

7 JUN 1938

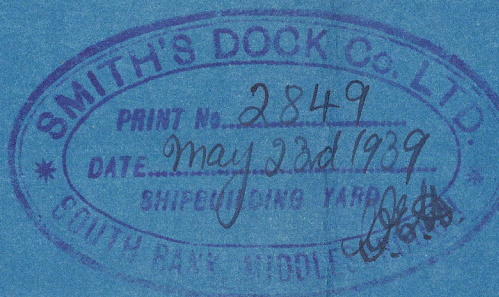
SHIP NO. 1066

Approved for Rudder only.

BALANCED RUDDER & STERN FRAME.

SCALE $\frac{1}{2}" = 1 \text{ FOOT.}$

TO LLOYD'S REQUIREMENTS.



RUDDER AREA 98 SQ. FT.

SPEED 13 KNOTS.

RUDDER STOCK $\frac{7}{8}"$ DIA.

BALANCE :- AREA ABAFT $\frac{1}{2}$ OF STOCK = 73.5
 AREA FORWARD " " = 24.5
 TOTAL 98.0

RUDDER STOCK FORGED IRON OR STEEL.

TOP & BOTTOM ARMS OF RUDDER OF ROLLED

MILD STEEL INGOTS OF SUITABLE ANALYSIS FOR ELECTRIC WELDING.

STERN FRAME BOSS OF FORGED STEEL OR CAST STEEL

VERTICAL COUPLING, STERN FRAME TRANSOME PIECE AND STERN

FRAME FOOT TO BE GAS CUT FROM MILD STEEL INGOTS.

