

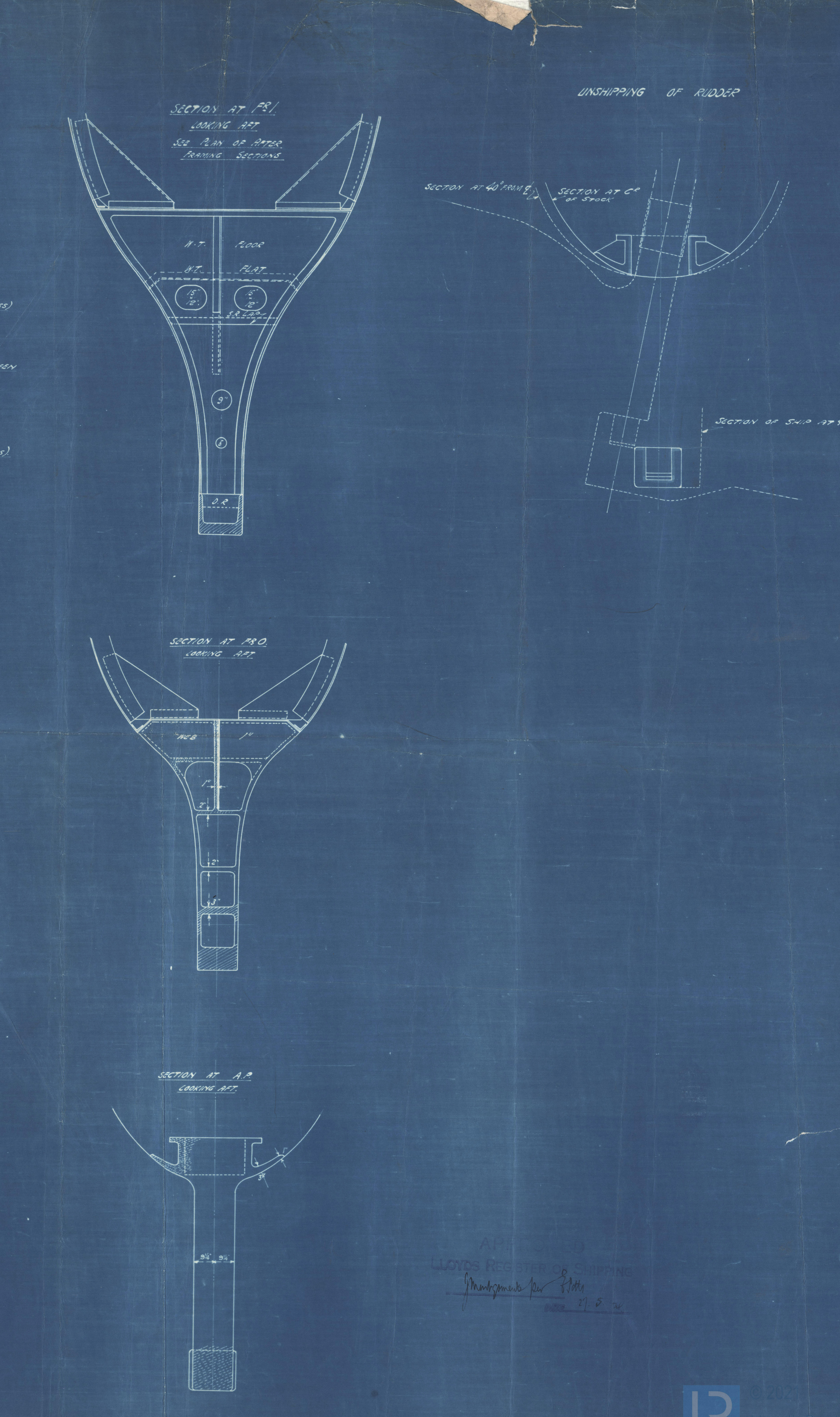
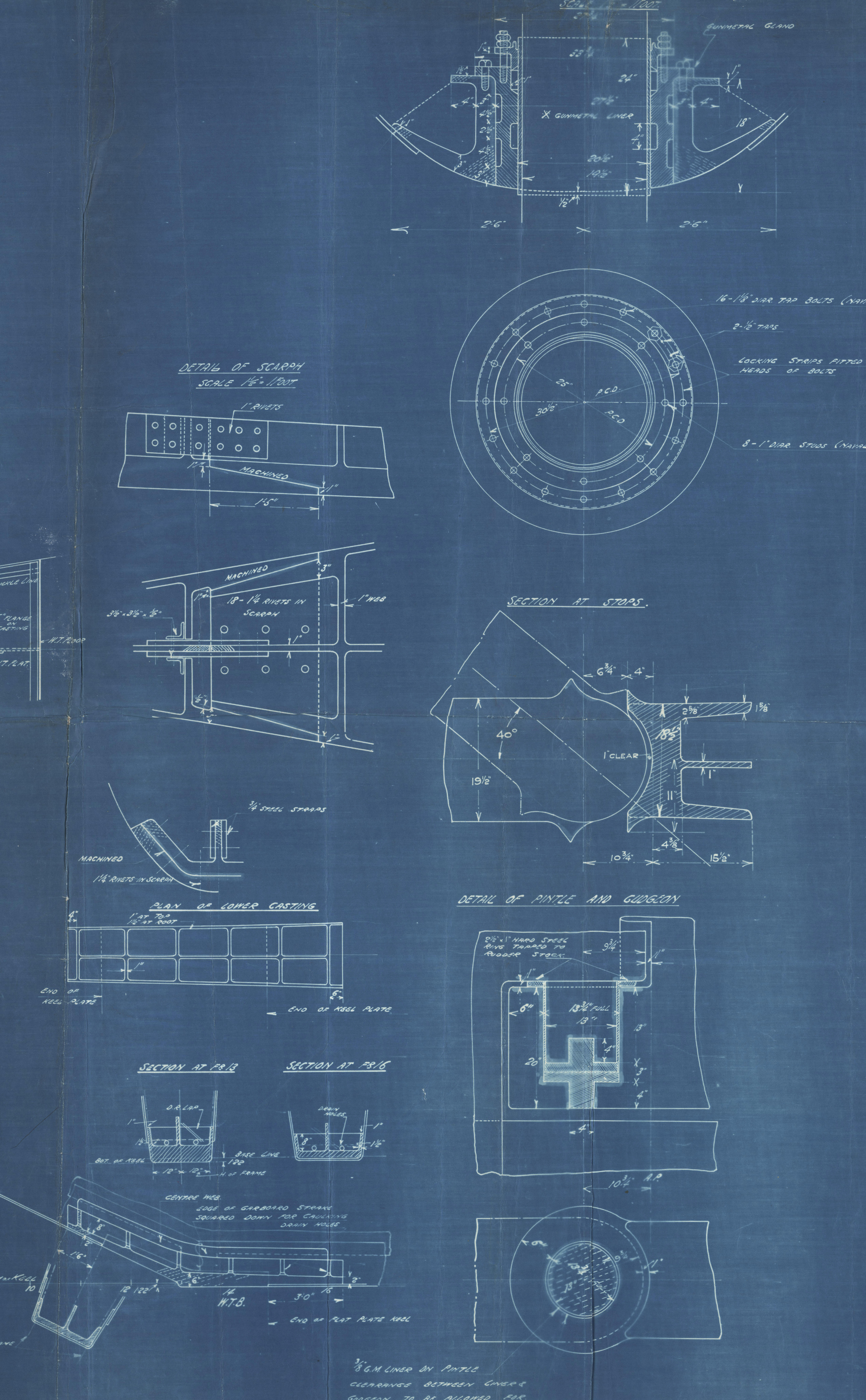
