

15 MAR 1945

No 736-8.

RUDDER PLAN.

DIMENSIONS:- 400'-0" BP x 55'-0" MLD x 30'-1" D. MLD.

TO PASS LLOYDS SURVEY AND TESTS CARRYING PETROLEUM IN BULK.
RUDDER FRAME OF CAST STEEL.
RUDDER AREA = 142.7 SQ. FT.
LLOYDS A & D = 273.
RUDDER ANGLES MAXIMUM 40°

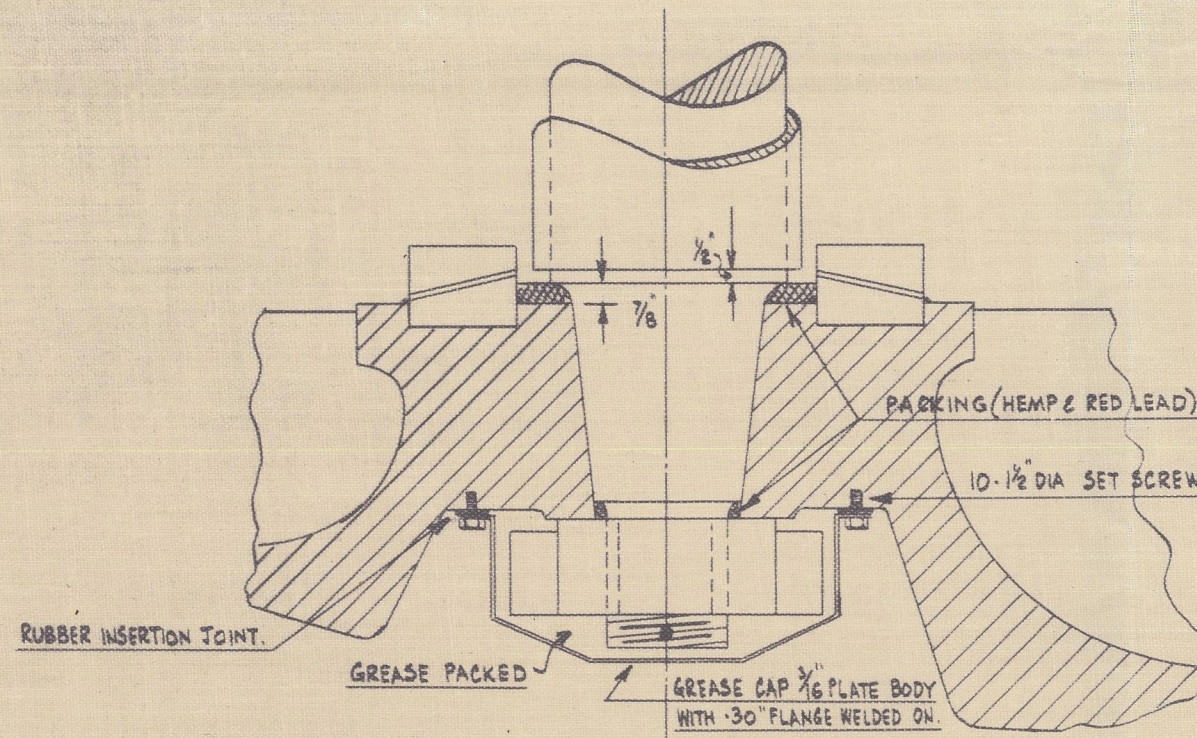
RUDDER STOCK OF FORGED STEEL.
RULE DIA. OF RUDDER STOCK = 8 1/2"
+ 10% FOR TANKERS = 9 1/2"
+ OWNERS EXTRA = 10"
DIA. OF RUDDER STOCK FITTED = 10"

DIMENSIONS ON THIS PLAN SHOULD BE CAREFULLY WORKED TO AS ANY EXCESS OVER ESTIMATED HEIGHT WILL NOT BE PAID FOR.
UPPER STOCK GUARDIONS & PINTLES TO BE IN A PERFECTLY VERTICAL LINE.
THREADS OF BOLTS TO BE WORTH STANDARD.
ALL RIVET HOLES TO BE DRILLED BY MAKERS.
RUDDER NOT TO BE PAINTED BUT GIVEN A COAT OF OIL BEFORE LEAVING MAKERS.
WEIGHT TO BE PAINTED ON RUDDER BEFORE DISPATCH.

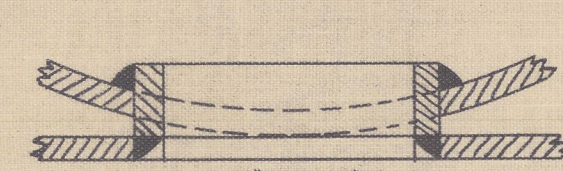
SEE NOTES AT END OF PLAN.

WATERTIGHT PACKING ARRANGEMENT
IN WAY OF MAIN PIECE CONE END.

SCALE: 1/4" = 1'

