

SHIP NOS. 387 - 388.

RUDDER PLAN.

SCALE: $\frac{1}{2}$ " = 1' 0".
FORGING - STEEL.

TO PASS BRITISH CORPORATION NO 387
LLOYDS NO 388
MAKERS WORKS. ARMS TO BE SHUNK ON & KEVED.

LLOYDS
Service Speed = 11 1/2 knots
Area of Rudder = 201.50 sq ft
CofG 484ft & PINTLES = 5.95 ft
Ax D = 201 x 5.58 = 1171
Rudder Head = 14.45' x 14.45' (10%
TANKER'S ICE)
= 15 1/2' Dia + OWNERS EXTRA
= 16 1/2' Dia

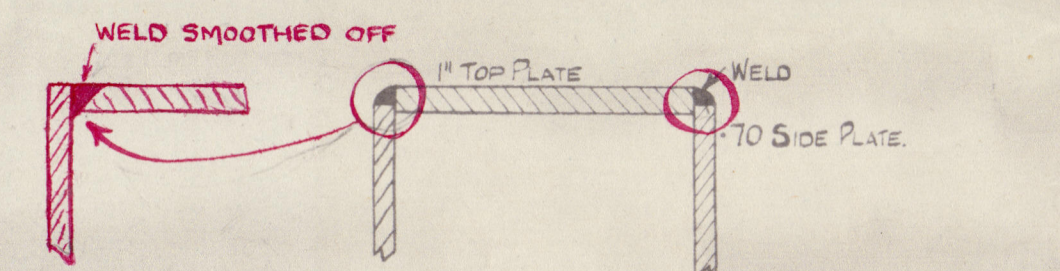
BRITISH CORPORATION
S = 20 1/2' x 4' x 11' 1/2'
= 5.4' Dia + 10% TANKER & ICE STIFF
= 14.85' Dia + 10% AREA (OWNERS EXTRA)
= 15 3/4' Dia STOCK BY RULE.
= 16 1/2' Dia STOCK ACTUAL.

Handwritten:
25.5 x 12.16 = 310.16
25.5 x 11.7 = 298.35
12.5" dia min Rule.
16 1/2" dia A = 212.5 sq ft
212.5 / 10.61 = 20.02
14.5' = 22' = 15.2
1228 = 15.2 x 81
2250 Rudder.

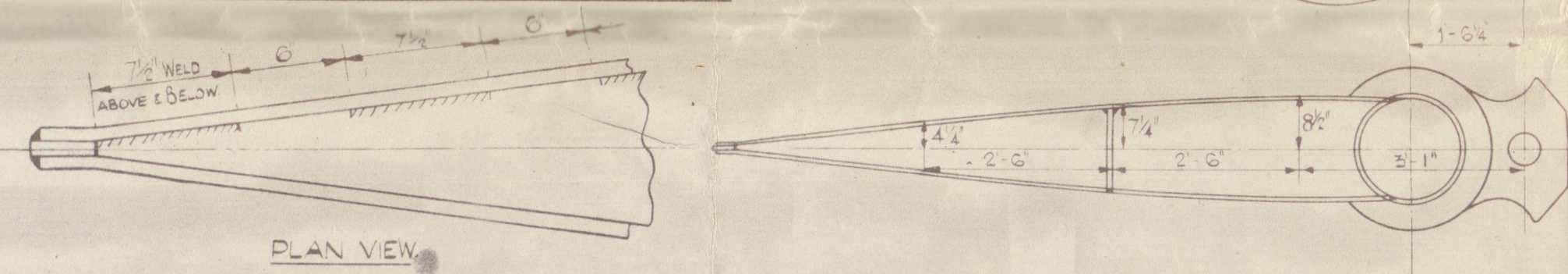
RUDDER & SCANTLING OF RUDDER ARE ON BASIS OF 10% DIA STOCK.
STEERING EQUIPMENT TO SUIT 15 3/4' DIA RUDDER HEAD.

