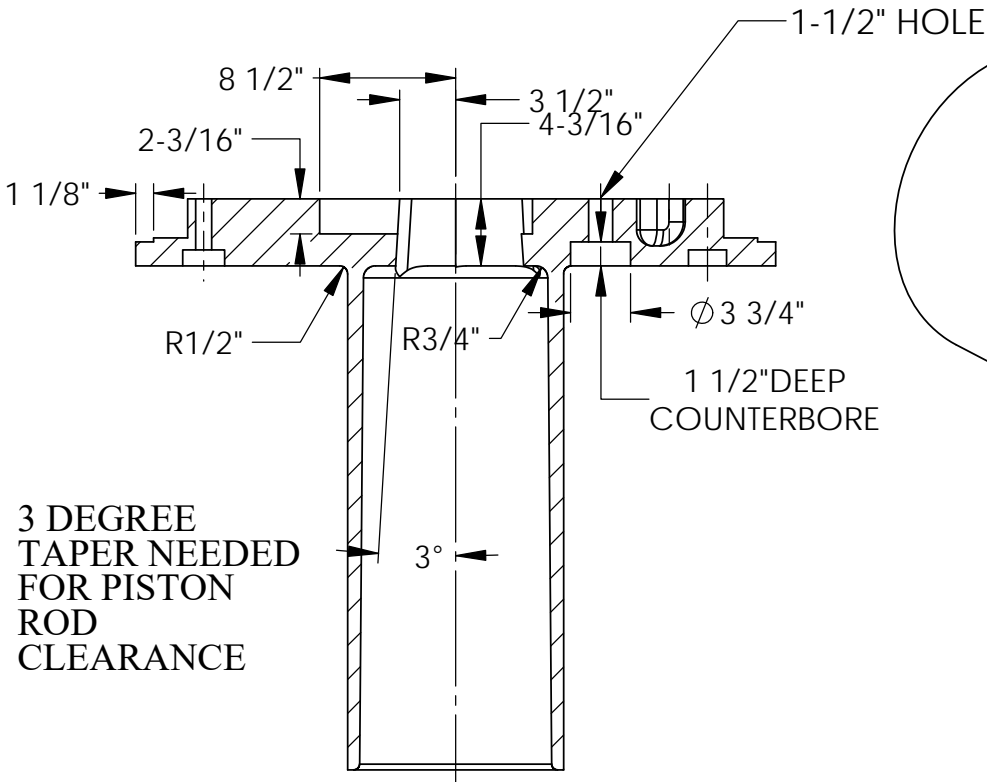
U.S.S. Monitor Steam Engine

| | | |
|-----------------------|--------------------------------|-----------------------------------|
| Material Babbitt | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 19.05 | Trunk Bearing Insert | |
| Scale 1:4 | | |
| Part # C 7 | | |