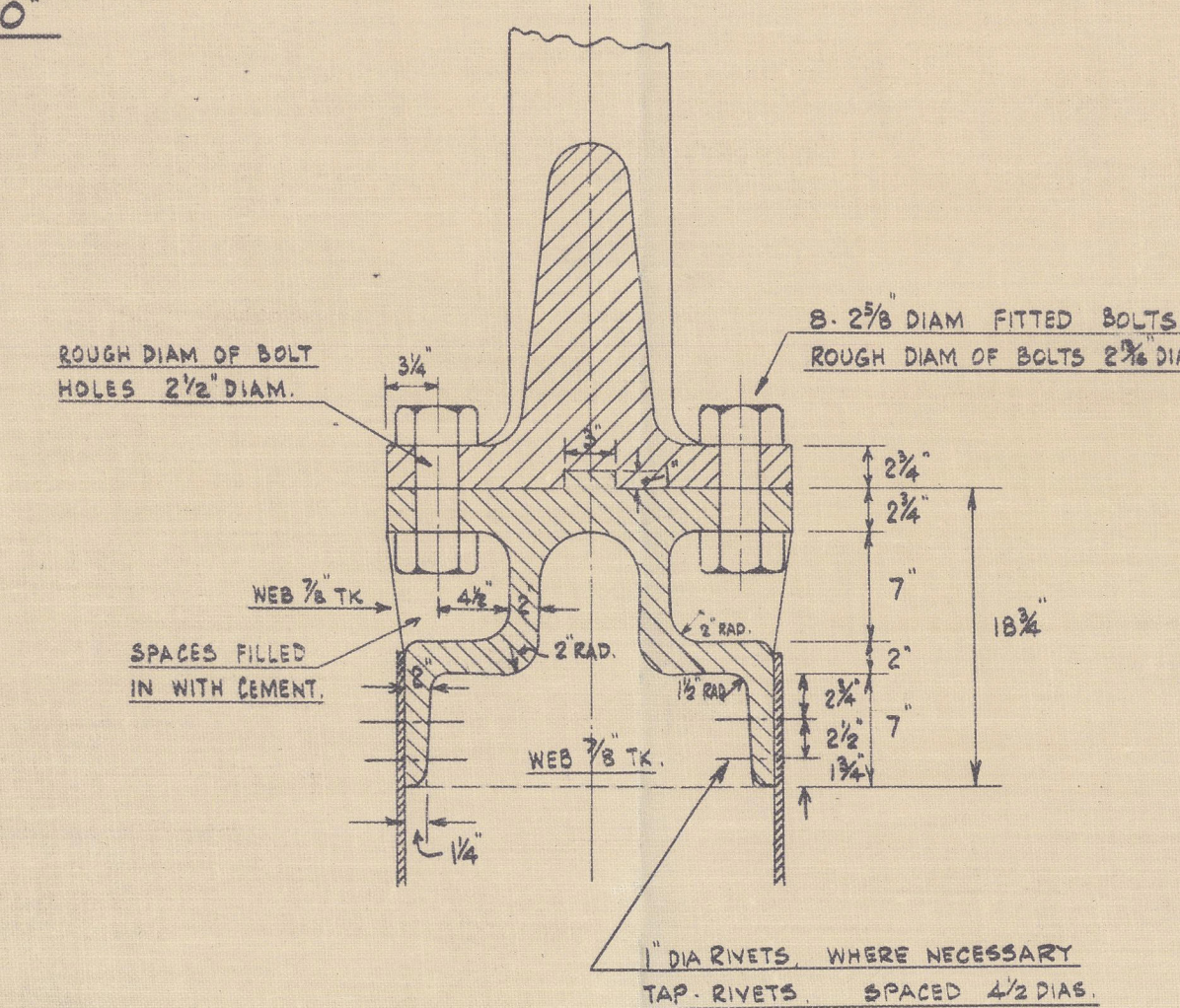


DETAIL OF HANDHOLE
SCALE: 1/4" = 1'

