

PAUL A RUSSELL

8

REEDS MARINE ENGINEERING AND TECHNOLOGY

# GENERAL ENGINEERING KNOWLEDGE

For Marine Engineers

6th Edition

# CONTENTS

## PREFACE

vii

## 1 MATERIALS

1

Manufacture of Iron and Steel	1
Converting Iron to Steel	2
Cast Iron	6
Simple Metallurgy of Iron, Cast Iron and Steel and the Effect of Carbon	7
Killed Steel	9
Properties of Materials	9
Testing of Materials	12
Treatment of Metals	26
Forming of Metals	32
Elements in Irons and Steels	34
Effect of Alloying Elements	35
Non-ferrous Metals	36
Non-metallic Materials	39
Welding	41
Gas Cutting	51

## 2 FUEL TECHNOLOGY

54

Liquid Fuels	54
Testing of Liquid Fuel and Oils	58
Combustion of Fuel	77
Analysis of Flue Gases	87
Boiler Combustion Equipment	93
Gaseous Fuels	98

## 3 BOILERS AND ANCILLARIES

104

Introduction	104
Safety Valves	106
Water Level Indicators	114
Boiler Controls	123
Other Boiler Mountings	126
Other Boiler Fittings	128
Boilers	129
Some Defects, Causes and Repairs in Auxiliary Boilers	135
Boiler Testing	138
Packaged Auxiliary Boiler	141
Reducing Valve	143
Thermal Fluid Systems	144

Evaporators (Fresh Water Generation at Sea)	145
Methods of Controlling and Minimising Scale (Evaporators)	147
Low-pressure Evaporating and Distilling Plants	150
Two-stage Flash Evaporator	152
<b>4 CORROSION, WATER TREATMENT AND TESTS</b>	<b>157</b>
Corrosion	157
Corrosion of Metals in Sea Water	158
Other Corrosion Topics	161
Corrosion in Boilers	162
Analysis of Sea Water	167
Analysis of a Fresh Water Sample	170
Boiler Water Treatment	172
Lime and Soda Treatment	173
Caustic Soda (sodium hydroxide, NaOH) Treatment	175
Phosphate Treatment	176
Boilers Not in Service	180
Cleaning of New Boilers	180
Boiler Water Tests	181
Diesel Engine Cooling Water	191
<b>5 MANOEUVRING AND STEERING</b>	<b>194</b>
Steering Gears, Stabilisers, Rudders and Thrusters	194
Steering Systems	195
Power (Amplifier) Units	201
Actuator (Servo) Mechanisms	205
Principal Rules Relating to Steering Gears	217
The Ship Stabiliser	220
Auto Control	224
<b>6 POWER TRANSMISSION SYSTEMS</b>	<b>226</b>
Introduction and Basic Design Considerations	226
Shaft Line Transmission	229
Alignment	229
Crankshaft Deflections	239
Shafting Stresses	245
Guidelines for Transmission Shafts	250
The Propeller Shaft and Stern Tube	255
Simple Balancing	273
Simple Vibration	276
<b>7 REFRIGERATION AND AIR CONDITIONING</b>	<b>285</b>
Ozone Depleting Substances	285
Basic Principles of the Refrigeration Cycle	286

Refrigerants	288
The Vapour Compression System	295
Compressor	302
Heat Exchangers	308
Direct Expansion Units	311
Absorption-type Refrigerator Unit	316
Brine Circuits	318
Basic Principles of Air Conditioning	320
Insulation	328
Gas Containment Systems	331
<b>8 FIRE AND SAFETY</b>	<b>335</b>
Principle of Fire	336
Fire Prevention and Precautions	336
Classification of Fires and Extinguishing Methods	337
Fire Detection Methods	340
Critical Analysis of Fire Extinguishing Media	349
Portable Fire Extinguishers	352
Fixed Firefighting Installations	357
Water Spray Systems	370
Breathing Apparatus	378
<b>9 PUMPS AND PUMPING SYSTEMS</b>	<b>382</b>
Types of Pumps	383
Positive Displacement Pumps	387
Roto-dynamic Pumps	389
Comparison of Pumps, Suction Lift, Cavitation	400
Associated Equipment and Systems	402
Prevention of Pollution of the Sea by Oil	412
Injectors and Ejectors	422
Sewage and Sludge	423
Pipe Arrangements and Fittings	426
Some Rules Relating to Pumping Systems' Bilge System	431
<b>10 ON-BOARD MANAGEMENT OF FUEL AND LUBRICATING OIL</b>	<b>436</b>
Clarification and Separation	450
Centrifuges	453
Centrifugal Purification	460
Lubrication	463
Grease	477
<b>11 INSTRUMENTATION AND CONTROL</b>	<b>478</b>
Instruments	480
Telemetry	495

