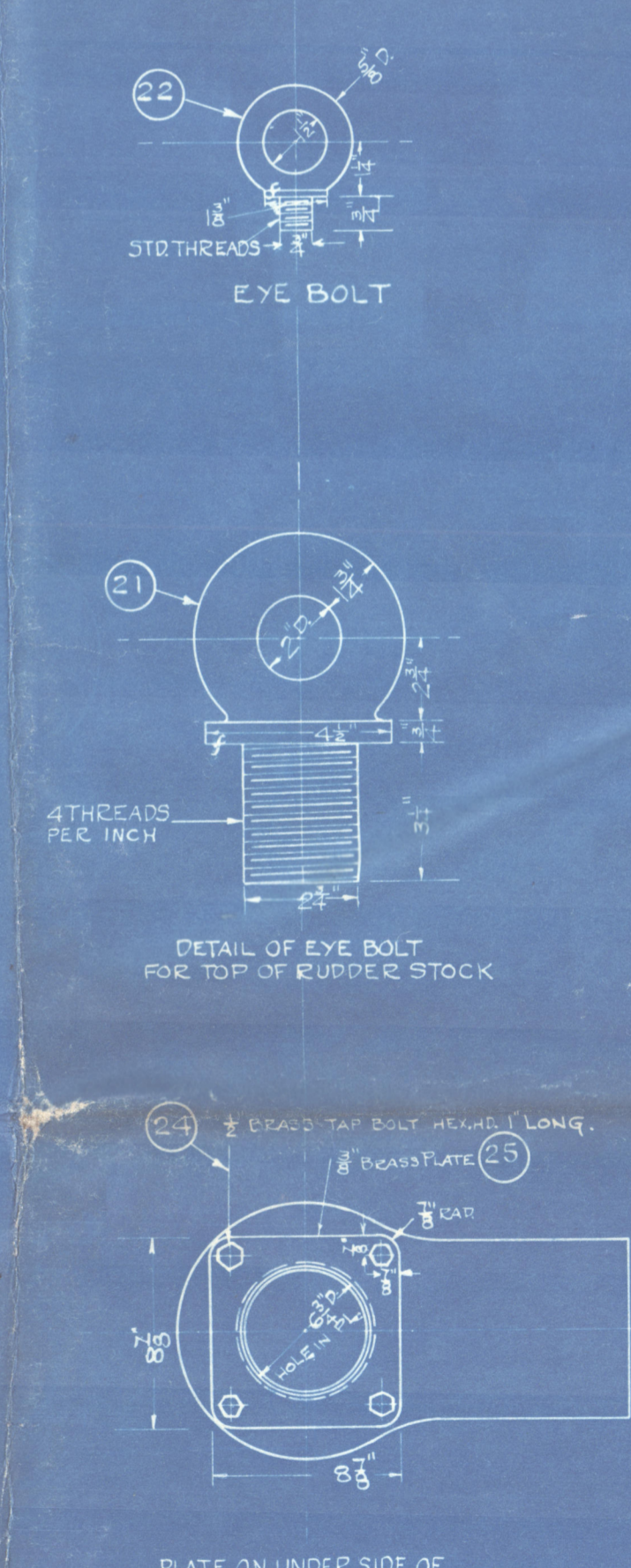