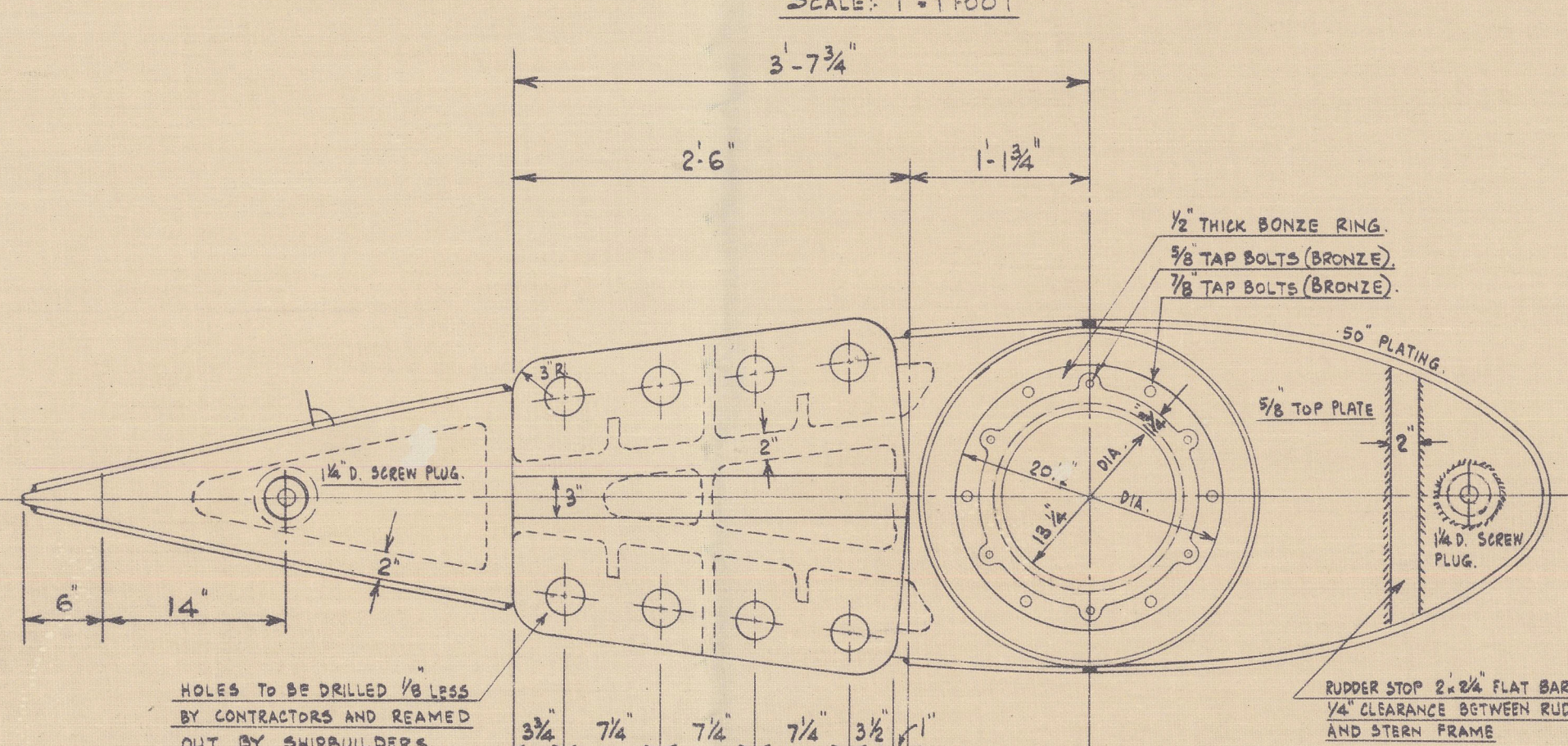


Speed not
Exceeding
12 knots

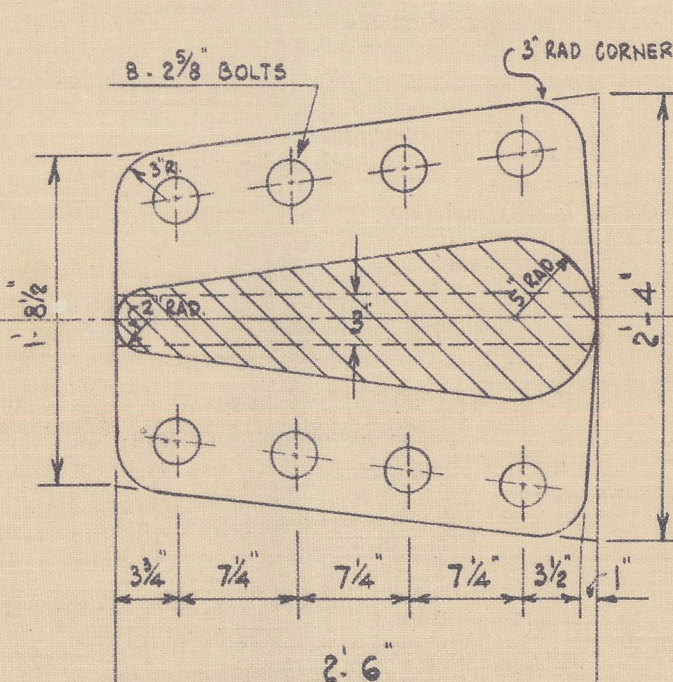
SECTION THRO' COUPLING.



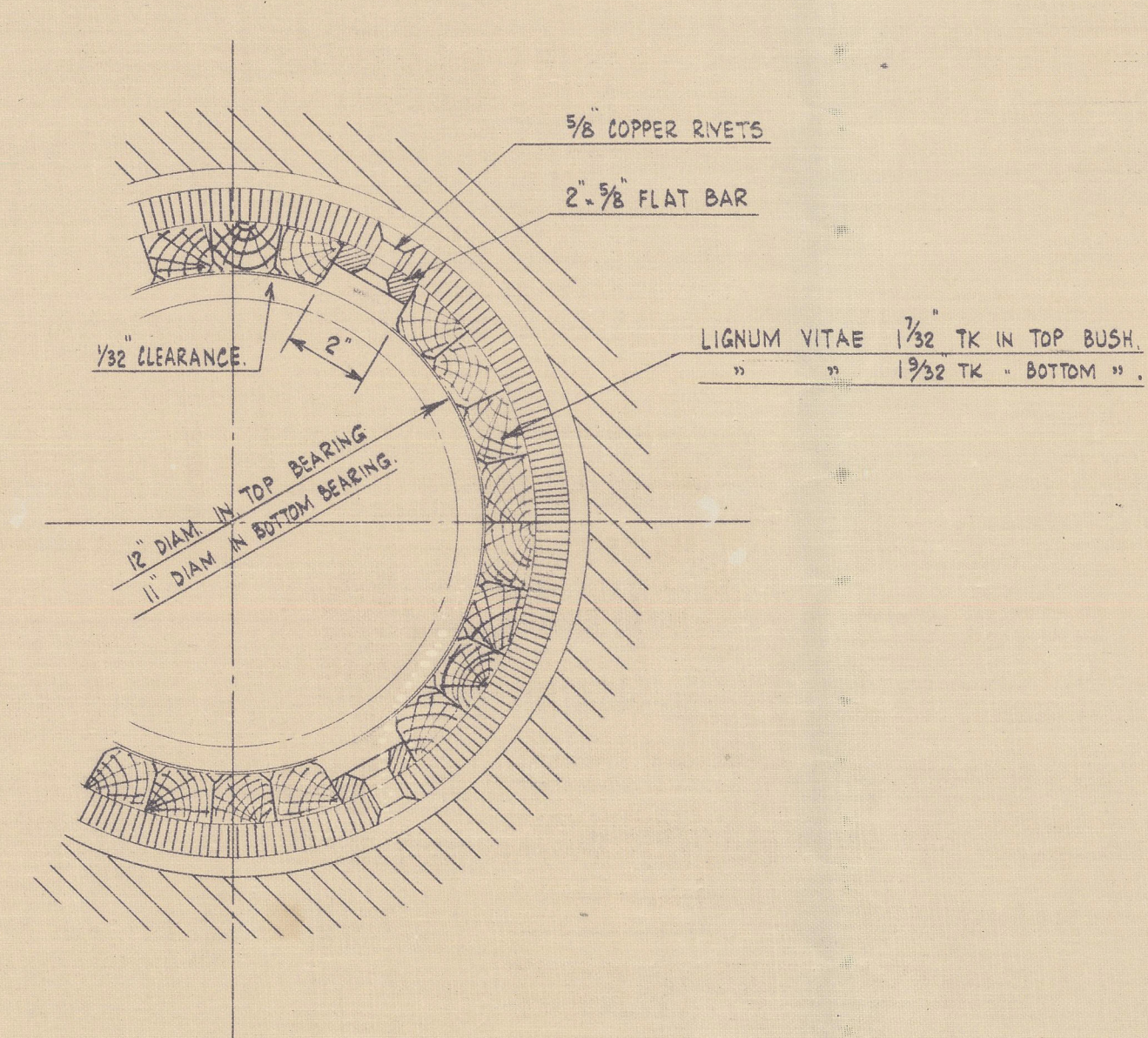
SECTION AT B-B
SCALE: 1" = 1'00"