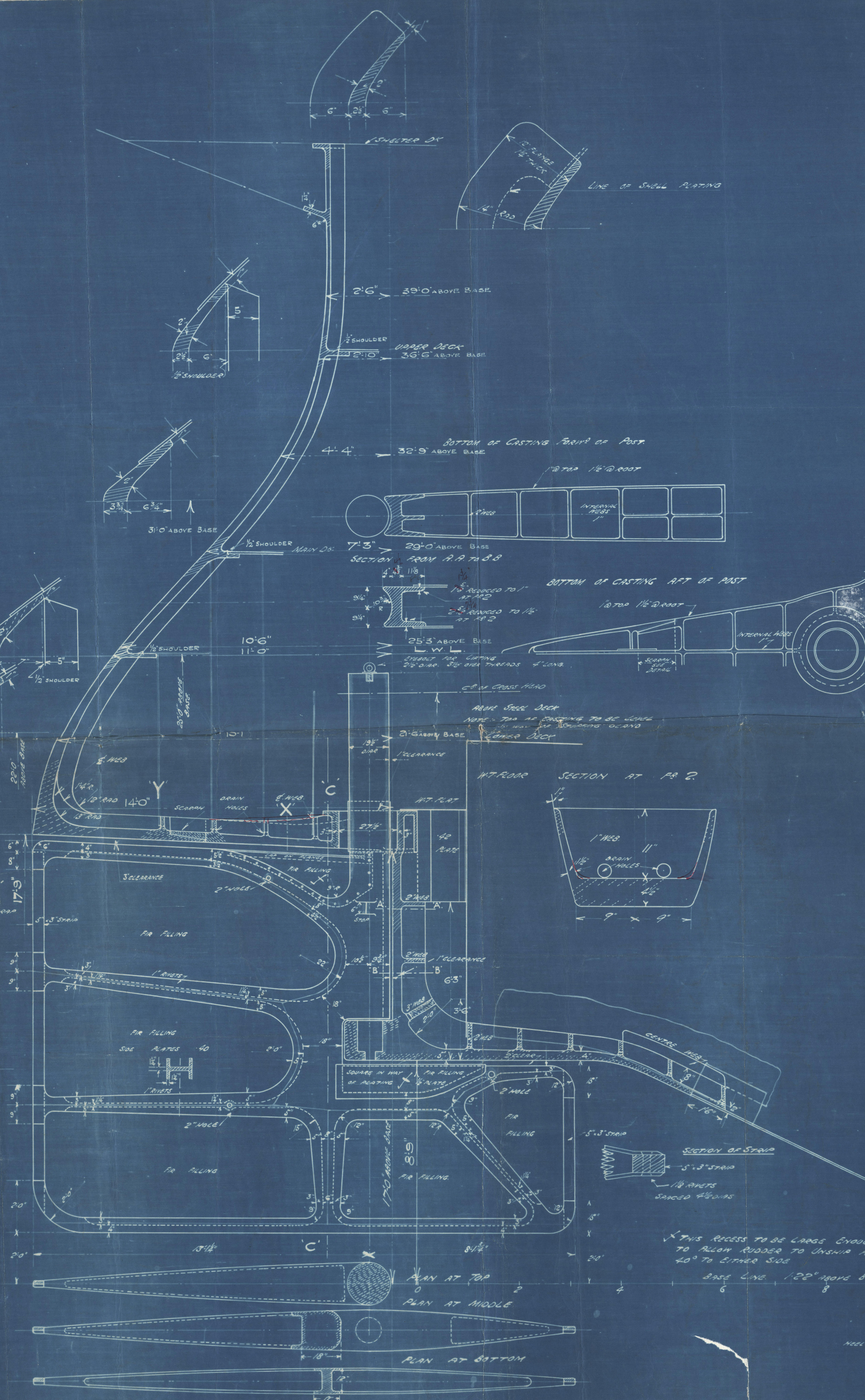