RUDDER HEAD RUDDER POST TO BE COUPLED TOGETHER BY 0-4 1/2" DIA FITTED BOLTS.
PORTABLE STEEL PINTLES OF TURNED STEEL, TAPERED IN RUDDER ARMS.
SCREWED UP TIGHT BY NUTS & SPLIT PINS, ALL SUPPLIED BY MAKERS.
CAPE TO BE TAKEN THAT CENTRES OF PINTLES ARE IN LINE, SO THAT THE RUDDER WILL BE A
GOOD RIGGING FIT ALSO TO BE SQUARE TO BASE LINE OF SHIP.
COUPLING MACHINED & TO BE A GOOD FIT.
RUDDER PLATES SUPPLIED & FITTED BY SHIPBUILDERS.
EXACT SPACING OF RUDDER ARMS & GAUGE FOR TURNING PINTLES WILL BE SENT LATER.
POINT GAUGE TO BE SUPPLIED TO SHIPBUILDERS OF RUDDER HEAD AFTER MACHINING.
ALL MACHINING & DRAWING TO BE DONE BY MAKERS.
FORGING MAKERS TO ADVANCE FOR ANY NECESSARY ADJUSTMENT BEFORE DISPATCHING.
ANY ALTERATION TO BE NOTIFIED TO THE LLOYDS SHIPBUILDING CO. LTD.
WRITTEN DIMENSIONS ONLY TO BE TAKEN.
DIMENSIONS SHOULD BE CAREFULLY WORKED TO AS WE ONLY PAY ON WEIGHTS
CALCULATED TO THREE DIMENSIONS.

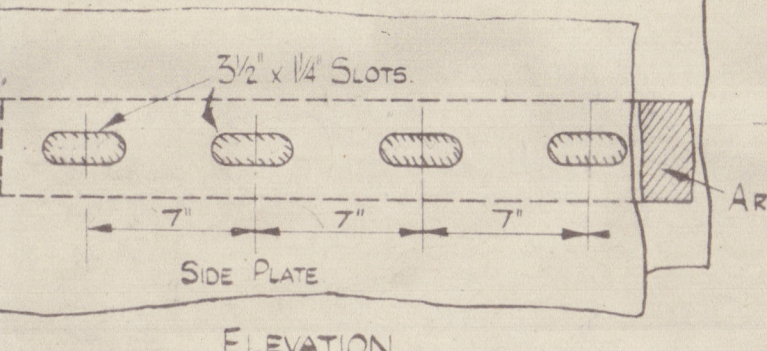
WELDING OF SIDE PLATES TO TOP PLATE.



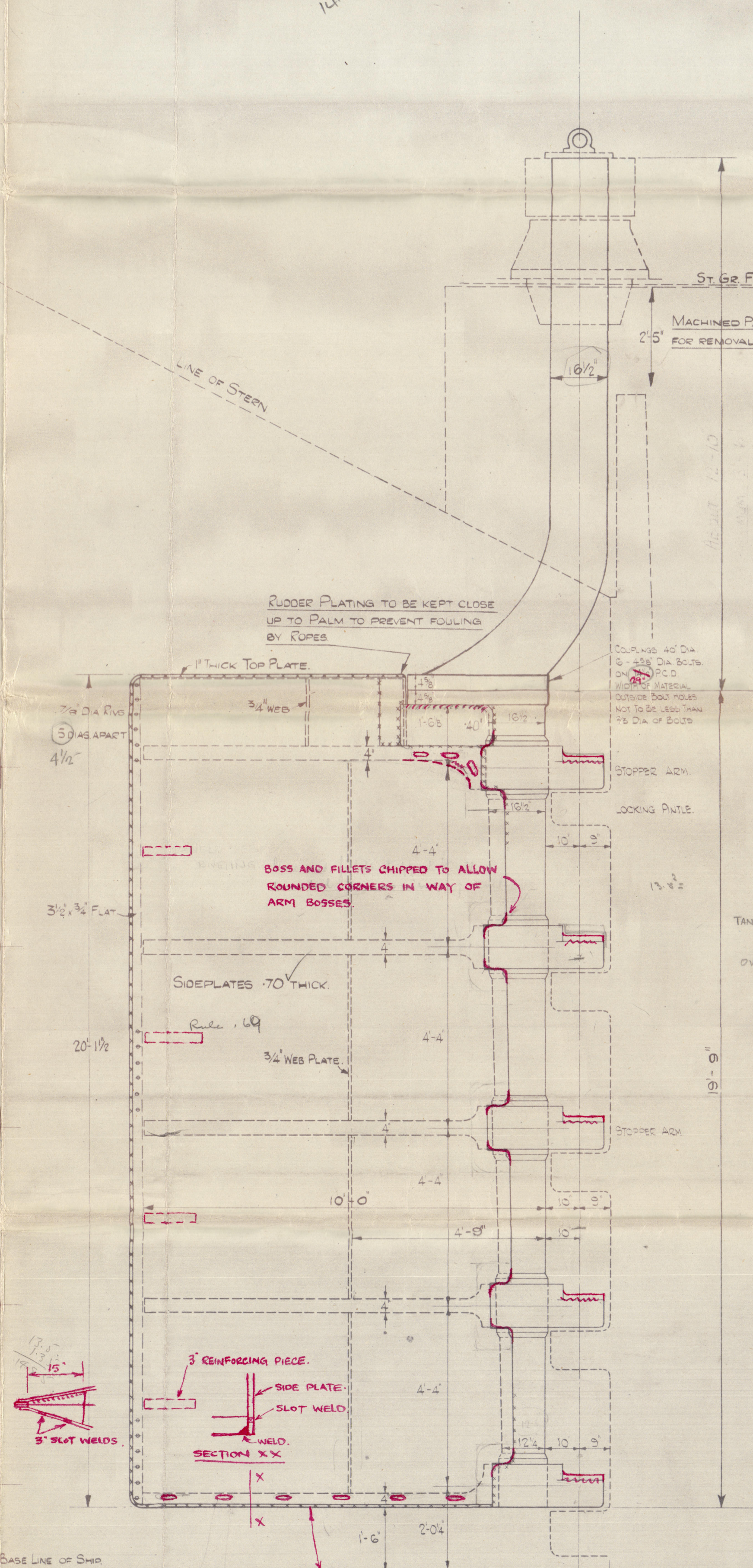
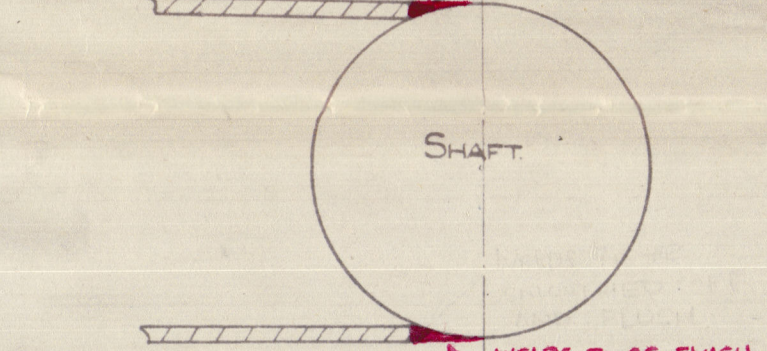
WELDING OF SIDE PLATES TO ARMS.



