

AMENDED
M.V. TANKER N°32
STERNFRAME & RUDDER
SCALES $\frac{1}{2}$ " & $1\frac{1}{2}$ " = 1 FOOT.

SPEED OF VESSEL = 11 KNOTS

AREA OF RUDDER = 153.8 SQ FEET

CENTRE OF GRAVITY = 3.718 FEET

A & D = 572

DIA. OF RUDDER STOCK + 10% = $11\frac{1}{8}$ " DIA.

RUDDER TO BE OF BEST FORGED STEEL.
STERNFRAME TO BE OF BEST FORGED IRON.
ALL TO LLOYDS LATEST TESTS & REQUIREMENTS.

THE STERNFRAME TO BE IN TWO PARTS SCARPHED WHERE SHOWN TO BE OF BEST FORGED IRON & WITH SOLD GUDGEON BUSHED WITH LEADUM VITAE TO TAKE THE RUDDER PINTLES. LEADUM VITAE BUSHES TO BE SUPPLIED & FITTED BY STERNFRAME MAKER.
THE STERNFRAME TO BE DRILLED FOR $\frac{1}{8}$ " RIVETS TO TAKE SHELL PLATING. THE RUDDER POST TO BE DRILLED FOR $\frac{1}{8}$ " DIA. TAP RIVETS TO TAKE RUDDER PIN PLATES. ALL MACHINING & DRILLING TO BE DONE BY MAKERS.
STERNFRAME MAKERS TO SUPPLY SHIPBUILDERS AS SOON AS EVER POSSIBLE WITH SKETCH GIVING SPACING, DEPTH & DIA. OF GUDGEONS TAKEN FROM ACTUAL STERN FRAME FOR USE OF RUDDER MAKERS.

RUDDER STOCK & MAIN PIECE OF BEST FORGED STEEL DRAWN FROM SOLD INGOT. RUDDER ARMS OF BEST FORGED STEEL SHAPED ON & KEPT TO MAIN PIECE ARMS FITTED ON ALTERNATE SIDES OF RUDDER PLATE. ARMS TO SUIT GUDGEONS ON STERNFRAME. RIVET HOLES IN ARMS TO BE COUNTERSUNK ON OUTER SIDE OF ARMS. ALL MACHINING & DRILLING TO BE DONE BY MAKERS.

STEEL PINTLES TO BE PORTABLE, SHEATHED WITH BRASS, LET IN TO RUDDER & ARMS WITH A TAPER & SECURED ON TOP WITH HEX NUTS & SPLIT PINS.

COUPLING TO BE SO ARRANGED THAT LOWER PART OF RUDDER MAY BE UNSHIPED WITHOUT REMOVING UPPER STOCK.

