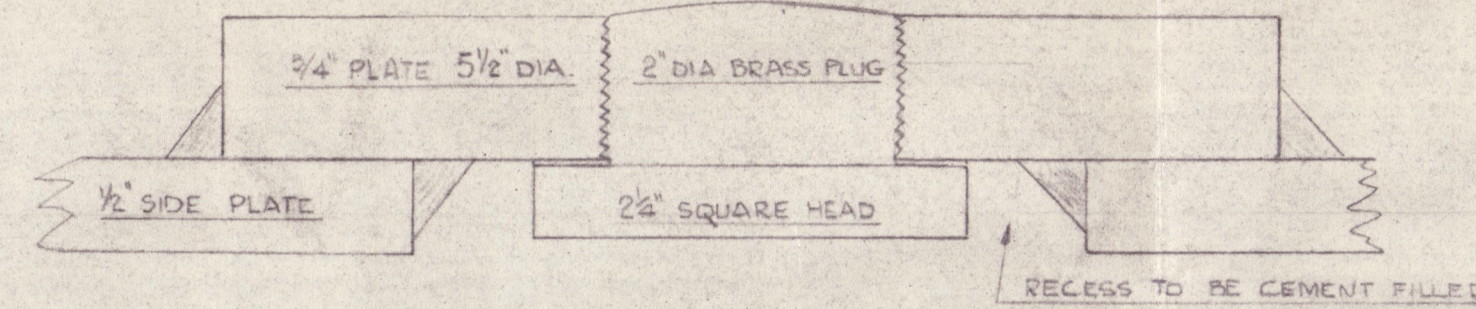


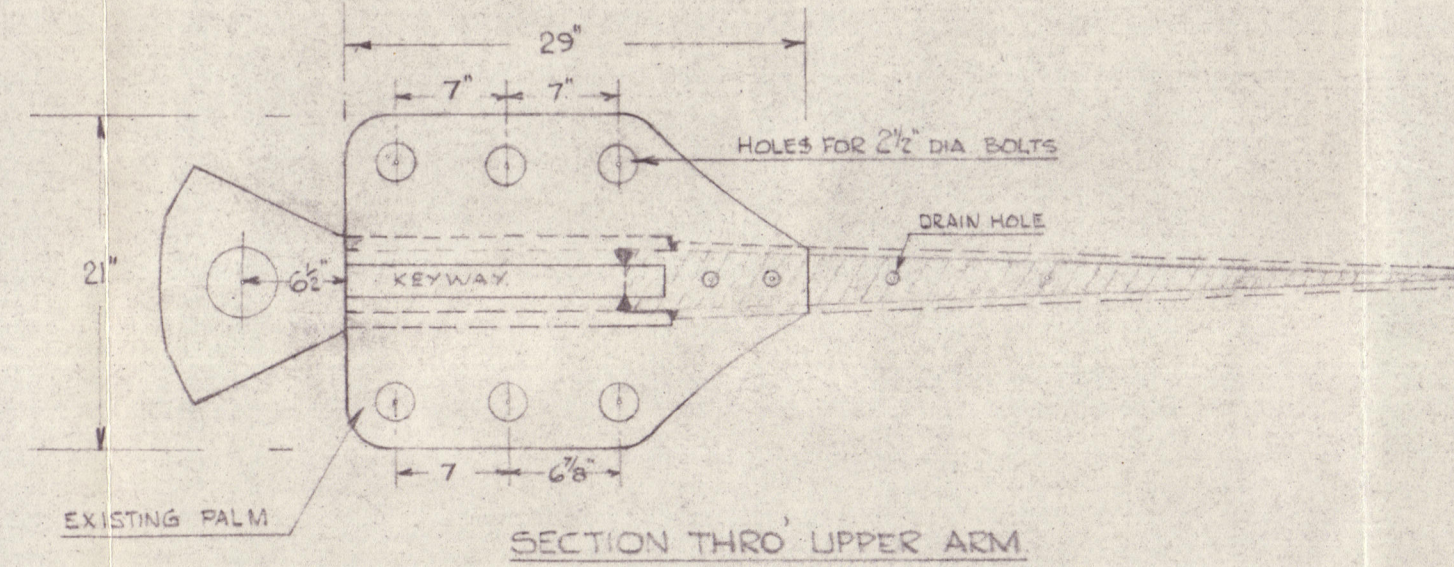
5/8" DIA. BOLT WELDED TO 2" VERT. WEB
IN WAY OF SLOTS FOR HOLDING CLOSING
PLATE IN POSITION BEFORE WELDING.
BOLTS TO BE CUT OFF AFTERWARDS.

