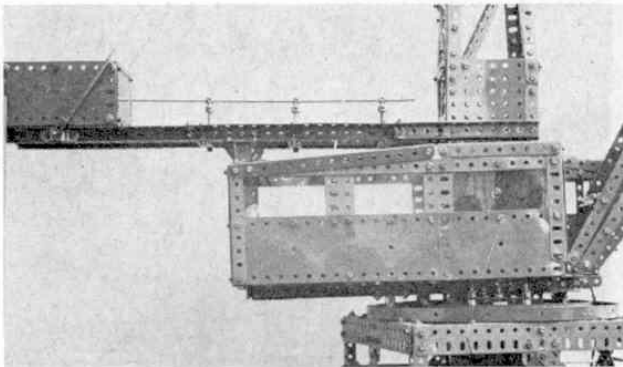


Fig. 10. Above: Base of a free-standing Monotower Crane heavily reinforced with compound girders to take the entire downward thrust of the crane's superstructure on a simple ball bearing.

Fig. 11. Below: Counter balance ballast box typical of that employed on Monotower Cranes. Note that side thrust rollers only are employed in the turntable.



model makers, in the absence of suitable scrap lead, the ballast may be provided by spare Meccano Strips, Plates, Washers and Nuts & Bolts, the use of which makes the ballast adjustment very simple. In calculating safety factors of the nature outlined, the crane engineer must also take wind speeds into consideration and stresses on the hoisting gear and crane stability which could arise through operator errors.

In the last two types of crane mentioned, the revolving superstructure has been carried on a strong centre post made of Angle Girders cross braced with strips which pivots inside the crane tower and is an ideal method of slewing such cranes as no heavy turntable is required at the upper level, a light-duty side thrust roller race being all that is required.

The types of crane which the Meccano enthusiast can model are legion and hundreds of examples of them are to be seen all over the country whether inland or at seaports. Mobile cranes form a class of their own although the principles outlined are as important for these as for any other class of crane. The gantry crane is another very popular type which is very well covered by the Meccano Manuals of Instructions and since it is virtually a travelling bridge its inherent stability is a built-in feature allowing it to cope with the greatest loads, weight for weight, by comparison with any other type of crane.

No mention of crane structures would be complete without reference to the Giant Block-Setting Cranes which have featured in Meccano literature for more than half a century. Very few of these juggernauts survive to-day as the breakwaters and harbours which they built over the past century are now well established and modern construction utilises pre-cast, or site-poured concrete by contrast with the fifty-ton blocks of solid masonry which these veteran 'Titans' set into place with precision of a trained eye and a steady nerve. Such cranes are fascinating challenges for the Meccano modeller and Fig. 12 shows some aspects of their rugged structure which may be reproduced in Meccano.

In the following chapter we shall be considering motions of the crane, in particular the hoisting mechanisms and types of turntables. The range of Meccano parts is so vast by comparison with any competitive system that highly efficient turntables and powerful drives to them may be constructed from the existing Meccano range without resort to purpose-made parts or 'foreign' bodies and diameters varying from 1 in. to a couple of feet are well within the scope of the system.

Part 4—Winding Gear

NO MATTER to what size a model crane is made, the greatest satisfaction to the modeller comes when it springs to life with the first movement of its winding drum. The simplest form of ready-made winder in the Meccano system is the Crank Handle which is found in all Meccano Outfits from the smallest to the largest and with the simple set-up shown in Fig. 1. it is perfectly efficient. At one time, younger modellers had some difficulty in securing the hoisting cord to the Crank Handle, as simple hitches and knots gave no real grip, but with the introduction of the Cord Anchoring Spring, Part No. 176, a positive grip was assured.

Two points are worth noting with regard to the use of this part as a cord anchor. It is important that, when the winding handle is turned, tension come on to the small loop arm of the Anchoring Spring in such a way as to tend to wrap the Spring more tightly round the shaft as the load is hoisted. Fig. 1 shows the Cord Anchoring Spring correctly set for hoisting with a clockwise motion. Before attaching the hoisting cord to the Spring, the cord should first be tied with a half-hitch round the shaft and its 'tail' secured to the small loop on the Spring. This prevents 'snatch' when the hoisting cord has run out to its fullest extent.