Automation and Control	504
Control Systems	509

**12 MANAGEMENT AND LEADERSHIP** **520**

The Regulation of Shipping	520
Technical Issues that Require Careful Management	526
Ship Management	545
Company Management Structures	546
Machinery Maintenance	548
Report Writing	560

**TEST EXAMPLES** **569****INDEX** **591**

# INDEX

- 0.1% proof test 15
- Absolute temperature-entropy 300
- Absorption type refrigerator units 316-17
- Acidity, testing for (in liquid fuel) 72
- Acoustic emissions 553
- Actuator (servo) mechanisms 205-12
  - electrical steering gear 213-16
  - electric single motor steering gear 216
  - electro-hydraulic ram steering gear 205-10
  - electro-hydraulic rotary vane steering gear 210-16
- Air conditioning and refrigeration 285-334
- Air conditioning, basic principles of 320-8
  - circuits 324-7
  - contamination 326
  - Dalton's Laws 321
  - dehumidifiers 327-8
  - dew point 322
  - dry bulb temperatures 323
  - Legionella bacteria 326
  - partial pressures 321
  - per cent relative humidity 321
  - psychrometric charts 323-4
  - simple heat pump circuits 326-7
  - specific humidity 321
  - wet bulb temperatures 323
- Alfa-Laval
  - centrifuge, bowl type 431-2
  - fresh water generators 151
  - plate type heat exchangers 405-6
- Alignment 229-31
  - aft end installations 236, 238
  - bedplate 235
  - crankshaft 235
  - engine to propeller shaft 236
  - shaft 223-6, 230-1
- Alkalinity
  - testing for in boiler water 184-5
  - testing for in liquid fuel 72
- Alloying elements, effect of
  - chromium 36
  - molybdenum 36
  - nickel 35
  - vanadium 36
- Alternative fuels 101
- Aluminium 37
- Annealing 28
- Asbestos 40
- Ash 72
- Auto control steering systems 224-5
- Automatic boiler control systems 514-15
- Automatic water valves 314
- Auto-Klean strainer 442-3
- Axial flow pumps 394-6
- Balancing (power transmission systems)
  - inertia force of reciprocating mass 275
  - in line engines 275
  - multiple revolving masses 273, 275
  - single revolving mass 273
- Ballast 433
- Ball bearings 270, 273
- Bend test 23
- Bessemer process 2-3
- Bilge pumps 399-400, 431-3
- Blackheart process 29
- Blow down valves 127, 139-41
- Boilers and ancillaries 104-156
- Boiler combustion 93-8
  - equipment 93-8
  - heat balance 91-2
  - viscosity control 96-7
- Boiler controls 123-5
- Boiler corrosion 162-6
  - atomic and ionic theory 162-3
  - causes of 165-6
  - effects of salts and gases in feed water 166
  - electro-chemical 164-5
  - pH values 163
- Boiler defects 135-8
  - combustion chamber 136-7
  - cracks 135, 137, 138
  - deformation 135, 136-7
  - furnaces 135-6
  - shell and end plates 137-8
  - wastage 135, 137, 138
- Boiler fittings 128-9
- Boiler mountings 126-8
  - air vents 128
  - blow down valves 127
  - feed check valves 126-7
  - main stop valves 127
  - vacuum breakers 128
- Boiler, packaged auxiliary 141
- Boiler repairs 135-8
- Boiler testing 138-41
  - blowing down and opening up 139-41
  - hydraulic 138-9
- Boiler types
  - Cochran exhaust gas 133-4
  - waste heat 125-33

