

(102-1) EYE BOLT FOR RUDDER STOCK

BILL OF MATERIAL					
Pc No	NAME	No Pcs	MATERIAL	REMARKS	B/M NO
102	RUDDER STOCK	1	CAST STL	TO MEET ABS. REQUIREMENTS	858-33
102-1	EYE BOLT	1	WSTL GALV	2 $\frac{1}{2}$ DIA. THREADS	858-33
102-2	KEY 2.000 <sup>+0.000</sup> <sub>-.001</sub> x 2-4 $\frac{1}{8}$ "	2	KEY STOCK		858-33

NOTE: ITEM 1. VARIATION IN SQUARENESS OF FACE OF PALM BOTH SIDES NOT OVER .005"

ITEM 2. PALM MILLING TO HAVE 75% BEARING. MAXIMUM DEPRESSION IN REMAINING 25% NOT OVER .006"

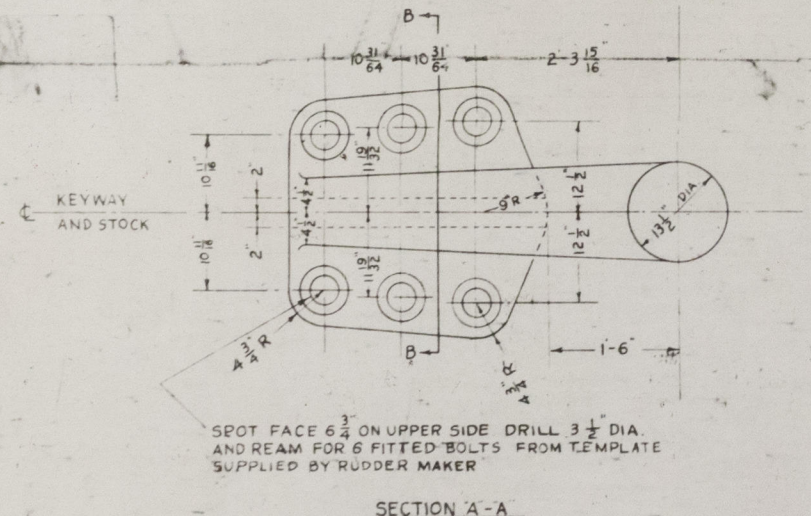
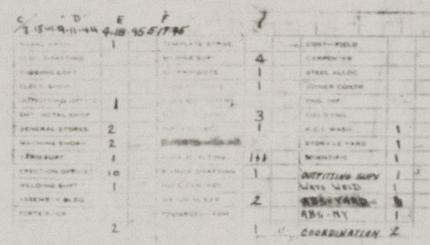
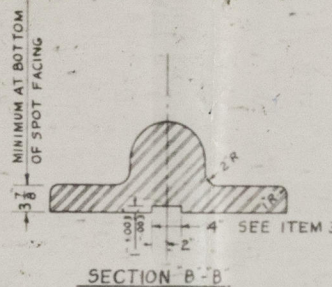
ITEM 3. KEYWAY IN PALM TO BE MILLED, FINISHED & FITTED TO PG.15 ON DWG. K-703-2, ALT.B. AND MATCH MARKED.

[E<sup>1</sup>] ITEM 4. WIDTH OF KEYWAYS IN SHAFT TO BE MILLED & UNDERSIZE AND FINISHED AT SHIPYARD. DEPTH OF KEYWAY 1.030" PLUS OR MINUS .003". WIDTH OF FINISHED KEYWAY PLUS OR MINUS .001"

ITEM 5. THICKNESS OF PALM AT BOTTOM OF SPOT FACING 3/16" MINIMUM

ITEM 6. RUDDER STOCK SHALL BE ASSEMBLED WITH RUDDER SHOWN ON DWG. K-703-2, ALT.B. AFTER ALL MACHINING HAS BEEN COMPLETED WITH KEY, PG.15, & COUPLING BOLTS, PG.17, SHOWN ON DWG. K-703-2, ALT.B. PROPERLY FITTED. THE ENTIRE ASSEMBLY SHALL BE ALIGNED FROM THE LOWER PINTLE TO THE TOP OF THE RUDDER STOCK TO WITHIN .020 INCHES OF A TRUE LINE BOTH FORE & AFT & ATHWARTSHIP

[D<sup>2</sup>]



SECTION "A-A"

[illegible]

9-3-43		1/2 CS	1/2 CS	1/2 CS	1/2 CS	1/2 CS
DATE ISSUED	USMC WASH	USMC WC	USMC GC	AB S	MMI	ALA DD B S
	USMC W	USMC G	USMC C	AB S	MMI	MARINSHIP CO
	USMC W	USMC G	USMC C	AB S	MMI	KCIV
	USMC W	USMC G	USMC C	AB S	MMI	KCLIP

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USMC HULLS 1914-60, 2393-2430, 2720-2725, 2843-2853

UNITED STATES MARITIME COMMISSION

EFFECTIVE HULL 57, USMC 1914

**KAISER COMPANY, INC**  
 PORTLAND, OREGON

KM-858-3

*Gal. Rpt. 53*

**TROCHURUS**  
 DETAIL OF  
 RUDDER STOCK &  
 EYE BOLT

SCALE 1" = 6" - LFT

DRAWN ADM

TRACED ADM

CHECKED *FR*

DATE 7-23-43

SUBMITTED *J.W.*

APPROVED *Robert M. Miller*  
 NAVAL ARCHITECT

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APPROVALS

A.B.S. *John Campbell* 7-23-43

U.S.M.C.H. *John Campbell* 7-23-43

KAISER CO

DRWG. NO. KM-858-3

PORTLAND YARD

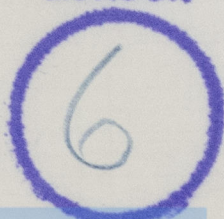
ALT. F



"TROCHURUS" ★

ludder stock & eye bolt

RECORDS DEPT.,  
LONDON



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Foundation

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