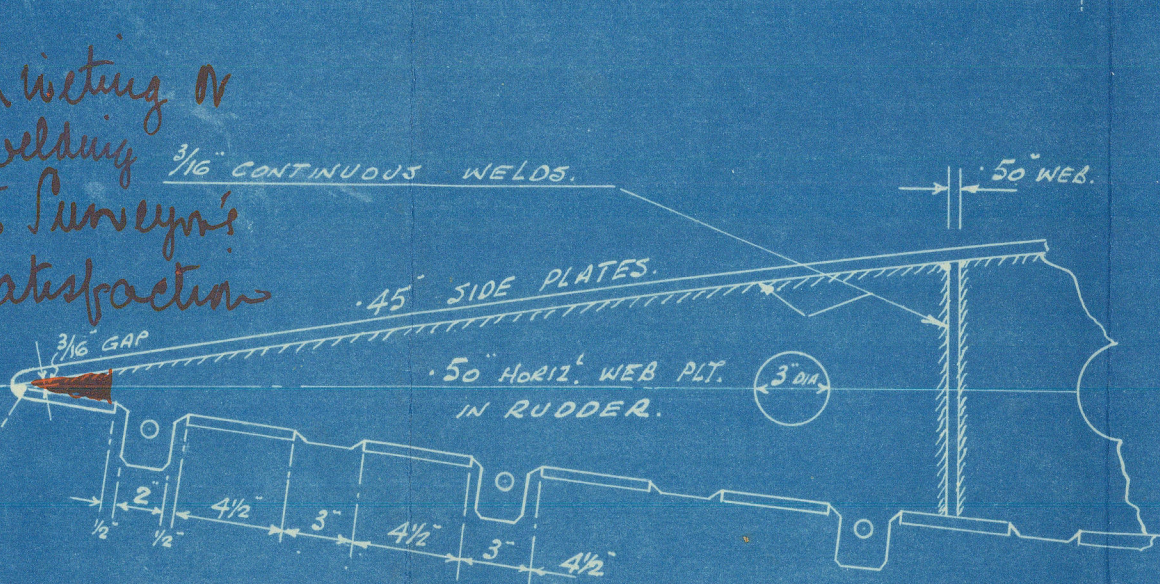
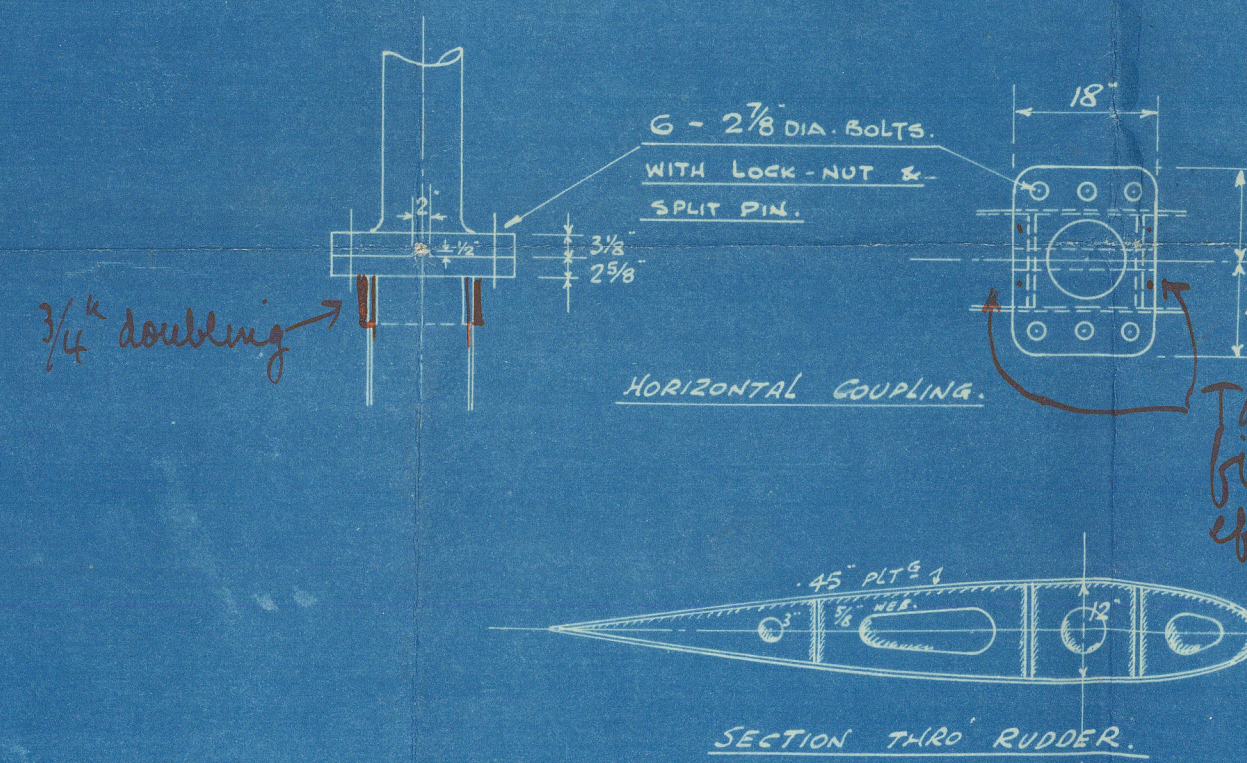
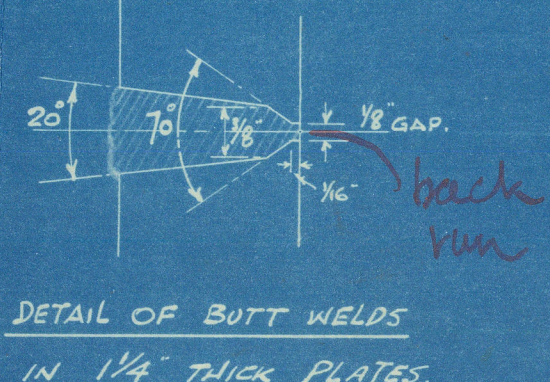
