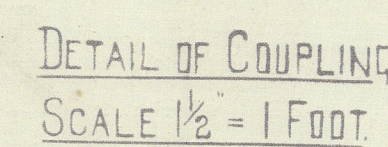
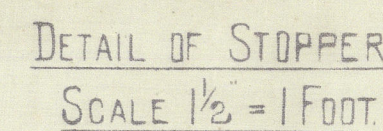


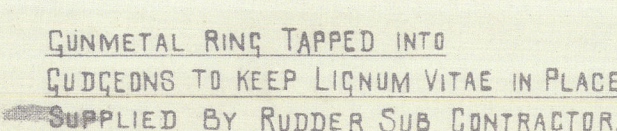
11.7.19.

STERNPOST AND RUDDER TO BE FORGED GRAP STEEL ALL TO LLOYDS TESTS  
GREAT CARE TO BE TAKEN WHEN BORING PINTLES TO HAVE THEIR CENTRES PERFECTLY  
FAIR WITH CENTRE OF STOCK BOTH FORE & AFT & ACROSS

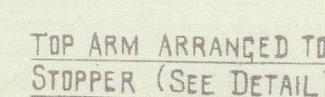


GAUGE TO BE SUPPLIED TO  
MAKERS OF STEERING GEAR &  
RUDDER HEAD TURNED BRIGHT  
FOR QUADRANT & STUFFING  
BOX ETC.

6 BOLTS 2 3/8 DIA. NUTS TO BE  
IN PROPORTION TO BOLTS & FITTED  
WITH SPLIT PINS TO PREVENT TURNING

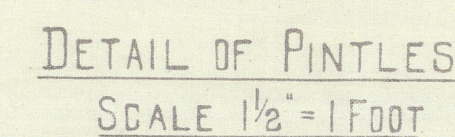


LOCKING HEAD ON TOP PINTLE  
ONLY 6-2 1/2 CHEESE HEAD  
1/16 CLEARANCE.  
3/8 GUNMETAL LINER ON PINTLE  
SUPPLIED BY RUDDER SUB CONTRACTOR  
1/2 LIGNUM VITAE ON SHOE SUPPLIED  
BY STERN FRAME SUB CONTRACTOR.  
NUT IN PROPORTION SUPPLIED  
BY RUDDER SUB CONTRACTOR  
3/8 SPLIT PIN SUPPLIED BY  
RUDDER SUB CONTRACTOR