For younger model-builders, the process of fitting a

MECCANO CONSTRUCTORS GUIDE

Part 5: Rotating Superstructures by Bert Love

BBROADLY SPEAKING, rotating superstructures can be placed into one of three categories as follows:

- (1) Static balanced structures, such as gun turrets and roundabouts.
- (2) Counterweighted structures, such as hammerhead cranes and,
- (3) Pivoting structures which swing around a mast, such as tower cranes.

Swing bridges and locomotive turntables fall into the first category which is concerned with rotating structures which are more or less permanently balanced and are therefore fairly simple in design. A large roller path is provided in the form of a ring and a central pivot post is anchored to centralise the rotating structure. In many cases the stability of such turntables is provided purely by gravity from the sheer weight of the revolving

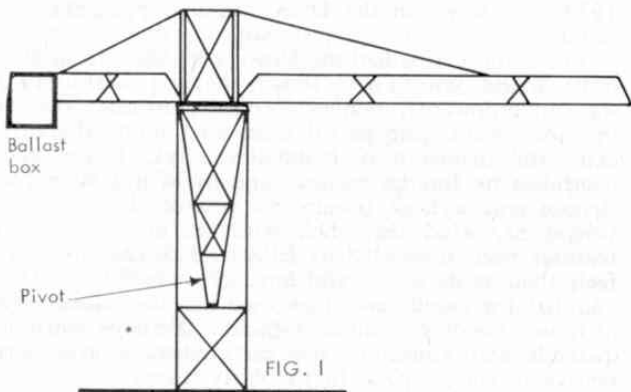
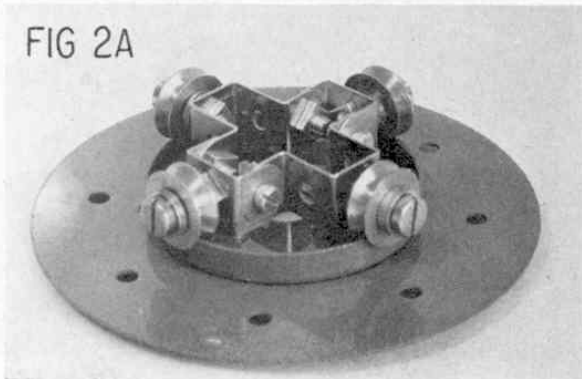


Diagram of a tower crane employing a rotating mast.

mass. A classical case of this is illustrated in the scuttling of the German Grand Fleet in Scapa Flow, after the 1919 Armistice. When the great Battleships and Cruisers were salvaged they were found to be without their heavy guns. When the ships capsized and turned turtle, the gun barbets simply fell out of their deep circular wells, where they simply rested on roller bearings, and plunged to the bottom of the ocean. Although the fairground roundabout is, generally speaking, a balanced rotating structure, many traditional types did pivot about a central mast and to maintain smooth running, a good fairman, in loading his machine,

FIG 2A



A miniature roller bearing used at the foot of a crane mast.

especially with heavy adults, would see that they were equally distributed round the 'ride'.

The two diagrams Fig. 1 and Fig 1a (not to scale) illustrate cranes that fall into the second two categories. In the first diagram we see the general outlines of a tower crane which represents those types which make use of a central mast for their rotation of the long boom. The tapered mast which runs down through the tower is pivotted in a fixed bearing, as shown, and this often takes the form of a phosphor bronze pad. It is important to realise that, in such a crane, the entire weight of the rotating structure is carried by the bearing at the foot of the mast and a roller ring situated at the break of the tower is a very light-duty affair which supports only the lateral, or sideways 'lean' of the crane when under load. This system has the advantage of being safe; requires no heavy components; can be made up from light-weight lattice components and absorbs both wind displacement and 'whipping' of the crane boom under awkward load conditions or jarring. The tilting moment from the load (or ballast box) is also transmitted to the foot of the mast so that the tower contributes to the general stability of the crane and must be designed and anchored accordingly.