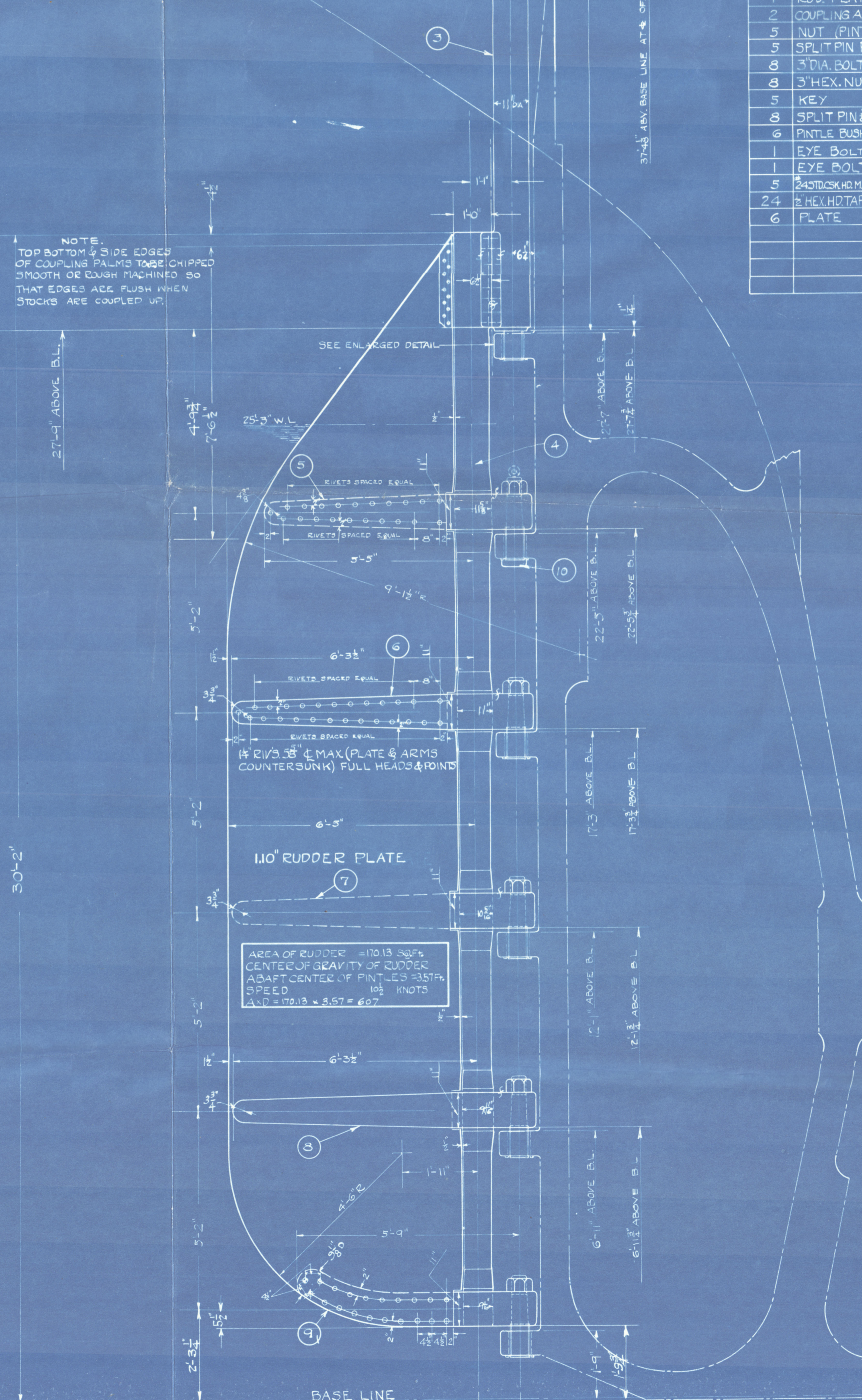
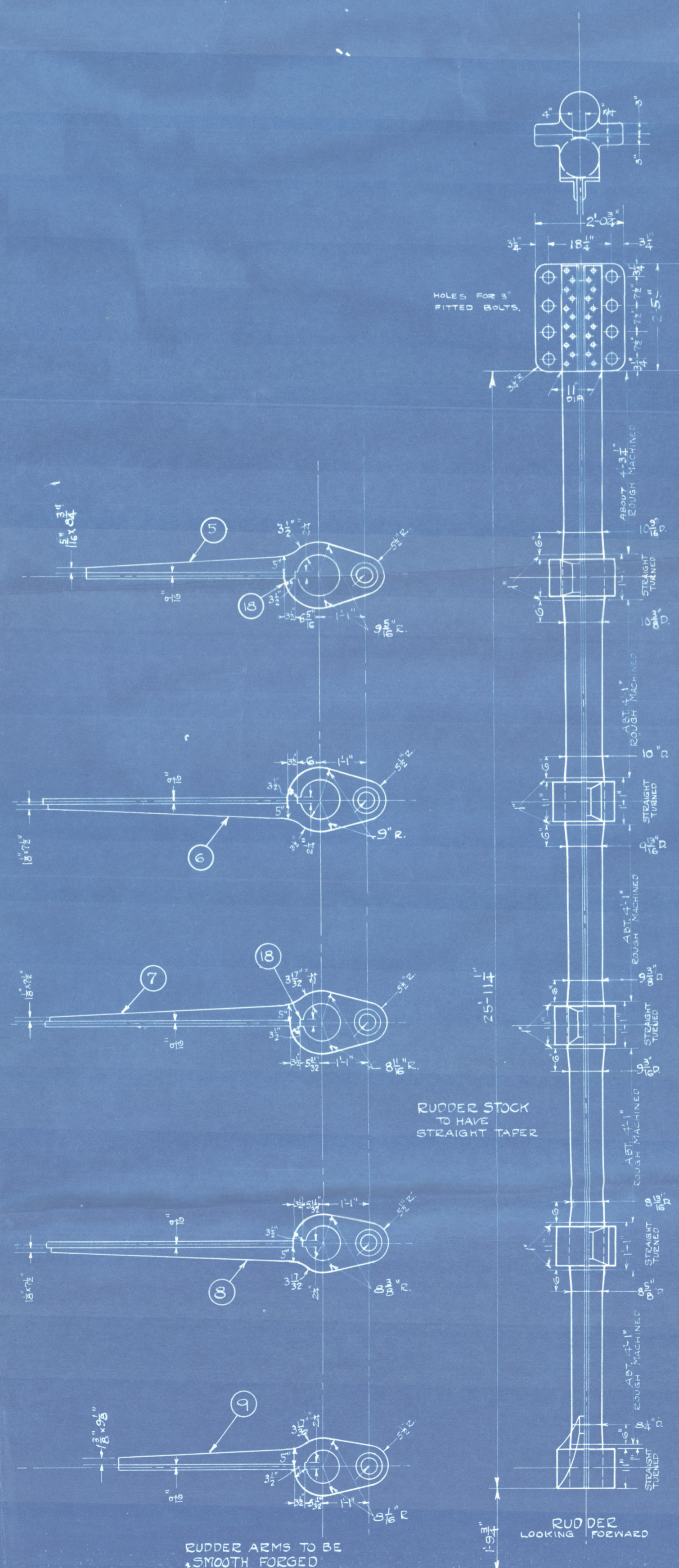
