

S. S. NO. 938.

425' 0" x 34' 6" x 32' 9"

STERNFRAME & RUDDER.

SCALE 1/2 INCH = FOOT.

INVOICED WEIGHT OF STERN FRAME = 303 CWTs. CAL^W WT. 298 CWTs.
 " " " RUDDER FRAME AND PLATE 357 CWTs.
 CALCULATED WT. OF RUDDER FRAME = 302 CWTs. WT. OF PLATE = 55 CWTs. TOTAL WT. 357 CWTs.
 STERNFRAME OF CAST STEEL

RUDDER STOCK AND POST OF NGOT STEEL

RUDDER ARMS AND PINTLE NUTS OF CAST STEEL

TESTS TO BE IN ACCORDANCE WITH SPECIFICATION

PARTICULARS OF SECTIONS WILL BE SUPPLIED BY SHIPBUILDERS.

FIGURES & NOTES IN BROWN
 TAKEN FROM STERN FRAME

DETAIL OF COUPLING
 SCALE 1/2 INS = 1 FOOT

KEYWAY 2 1/2" X 1 1/2" KEY CUT OUT
 OF BOTTOM PORTION OF COUPLING

6-3/4" BOLTS

GROOVE TO TAKE
 RUDDER PLATE

STERNFRAME TO BE DRILLED FOR 1/8" RIVETS
 SPACED 5 1/2" APART CENTRE TO CENTRE. HOLES TO BE RIMMED ON INSIDE TO ALLOW
 RIVETS TO BE TIGHTENED
 HOLES DRILLED IN WAY OF WEBS FOR 1" TAP
 RIVETS 1/2" DEEP
 SCARPH AND WEBS TO BE MACHINED PERFECTLY TRUE
 GUDGONS TO BE BORED OUT AND BUSHED AS SHOWN

SECTION TWO G.G.
 2 1/2" FORWARD OF A.P.

DETAIL OF WEBS
 SCALE 1/2 INS = 1 FOOT

2" HOLE
 ALL WEBS TO BE FOLLOWED OUT

FORWARD END OF CASTING - OUTSIDE VIEW

CASTING INCREASED 5/8" TO FLUSH
 WITH INSIDE OF SHELL PLATE

NOTES: RUDDER FORGINGS OR CASTINGS TO BE PROPERLY ANNEALED & TESTED IN PRESENCE OF BRITISH CORPORATION

SURVEYOR & ALL TO PASS BOARD OF TRADE REQUIREMENTS

B.S. TEST PIECES "C", "D" OR "E" AS APPROVED TO BE LEFT ON FORGINGS OR CASTINGS & CUT OFF IN PRESENCE OF BOARD OF TRADE SURVEYOR

THEY ARE TO PASS BOARD OF TRADE TESTS & ALSO SATISFY THE FOLLOWING CONDITIONS

ULTIMATE TENSILE STRENGTH: CASTINGS NOT LESS THAN 28 & NOT MORE THAN 35 TONS PER SQ. INCH

FORGINGS " " " 28 & " " " 32

ELONGATION: CASTINGS " " " 15%

FORGINGS " " " 25%

BENDING TESTS: CASTINGS ON BAR 1" SQUARE OVER RADIUS 1 1/2" ANGLE NOT LESS THAN 60° TO 90°

FORGINGS " " " 1" " " 1 1/2" FOR TENSILE STRENGTH OF 28 TO 32 TONS ANGLE NOT LESS THAN 180°

DETAIL OF UPPER GUDGONS
 AND PINTLE
 SCALE 1/2 INS = 1 FOOT

DROP TEST
 BEFORE THE RUDDER ARMS LEAVE THE
 MAKERS WORKS EACH ONE IS TO BE DROPPED
 TO THE GROUND FROM A HEIGHT APPROVED BY OWNERS
 IN THE PRESENCE OF AND TO THE SATISFACTION
 OF OWNERS REPRESENTATIVE

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Palmer

938

Stemfr. Kudder

Bag

Palmer S. & S. Co.

938

Stemfr. Kudder

melampus

24.3.24



No 2020

Lloyd's Register
Foundation

004257-004262-0148