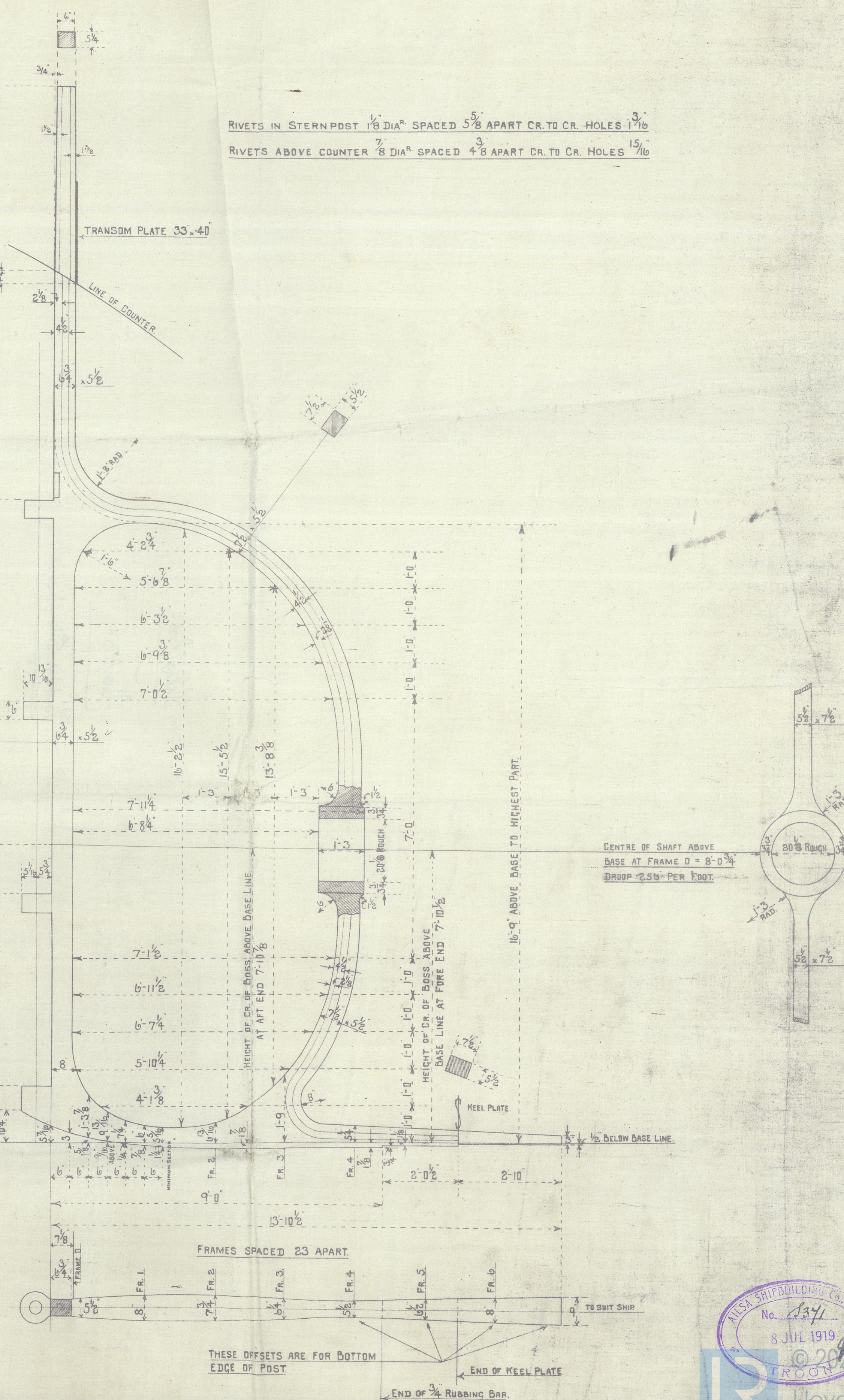
NOTE: ARMS TO BE SHRUNK UP  
 & KEYED TO MAIN PIECE.

NOTE:- MAIN PIECES TO BE INCREASED 10% IN DIA.<sup>R</sup>  
IN WAY OF EACH ARM TO ADMIT OF AN  
EFFICIENT KEYWAY BEING CUT.



CUNMETAL RING TAPPED INTO CUDGEON  
TO KEEP LIQNUM VITAE IN PLACE.  
SUPPLIED BY STERN FRAME SUB CONTRACTOR

DETAIL OF HEEL PINTLE  
SCALE  $1\frac{1}{2} = 1$  FOOT.



RIVETS IN STERN POST  $1\frac{1}{8}$ " DIA<sup>R</sup> SPACED  $5\frac{5}{8}$ " APART CR. TO CR. HOLES  $3\frac{1}{16}$ "

RIVETS ABOVE COUNTER  $7\frac{7}{8}$ " DIA<sup>R</sup> SPACED  $4\frac{3}{8}$ " APART CR. TO CR. HOLES  $1\frac{1}{16}$ "

CENTRE OF SHAFT ABOVE  
BASE AT FRAME D = 8'-0"  
DROOP .25" PER FOOT

FRAMES SPACED 23 APART

THESE OFFSETS ARE FOR BOTTOM  
EDGE OF POST.

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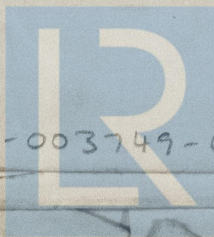
Ailsa Gos.

No. 370-1

Rudder (Stemframe)

Amended Plan  
of  
Rudder  
"Halcyon"

GLASGOW REPORT No. 41489.



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003742-003749-0158

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