WELDING OF SIDE PLATES TO SHAFT.

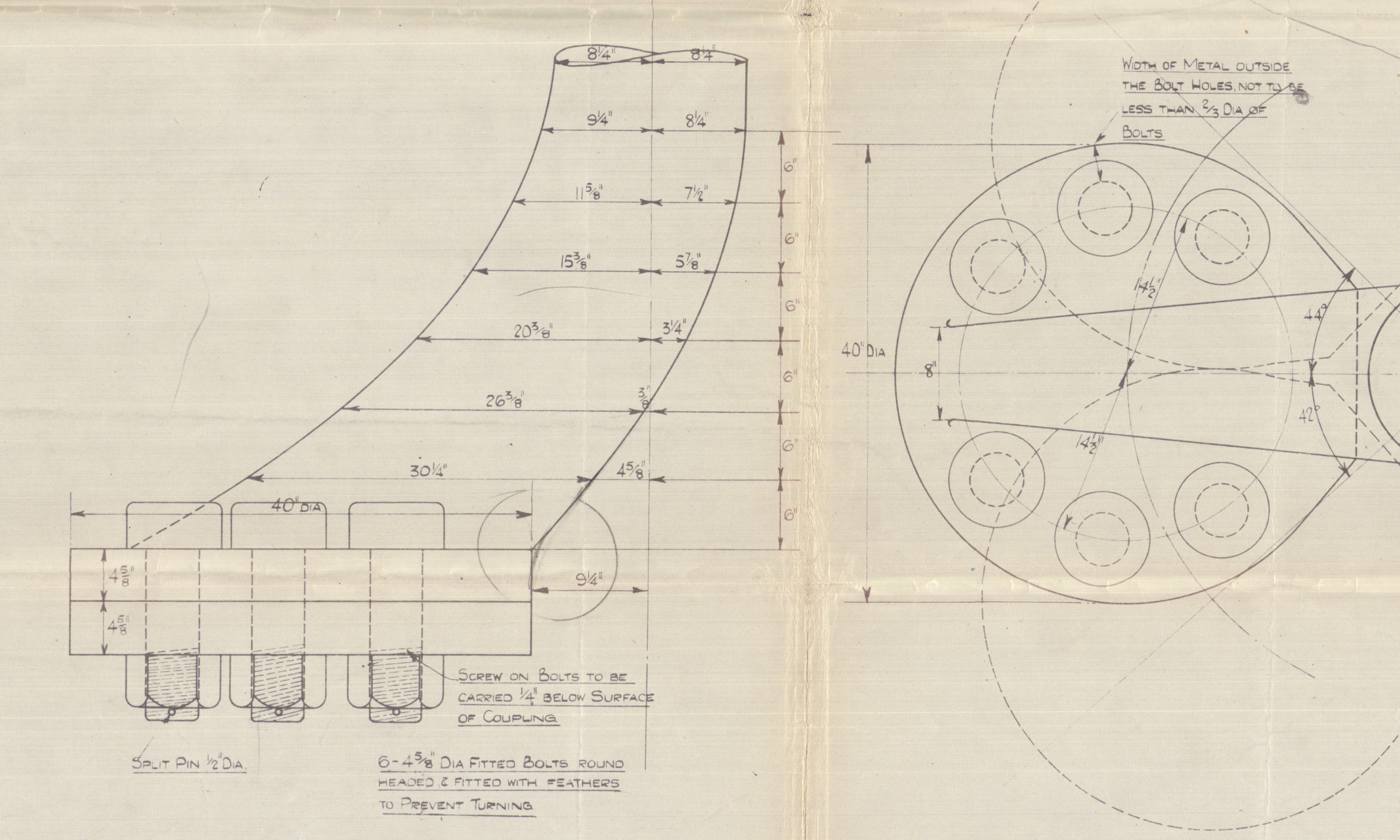
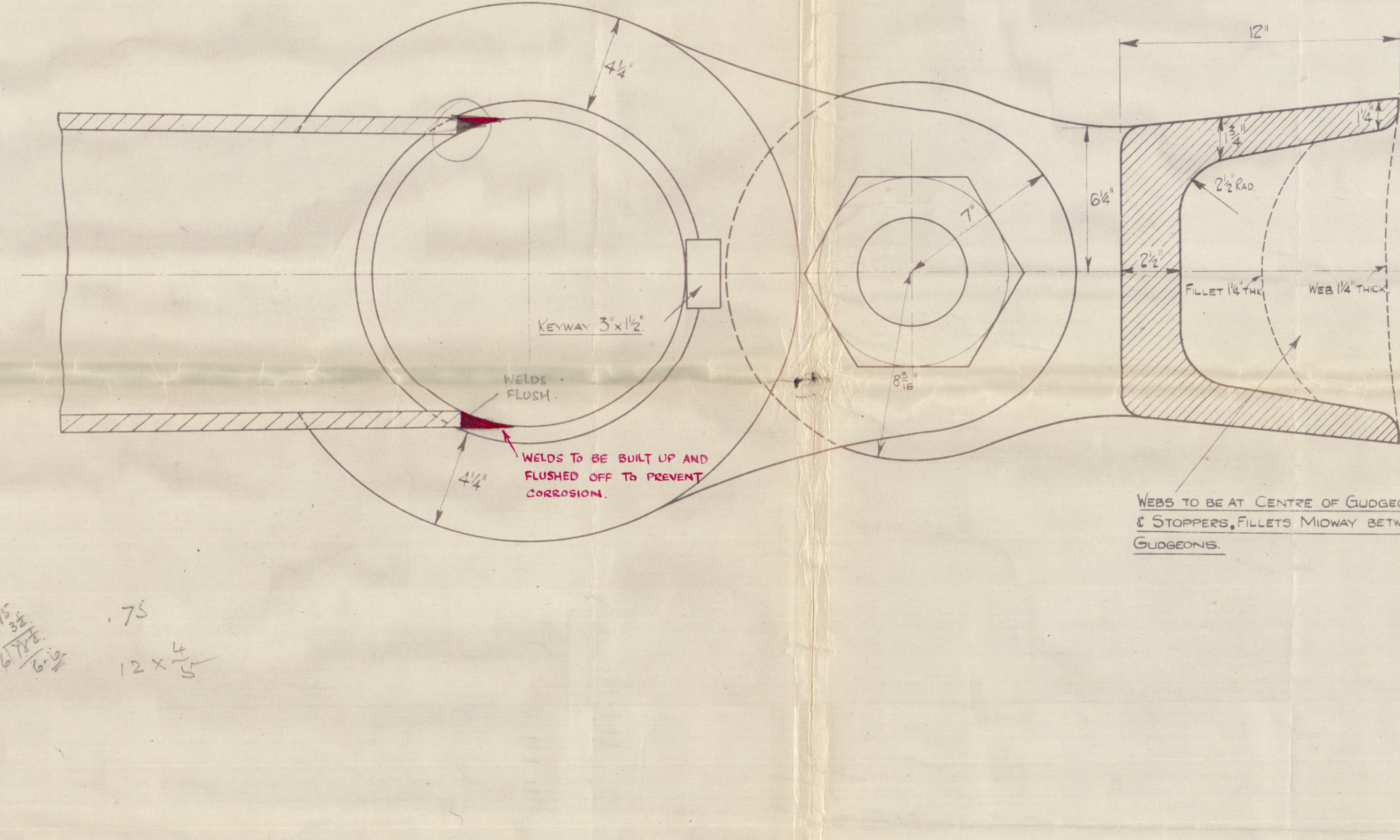