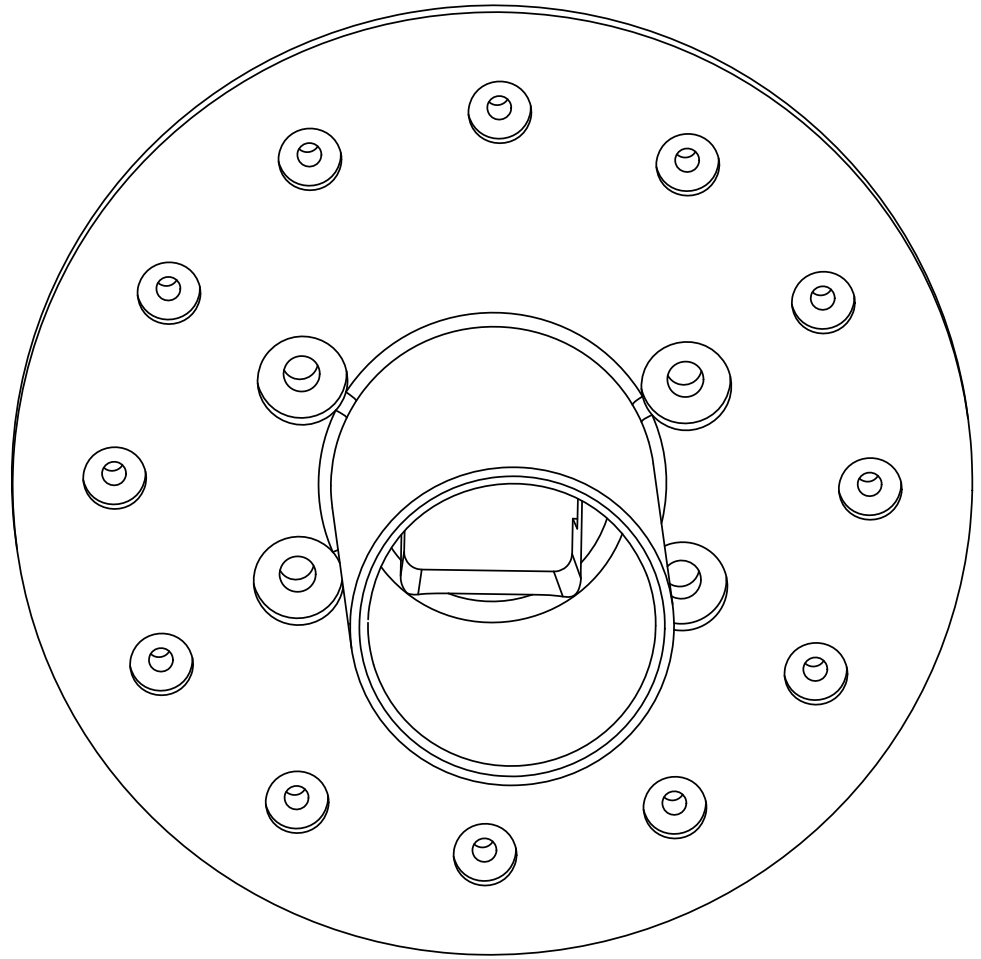
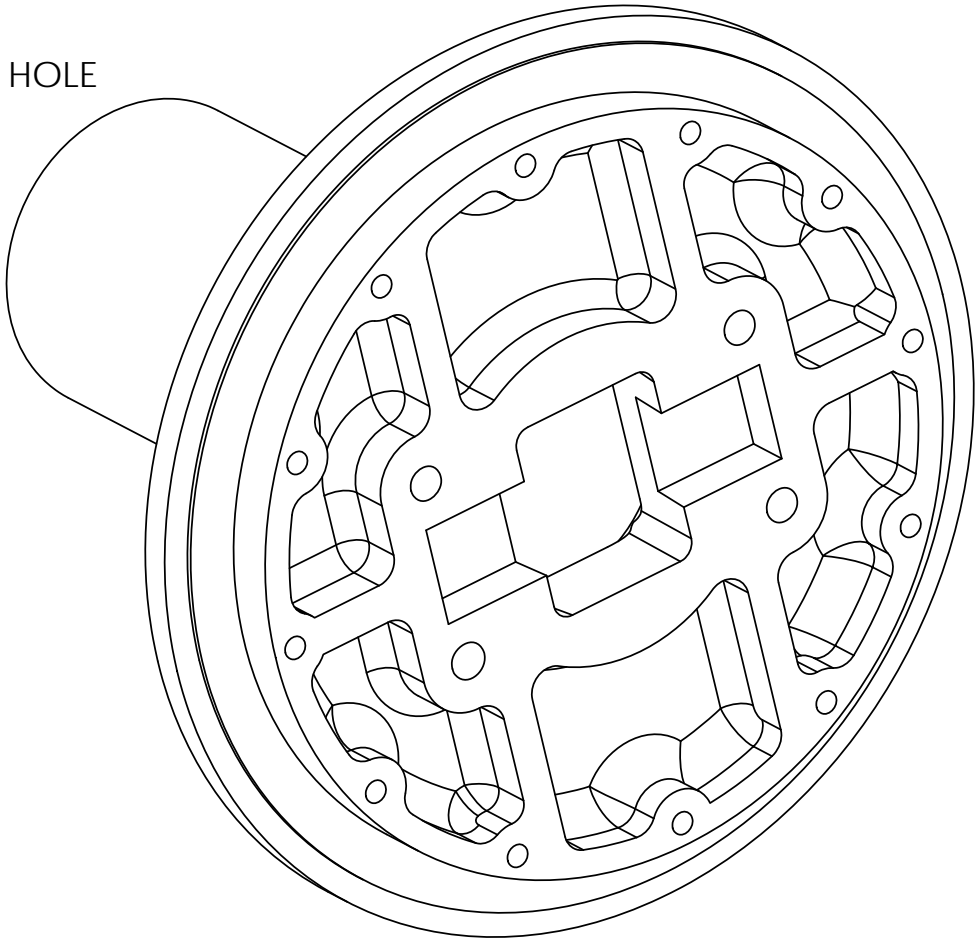