HALF SIZE DETAIL OF PLUG WELDING SLOTS IN 2" VERT. WEB
TO BE SPACED 12" APART CENTRE TO CENTRE.

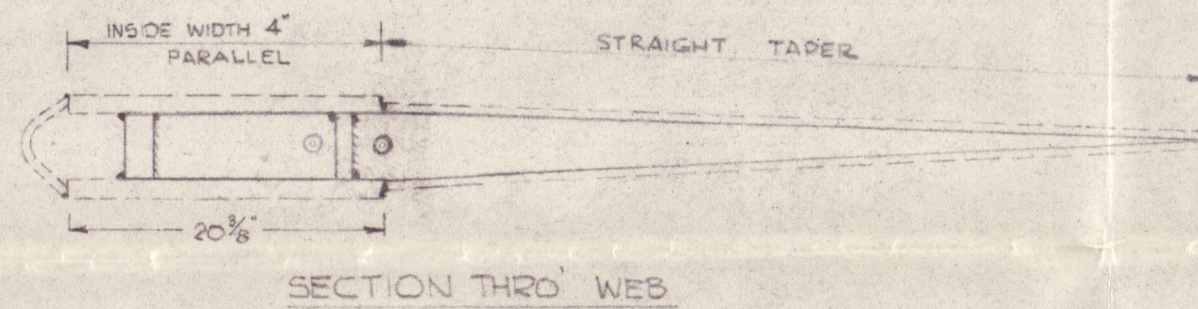
NB. * THESE DIMENSIONS WERE LIFTED FROM RUDDER AFTER DAMAGE
& SHOULD BE CHECKED FROM VESSEL'S STERNFRAME