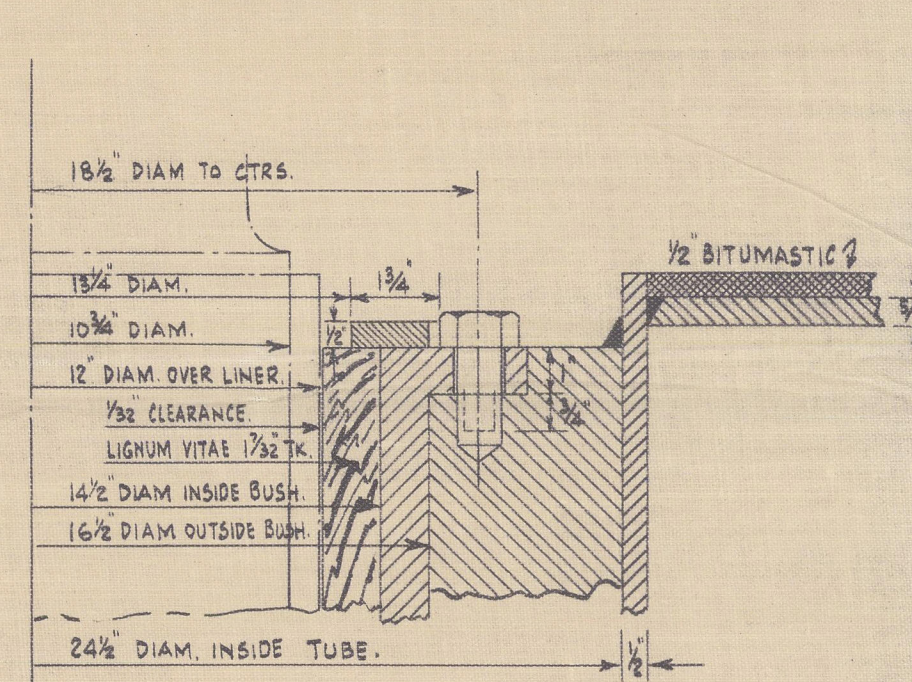
RUDDER STOCK COUPLING.



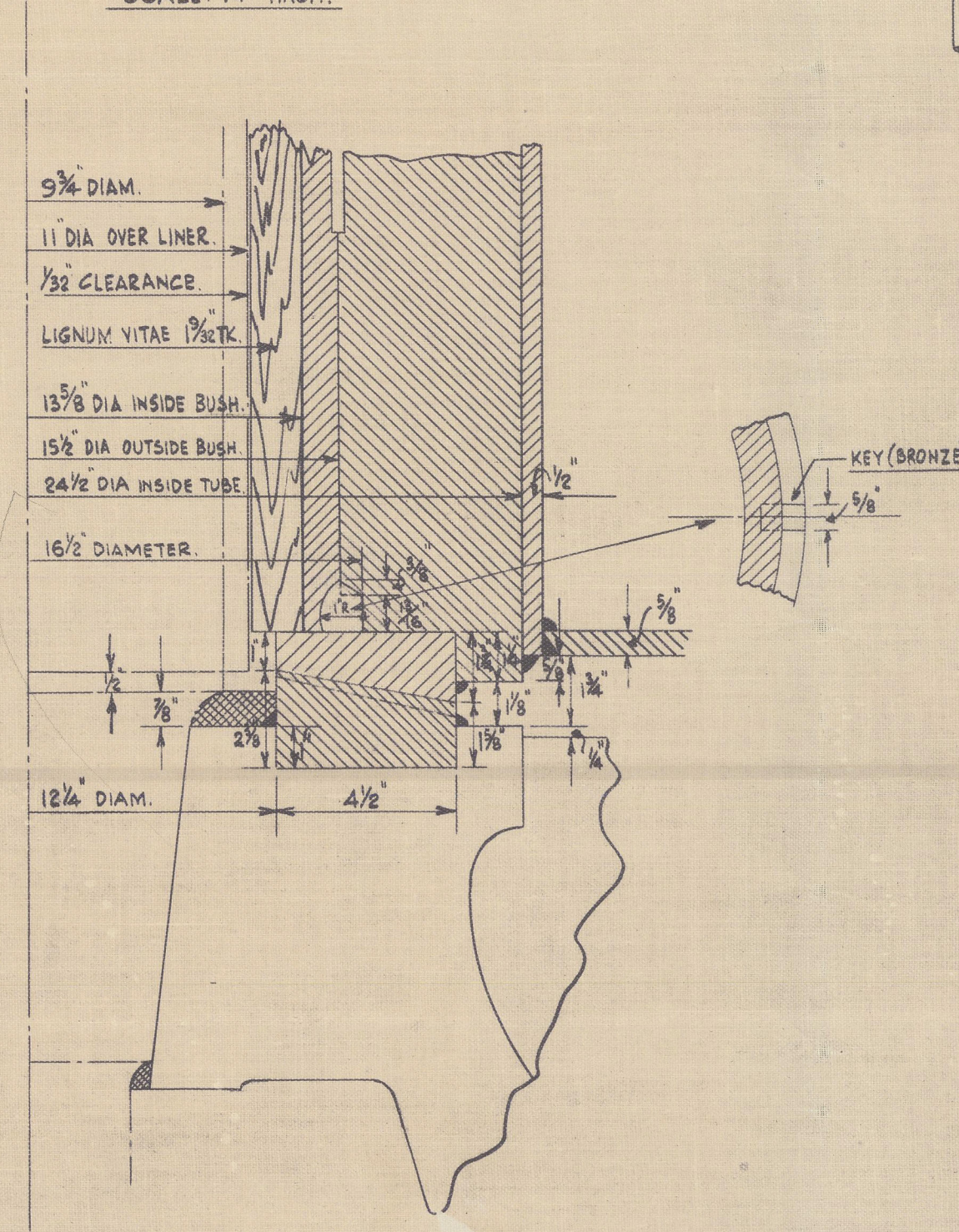
DETAIL OF LIGNUM VITAE BUSHES
SCALE: 1/4" = 1"