U.S.S. Monitor Steam Engine

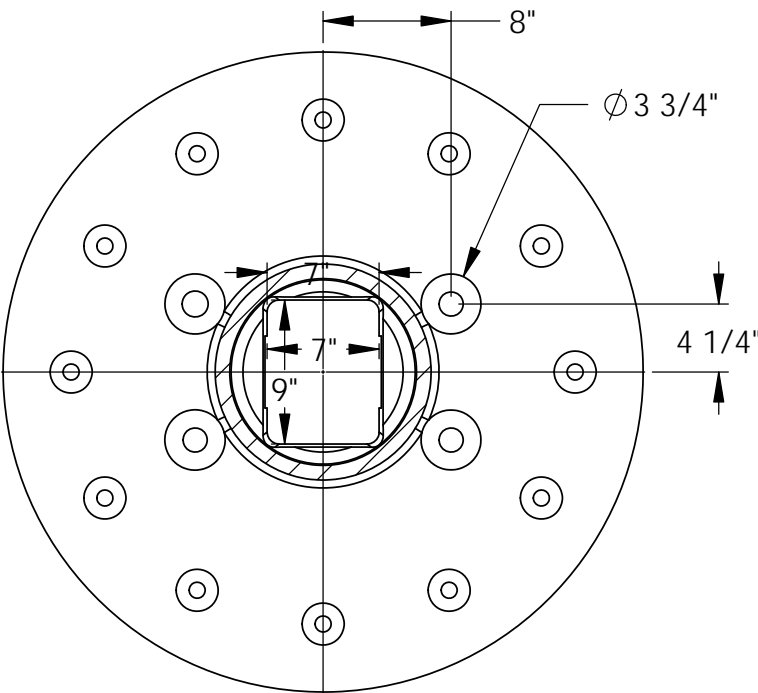
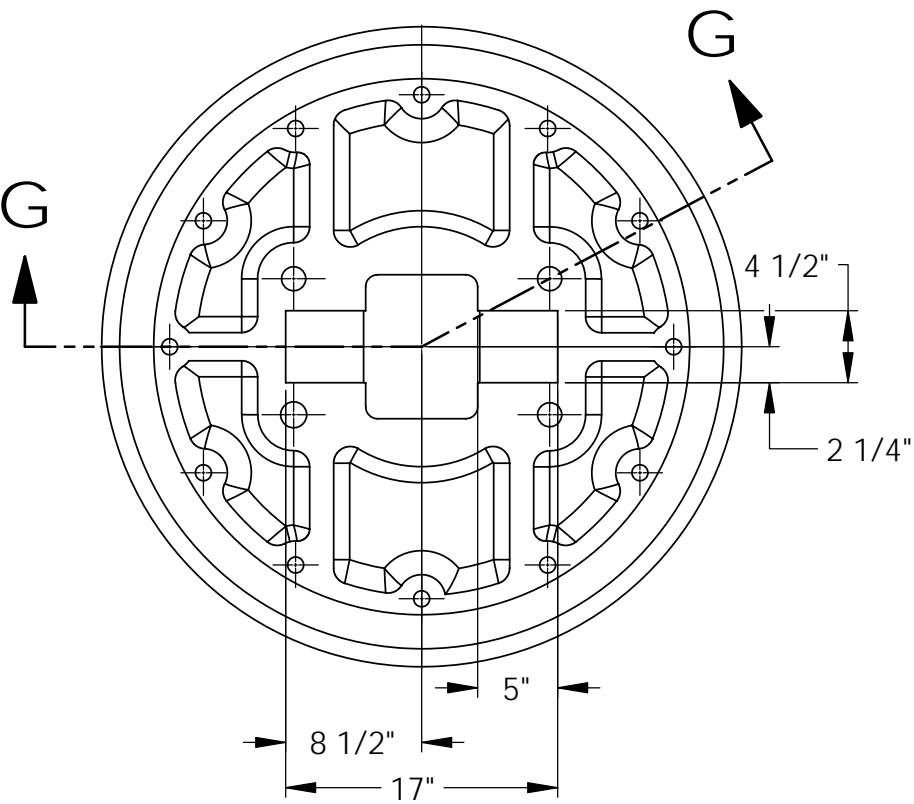
| | | |
|-------------------------------|--------------------------------------------------------------------------------------------------|------------------------------------------|
| Material Cast Iron | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 980.88 | <div> <div>Description</div> <div> <div>Piston Trunk</div> <div>SHEET 1 OF 2</div> </div> </div> | |
| Scale 1:10 | | |
| Part # C 9 | | |



