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Enlarged, and Specially Arranged, With Tes The present volume is, in a large measure, the outcome of the gratifying reception with which the smaller work, "Know your Own Ship," published in the Nautical Series, met on its first and subsequent editions. The success of that book emboldened its Author to embark, at the suggestion of the publishers, upon the preparation of a larger and more important undertaking, the result of which is now presented to the reader in the hope that it will be found, not less than the former work, to merit the approval of that section of the shipbuilding world for whose needs it has been specially devised. A sketch of the plan of the book will be found at the end of this preface; it is therefore unnecessary here to do more than briefly outline the circumstances under which it has been written. The work has taken four years to complete, the Author having been unable to devote more than his leisure hours to its composition. A careful study of some years' duration, carried out in that centre of the steel trade, the Cleveland district, has afforded the necessary basis for the first two chapters, while the subsequent chapters are the result of the Author's daily experience in the profession of ship construction and maintenance. The book has been copiously illustrated, and no expense has been spared in the preparation and execution of diagrams intended to amplify and elucidate the text. These have been placed in close juxtaposition to those portions of the work to which they refer, the Author conceiving that they will thus prove more readily available for purposes of reference than if they had been published as a separate volume, as is sometimes done in works of this class. The whole subject has been treated from

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