After considerable wear, the phosphor bronze bearing is replaced by 'jacking up' the mast, the upper roller race being designed to allow its rollers to move vertically, and a new bearing inserted. This type of crane is

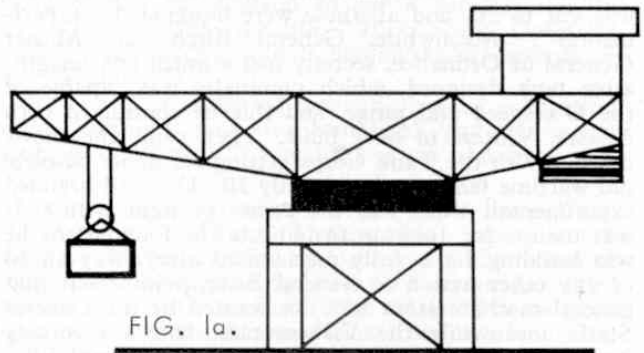


Diagram of a block-setting or hammerhead crane employing a heavy turntable and platform.

very easy to build in Meccano, the pivot at the foot of the mast being provided by a Meccano Steel Ball, Part No. 168d, trapped in the sockets of a pair of Socket Couplings, Part No. 171, one of which is secured to the foot of the mast and one to the base girders of the tower. The upper roller race to take the lateral thrust can be made from any of the Meccano Circular Strips or Circular Flange Rings, against which six or eight Flanged wheels are set to roll round on the inside. Fig. 1a represents the heavy type of crane which is a familiar sight in ports and dockyards and is well known as a favourite type of modelling by the advanced enthusiast. This type of crane requires quite a massive roller bearing because of the sheer physical weight of the rotating superstructure plus the very heavy loads which these giants can handle. Even larger and heavier turntables are used by the World's largest Draglines which literally 'sit' on their own roller bearings and drag

them across the face of the earth.

In considering the reproduction of the various turntables found in engineering practice, the Meccano Constructor must use his ingenuity to overcome problems within the limits of the parts at his disposal. Referring back to the tower crane, one problem which does arise is the supply of power to the cab controls when it is necessary to pass a cable up through the crane mast. Obviously a hollow pivot bearing is required and Fig. 2 shows how this can be done. One of the neatest and smallest thrust roller bearings which can be built in Meccano is shown in Fig. 2a which has the excellent advantage of being completely self-centring. The lower part of this bearing is a Wheel Flange, Part No. 137, bolted to a Circular Palte. As both of these parts have a substantial hole in the centre, a generous size of multicore cable can be passed right through the

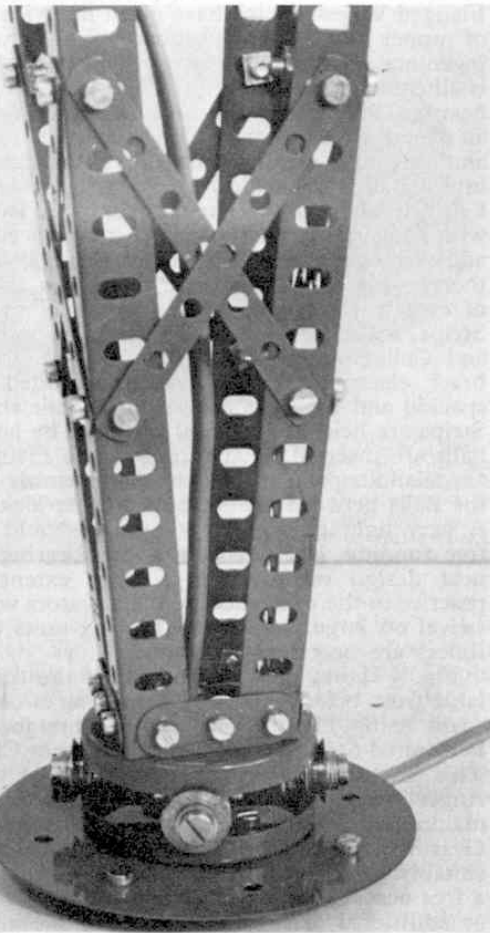


FIG 2

A hollow pedestal-bearing for the foot of a crane mast, through which a power cable is fed.

middle of this neat little roller bearing without impairing its efficiency. The foot of the crane mast is fixed to a second Wheel Flange by Angle Brackets, as shown, and the whole mast can then be rotated by a suitable drive at cab level, or by attaching a $3\frac{1}{2}$ in. Gear Ring, Part No. 180, to the foot of the mast.

Moving up a little in size, we come to the purpose-made Ball Thrust Bearing, Part No. 168. This is a versatile component as its three parts can be used independently and Fig. 3 shows an exploded view of a built-up Ball Bearing on a model of a mobile crane. Only the top section and actual Ball-race of the bearing are used in this case, the lower flange being replaced by a $3\frac{1}{2}$ in.