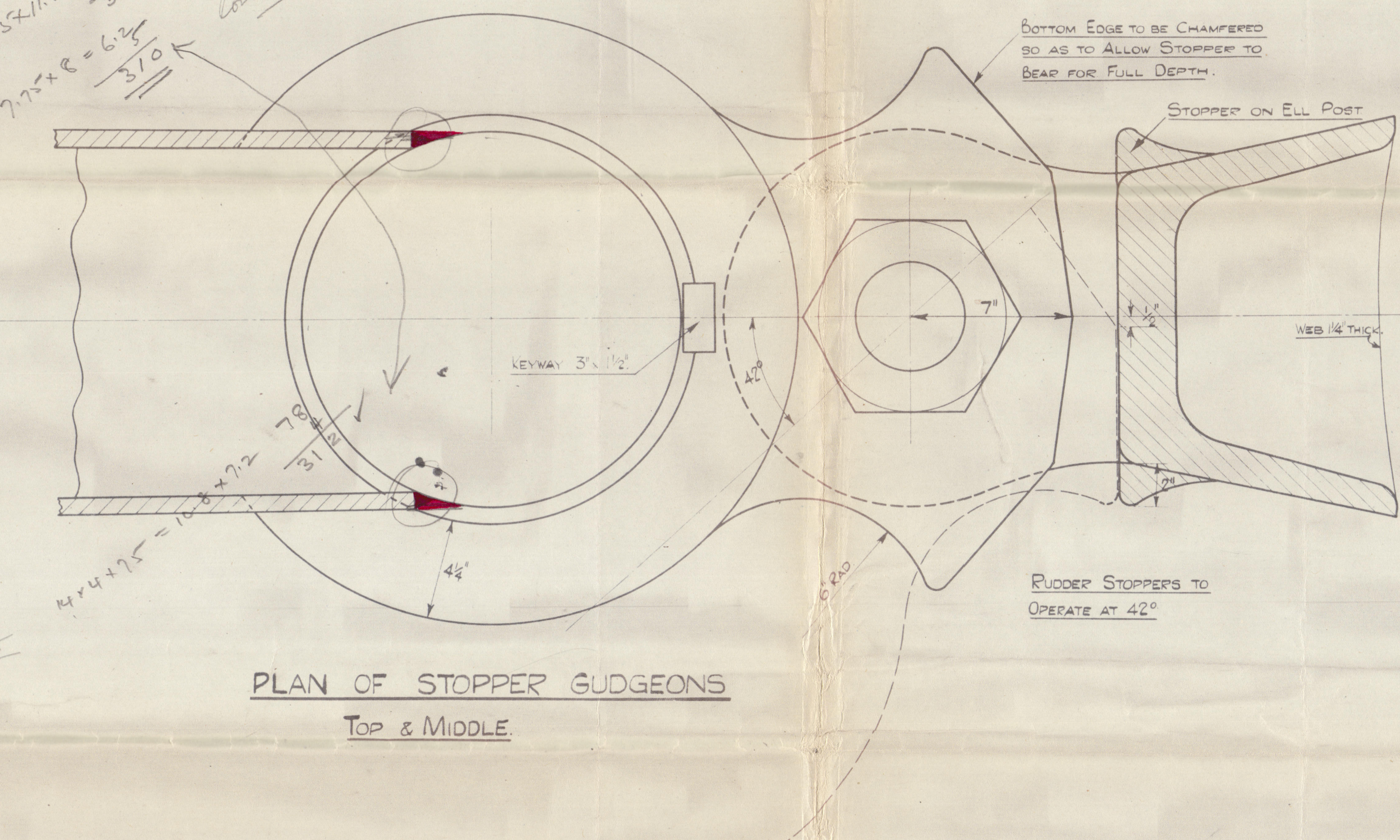
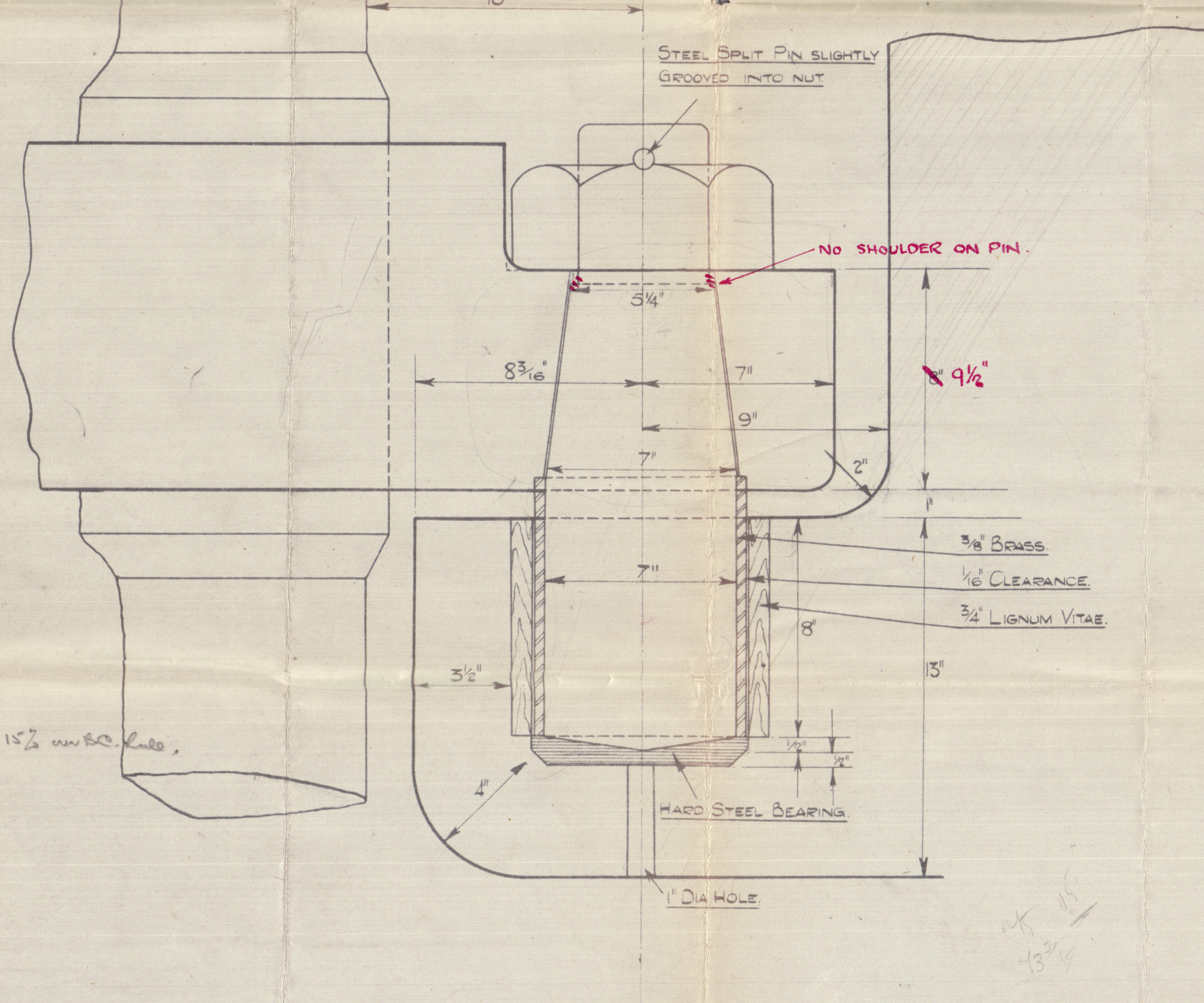
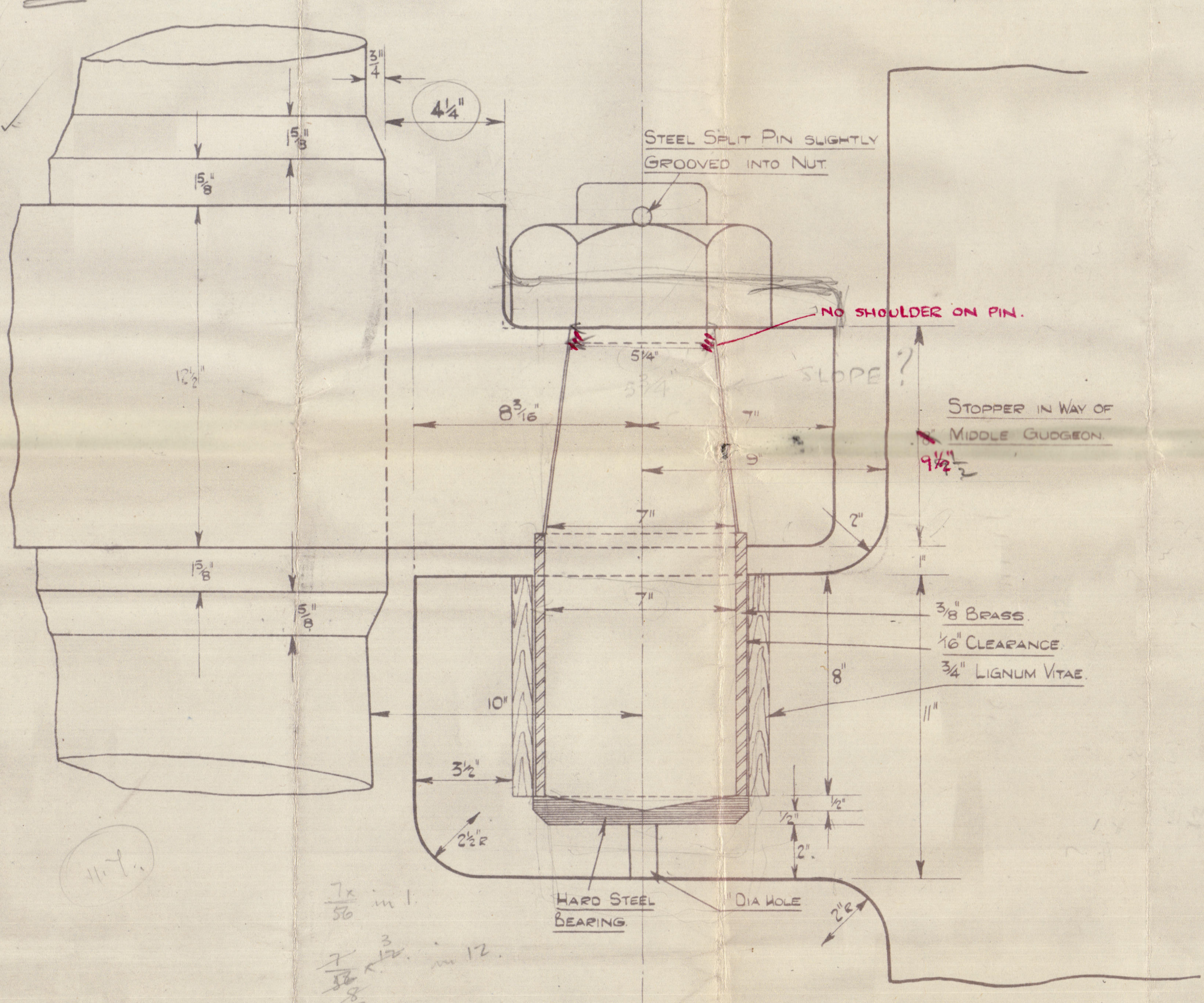