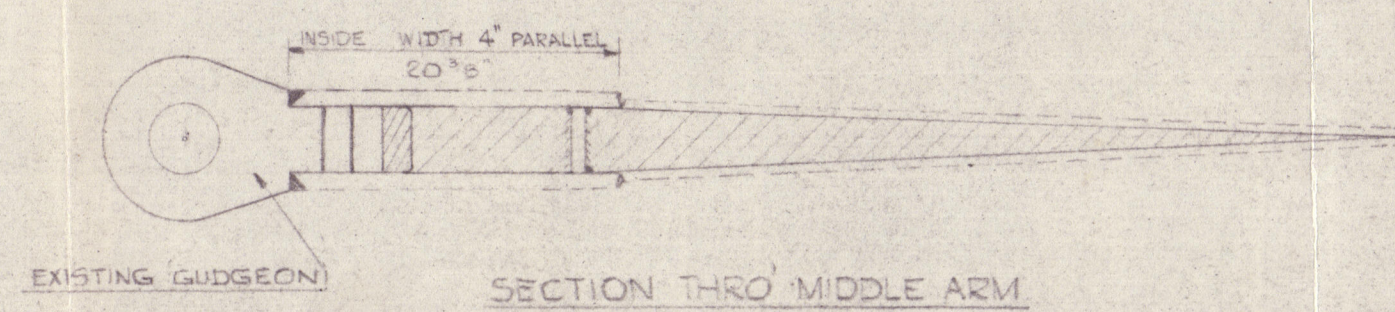
FULL SCALE DETAIL OF FILLING PLUGS
1 TO BE FITTED EACH SIDE OF RUDDER



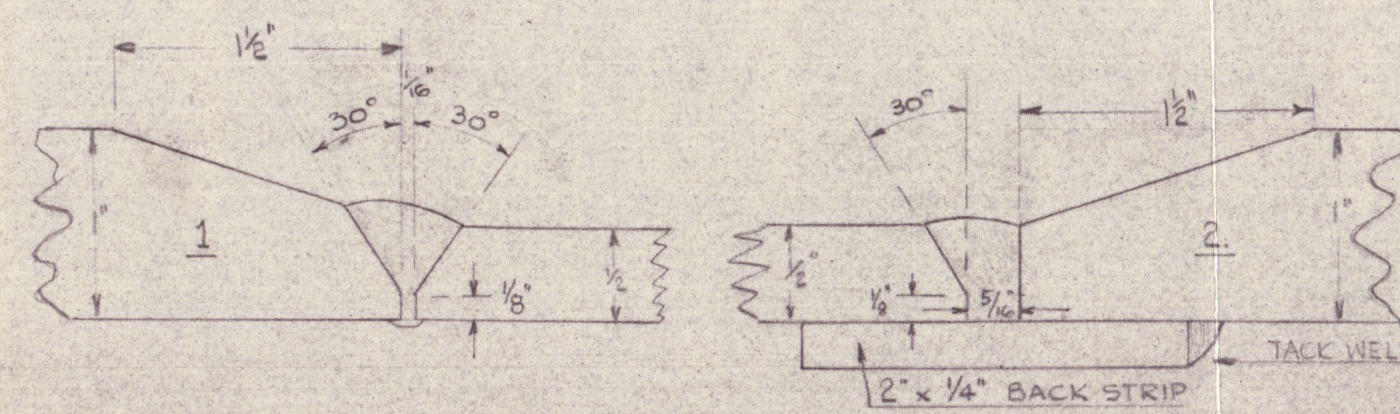