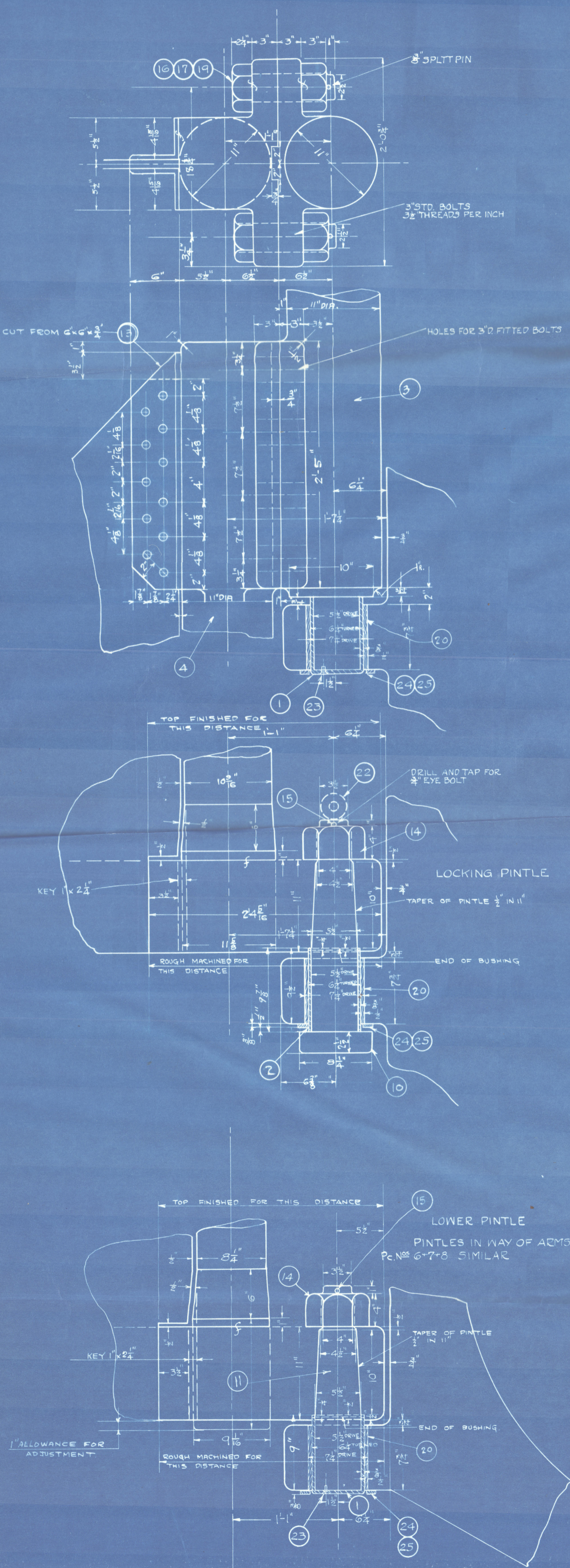