Gear Wheel. The parts shown in Fig. 3 are separated for clarity but, in action, the top flanged would cover the Balls which, in turn, would ride on the flat surface of the large Gear Wheel. The hand wheel driving the slewing Pinion would be replaced by a mechanism inside the cab of the crane, of course. A Bearing of this nature must have an Axle Rod passing up through

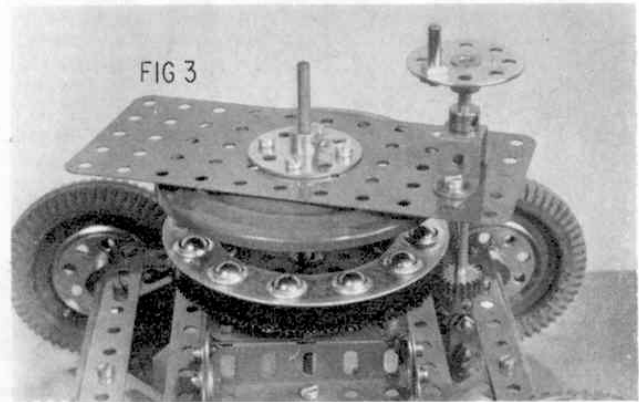


FIG 3
An "exploded" view of a ball bearing for a model mobile crane. All three parts of the bearing are in contact when operating.

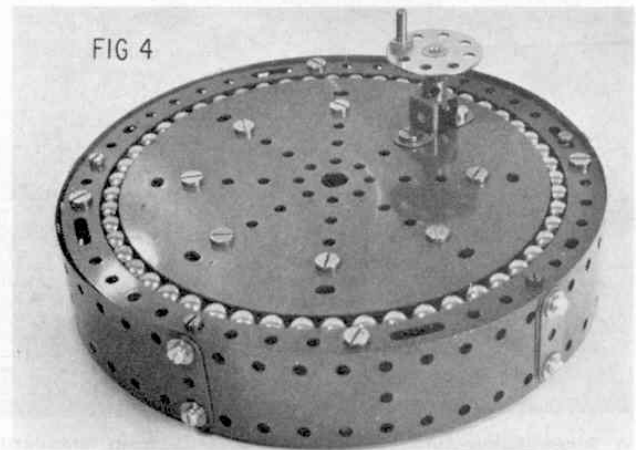


FIG 4

A built-up flush-level multi-ball turntable. Pivot Bolt construction ensures essential concentricity.

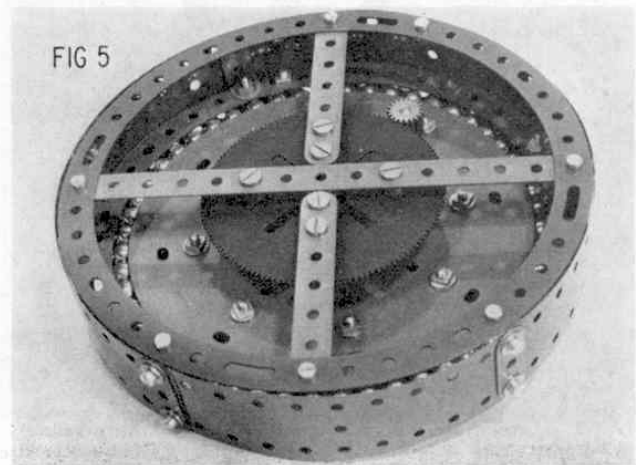
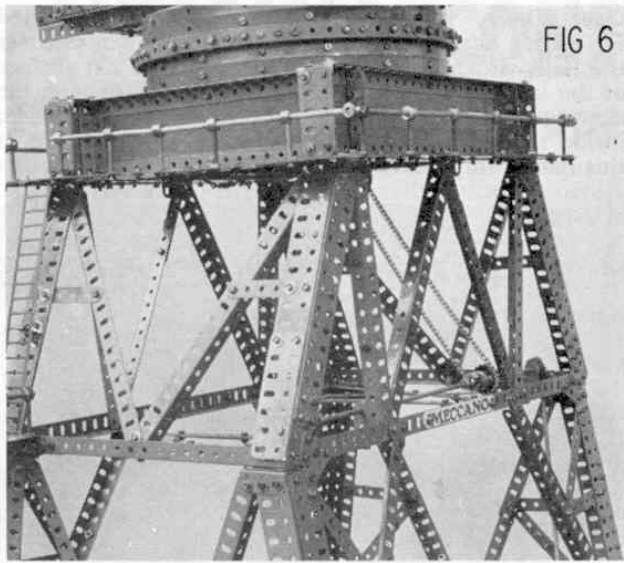
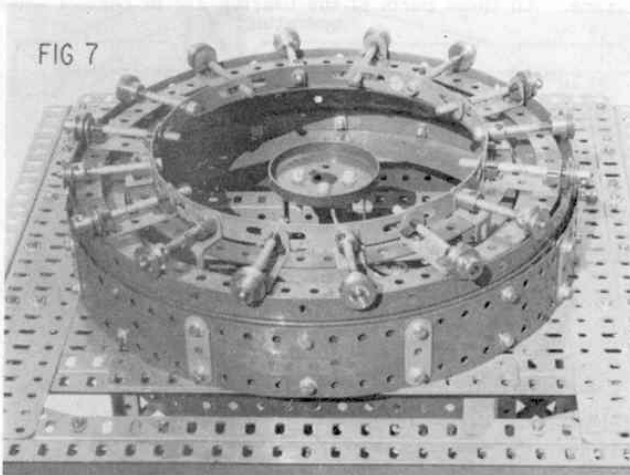