SECTION THRO' UPPER ARM



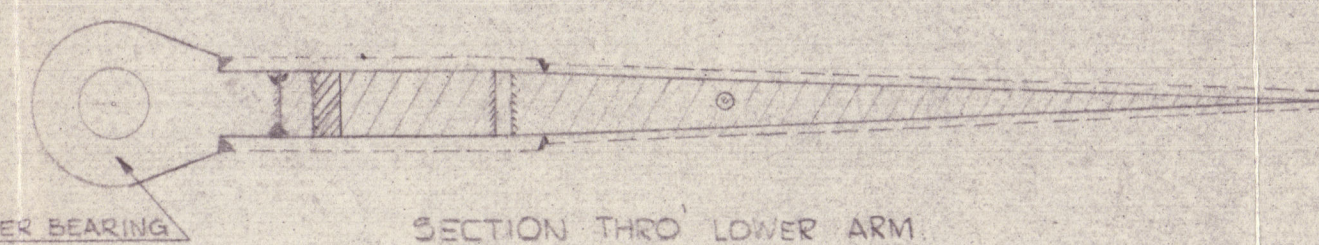
SECTION THRO' WEB



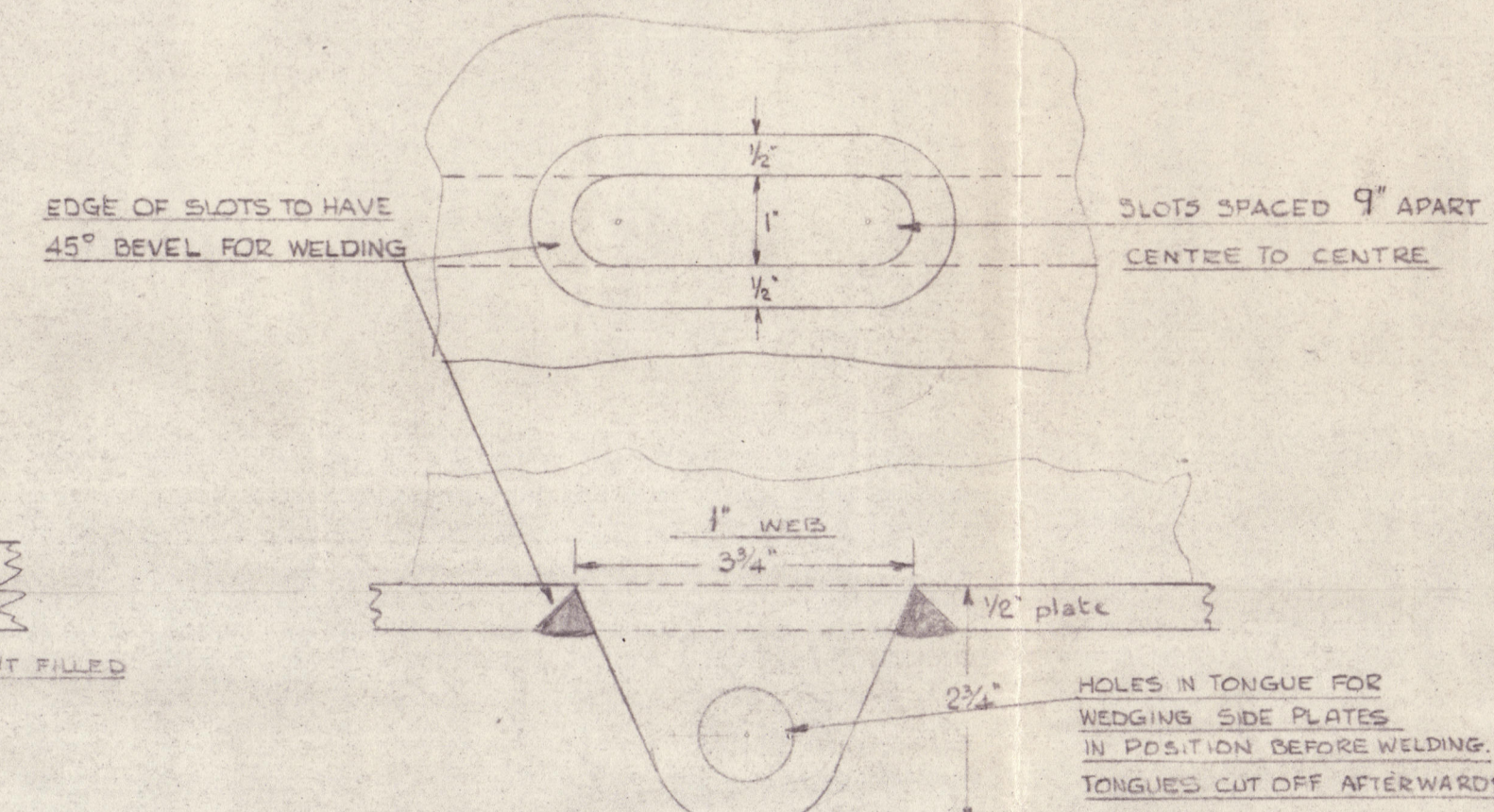
SECTION THRO' MIDDLE ARM