- Boiler water tests see: Testing boiler water
- Boiler water treatments 172–80
  - caustic embrittlement, prevention of 179–80
  - caustic soda 174–6
  - coagulants 177
  - condensate line 179
  - de-aeration 178–9
  - lime and soda 172–4
  - low-pressure boilers 172–4
  - phosphate 176–80
- Bomb Calorimeter 65–6
- Bourdon pressure gauge 486–7
- Brass 37
- Brazing 51
- Breathing apparatus (emergency) 378–81
- Brine circuits 318–20
  - battery system 319
  - hold ventilation control 320
  - ice making 319
  - properties of brine 318–19
- Brinell hardness test 15–16
- bronze 37
  
- Calculated Carbon Aromaticity Index 71
- Calibration of instrumentation 493–4
- Calorific value of liquid fuel 65–67
- Carbon
  - combustion of 79
  - residue testing 68–9
- Cargo pumps 397–9
- Case hardening 29–30
- Cast iron 149–60
  - simple metallurgy 6–7
- Caustic soda treatment 174–6
- Cavitation 400–2
- Centrifugal casting 33–4
- Centrifugal compressors 306–7
- Centrifugal filters 446
- Centrifugal pumps 389–94
- Centrifugal purification 460–3
  - of fuel oils 460–1
  - of lubricating oils 461–3
- Centrifuges 453–60
  - Alfa-Laval bowl type 455–6
  - disc type, action of particles in 453–4
  - self-cleaning purifier 458–60
  - Sharples super-centrifuge 456–8
- Cetane number, testing for 73–4
- CFC refrigerants 293
- Chloride tests 185
- Chromium 36
- Clarification (fuel) 450–1
- Classification of ships 527–8
- Coalescers 445–6
  
- Cochran boilers
  - exhaust gas 133–4
  - single pass composite 131
  - spheroid 133
- Cold working 34
- Combustion of fuel 77–87
  - air for 81–3
  - boilers 93–8
  - boiler combustion heat balance 91–2
  - calorific value 81
  - carbon 79
  - equipment 99
  - flame temperature 86
  - hydrocarbons 83–5
  - hydrogen 79
  - liquid natural gas 85–6
  - oil fuel additives 86–7
  - sulphur 80–1
- Combustion gas detector 348–9
- Composite materials 40–1
- Compressors 303–8
  - centrifugal 306–7
  - hall screw 308
  - reciprocating 303–4
  - rotary 306
  - screw 307
  - veebloc 304–5
- Condensers 308–9
- Conradson method 68–9
- Control and instrumentation 478–519
- Control systems 509–19
  - automatic boiler 514–15
  - bridge control of IC engine 517–19
  - diaphragm valve 510–11
  - fluid temperature control 513–14
  - position indicator 512–13
  - unmanned machinery spaces
    - operation 515–17
- Control theory 504–509
  - close loop control system 505
  - electrical-electronic controller 509
  - pneumatic controller 508–9
  - proportional control 506–8
- Cooling systems, central 406–7
- Cooling water, diesel engine 191
- Copper 36–7
- Copper-nickel alloys 38
- Corrosion 157–67
  - boiler 162–6
  - de-zincification 160
  - electro-chemical 164–5
  - fatigue 162
  - fretting 161
  - graphitisation of cast iron 159–60