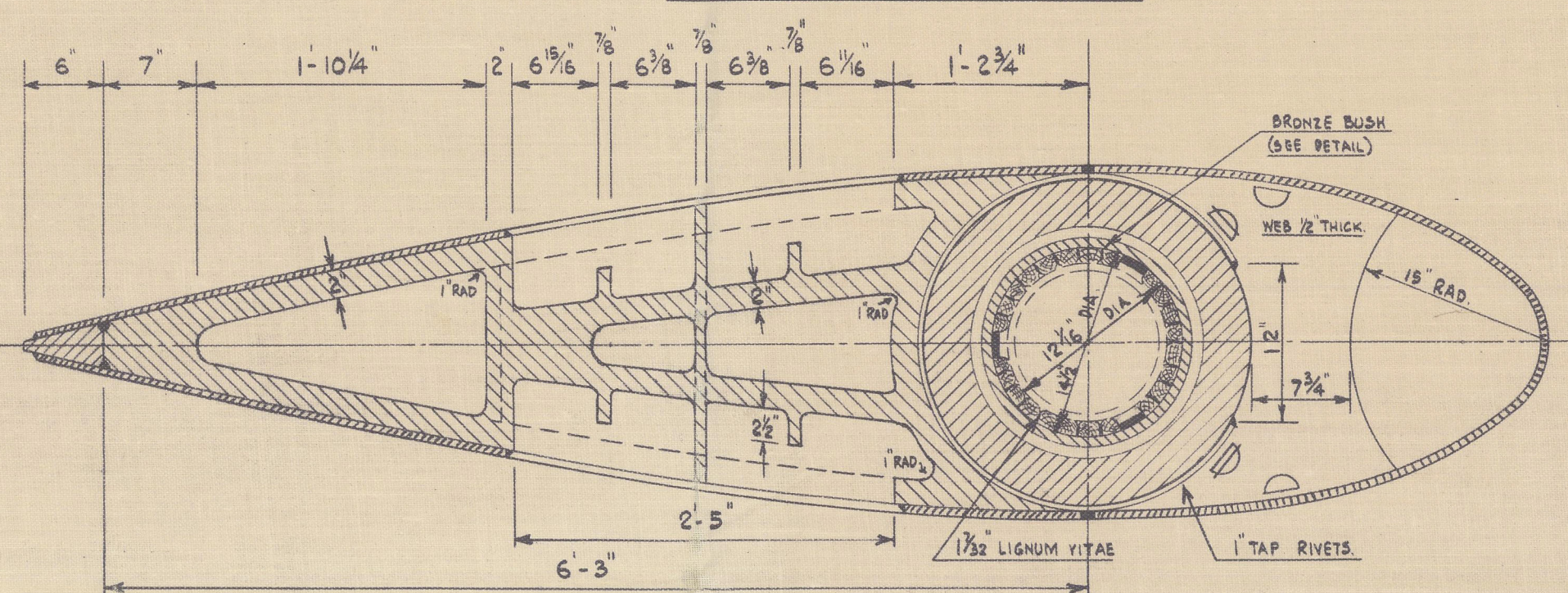
ARRANGEMENT OF BRONZE RING.
SCALE: 1/4" = 1"