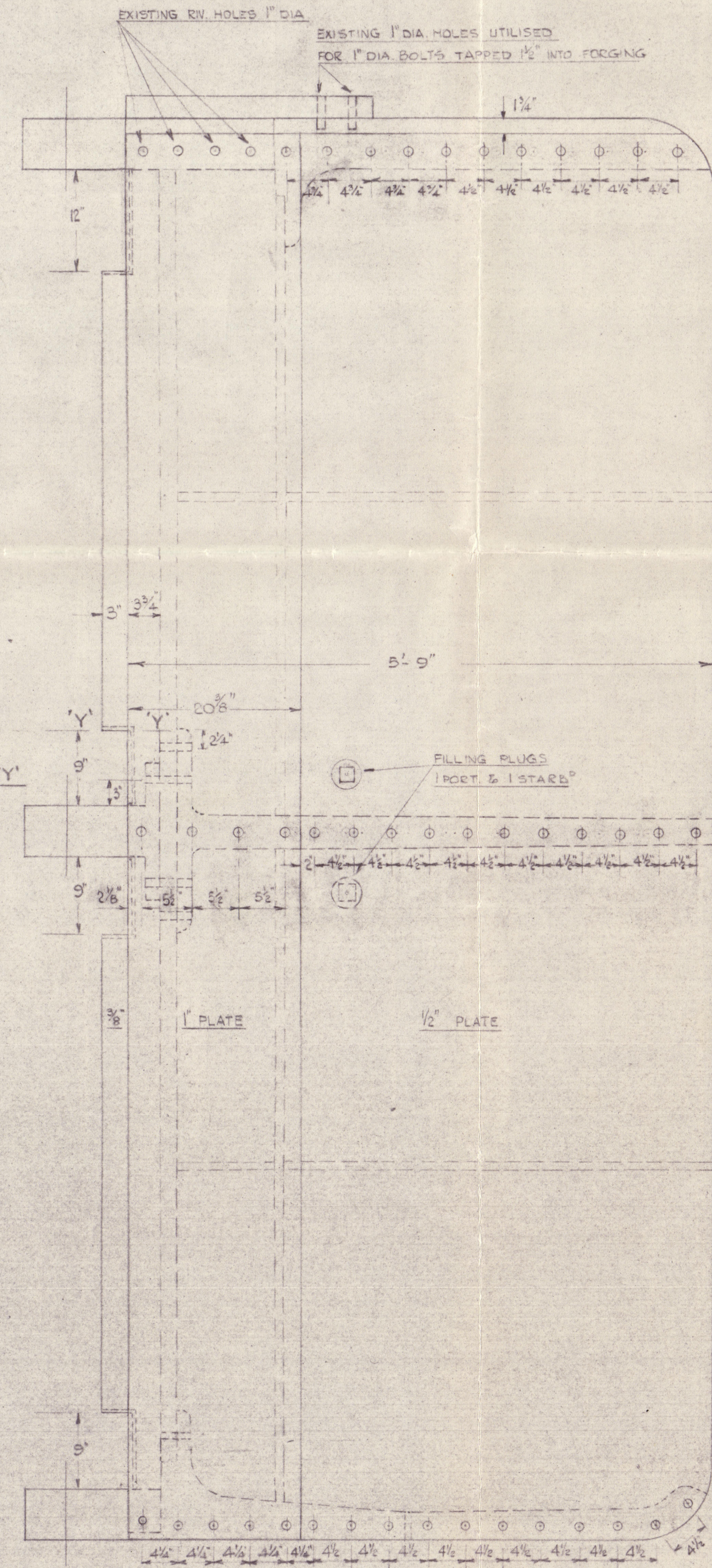
FULL SIZE DETAILS OF BUTTS IN SIDE PLATES OF RUDDER
BACK STRIP FITTED INTERCOSTALLY BETWEEN ARMS & WEBS
IN SEALING PLATE ONLY