- metals in sea water 158–160
  - pitting 161
  - stress 160
  - velocity of sea water 160
  - white metal bearings 476
- Cotton 40
- Crankcase oil dilution 74
- Crankshafts 249–50
  - bedplate alignment 235
  - deflections 239–45
- Crankweb allowance deflections 241
- Creep test 20–21
- Dalton's Laws 321
- De-aeration 178–9
- Dehumidifiers 327–8
- Density of liquid fuel 58–9
- Desalination plant, reverse osmosis 155–6
- De-zincification 160
- Diaphragm valves 510–12
- Die casting 33
- Diesel engine cooling water 191–3
- Direct expansion units 311–16
  - automatic water valve 314
  - electrical control switch 312–13
  - magnetic liquid stop valve 314–16
  - thermostatic expansion valve 313
- Dissociation 90–1
- Dissolved oxygen tests 188
- Distillation process 56
- DP cell transmitter 97
- Drinking water 154–5, 410–11
- Dynamometer 268–9
- Ejectors 422
- Electric arc welding 46–50
- Electrical-electronic controllers 509
- Electro-chemical corrosion 164–5
- Electro-hydraulic systems 197
- Electro-pneumatic transducers 501
- Elements in irons and steels 34–5
- Epoxy resin 40
- Evaporators 145–156, 309
  - fresh water generator (alfa-laval) 151
  - low-pressure evaporating and distilling plants 150–2
  - methods of controlling and minimizing scale 147–50
  - simple vertical 149
  - two-stage flash evaporator 152–3
- Explosive vapour concentration 99–100
- Fatigue test 21–3
- Feed water, effect of salts and gases in 166
- Filtration (of fuel) 441–42
- Fire and safety 335–81
- Fire
  - alarms 341–3
  - classification of 337–40
  - detection methods 340–49
  - extinguishers (portable) 352–7
  - extinguishing methods 349–52
  - installations (fixed firefighting) 357–70
  - prevention and precautions 336–7
  - principles of 336
  - water spray systems 370–6
- Flame hardening 30
- Flash point of liquid fuel 63–5
- Flow measurement 489–91
- Flue gases, analysis of 88–92
  - boiler combustion heat balance 91–2
  - dissociation 90–1
  - pollutants 88–90
- Fluid temperature controls 513–14
- Forging 34
- Forming metals 32–4
- Fresh water
  - analysis of 170–2
  - generators (Alfa-Laval) 151
  - treatment plants 410–11
- Fretting corrosion 161
- Fuels
  - alternative 101
  - gaseous 98–101
  - liquid see: liquid fuels
- Fuel management 436–77
- Fuel technology 54–103
- Galvanic action 158–9, 165
- Gas (combustion) detector 348–9
- Gas cutting 51–2
- Gas explosion-detector meter 100
- Gaseous fuels 98–101
  - alternative fuels 101
  - combustion equipment 99
  - explosive and toxic vapour concentration 99–100
- Gear pumps 387–8
- Graphitisation of cast iron 159–60
- Gravity separation (of fuel) 439–41
- Grease 477
- Hardening 26–8, 29–31
  - case 29–30
  - flame 30
  - induction 31
  - work 29
- Hardness (boiler water) 186–7

- Hardness tests
    - Brinell 15–16
    - Microhardness 16, 17
    - Rockwell 15
    - Vickers 16, 17
  - Harmonised System of Survey and Certification 531
  - Heat exchangers 308–11, 402–6
    - condensers 308–9
    - evaporators 309
    - liquid level control 310
    - plate type 405–6
    - shell and tube type 404–5
    - thermodynamic characteristics 402–3
  - Heat sensors 344–5
  - Heat transfer
    - fluids 309
    - insulation 328–31
    - vapour compression systems 295
  - Hele-Shaw pump 202–4
  - Hydrazine tests 190
  - Hydrocarbons 55–6
    - combustion of 83–4
  - Hydrodynamic lubrication 470–1
  - Hydrogen, combustion of 79
  - Ice-water-steam phase changes 286–8
  - Ignition properties of combustible products 84
  - Impact tests 17–20
  - Inducers 401–2
  - Induction hardening 31
  - Injectors 422
  - Instrumentation and control 478–519
  - Insulation 328–31
  - IP method 69–70
  - Iron and steel
    - elements in 34–5
    - manufacture of 1–6
  - ISO Specification for marine fuels 77–8
  - IZOD values 18
  - Journal bearings 472
  - lacquering 474
  - LD method 3–5
  - leadership and management 520–67
    - communication 543–5
    - company management
      - structures 546–8
    - contingency theory 535–7
    - delegation 537–8
    - motivation 538–43
    - report writing 560–7
    - ship management 545–6
    - style theory 534–5
    - team motivation 541–3
  - training 531–2
  - trait theory 533–4
- Legionella bacteria 326
- Level measurement 488
- Lime and soda treatment 172–4
- Liquid fuels 54–87
  - combustion of 77–87
  - complex processing with catalytic cracking and visbreaking 56–8
  - distillation process 56
  - petroleum, composition of 55–6
  - straight run refinery layout 56
  - testing see: testing liquid fuel and oils
- Liquid natural gas 83, 85–6, 101
- Liquid petroleum gas 99, 101
- Lubrication 463–
  - bearings 469–70, 471, 472–3
  - fundamentals 469
  - hydrodynamic 471, 472
- Lubricating oil 464–8
  - additives 464–6
  - manufacture of 463–4
- Microbial degradation of 467–8
- Magnetic liquid stop valves 314–16
- Maintenance (machinery) 548–60
  - acoustic emission 553
  - condition-based 550–3
  - condition/performance
    - monitoring 555–6
  - non-destructive testing 556–7
  - noise analysis 553–4
  - oil analysis 554
  - planned 549–50
  - record books, engine room 557–8
  - strategic approach to 558–60
  - vibration analysis 553–4
- Management and leadership 520–67
  - communication 543–5
  - company management
    - structures 546–8
  - contingency theory 535–7
  - delegation 537–8
  - motivation 538–43
  - report writing 560–7
  - ship management 545–6
  - style theory 534–5
  - team motivation 541–3
  - training 531–2
  - trait theory 533–4
- Manganese 34–5
- Manoeuvring 194–225
- Manometers 485–6
- Manufacture of iron and steel 1–6
  - acid and basic processes 5–6
  - Bessemer process 2–3