# DETAIL OF COUPLING



- ## GENERAL NOTES
1. ALL RUDDER ARMS TO BE SHEUNK AND KEYED TO RUDDER STOCK.
  2. QUALITY OF FORGINGS TO BE IN ACCORDANCE WITH LLOYDS REQUIREMENTS AND TO BE INSPECTED AND TESTED BY THEIR REPRESENTATIVE.
  3. PINTLE HOLES IN ARMS TO BE FINISHED BORED AFTER RUDDER IS ASSEMBLED SO AS TO INSURE PROPER ALIGNMENT.
  4. TOP OF ARMS IN FLAT TO BE FINISHED MACHINED; BOTTOM FLAT TO BE ROUGH MACHINED.
  5. STOCK FORGINGS TO BE IN ACCORDANCE WITH PLAN 381-89-2.
  6. DISTANCE BETWEEN ARMS IS APPROXIMATE, ARMS TO BE PLACED IN ACCORDANCE WITH DIMENSIONS TAKEN FROM STERN FRAME.

## BILL OF MATERIAL

AMOUNTS GIVEN FOR ONE SHIP

NO.	NAME	QTY.	CHAR.	DETAIL	MATERIAL	W.T.	REMARKS	GROUP	SEC.
1	PINTLE BUSHING	1			COMP. H.	M-17			
2	PINTLE BUSHING	2			COMP. H.	M-17			
3	RUDD. STK. (UPPER)	1			W. STEEL				
4	RUDD. STK. (LOWER)	1			W. STEEL				
5	RUDD. ARM	2			W. STEEL				
6	RUDD. ARM	2			W. STEEL				
7	RUDD. ARM	2			W. STEEL				
8	RUDD. ARM	2			W. STEEL				
9	RUDD. ARM	2			W. STEEL				
10	PINTLE (LOCK)	1			W. STEEL				
11	RUDD. PLATE	1			W. STEEL				
12	COUPLING ANGLE	1			STEEL		110" PLATE		
13	NUT (PINTLE)	1			W. STEEL		4" TO SUIT PIECE 10411		
14	SPLIT PIN PTL.	1			BRASS		3/8" DIA. X 4 1/2" UNDER HD		
15	3" DIA. BOLT HEX.	1			W. STEEL		10" UNDER HD		
16	3" HEX. NUT	1			W. STEEL		FOR PC 106		
17	KEY	1			W. STEEL		1/2" X 1 1/2"		
18	SPLIT PIN 3/8" DIA.	1			BRASS		3/8" DIA. X 5 1/2" UNDER HD		
19	PINTLE BUSHING	2			W. STEEL				
20	EYE BOLT	1			W. STEEL		FOR LIFTING RUDDER POST		
21	EYE BOLT	1			W. STEEL		FOR LIFTING RUDDER POST		
22	BRASS WASHWATER	1			BRASS		10" X 2 1/2" LONG OVER ALL		
23	BRASS WASHWATER	1			BRASS		LENGTH 1" UNDER HD		
24	PLATE	1			BRASS		FOR HOLDING BUSHING		

## 1-68-180

MATERIAL

CHARGE

ALL WORK SHOWN ON THIS DRAWING TO BE CHARGED TO 381-89-01.

DATE	LIBRARY	DATE	LIBRARY

PRINTS

MAY 5 1920 LLOYDS

DATE SUBMITTED DATE APPROVED

381-382-383-384

FOR CONTRACTS

MERCHANT SHIPBUILDING CORPORATION

CHESTER YARD CHESTER, PA.

RUDDER

SCALE 1/4" = 1 FT.

DATE

WLS. WLS.

DRAWN BY TRACED BY CHECKED BY

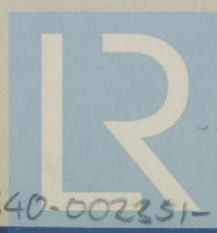
DR. NO. 381-89-1

MERCHANT SHIPBUILDING CORPORATION  
CHESTER YARD

MAY 20 2020

*Lloyd's*  
Lloyd's Register

002340-002351-0263



Foundation