

5.3.37

# SECTION AT ARM.

## PLAN OF SOLE PIECE.

## HORIZONTAL SECTION I.

## DETAIL OF LOCKING PINTLE.

## SECTION AT C-D.

## SECTION AT A-B.

## DETAIL OF BEARING PINTLE.

## SECTION AT FR NO 4.

## SECTIONS AT FRAMES.

## DETAIL OF KEYWAYS IN MAIN PIECE FOR ARMS.

## NOTES.

**RUDDER FRAME.**  
STOCK, MAINPIECE & ARMS ALL OF FORGED STEEL.  
ARMS HUNG ON & KEYS.  
ALL TO BE IN ACCORDANCE WITH THE REQUIREMENTS  
& TESTS OF LLOYD'S REGISTER OF SHIPPING.  
AREA OF RUDDER 11.56 SQ. FEET.  
CENTRE OF GRAVITY 48.4 FT CENTRE LINE  
OF PINTLES 5.5 FT.  
SPEED 11 KNOTS.  
FORGINGS TO BE INSPECTED & PASSED BY LLOYD'S  
SURVEYOR BEFORE LEAVING MAKERS' WORKS.  
RUDDER MAKERS TO SUPPLY SHIPBUILDERS  
(FOR STEERING GEAR MAKERS) WITH GAUGES  
OF STOCK DIAMETERS.  
PINTLES & LINERS TO BE SUPPLIED BY  
RUDDER MAKERS.

**ELL POST.**  
TO BE OF FIRST CLASS ANNEALED CAST STEEL  
TO CONFORM WITH THE REQUIREMENTS & TESTS  
OF LLOYD'S REGISTER OF SHIPPING.  
LIGNUM VITE & GUNMETAL BUSHES TO BE  
SUPPLIED BY ELL POST MAKERS.  
GREAT CARE TO BE TAKEN THAT THE HOLES IN  
THE GUDGEONS ARE IN LINE & PERPENDICULAR  
TO THE BASE LINE.  
PATTERNS TO BE SUPPLIED BY ELL POST MAKERS.  
ELL POST MAKERS TO SUPPLY SHIPBUILDERS  
(FOR RUDDER MAKERS) WITH PARTICULARS  
OF SPACING OF GUDGEONS & GAUGES FOR  
PINTLES.

GENERAL: EXPOSED EDGES OF FORGINGS  
& CASTINGS TO BE ROUNDED OFF.  
ALL SURFACES TO WHICH PLATING IS ATTACHED  
ARE TO BE FLAT & FAIR & TO BE ROUGH  
MACHINED IF NECESSARY.  
ALL RIVET HOLES TO BE DRILLED & TO BE  
1/16" LARGER DIA. THAN RIVETS.  
DIMENSIONS TO BE CAREFULLY WORKED TO.  
AS WE PAY ONLY ON WEIGHTS CALCULATED  
TO THESE SIZES.  
WRITTEN DIMENSIONS ONLY TO BE TAKEN  
SHIPBUILDERS TO BE NOTIFIED OF ANY PROPOSED  
DEPARTURE FROM THIS DRAWING & SAME TO  
BE AGREED TO BEFORE ITEMS ARE  
DESPATCHED.  
ALL DRILLING & MACHINING TO BE DONE BY MAKERS.

T. S. S. Nos. 277 & 8.  
ELL POST & RUDDER FRAME.  
Scale 1:10, 1:5 & 1:25.

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FURNESS S.B. C<sup>th</sup>

N<sup>o</sup> 277 + 278

STERN POST + RUDDER.

(4)

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