SECTION G-G
SCALE 1 : 12
DETAILING WRISTPIN DIMS
AND 1-1/2" COUNTERBORE



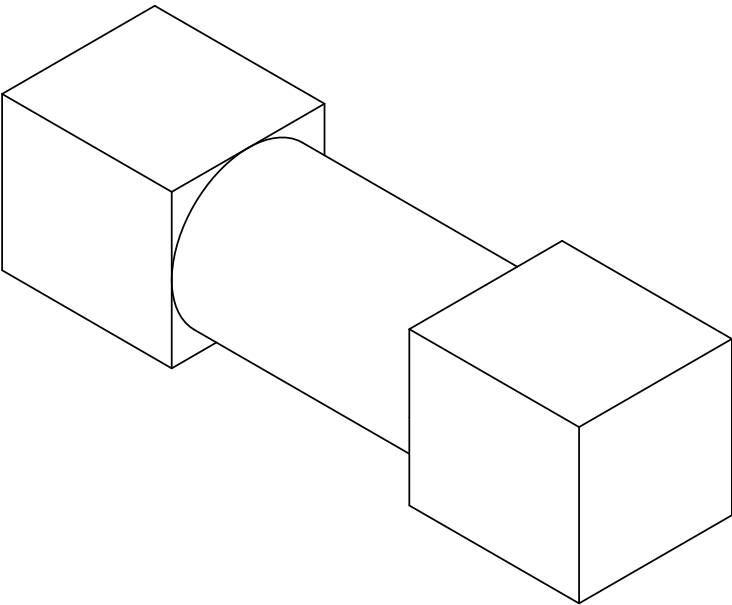
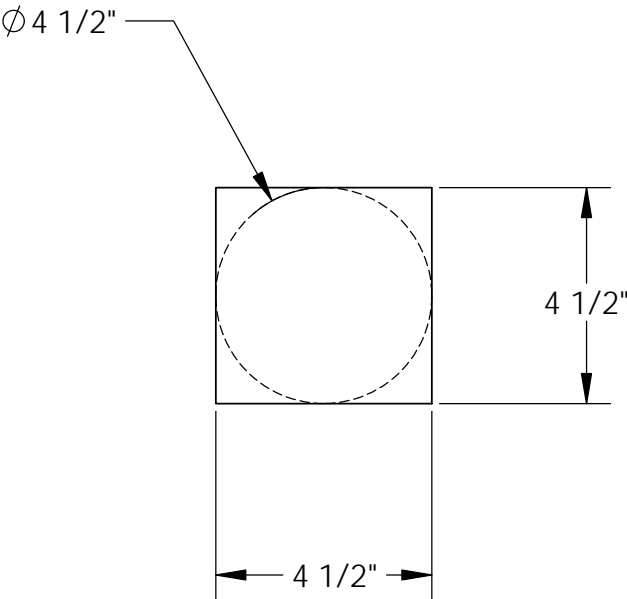
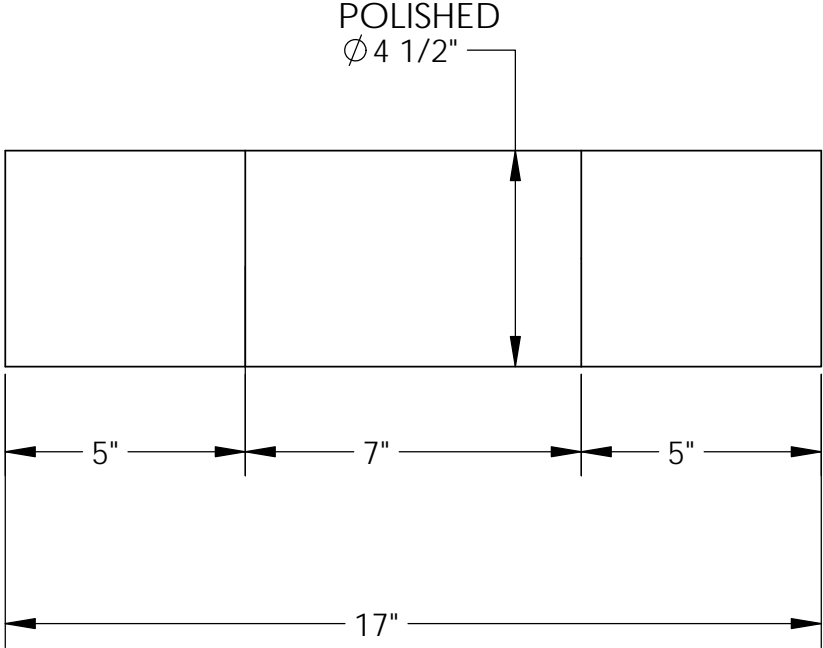
ISO VIEWS AT
SCALE 1:8