FIG 5

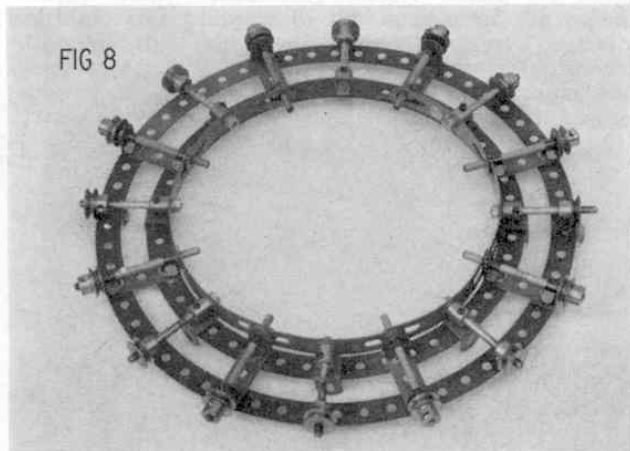
An underside view of the mechanism shown in Fig. 4 illustrating the location of the $3\frac{1}{2}$ in. slewing gear.



A good example of a tower design to support a heavy crane turntable.



A large heavy-duty roller bearing built from standard Meccano Parts. The centre Wheel Flange is used as a current collector.



A lightweight "hollow" centre spider with alternate "floating" rollers. All rollers are free-running and are located entirely by the centralising action of the large Flanged Rings.

its centre to centralise the whole bearing and a suitable locking device, such as Collars or Bush Wheels, must be added to prevent the bearing from lifting apart under load conditions. This can be quite a serious disadvantage to the model builder who takes his turntable design seriously and he would aim to fit 'hook rollers' to his model, as is frequently done in full-size prototypes. Hook rollers are often fitted to excavators and similar machines which have a natural tendency to tilt when they are removing stubborn soils and rocks. The purpose of such rollers is to hook underneath the bottom of the turntable ring and to 'pick up' the turntable bodily if the machine starts to tilt.

Many average-size turntables for models have been published in Meccano Magazine from time to time, utilising the $5\frac{1}{2}$ in. Circular parts as roller rings or flanges but few have employed hook rollers, if any, and many have been out of proportion due to the use of Flanged Wheels which have given too wide a separation of upper and lower portions of the turntable. An ingenious method of overcoming these disadvantages is illustrated in Fig. 4 and Fig. 5 which show a ball bearing, the essential features of which do not exceed an overall depth of $\frac{3}{8}$ in. Construction requires patience and care and the insertion of 52 Meccano Steel Balls into a Ball Race made from $7\frac{1}{2}$ in. Circular Strips and 6 in. Circular Plates. The two Plates are locked together with Pivot Bolts, as shown, to ensure accurate register and each one carries a Collar for critical spacing between the two Plates. Collars *must* be chosen with care to be of exactly the same length. In spacing the Circular Strips, Pivot Bolts are again used for accurate register and Collars are used for spacing, but, this time, one brass electrical Thin Washer is added for critical spacing and the Balls are inserted while the Plates and Strips are held in a vertical plane. The last half dozen balls are inserted by slacking off one Pivot Bolt in the Circular Strips at the top of the assembly and pushing the Balls between the Strips before re-locking the Bolt. A very light greasing (not oiling) should then give a free running, but not sloppy, ball bearing. This very neat design conforms to a large extent to modern practice in the construction of excavators which actually swivel on large, sealed ball bearing units and no hook rollers are necessary of course.