SECTION THRO' LOWER ARM



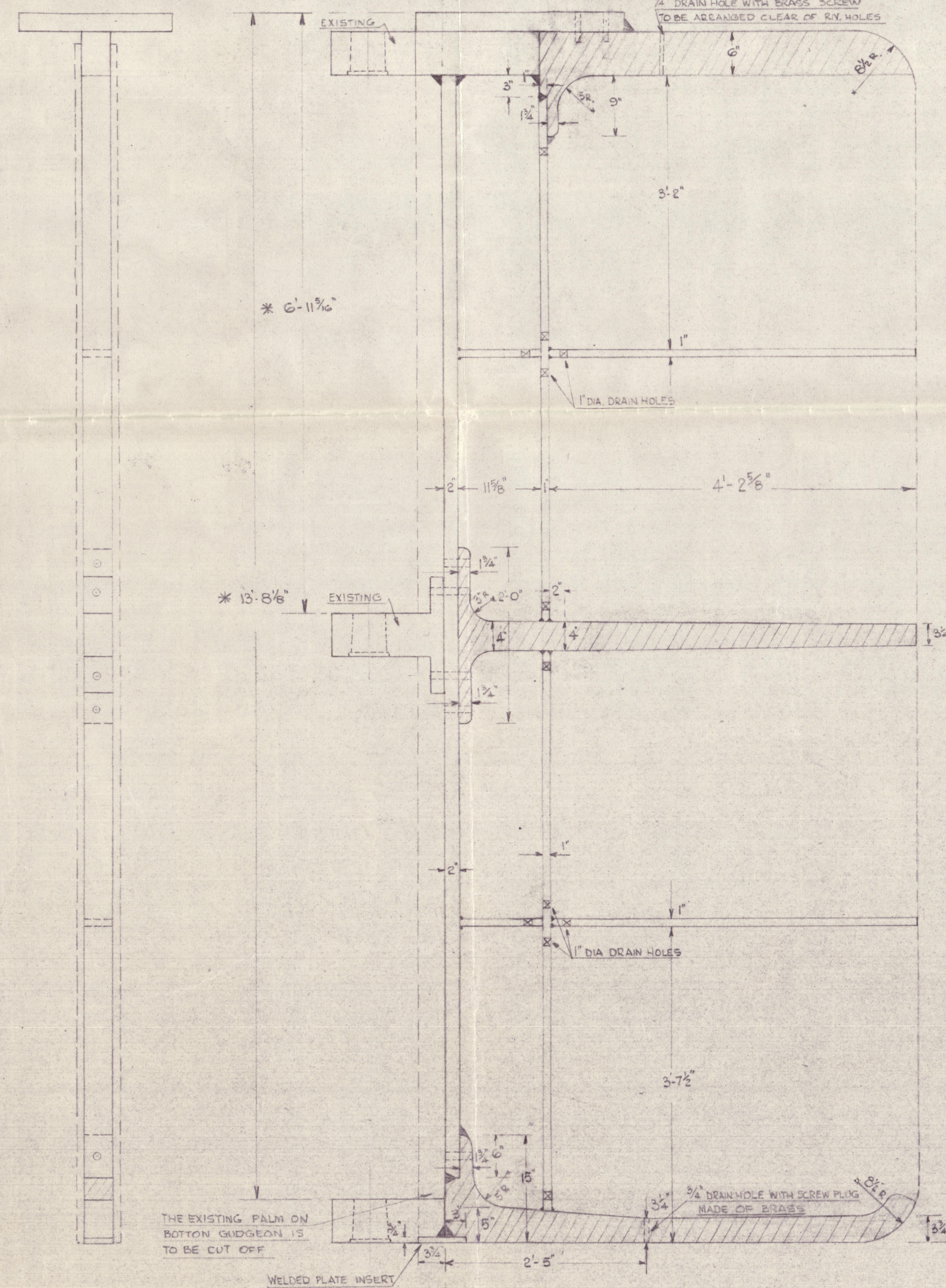
HALF SIZE DETAILS OF SLOT WELDS TO WEBS



PROFILE OF RUDDER
1" DIA. RIV. USED THROUGHOUT

ASSEMBLY PROCEDURE

THE TOP & BOTTOM CASTINGS & FORGINGS ARE TO BE PREPARED FOR WELDING
BY HAVING 30° CHAMFERS 2" DEEP PLANED ON THE BUTTING EDGES.
THEY ARE THEN TO BE WELDED TO FORM ARMS. THE 3 ARMS ARE TO BE ATTACHED TO THE 2"
VERTICAL WEB. THE FIRST 1" SIDE PLATE IS TO BE PLACED IN POSITION &
THE 2" VERTICAL WEB WITH ARMS ATTACHED IS TO BE WELDED TO IT.
THE 1" VERTICAL WEB TOGETHER WITH THE SHORT 1" HORIZ. WEBS ARE TO BE
PLACED ON THE SIDE PLATE & WELDED IN PLACE.
THE SECOND 1" SIDE PLATE IS THEN PLACED IN POSITION & WELDED TO THE
FORE EDGE OF 2" VERTICAL WEB & THE AFTER EDGE OF THE 1" VERTICAL WEB.
ADDITIONAL ATTACHMENT BEING PROVIDED ON THESE 2 MEMBERS BY
SLOT & PLUG WELDS (DETAILS AS SHOWN).
THE 1" SIDE PLATES ARE NOW TO BE RIVETED TO THE FORGED SIDE ARMS
& CASTINGS. THE FIRST OF 1/2" SIDE PLATES WITH HORIZ. WEBS
ALREADY ATTACHED IS TO BE POSITIONED & BUTT WELDED TO THE 1"
SIDE PLATE. THE FINAL 1/2" SIDE PLATE IS THEN PLACED IN POSITION
& BUTT WELDED TO ITS RESPECTIVE 1" SIDE PLATE USING THE 2 1/2"
BACK STRIP. THE RIVETING OF THE ARMS IS THEN TO BE COMPLETED.
THE SLOTS IN WAY OF THE HORIZ. WEBS ARE NOW TO BE WELDED AS
SHOWN & THE ASSEMBLY COMPLETED BY WELDING UP THE TRAILING
EDGES OF THE 2 SIDE PLATES & FITTING THE FAIRING PLATES
AT THE LEADING EDGE.



SECTION 'XX' LOOKING AFT

RUDDER FRAMING
PLATING DOTTED

Q	R 4021	Item D 300	SINGAPORE HARBOUR BOARD.	Scale 1/4" = 1' AS SHOWN
			SINGAPORE	Drawn NTB
			SHIPBUILDERS, ENGINEERS	2020
			& BOILERMAKERS.	Checked
			Date 18-7-51	MS 100
			32-1-51	

002717-002724-0104

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Foundation

S.S. "FOSSARUS"

SINGAPORE REPORT

Nº 8497

DATED 5/3/51.

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