SECTION E-E
SCALE 1 : 12

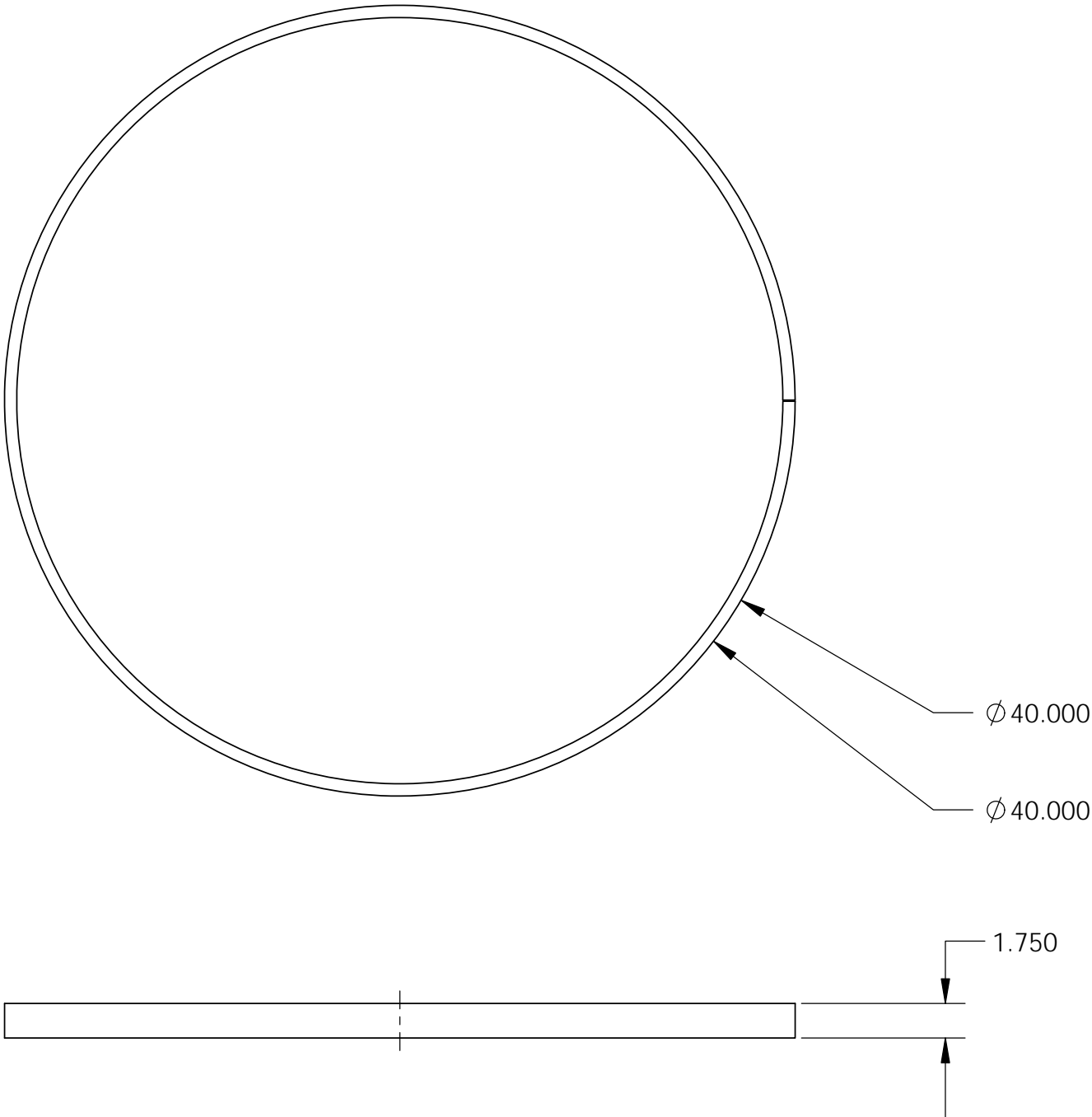
U.S.S. Monitor Steam Engine

| | | |
|------------------------|--------------------------------|-----------------------------------|
| Material Cast Iron | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 980.88 | Piston Trunk SHEET 2 OF 2 | |
| Scale 1:12 | | |
| Part # C 9 | | |



