

TO PASS LLOYDS SURVEY & TESTS

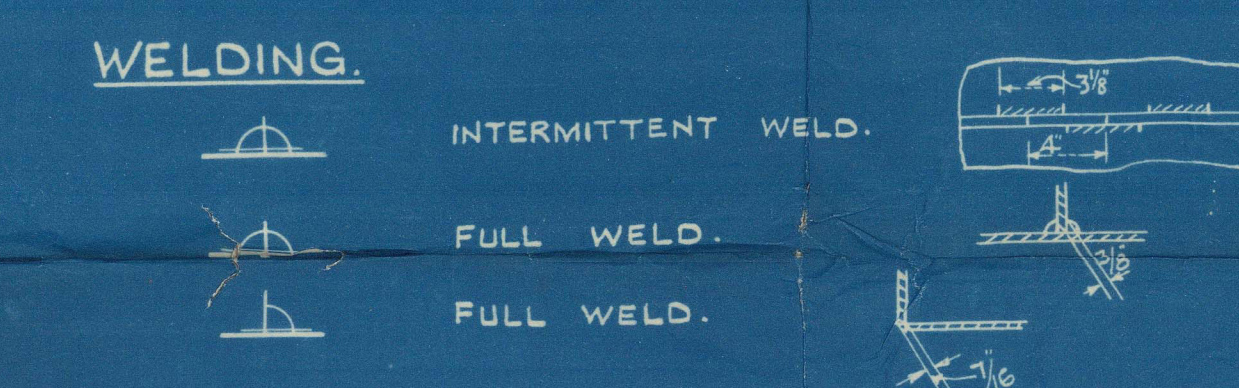
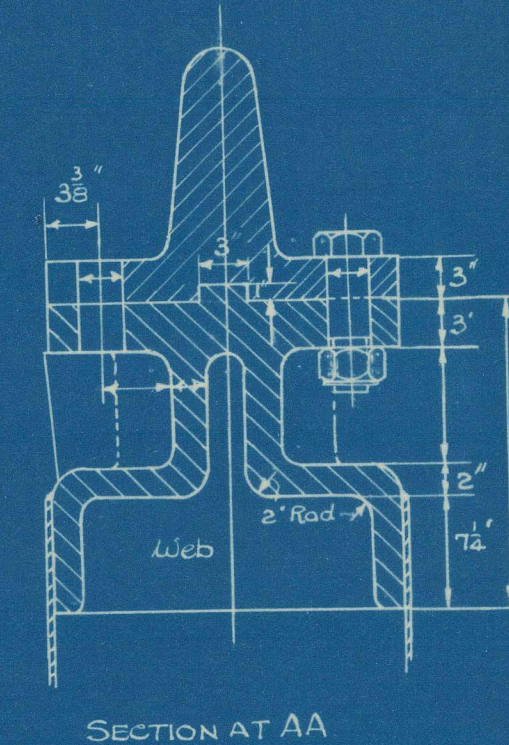
STERN FRAME OF CAST STEEL
RUDDER STOCK OF FORGED STEEL
RUDDER MAIN PIECE OF " "

AREA ABAFT C/LINE OF PINTLES = 123'4 3/4"
 " FORD " " " " = 53'2 "
 SPEED IN KNOTS = 11 KNOTS
 RULE DIA OF STOCK + 10% FOR TANKERS = 10 3/4"
 FOR MINISTRY OF SHIPPING = 12" DIA

Spacing of rivet holes not to exceed that shown on plan.
Rivet holes to be drilled $1/32"$ larger than diameter shown on plan.
Form of Gasing to be carefully checked before leaving the makers works.
Rivets to be made of Silemfrim where shipped to be supplied later.
All drilling and machining to be done by makers and the stern boss frame to be bored to rough bore dia.
Coupling Bolts to have standard Whitworth Threads.
Dimensions on Plan should be carefully worked to as the only Pay on weights calculated to these dimensions.

RUDDER FRAME

All bronze and Lignum Vitae bushes to be supplied by the makers.
Ratchet Stock to be turned to Gauge and Keyways for Tiller etc to be accurately cut to dimensions which will be supplied later.
Length of Wooden Stock to be confirmed.
Spacing of River Holes not to be confirmed but on plan.
Holes drilled 7/8" Dia in 1" diameter.
Hard steel Bearing Ring for lower bearing to be supplied by the makers.
The casting leading should be carefully carried out to the surveyors satisfaction.
Side and End Palleting to be supplied by the shipbuilders and the Ratchet assemblies by the shipbuilders yard.
Excesses on Plan should be carefully worked to as we only pay on weights calculated to these dimensions.



WELDING.

UPPER BEARING RING
HARD STEEL

LOWER BEARING RING
HARD STEEL

Lloyds
Wm
S. H. & W. R. 1686 &
1604 (29)

Stem Frame &
Rudder.

Ennerdale,
NEWCASTLE ON TYNE.

Report No. 99657.

~~Isle of Wight to Luminous~~

~~Isle of Wight~~



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