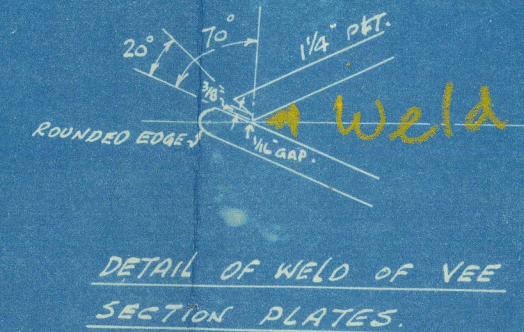
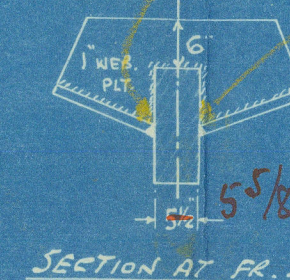
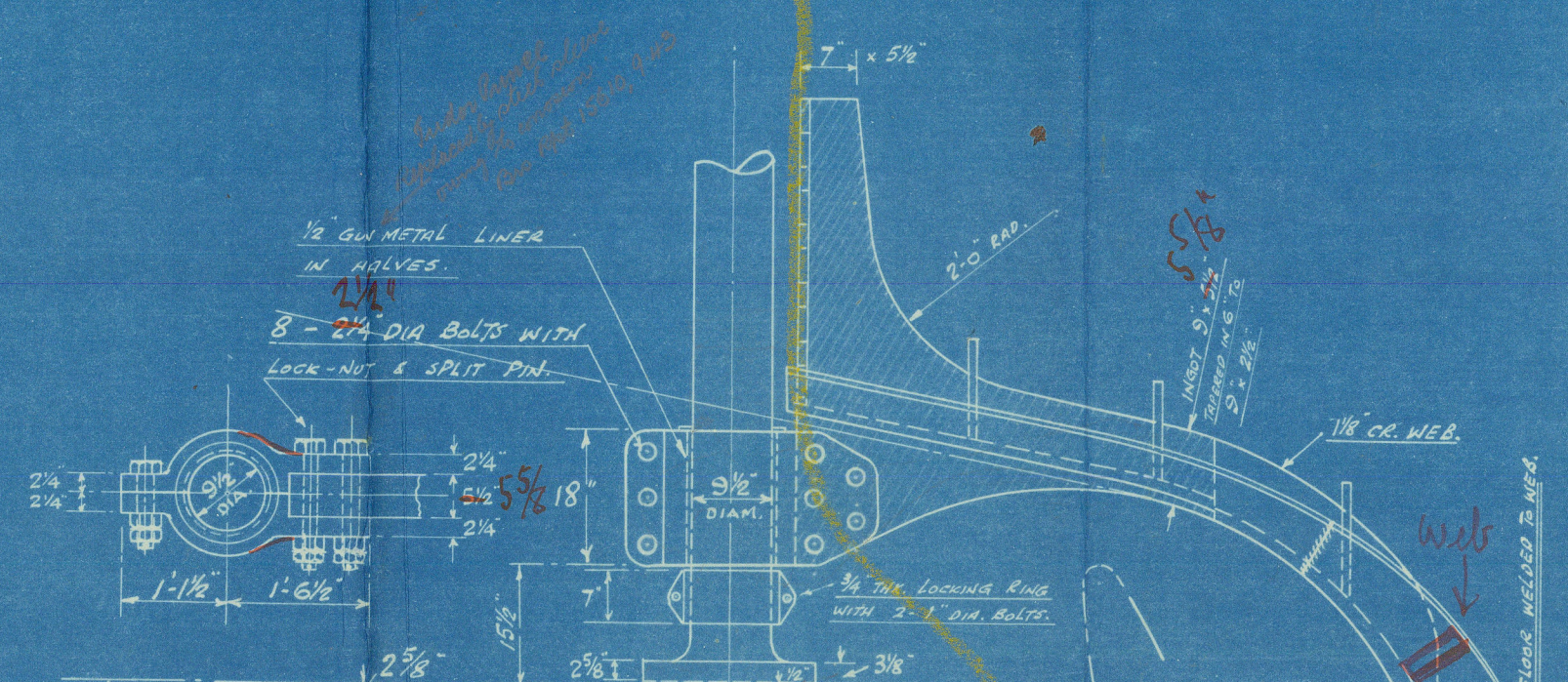