- modern processes 3–5
- open hearth process 3
- Marine Distillate Fuels 77
- Marine Residual Fuels 78
- MARPOL 88–90
- Materials 1–53
  - non-metallic 39–41
  - properties of 9–11
  - testing see: testing materials
  - treatment of see: treatment of materials
- Mechatronics 501–3
- Metals, composition and
  - qualities of 44–5
- Metals, forming of
  - centrifugal casting 33–4
  - cold working 34
  - die casting 33
  - forging 34
  - sand casting 32–3
- Metals, non-ferrous 36–9
- methane 85–6
- Michell bearings 473–6
- Microhardness test 16, 17
- M Notices 522–5
- Molybdenum 36
  
- Nesslerisers 187, 188
- Nickel 35
- Nitriding 30
- Nitrile 40
- non-ferrous metals
  - aluminium 37
  - brass 37
  - bronze 37
  - copper 36–7
  - copper-nickel alloys 38
  - titanium 39
  - white metals 38–9
- Non-metallic materials
  - composites 40–1
  - plastics (polymers) 39–40
- Normalising (materials) 28
  
- Octane number, testing for 73
- OF burner (Wallsend-Howden) 94
- Oil filters
  - coalescers 445–6
  - streamlined lubricating 444, 445
- Oil fuel additives 86–7
- Oil fuel installations 434–5
- Oil mist detectors 554–5
- Oil mist eliminators 444
- Oil module 447–9
- Oil-water ballast chest 428, 429–30
- Oil-water separators 414–21
  - automatic 416–21
- Open hearth process 3
- Ozone depleting substances 285–6
  
- Packaged auxiliary boilers 141–2
- Pensky Marten test 63–4
- Petroleum, composition of 55–6
- Phosphates
  - tests 186
  - treatment 176–7
- Phosphorous 35
- Pilgrim wire method 239
- Pipe arrangements and fittings 426–31
  - bilge injection valve 429
  - bilge pump arrangement, typical 426–7
  - deep tank piping arrangement 428
  - oil-water ballast chest 429–30
- Pitting corrosion 161
- Plastics (polymers) 39–40
- Plate type heat exchangers 405–6
- Pneumatic controllers 508–9
- Pollutants in flue gases 88–9
- Pollution, preventing (oil) 412–21
  - oil-water separator 414–21
- Port State Control 521–2
- Position indicators 512–13
- Pour point of liquid fuel 67–8
- Power (amplifier) units 201–5
  - Hele-Shaw pump 202–4
- Power transmission systems 226–84
  - aft end installations 236, 238
  - alignment 229–39
    - balancing 273–5
    - crankshaft and bedplate alignment 235
    - crankshaft deflections 239–45
    - engine alignment to the propeller shaft line
      - transmission 236
    - pilgrim wire method 239
    - propeller shaft 255–73
    - shafting stresses 245–50
    - shaft line 229
    - stern tube 255–73
    - turbine engine vessels 238
    - vibrations 276–84
- Pressure, measurement of 485–7
- Propellers 261–266
  - blade design 263–5
  - controllable pitch 265–6
- Propeller shafts 255–73
  - alternative stern gear 260–1
  - dynamometer 268–9
  - oil lubricated type 258–9
  - thrust block 270
  - torsionmeter 266–8
  - water lubricated type 255–8
  - withdrawable stern gear system 260–1
- Proportional control 506–8

