



BILL OF MATERIAL					
NO.	PIECE NO.	NAME	MATERIAL	DETAIL NO.	REFERENCE
1	1	4" O.D. EXTRA STRONG PIPE	STEEL	3	
2	2	LOWER RUDDER STOCK	STEEL	2A	
3	3	UPPER RUDDER STOCK	STEEL	4F	
4	4	PINTLE	STEEL	2D	
5	5	PINTLE BUSHING	BRONZE	2D	
6	6	40.8" TOP PLATE	STEEL	3, 4	
7	7	40.8" TOP PLATE	STEEL	3, 4	
8	8	17.85" SIDE PLATE	STEEL	3	
9	9	17.85" FAIRING PLATE	STEEL	2-B, 3	
10	10	17.85" FAIRING PLATE	STEEL	2-B, 3	
11	11	40.8" RUDDER PLATE	STEEL	2-B, 3	
12	12	RUDDER ARM 4" THK.	STEEL	2-B, 3	
13	13	RUDDER ARM 5" THK.	STEEL	2-B, 3	
14	14	2 1/2" D. HEX H.D. FITTED BOLT	STEEL	L-9 1/2"	
15	15	2 1/2" D. HEX NUT	STEEL	2F	
16	16	7/8" B. SPLIT PINS L-3"	STEEL	2F	
17	17	40.8" BOTTOM PLATE	STEEL	3	
18	18	40.8" BOTTOM PLATE	STEEL	3	
19	19	1 1/2" F.B. BACKING STRIP	STEEL	2A	
20	20	HALF BUSHINGS	BRONZE	4H	
21	21	1" DIA. L.P.S. PLUGS	BRASS	4F	
22	22	3" EX. STRONG PIPE	STEEL	L-10 1/2"	
23	23	2" DIA. PLUG & STD. PIPE THMS	BRASS	2B	
24	24	7/8" STAINLESS STEEL PL.	STAINLESS STEEL	2A	

WELDING SYMBOLS	
	CONTINUOUS FILLET WELD BOTH SIDES
	CONTINUOUS FILLET WELD FAR SIDE
	CONTINUOUS FILLET WELD NEAR SIDE
	INTERMITTENT FILLET WELD BOTH SIDES
	INTERMITTENT FILLET WELD FAR SIDE
	INTERMITTENT FILLET WELD NEAR SIDE
	BUTT WELD V-OUT BOTH SIDES
	BUTT WELD V-OUT FAR SIDE
	BUTT WELD V-OUT NEAR SIDE
	BUTT WELD V-OUT FAR SIDE REINFORCE
	BUTT WELD V-OUT NEAR SIDE REINFORCE
	WELD ALL AROUND

NOTES:

1. ALL WELDING SURFACES TO BE CLEANED THOROUGHLY BEFORE WELDING.
2. INTERIOR OF RUDDER TO BE COATED WITH "KOMUL" OR EQUAL BY COMPLETELY FILLING AND DRAINING.
3. HOLES FOR FITTED BOLTS TO BE DRILLED UNDERSIZE AND REAMED TO SUIT ON SHIP.
4. 1" DIA. SOLID BRASS PLUGS TO BE PROVIDED AS SHOWN FOR FILLING & DRAINING RUDDER STOCK.

REFERENCE

THIS PLAN WAS DULICATED AND ALTERED FROM NEWPORT NEWS DWG. 131906 AND WAS MADE FROM WORK AS ACTUALLY CONSTRUCTED

TRAVELSTAR
(Shimonsaki Report No. 303)
Rudder fitted at Sasebo 2/64
(Plan approved Koba letter 6/2/54)

AMERICAN BUREAU OF SHIPPING
APPROVED DP BROWN 12-27-51
AMERICAN BUREAU OF SHIPPING
APPROVED 4-1-53 L.C. HOST CHIEF SURVEYOR
LLOYDS REGISTER OF SHIPPING
APPROVED 4-22-53 J.G. BUCHANAN

CONTRACT
BETHLEHEM STEEL COMPANY
SHIPBUILDING DIVISION
BALTIMORE YARD BALTIMORE MD.
SINGLE PLATE RUDDER
FOR STANFORD LIBERTY SHIP
Drawn By: F.W.C. Chief Draftsman
Traced By: K.L.H. Chief Engineer
Checked By: K.L.H. Inspector
Scale AS NOTED DATA 11-27-51
DRAWING No. 34571 ACT 4

Single Plate rudder

"Trenwalston"

Rpt. no. Smk. 303



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Lloyd's Register
Foundation

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