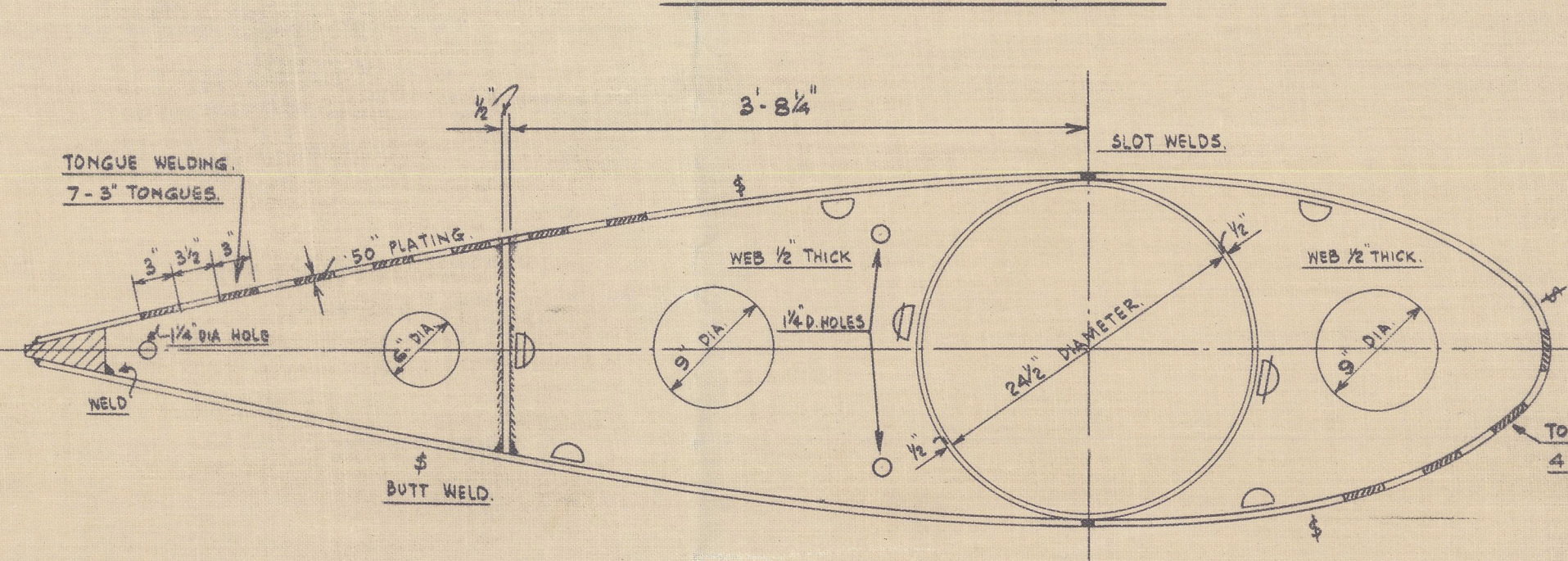
ARRANGEMENT OF BEARING RINGS.
SCALE: 1/4" = 1"



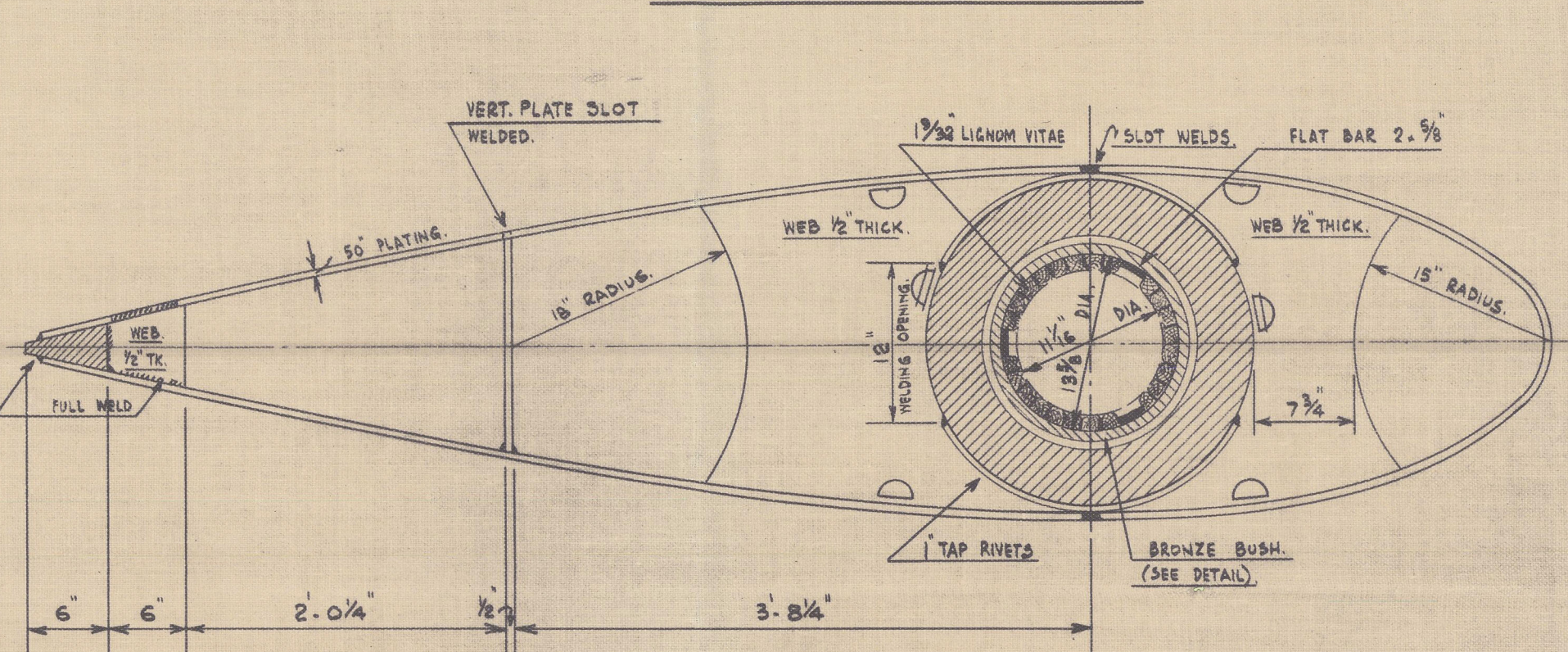
SECTION AT C-C.