U.S.S. Monitor Steam Engine

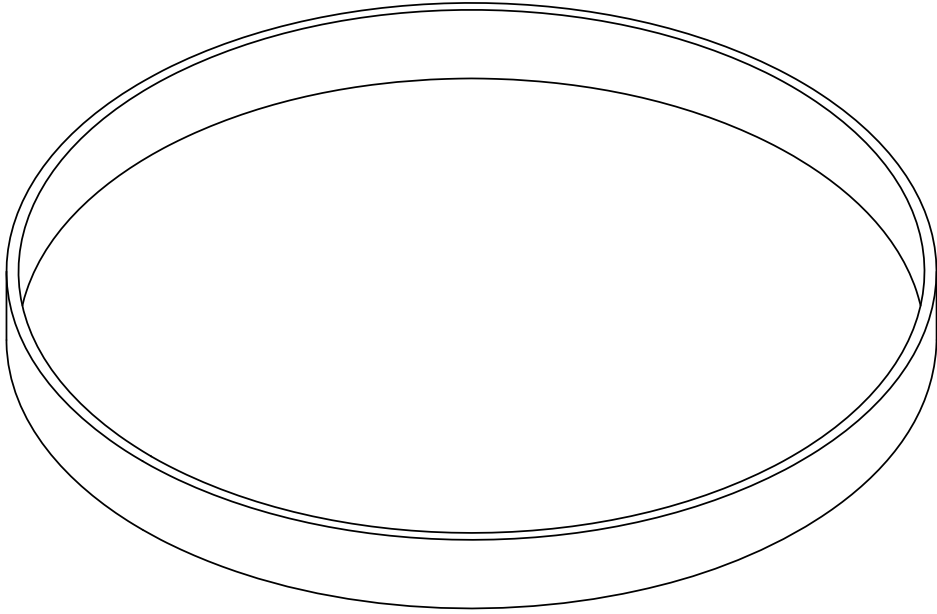
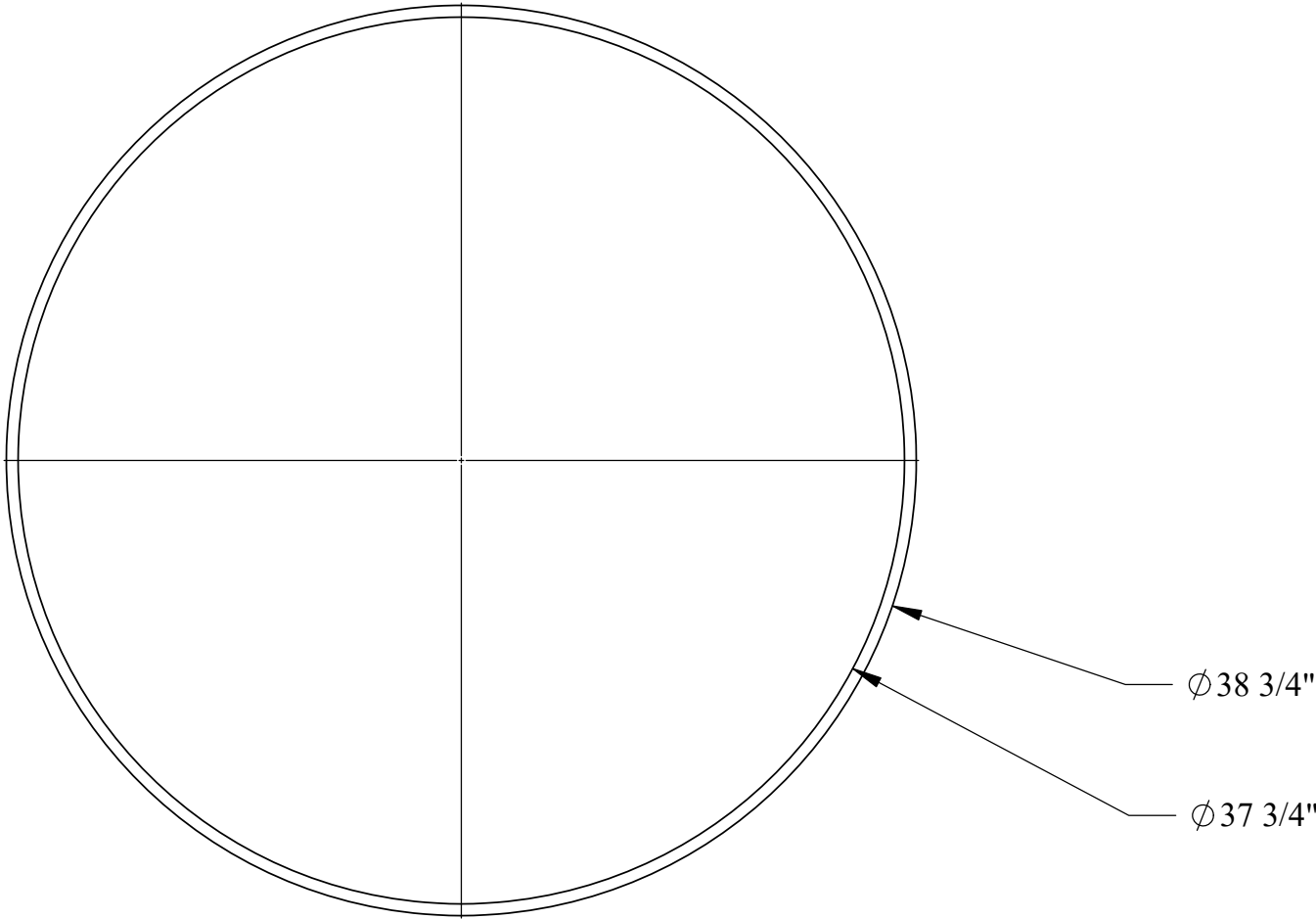
| | | |
|-----------------------|--------------------------------|-----------------------------------|
| Material STEEL | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 89.57 | Description Piston Wristpin | |
| Scale 1:4 | | |
| Part # C 10 | | |