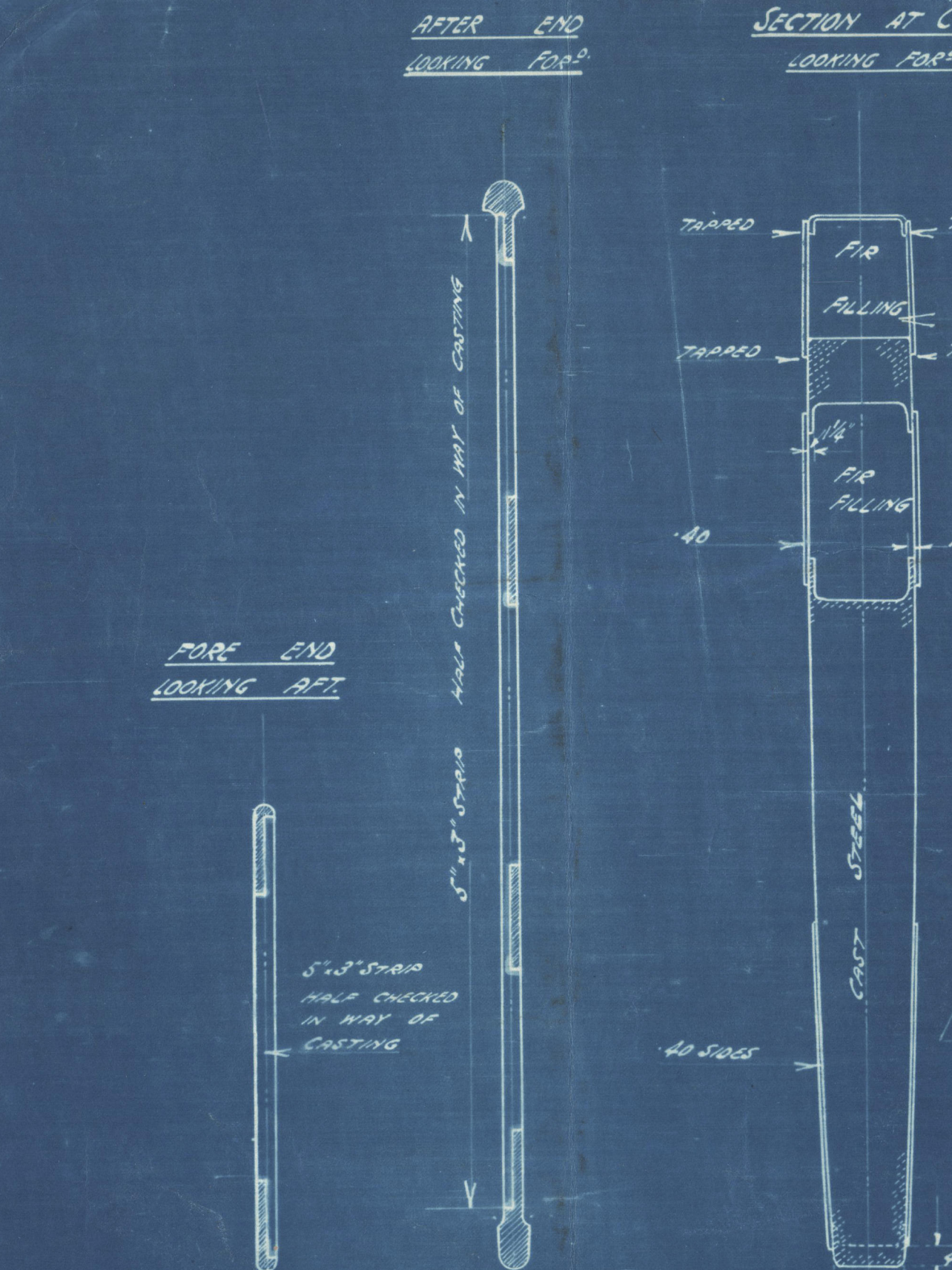
Nº 640.
STERNPOST & RUDDER.