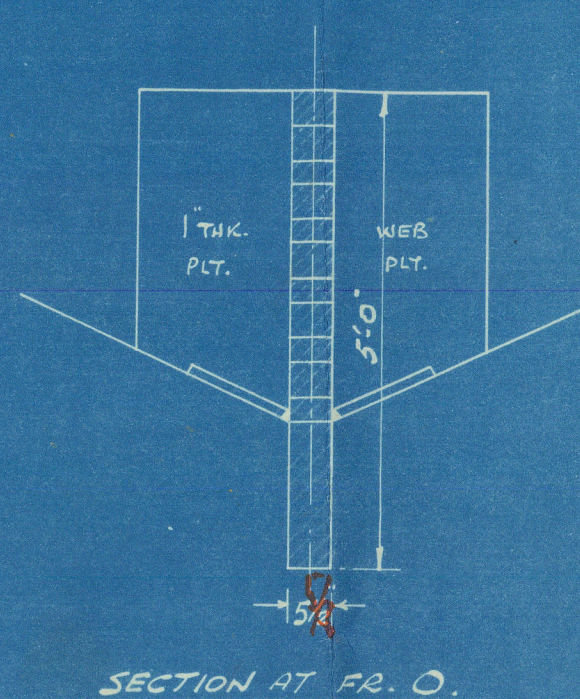
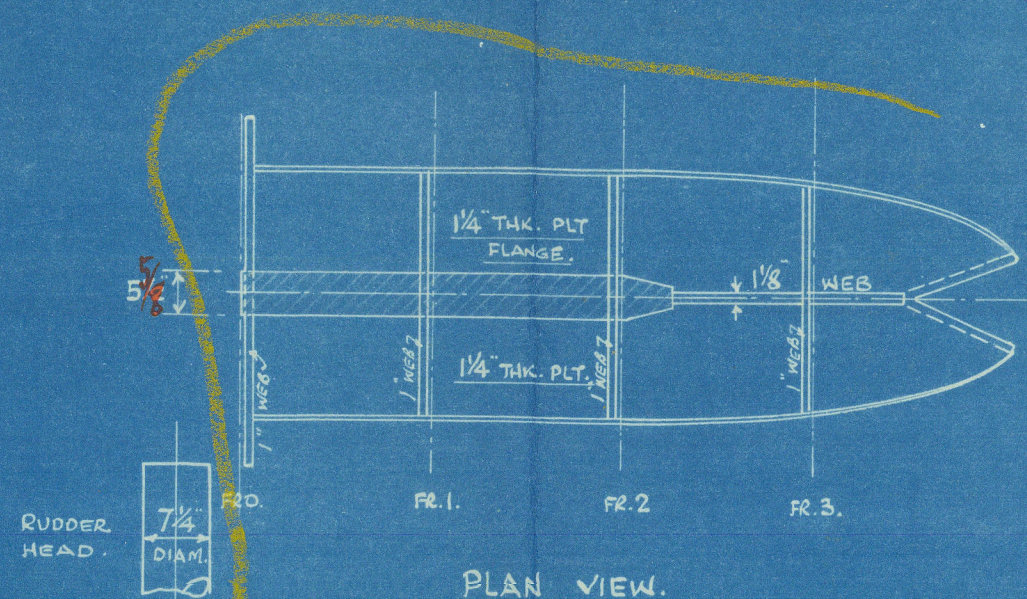
STEEL TO BE SUITABLE FOR ELECTRIC WELDING.

