

RUDDER.

SCALE $\frac{1}{2}$ " = 1 FOOT.

NOTES.

RUDDER STOCK TO BE OF INGT STEEL. 1 ARMS OF FORGED SCRAP. ARMS TO BE AT RIGHT ANGLES TO CENTRE LINE OF PINTLES, BASED OUT ACCURATELY & CAREFULLY SHUNK ON POST AND KEYED. KEYS TO BE OF MILD STEEL AND TO HAVE A TAPER OF $\frac{1}{8}$ " IN 10". BOTH KEYS AND KEY SEATS TO BE ACCURATELY MACHINED TO DIMENSIONS GIVEN. KEYS TO BE DRIVEN DOWN EXCEPT THAT IN TOP SNUG WHICH IS TO BE DRIVEN UP. RUDDER POST TO BE TURNED SMOOTH WHERE ARMS ARE SHUNK ON. RUDDER IS HARD OVER AT 40° WITH CENTRE LINE OF SHIP. STOPPERS TO HAVE 8" CLEARANCE WHEN RUDDER IS HARD OVER. RUDDER FRAME TO BE TESTED AND PASSED BY LLOYDS & BOARD OF TRADE. PINTLES & BRASS BUSHES TO BE SUPPLIED BY CONTRACTOR. MOULDS OF STOPPER WILL BE SUPPLIED. WORK TO MOULDS IN PREFERENCE TO PLAN. RIVET HOLES TO BE BORED TO GAUGE AND SPACED AS SHOWN ON MOULDS. PARTS COLOURED RED TO BE MACHINED. ALL MACHINING TO BE DONE BY CONTRACTOR. BOLTS & NUTS FOR COUPLING TO BE SUPPLIED BY MAKER OF RUDDER. EDGES OF ARMS TO BE CHAMFERED.

RIVETING.

RIVET HOLES $\frac{5}{16}$ " DIA FOR $\frac{1}{4}$ " RIVETS SPACED 5" 6" 8" 10" NOT TO BE DIRECTLY OPPOSITE EACH OTHER EXCEPT AT OUTER END OF ARMS. RIVET HOLES IN ARMS TO BE C&K ON OPPOSITE SIDE FROM PLATE. PLATE RIVETS TO HAVE FULL HEADS & POINTS (HYDRAULIC RIVETING).

SCARPH TO BE ACCURATELY MACHINED & FITTED TOGETHER BEFORE LEAVING MAKERS WORKS.

POINTS SQUARE OFF FACE OF SCARPH.

SPLIT PINS.

NUTS 2" DEEP.

FITTED BOLTS TO HAVE $\frac{1}{4}$ " TAPER IN 10". DIA CLEAR OF THREADS = 2". DIA AT BOTTOM OF THREADS = 2". SORROWED 9 THREADS PER INCH.