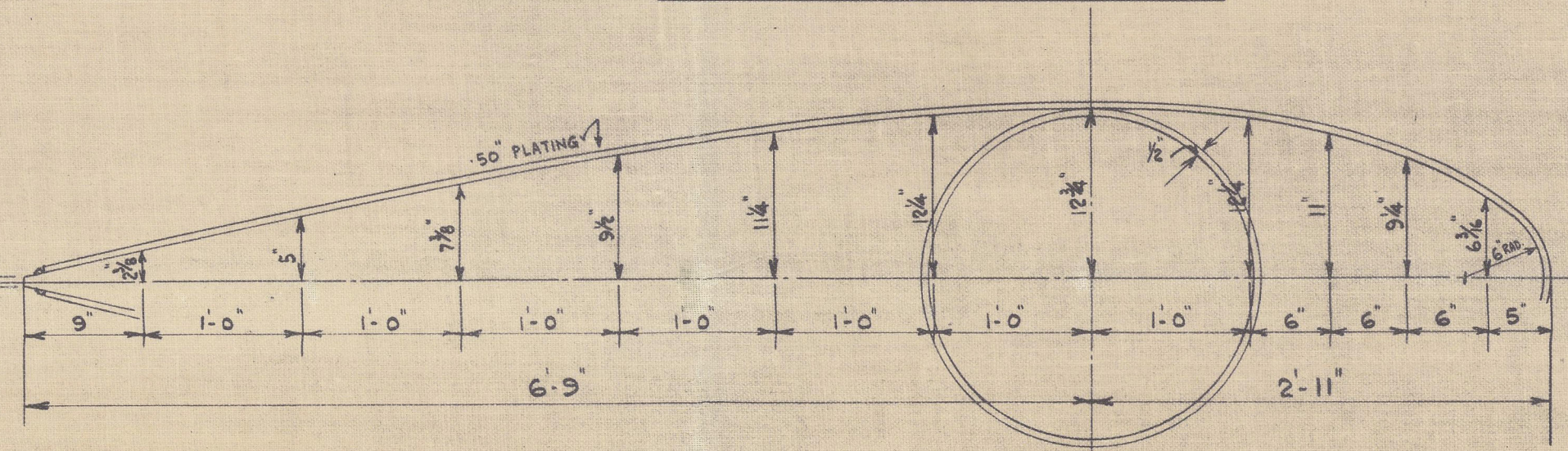
SECTION AT D-D.



SECTION AT E-E.



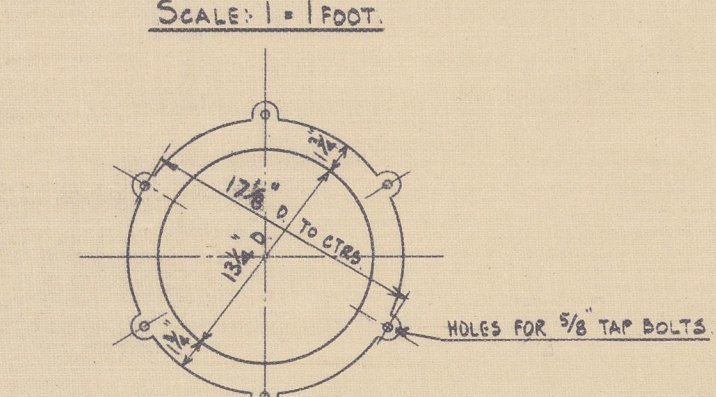
PROFILE OF RUDDER.



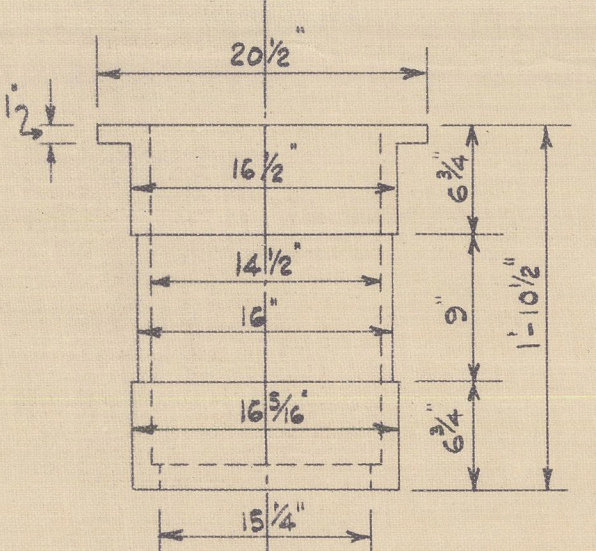
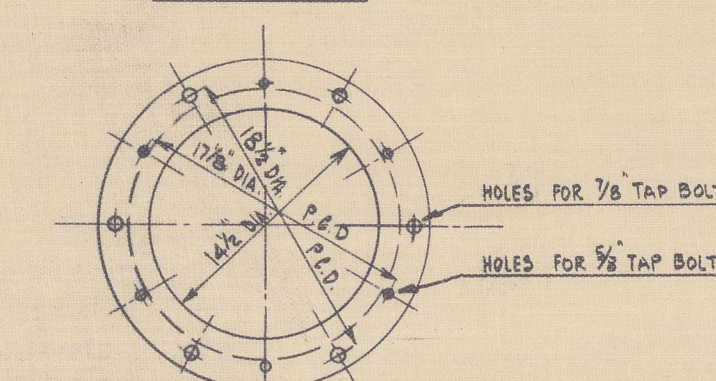
NOTES:-

1. THE FORWARD AND AFTER PART OF THE RUDDER IS TO BE FILLED WITH SOLUTION AND SUBJECTED TO A PRESSURE OF 14.185 PER SQ. INCH, IN WHICH CONDITION THE SAME WILL HAVE TO BE ACCEPTED BY LLOYD AFTER THAT THE SOLUTION WILL HAVE TO BE REMOVED AND THE SCREW PLUGS INSERTED.
2. INSIDE PIPE IN THE RUDDER IS TO BE COATED WITH SOLUTION.
3. THE ELECTRIC WELDING SHOULD BE CARRIED OUT TO THE SATISFACTION OF THE SOCIETY'S SURVEYORS AND THE REGULATIONS FOR THE APPLICATION OF ELECTRIC ARC WELDING TO SHIP CONSTRUCTION SHOULD BE COMPLIED WITH.
4. CARE SHOULD BE TAKEN THAT THE RUDDER STOCK IS FLUSH WITH THE RUDDER BEARINGS (OR THE CYLINDRICAL RUDDER POST).
5. FOR STERN FRAME SEE SEPARATE PLAN.