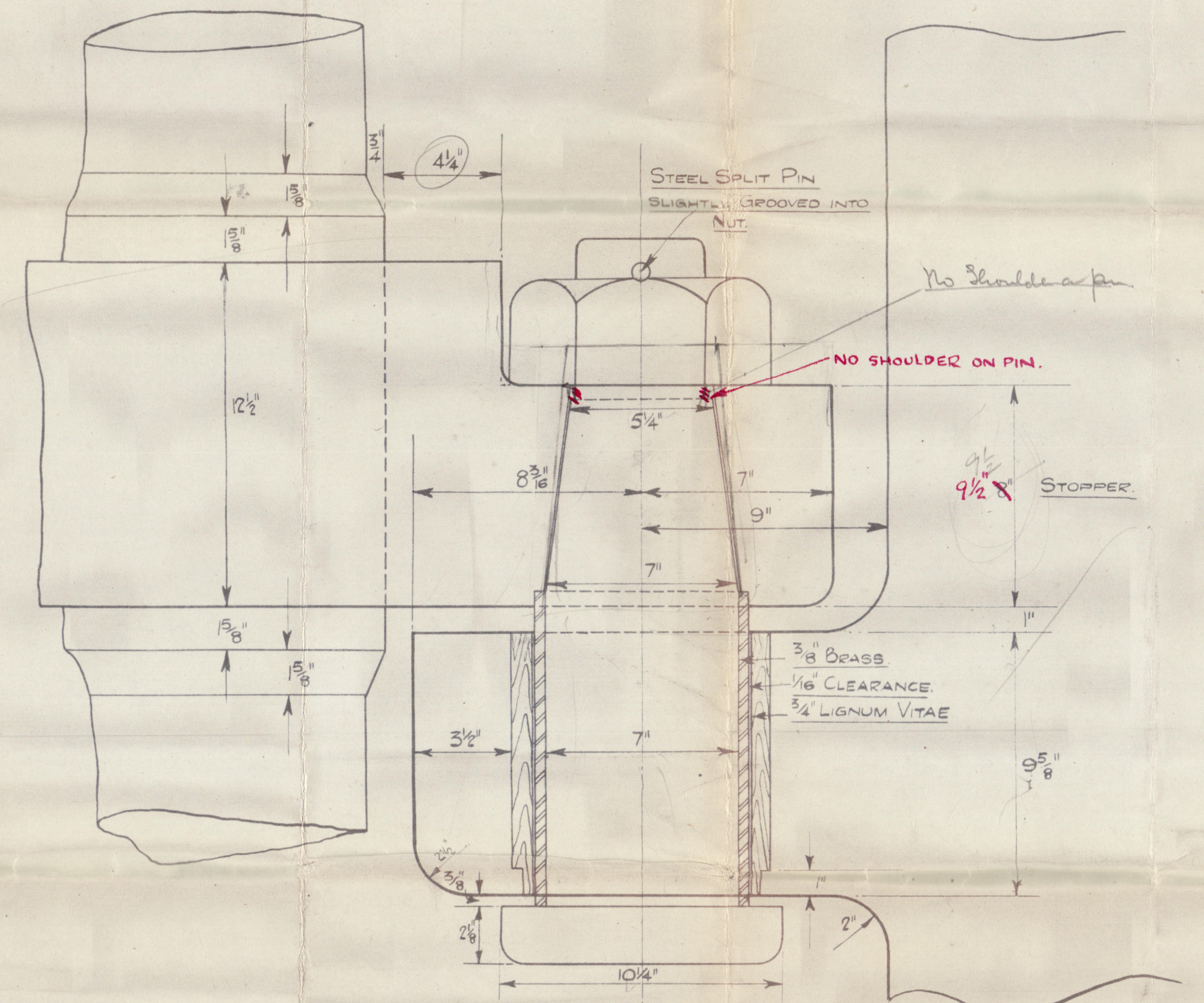
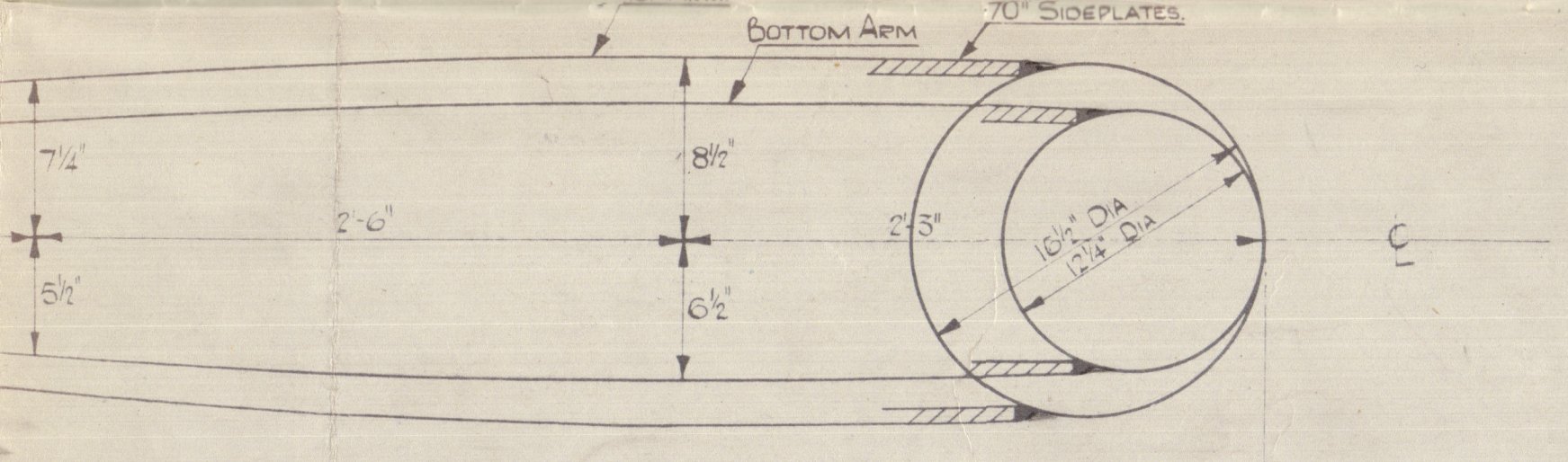


WELDING OF SIDE PLATES TO SHAFT.



RUDDER OFFSETS.

SCALE: $\frac{1}{16}$ " = 1' 0".



2 SEP 1944

Approved (by 604)
6.9.44
[Signature]

TN 6901

20

Rudder

Gurness & Co.

No. 387.

6.9.44.

SOUTHERN VENTURER

Bag

2 SEP 1944

Gurness 387

Rudder

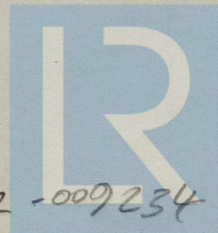
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