SCALE 1/2" = 1 FOOT.
DETAILS 1 1/2" = 1 FOOT.

SPEED AT SEA = 20 KNOTS

NOTES—
RUDDER SIDE PLATES RIVETED WHERE POSSIBLE IN ARMS ON ONE SIDE BY 1" AND 1/8" RIVETS AND SECURED ON OTHER SIDE BY 1/8" TAPS. RIVETS AND TAPS SPACED 4 1/2" DIAS. C5 TO C8. RIVET HOLES TO BE MARKED OFF BY LOFTSMAN. PARTS TINTED RED TO BE MACHINED. TEST PIECES TO BE ARRANGED FOR. RIVETS IN STERN FRAME 1 1/4" DIA. SPACED 4 1/2" DIAS.
ALL CASTINGS TO BE OF STEEL.
UNSHIPPING OF RUDDER TO BE TESTED IN MOULD LIFT TO VERIFY THE 27 1/2" DIA. OPENING IN STERN CASTING AND TO DETERMINE SIZE OF PORTABLE PIECES. PATTERNS FOR STERNPOST, RUDDER AND HEELPIECE TO BE MADE IN S/Y.
ALL DRILLINGS FOR RIVET AND TAP HOLES TO BE DONE AT FOUNDRY.
X ITEMS MARKED THUS TO BE SUPPLIED BY CONTRACTOR.

ESTIMATED WEIGHTS
A. PORTION ART OF SCARPH... TONS
B. FORD...
C. HEELPIECE...
RUDDER...
RUDDER...
RUDDER...



Wm Beardmore & Co.

No 640

Sternframe & Rudds

o/o

Conte Brancamano

GLASGOW REPORT No 45140

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Lloyd's Register
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