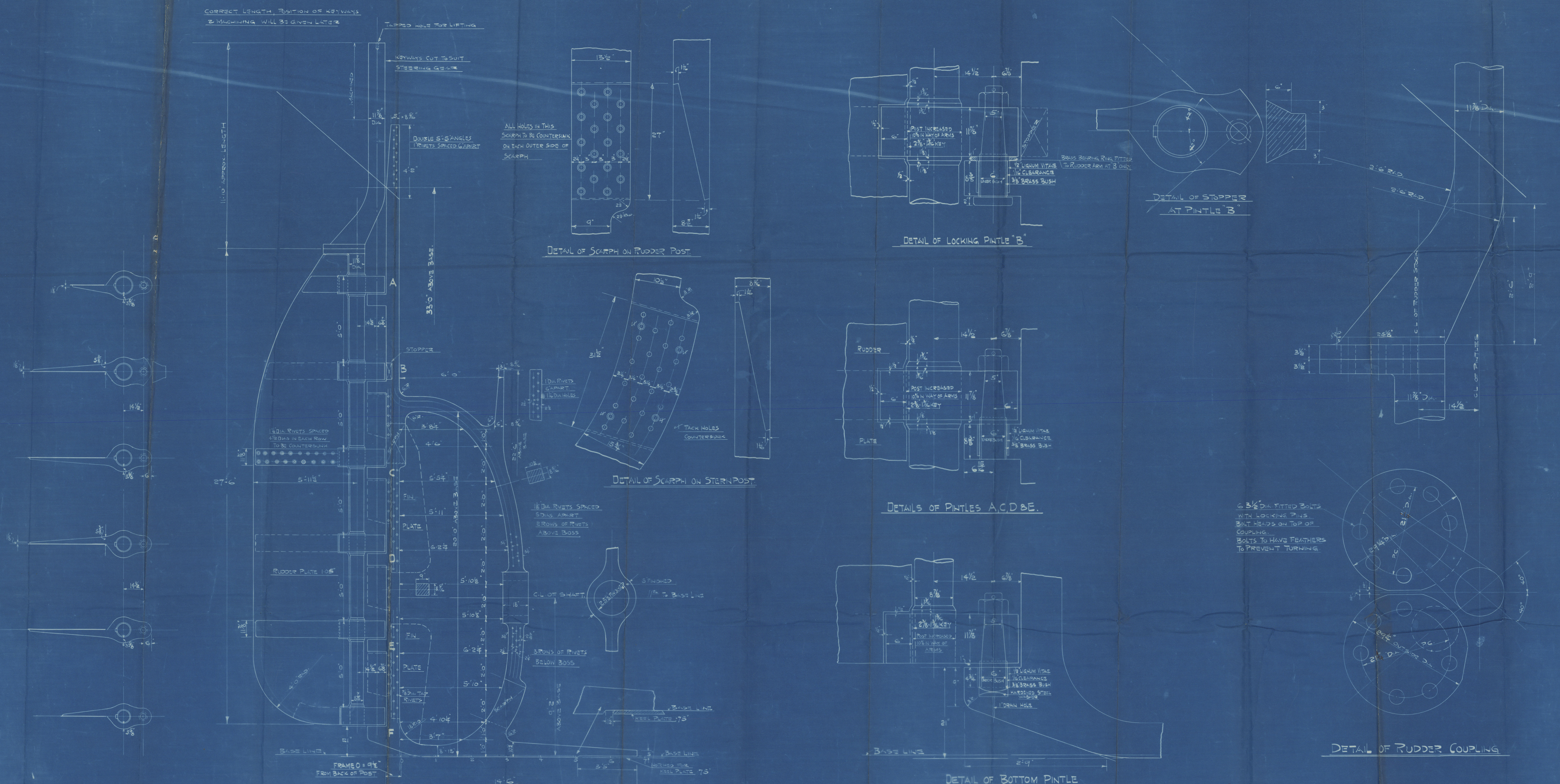
CARE TO BE TAKEN THAT CENTRE LINE OF RUDDER STOCK & PINTLES ARE IN A PERFECTLY STRAIGHT LINE BOTH FORE & AFT & THWARTSHIPS & THE SURFACES OF THE RUDDER ARMS ARE IN A TRUE PLANE TO RECEIVE THE RUDDER PLATE.

RUDDER MAKERS TO SUPPLY SHIPBUILDERS AS SOON AS EVER POSSIBLE WITH POST GAUGE GIVING FINISHED DIA. OF RUDDER STOCK & IN WAY OF TILLER.

NO SHARP EDGES OF FORGING WHERE EXPOSED. CORNERS TO BE ROUNDED. SCARPHS TO BE ACCURATELY FITTED & DRILLED IN POSITION.

A SEPARATE PLAN TO BE SENT LATER SHOWING EXACT POSITION OF RIVET HOLES TO SUIT SHELL LINDINGS ALSO POSITION OF TAP HOLES TO TAKE PIN PLATES ON RUDDER POST.

A SEPARATE PLAN WILL FORWARD GIVING FULL SIZED SECTIONS OF STERN POST SOLE.



APPROVED
LLOYDS REGISTER OF SHIPPING
H. J. D.
DATE 10-7-30

Blythswood S.B. Co. Ltd.

No. 32.

Revised plan of Sternframe and
Rudder.

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Karabagh
GLASGOW REPORT No. 51783



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Foundation

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