Fig. 5 shows the construction of the complete turntable from below. A $3\frac{1}{2}$ in. Gear ring is centrally fixed, again using Pivot Bolts and Collars for spacing, to Perforated Strips attached to the bottom Circular Strip. This, in turn, is secured to the wall of the drum by Angle Brackets and care must be taken at this stage to maintain the $3\frac{1}{2}$ in. Gear Wheel quite centrally. The Gear Wheel could be replaced with a $3\frac{1}{2}$ in. Gear Ring suitably attached, when the bearing would then have a free access hole right up through its centre for cable or additional drive shafts to upper mechanisms.

As the Meccano turntables get larger, substantial bases are required to support them and Fig. 6 shows an excellent type of structure for this purpose in which heavy-section built-up girders are put to good use in providing a strong platform for the turntable.

A typical basic construction for the larger roller bearing is shown in Fig. 7. Three $9\frac{1}{2}$ in. Flanged Rings are used, two of them forming supports for the drum wall, made of three layers of $5\frac{1}{2}$ in. \times $1\frac{1}{2}$ in. Flexible Plates. These are stood off from the Rings by double washers and overlaid with $1\frac{1}{2}$ in. Perforated Strips. The Wheel flange mounted in the centre of the bearing is stood off by electrical Insulating Bushes to provide an electrical slip ring feed to the revolving superstructure. Fig. 8 shows how simply the 'spider' is made. The outer ring is made of eight $4\frac{1}{2}$ in. Stepped

FIG 9

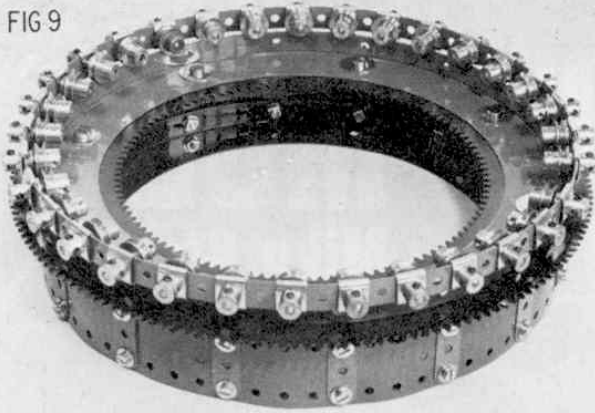
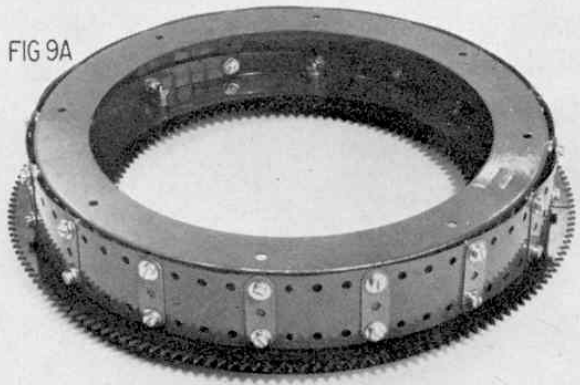


FIG 9A



Above: A roller race carrying 32 $\frac{1}{2}$ in. "rollers" and a complete ring of Large-Toothed Quadrants. No Nuts and Bolts are required for the roller ring. Below: An underside view of the roller race appearing in Fig. 9 showing how the ring of Quadrants is sandwiched between the top pair of Flanged Rings and accurately located by Pivot Bolts spaced with Washers.

Curved Strips bolted at their joins to $1\frac{1}{2}$ in. \times $\frac{1}{2}$ in. Double Angle Strips. These in turn are bolted to the inner ring which is a $7\frac{1}{2}$ in. Circular Strip. Each Double Angle Strip carries a 2 in. Axle Rod held in place by Spring Clips to provide spindles for eight of the 16 'rollers'. Interwoven between each pair of fixed rollers is a 'floating' roller mounted in a Rod Socket attached to a Formed Slotted Strip held in Place by a $\frac{1}{2}$ in. Reversed Angle Bracket which simply clips over the Circular Strip, but allows the $1\frac{1}{2}$ in. Axle Rod to move up and down to allow for any unevenness in the rim of the Flanged Ring.