- PTFE 40
- Pump drive motors, efficiency increases
  - by 409–10
- Pumps, comparison of (suction lift and cavitation) 400–2
  - inducers 401–2
- Pumps, positive displacement 387–9
  - gear 387–8
  - reciprocating 387
  - screw displacement 388
- Pumps, roto-dynamic 389–400
  - axial flow 394–6
  - cargo 397–9
  - centrifugal 389–94
  - emergency bilge 399–400
- Pumps, types of 383–400
  - axial flow 394–6
  - cargo 397–9
  - central priming system 385–7
  - centrifugal 389–94
  - classification 383–4
  - emergency bilge 399–400
  - gear 387–8
  - positive displacement 387–9
  - priming 384–7
  - reciprocating 387
  - roto-dynamic 389–400
  - screw displacement 388–9
- Purification, centrifugal 460–3
  
- Radiography 25–6
- Reciprocating pumps 387
- Reducing valves 143–4
- Refrigerants 288–95
  - CFCs 293
  - comparison of 292
  - desirable properties 288–9
  - gases 289–90
  - properties of 290–1
- Refrigeration and air conditioning 285–334
- Refrigeration cycle 286–8
- Refrigerator unit, absorption type 316–17
- Regulation of shipping 520–30
  - classification of ships 527–30
  - M Notices 522–5
  - Port State Control 521–2
- Report writing 560–7
- Reverse osmosis desalination plants 155–6
- Rockwell hardness test 15
- Roller bearings 270–3
- Rotary compressors 306
- Roto-dynamic pumps 389–400
- Rotor method 3, 4
- Rubber 40
  
- Safety and fire 335–81
- Safety valves 106–114
  - accumulation of pressure test 111–12
  - adjustment 111
  - full lift 112–13
  - full bore 113–14
  - improved high lift type 108–10
  - maintenance 111
  - operating principle of 106
  - types of 108
- Salinometers 183
- Salts 170
- Sand casting 32–3
- Screw compressors 307
- Screw displacement pumps 388–9
- Sea water, analysis of 167–9
- Self-cleaning purifiers 458–60
- Sensors 494–5
- Separation (fuel) 450–3
- Sewage and sludge 423–6
  - biological treatment plants 423–5
  - chemical treatment plants 425
  - retention systems 423
  - sludge incinerators 425–6
- Shafting alignment 231–4, 240
- Shafting rules 250–5
  - alignment verification 254
  - couplings and coupling bolts 254
  - crankshafts 251
  - crankwebs 251
  - intermediate shaft 250–1
  - liners 254
  - operation in ice, extra strength for 254
  - propeller shaft 251–2
  - stern tube bush 252–3
  - stern tube shaft 251
  - thrust shaft 251
  - turbine wheel shafts 251
  - ultrasonic tests 254
- Shafting stresses 245–50
  - crankshaft 249–50
  - intermediate shaft 246–7
  - propeller shaft 247–9
  - thrust shaft 247
- Shaft line transmission 229
- Sharples super-centrifuge 456–8
- Ship management 545–6
- Shipping regulations see: Regulation of shipping
- Ships, classification of 527–30
- Silicates 170–1
- Silicon 35
- Silicon nitride 40
- Smoke detectors 347
- Sodium 72
- SOLAS convention 59, 91, 180, 415, 497–500
- Soldering 51
- soot blowers 128–9