SPRING RATE OR EXPANSION OF THIS RING
ARE UNKNOWN

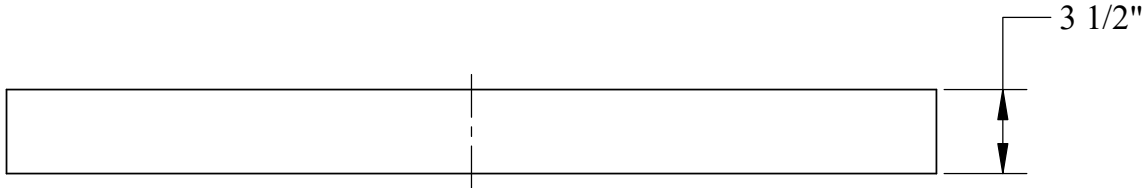
U.S.S. Monitor Steam Engine

| | | |
|-----------------------|--------------------------------|-----------------------------------|
| Material STEEL | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 38.60 | Description Piston Ring | |
| Scale 1:8 | | |
| Part # C 11 | | |



IT IS UNCLEAR WHETHER THIS RING WAS SPLIT AS OUTWARD EXPANDING SUPPORT RINGS WOULD NORMALLY BE USED. SINCE THE PISTON IS TWO PIECES, IT IS POSSIBLE THAT A PLAIN RING WAS USED AS SHOWN HERE

ACCORDING TO INFORMATION IN THE NATIONAL ARCHIVES ERICSSON USED A SPRING TYPE SUPPORT RING IN LATER ENGINES



U.S.S. Monitor Steam Engine

| | | |
|-----------------------|------------------------------------|-----------------------------------|
| Material STEEL | Drawn By - Date RWC 10-2018 | Sub-Assembly Cylinder Assembly |
| Weight (Lbs) 60.02 | Description Piston Support Ring | |
| Scale 1:8 | | |
| Part # C 12 | | |