

Rudder plates to be fitted by H.S.Lth. To be caulked & made watertight. Space between plates to be fitted with B.C. fir well seasoned, closely fitted and bedded in white lead.

RIVETING.

<u>PLATES TO CASTING</u>	<u>1/8" RIVETS</u>	<u>SPACED 4 1/2" DIA.</u>
<u>PLATES & STRAPS</u>	<u>1/8" "</u>	<u>" 4 1/2" "</u>

TAP RIVETS TO BE USED ON PORT SIDE OF RUDDER, AND
ORDINARY RIVETS WITH FULL HEAD & CON POINTS ON
STARBOARD SIDE WHEREVER PRACTICABLE.

SIDE PLATES & STRAPS TO BE RIVETED TOGETHER
BEFORE BEING PLACED IN POSITION ON CASTING.

1 1/2" TAP RIVETS ON PORT SIDE.
1 1/2" ORDINARY RIVETS ON STR. S.

SECTION AT N° 1 GUDGEON
Scale 1" = 1 Foot.

SECTION AT N° 2 GUDGEON

SECTION AT "BB."

SECTION AT CC.

SECTION AT "DD"

SECTION MT XX

DETAIL OF PINTLE & RUDDER STOP
AT N^o 1 GUDGEON.
SCALE 1 1/2" = 1 FOOT.

DETAIL OF RUDDER COUPLING
SCALE $1\frac{1}{2}'' = 1 \text{ FOOT}$

PATTERNS TO BE MADE FROM TEMPLATES, LIFTED FROM
MOULD LEFT FLOOR AT THE VARIOUS SECTIONS.

TO BE MACHINED TO DIMENSIONS GIVEN ON PLAN.
FINISHED COMPLETE BY MAKERS.

INSIDE TO RECEIVE TWO COATS OF RED LEAD BEFORE CLOSING UP

EXTRACTS FROM GOVT SPECIFICATION

TESTS FOR STEEL CASTINGS:

1. THE MATERIAL TO HAVE A TENSILE BREAKING STRENGTH BETWEEN THE LIMITS OF 20 TO 35 TONS PER SQUARE INCH OF SECTION IN THE STAMPEDED TEST PIECE WITH AN ELONGATION OF NOT LESS THAN 20 PER CENT.
2. THE MATERIAL TO BE SUBJECTED TO A STRENGTH OF 1.5 TIMES THE TENSILE BREAKING STRENGTH OF THE PIECE OR IN A PIECE, WHICH OF THE BREAKAGE AND THE FORCE NOT BE BEARING OF IT THROUGH AN HOLE OF 1/20 DIAMETER.
3. EACH CASTING TO BE SUBJECTED TO A WEIGHT OF ABOUT 5 POUNDS, OR TO A SIMILAR WEIGHT, AND ALLOWED TO FALL ON HARD GROUND. THE CASTING TO REMAIN ON THE GROUND WITHOUT BEING CRACKED.
4. AFTER THE "RAVE" TEST, THE CASTING TO BE SUBJECTED TO THE "WARM" HARDENING TEST IN ORDER TO PROVE STRENGTH.

TESTS FOR STEEL RIVETINGS:

STEEL FURNISHING TO BE MADE FIRST OPEN HEARTH STEEL, DECARBIZED SOUND, CLEAN & FREE FROM BLOWN, AND TO STAND THE FOLLOWING TESTS:

1. STRIPS CUT LENGTHWISE 2 IN. BY 1/4 IN. THICK THIN SLICES OF 28 TO 29 PS PER SQ. IN. OF SECTION, WITH AN ELONGATION OF 28 TO 29 PS PER CIRC.

2. BEND TESTS MAY TO BE MADE WITH BARS 1 1/4 IN. SECTION, TEST BARS SHOULD BE CAPABLE OF BENDING BOTH WITHOUT FRACTURE THROUGH AN ARC OF 180 DEGREES, AND A REMAIN OF NOT MORE THAN 1/16"

JUMPED WELDS ARE NOT TO BE USED ON IMPORTANT RIVETINGS.

FURNISHING TO BE TESTED BY STRESS & RISE PROVED.

RUDDER AREA ABAFT C. OF PINTLES = 100.6 Sq. Ft.

W.B.

APPROVED

DEC 24 1928

LLOYD'S REGISTER OF SHIPS
NEW YORK

SURVEYORS COPY

RUDDER PLAN

HALIFAX SHIPYARDS LIMITED

SCALE $\frac{1}{2}'' = 1'$ & $\frac{1}{2}'' = 100'$

DRAWN BY J.D.F. © 2020
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100% Satisfaction Guarantee
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