The choice of $\frac{1}{2}$ in. Fixed Pulleys has three advantages. First of all, they prevent unsightly spacing of the roller rings. The bosses (though completely free to revolve and not secured in any way) give lateral stability to the 'rollers' and prevent any wobble, and, finally, the whole roller bearing is once again completely self-centring with all the advantages of plenty of central space to bring up wiring or other mechanisms to the superstructure. This bearing is very simple to build and works beautifully with a heavy block-setting crane. The more weight on this turntable, the better are its self-centring properties. Slewing is carried out by the simple expedient of a 1 in. Pulley fitted with a Rubber Ring which bears against the lower roller ring from the outside and is driven from a mechanism in the superstructure.

Finally, Figs. 9, 9a, 10 and 10a show a further develop-

ment of the same roller bearing for the advanced constructor. Fig. 9 shows the 32 rollers employed and the way in which they are mounted. All of them are carried in Slide Pieces, Part No. 50 which does the dual job of holding the 1 in. Axle Rods forming spindles for the rollers and also of securing the lapped ends of the eight $5\frac{1}{2}$ in. Perforated Strips which form the external roller ring. Each pair of $5\frac{1}{2}$ in. Strips are lapped over three holes and locked simply by the jaws of the two Slide Pieces in that vicinity. The first and last $5\frac{1}{2}$ in. Strips are tucked back into their own 'tails', the two final Slide Pieces having been slipped on previously.

Fig. 9a shows how the new Large-Toothed Quadrants are sandwiched between the two top $9\frac{1}{2}$ in. Flanged Rings and located by Pivot Bolts spaced underneath with Collars. The upper 'deck' of the turntable is shown from below in Fig. 10a where it is seen to be perfectly symmetrical and is suitable for either of the last two turntables described. Fig. 10 shows the completed heavy-duty turntable fitted with an outrigger girder frame which carries the new 167c Pinion to mesh with the complete circle of Large Toothed Quadrants. Hook rollers may be mounted on this outrigger to engage below the toothed rack. With the Power Unit mounted as shown, set in the lowest ratio, one further stage of reduction via Bevel Gears, Part Nos. 30a and 30c, a nice scale speed of rotation is achieved with 6 volts which gives adequate power for a heavy crane. The Slide Piece method of construction is quite suitable for a lesser number of rollers or for internal mounting.

FIG 10

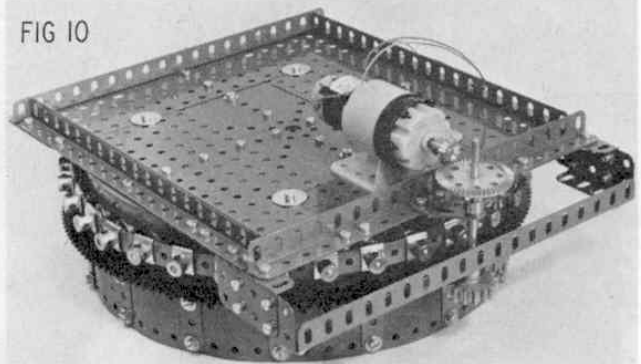
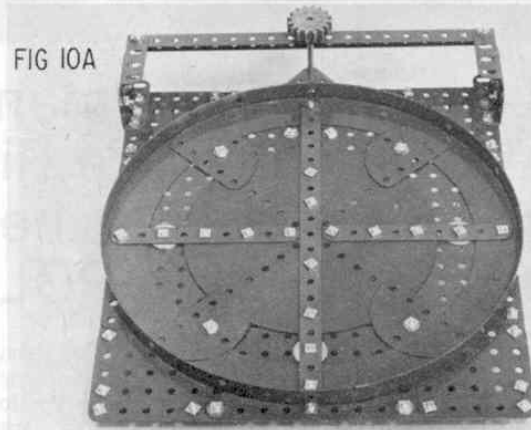


FIG 10A



Above: A heavy-duty crane turntable for the advanced modeller employing the latest Meccano components. Powerful slewing at scale speed is achieved with only six volts fed to the power unit. Below: The upper "deck" of the turntable suitable for either of the large turntables described in the text.