

N^o 711 M.S. DARA

FABRICATED RUDDER

SCALES: 1" = 1 FOOT & 1/2" = 1 FOOT. DETAILS AS MARKED.

PLAN N^o 9/D

MATERIAL MARKED: FR

LENGTH OF SHIP 375 Ft.
 AREA OF RUDDER (A) INCLUDING PAIRING PLATES & PINTLE BOSSES TO CL OF PINTLES 114.5 SQ. FT.
 CENTRE OF AREA OF RUDDER ABAFT CL OF PINTLES (D) 386 Ft.
 A x D 44.2
 RULE DIA OF STOCK 10 1/2"
 110% ON AREA TO OWNERS' REQ^d 11"
 SPEED 14 KNOTS

CASTINGS & FORGING TO PASS LLOYD'S & MINISTRY OF WAR TRANSPORT SURVEY & TESTS.

CASTINGS TO BE OF CAST STEEL & HEADSTOCK OF FORGED INGOT STEEL.
 HEADSTOCK TO BE TURNED TO GAUGE & KEYWAYS FOR TILLER ETC. TO BE ACCURATELY CUT TO DIMENSIONS WHICH WILL BE SUPPLIED LATER.
 CASTINGS TO BE DELIVERED TO SHIPBUILDER WITH 3" DIA SIGHTING HOLES BORED IN PINTLE BOSSES. AFTER ERECTION BY SHIPBUILDER, RUDDER TO BE SENT TO MAKERS OF CASTINGS FOR FINISHED BORING OF PINTLE BOSSES. CARE IS TO BE TAKEN THAT CR LINE OF PINTLES & CR LINE OF HEADSTOCK ARE IN A PERFECTLY STRAIGHT LINE BOTH FORE & AFT & ATHWARTSHIPS.
 PAIRING PLATES ARE NOT TO BE FITTED UNTIL BORING OF PINTLE BOSSES IS COMPLETE, TO GIVE FREE ACCESS FOR MACHINING.
 ALL DRILLING & MACHINING TO BE DONE BY MAKERS.
 CARE IS TO BE TAKEN THAT SCANTLINGS ARE ADHERED TO AS PAYMENT WILL ONLY BE MADE ON WEIGHT CALCULATED FROM SCANTLINGS SHOWN ON THIS PLAN. ANY ALTERATIONS MADE ARE TO BE NOTED TO S.C. & CO. LTD.
 WEIGHT OF CASTINGS & FORGING TO BE PAINTED ON EACH, BEFORE LEAVING MAKERS WORKS.
 SURFACES OF CASTINGS IN CONTACT WITH PLATES TO BE DRESSED FAIR TO PROVIDE A FLAT SURFACE FOR SLOT WELDS.

COUPLING OF INTERIOR OF RUDDER.

BEFORE CLOSING SIDE PLATE IS FITTED ALL INTERNAL SURFACES OF THE RUDDER SHOULD BE COATED TO WITHIN ABOUT 3" OF THE UPPER EDGE OF ALL WEBS. AFTER RUDDER HAS BEEN COMPLETED, COMPOSITION IS TO BE POURED IN AND THE RUDDER TURNED OVER AND TILTED UNTIL ALL EXPOSED SURFACES HAVE BEEN COVERED. REMAINDER OF COMPOSITION SHOULD THEN BE DRAINED OFF.

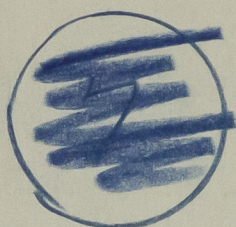
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BARCLAY, CURLE & Co.

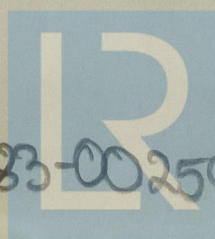
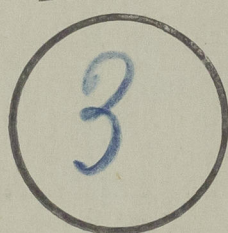
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FABRICATED RUDDER

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