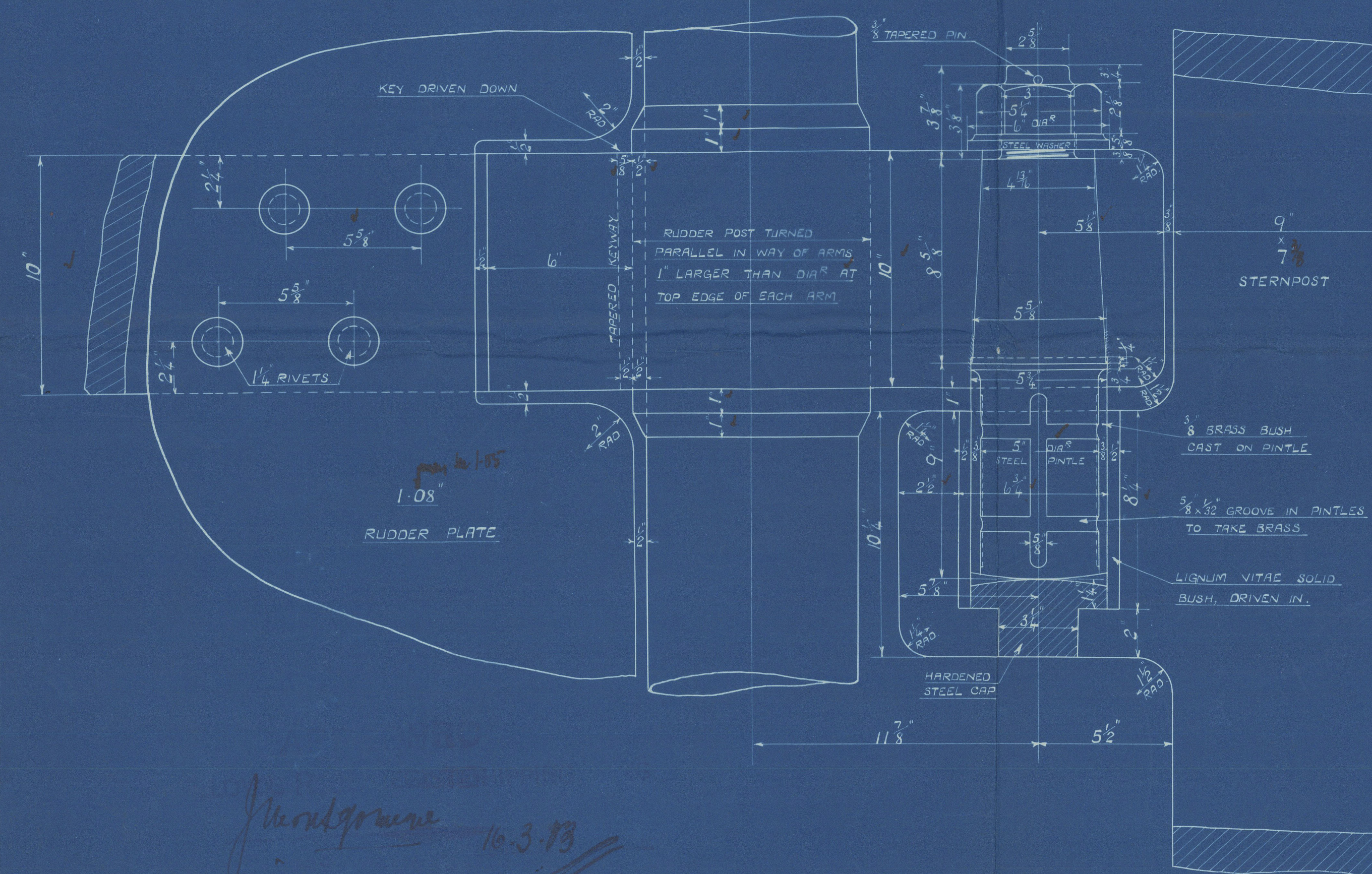
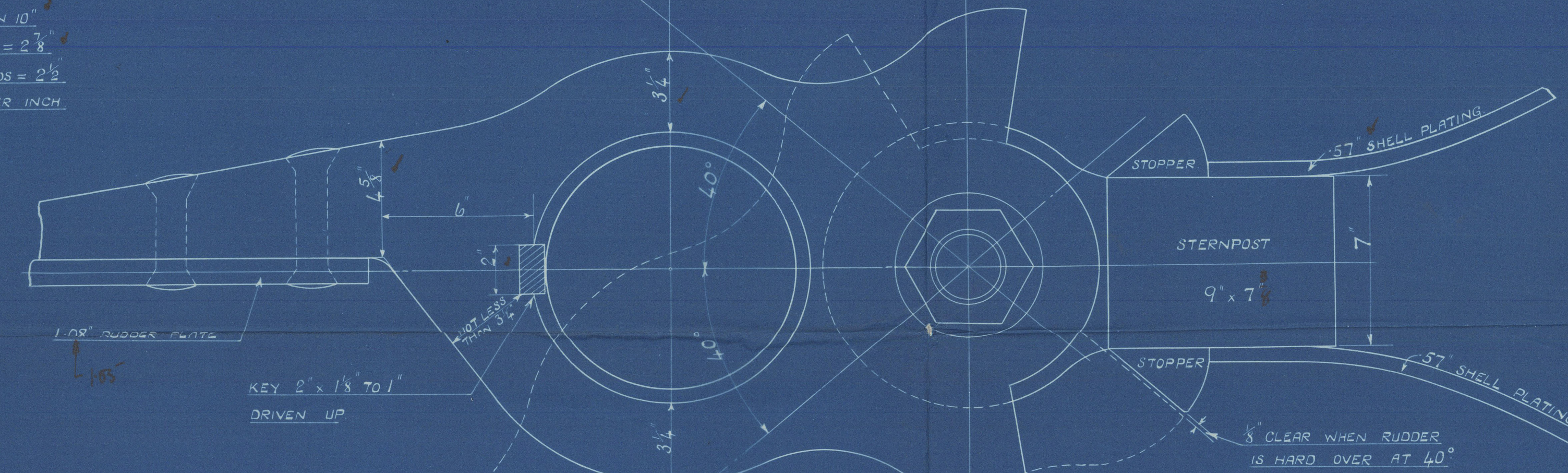
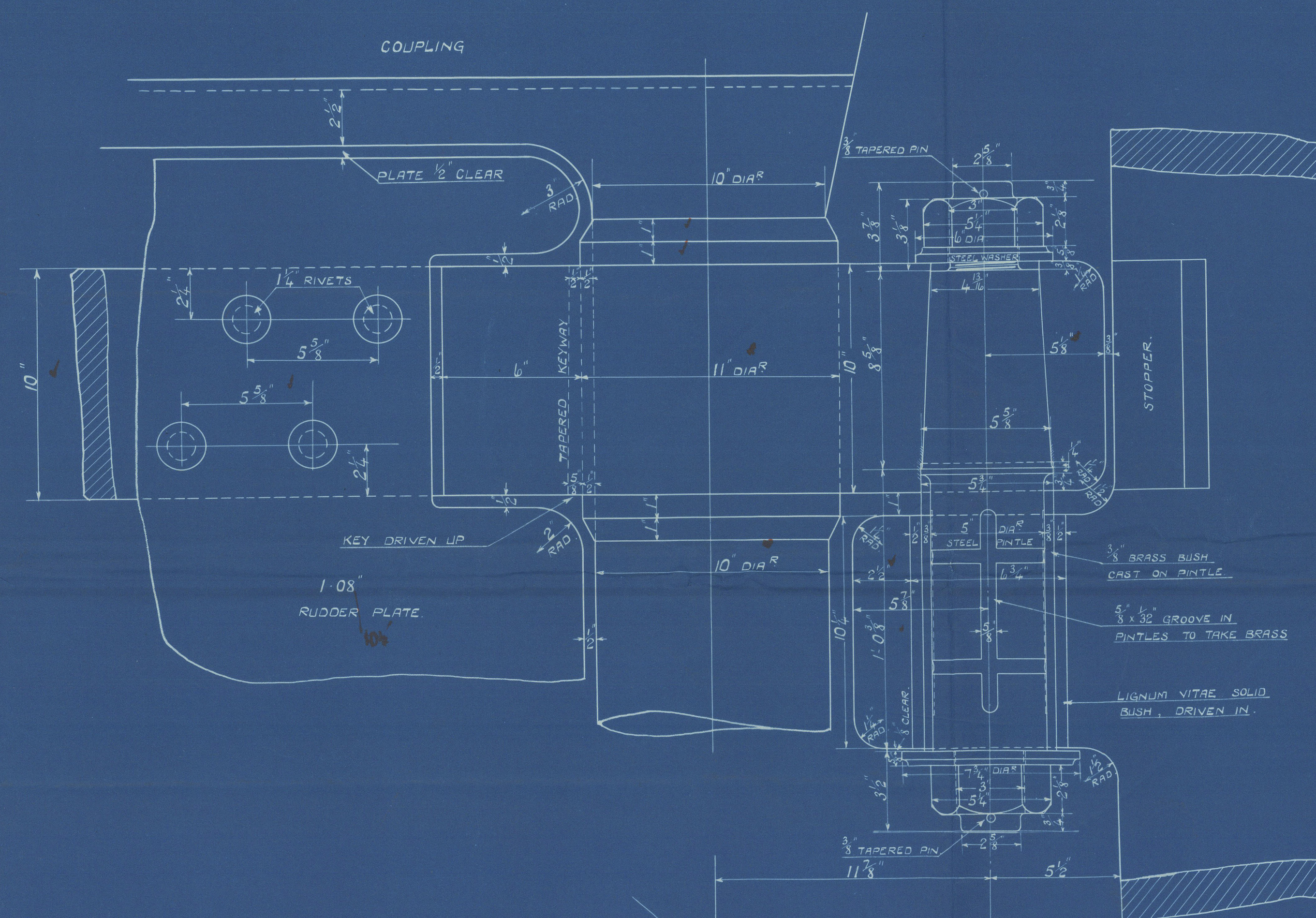
AREA OF RUDDER = A = 130 SQ FT
C.G. ABFT C^R LINE OF PINTLES = D = 3.63 FEET
A x D = 472. SPEED 10 KNOTS

EYEBOLT FOR LIFTING RUDDER TO BE SUPPLIED BY SHIPBUILDER. HOLE TO BE BORED & TAPPED BY CONTRACTOR.

UPPER DECK

BACK OF RUDDER POST & TOP OF SCARPH MUST INTERSECT ON CENTRE LINE OF PINTLES.

NOTE: HEIGHTS OF SNUGS AS LIFTED FROM STERNPOST CASTING TO BE WORKED TO WHEN MARKING RUDDER FRAME



DETAIL OF PINTLES & A B C D
SCALE 3" = 1 FOOT.

Handwritten signature and date: 16-3-13

Messrs Harland & Wolff.
Nos 610, 611, & 642.

Rudder Plan

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Rudder.

No 610 GLASGOW REPORT No. 43244

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