- Spheroidising anneal 32
- Sprinkler systems 370–3
- Stabilisers 220–4
  - auto control 224
  - electrical control 220–1
  - hydraulic control 221–4
- Steam atomising equipment 95
- Steel and iron
  - elements in 34–5
  - manufacture of 1–6
- Steel
  - simple metallurgy 7–9
- Steering systems 195–225
  - actuator (servo) mechanisms 205–17
  - auto control 224–5
  - electric single motor steering gear 216–17
  - electrical telemotor 199
  - electro-hydraulic 197, 205–8
  - power (amplifier) units 201–5
- Stern tubes 255–73
  - alternative stern gear 260–1
  - dynamometer 268–9
  - oil lubricated type 258–9
  - thrust block 270
  - torsionmeter 266–8
  - water lubricated type 255–8
  - withdrawable stern gear system 260–1
- sulphite tests 186
- sulphur 35, 75
  - combustion of 80–1
- telemetry 495–504
  - alarm scanning 496–9
  - amplifier 499, 500
  - communication systems 503–4
  - data logging 496–9
  - digital control systems 501–3
  - display panel and controls 495–6
  - mechatronics 501–3
  - signal media 501
  - transducer 500–1
- telemotors, electrical 199
- telemotor fluids 197
- temperature, measurement of 481–5
- tempering 26–8
- tensile tests 12–15
- test examples 569–90
- testing boiler water 181–90
  - alkalinity 184–5
  - chloride* 185
  - dissolved oxygen 188–9
  - dissolved solids 189–90
  - hardness 186–7
  - hydrazine 190
  - litmus papers 183
  - pH value 187
  - phosphate 186
  - salinometer 183
  - sulphite 186
- testing liquid fuel and oils 58–78
  - acidity or alkalinity 72
  - analysis (typical) 76
  - ash 72
  - calorific value 65–7
  - carbon aromaticity 71
  - carbon residue 68–9
  - cetane number 73–4
  - crankcase oil dilution 74
  - density 58–9
  - flash point 63–5
  - ISO Specification 76–8
  - octane number 73
  - pour point 67–8
  - sodium 72
  - sulphur 75
  - vanadium 72
  - viscosity 60–3
  - water in oil 69–70
- testing materials
  - 0.1% test 15
  - bend test 23
  - creep test 20–1
  - fatigue test 21–3
  - hardness test 15–17
  - impact test 17–20
  - non-destructive tests 23–6
  - tensile test 12–15
- thermal conductivity of insulating materials 330
- thermocouples 483–85
- thermodynamic cycles in vapour compression systems 299–301
- thermography 26
- thermostatic expansion valves 313–14
- thrust block 270, 271
- tiller, fork type 210, 211
- titanium 39
- torsionmeter 266–8
- toxic vapour concentration 99
- transmission, shaft line 229
- treatment of materials 26–32
  - annealing 28
  - Blackheart process 29
  - case hardening 29–30
  - flame hardening 30
  - hardening* 26–8, 29–30
  - induction hardening 31
  - nitriding 30
  - normalising 28
  - spheroidising anneal 32
  - tempering 26–8
  - work hardening 29

ultrasonics 25, 26

Vanadium 36, 72

Vapour compression system 295–308

common faults 299

critical temperature 302

heat transfer 295

operating cycle 296–8

temperature glide 302

thermodynamic cycles 299–302

types of compressor 302–8

Veebloc compressors 304

Venturi flow sensor 490

Vibrations 276–84

axial 278

dampers 278, 280

detuners 278

electric drives 283–4

gearboxes 282

general 276

high-cycle fatigue 281–2

low-cycle fatigue 281–2

pods 283–4

torsional 278, 280–1

torsional elastic curves 280

transverse 276–7

Vickers hardness test 17

Viscometer 97

Viscosity of liquid fuel 60–3

control 96–8

Wallsend-Howden OF burner 94

Ward Leonard electrical steering gear 213–16

Waste heat boilers 129–33

Water, analysis of 167–172

Water in oil testing 69–70

Water level indicators (boilers) 114–23

blowing procedure 114–20

glass water gauge 121

plate type water gauge 118

remote 120–23

Water supply, domestic 154–5, 410–11

Welding 41–51

White metals 38–39

White metal bearings 476

Work hardening 29

Worthington-Simpson priming system 363

Writing reports 537–42