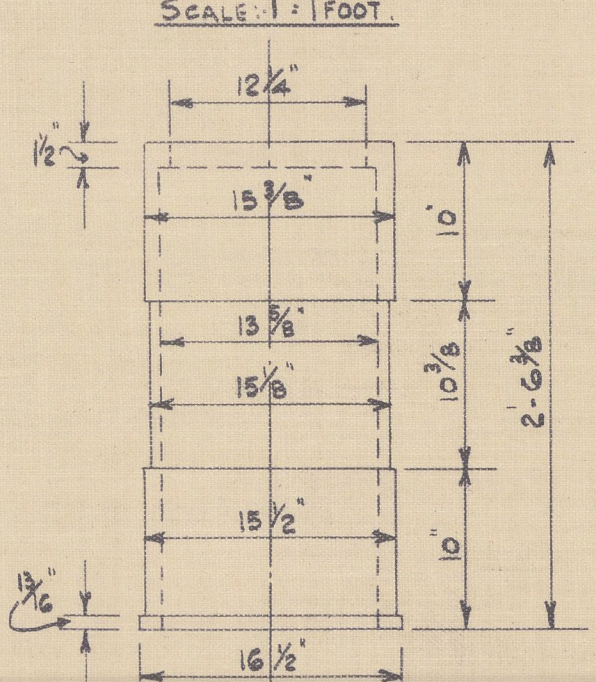
1/2" THICK BRONZE RING.
SCALE: 1" = 1'00"



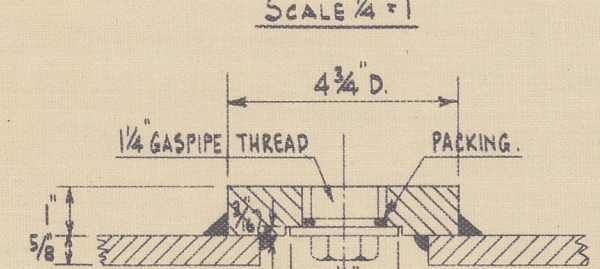
UPPER BRONZE BUSH.
SCALE: 1" = 1'00"



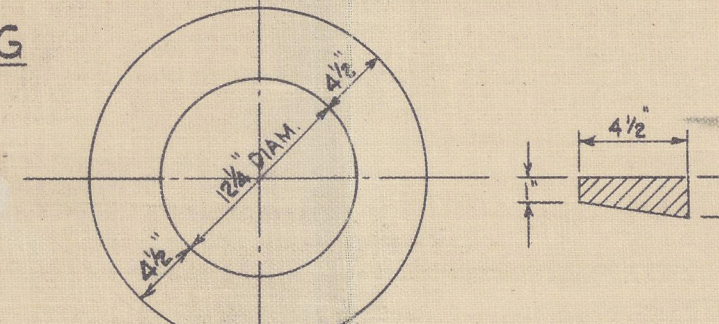
LOWER BRONZE BUSH.
SCALE: 1" = 1'00"



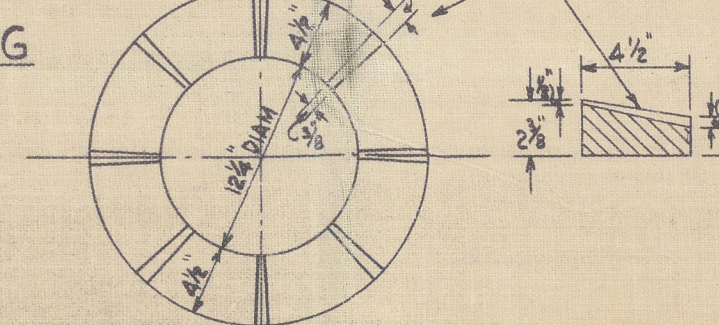
DETAIL OF SCREW PLUG.
SCALE: 1/4" = 1"



UPPER BEARING RING.



LOWER BEARING RING.



ITEM	MATERIAL
1 RUDDER BODY	MILD STEEL
1 COUPLING PIECE	CAST STEEL
1 UPPER BEARING	"
1 LOWER BEARING	"
1 UPPER BRONZE BUSH	BRONZE METAL
1 LOWER BRONZE BUSH	"
2 KEY	"
3 FLAT BAR	"
3 FLAT BAR	"
1 BRONZE RING	"
6 7/8" TAP BOLT, LENGTH 1 1/2"	"
6 3/4" TAP BOLT, LENGTH 1 3/4"	"
4 SCREEN PLUG, 1/2" GASPIPE THREAD	"
24 9/16" DIA. RIVET	COPPER
2 LIGNUM VITAE BUSH	LIGNUM VITAE
1 UPPER BEARING RING	HARD STEEL
1 LOWER BEARING RING	SOFT STEEL

all
6-3-45



W^M DOXFORD & SONS LTD.


YARD NOS 736-8

RUDDER PLAN

SUNDERLAND RPT. NO. 34502

British Commerce.

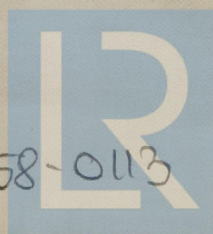
SUNDERLAND RPT. NO 34589

British Enterprise. 

5

SUNDERLAND RPT. NO. 35044

British Fortune



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