CARBON CONTENT NOT TO EXCEED 0.2%

MANGANESE " " " 0.6%

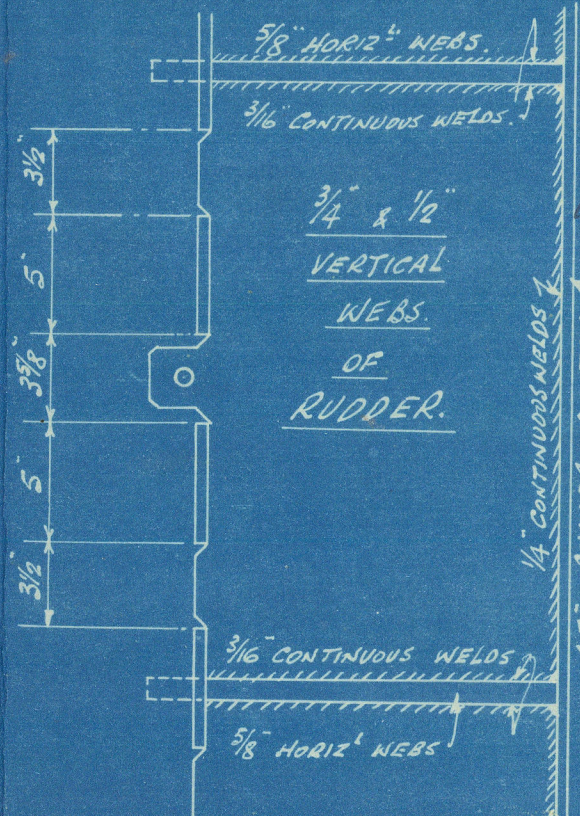
ELECTRODES PROPOSED:-

FLEETWELD, IRONEX, FASTEX, MUREX OVERHEAD, INVICTA, SHIELDWAY, TRANSWELD.

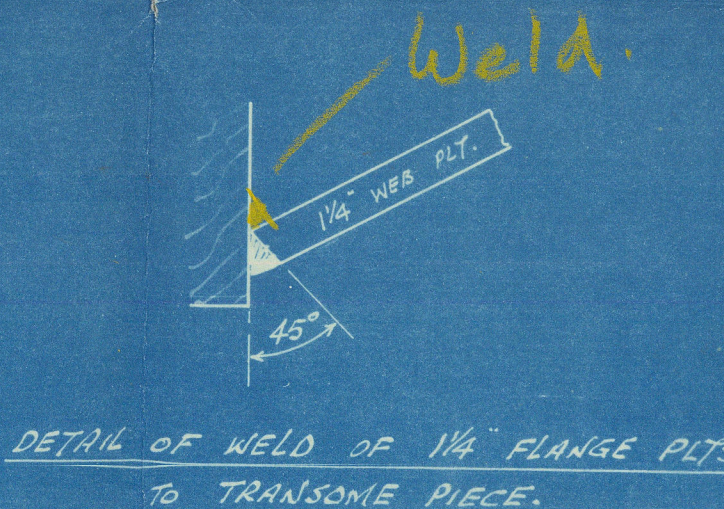
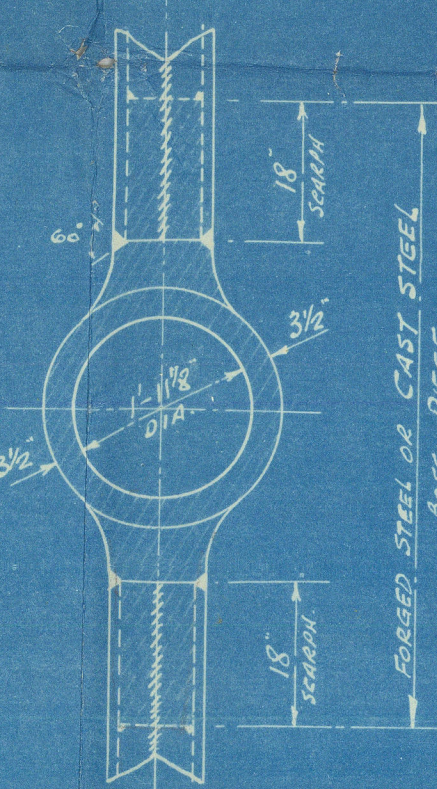
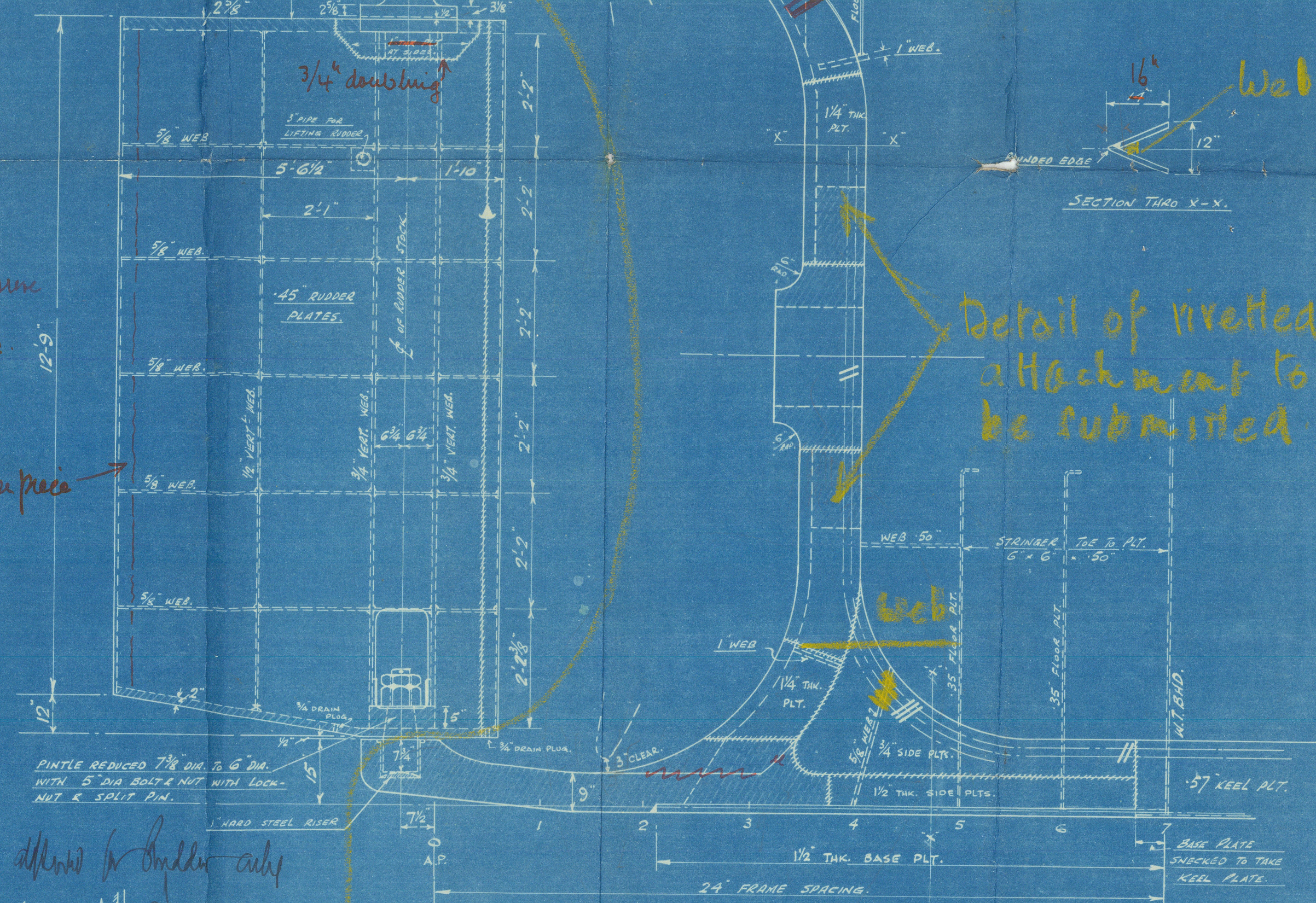


ARRG^t OF SLOT WELDS IN HORIZONTAL WEBS.

RUDDER WELDED TO-GETHER COMPLETE, WITH THE EXCEPTION OF ONE SIDE PLATE WHICH WILL BE FITTED AS PER DETAILS SHOWN FOR SLOT WELDS.
 $\frac{3}{4}"$ HOLES PUNCHED IN TABS OF WEBS TO ACCOMMODATE A DRIFT PUNCH FOR FORCING RUDDER PLATE INTO FAYING CONTACT WITH WEBS, PRIOR TO WELDING SLOTS.
 TABS CUT OFF & BURPED ON COMPLETION.



ARRG^t OF SLOT WELDS IN VERTICAL WEBS.




For Stern frame
 See letter

Messrs. Smiths Dock Co. Ltd.,

Yard No. 1066

Stem frame and Rudder

1066 S.S. "NORMAN PRINCE" 
MDB. RPT. No. 16835

1067 S.S. "LANCASTRIAN PRINCE"
MDB. RPT. No. 16850

1068 S.S. "TUDOR PRINCE"
MDB. RPT. No. 16852

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1069 S.S.
MDB. RPT. No.

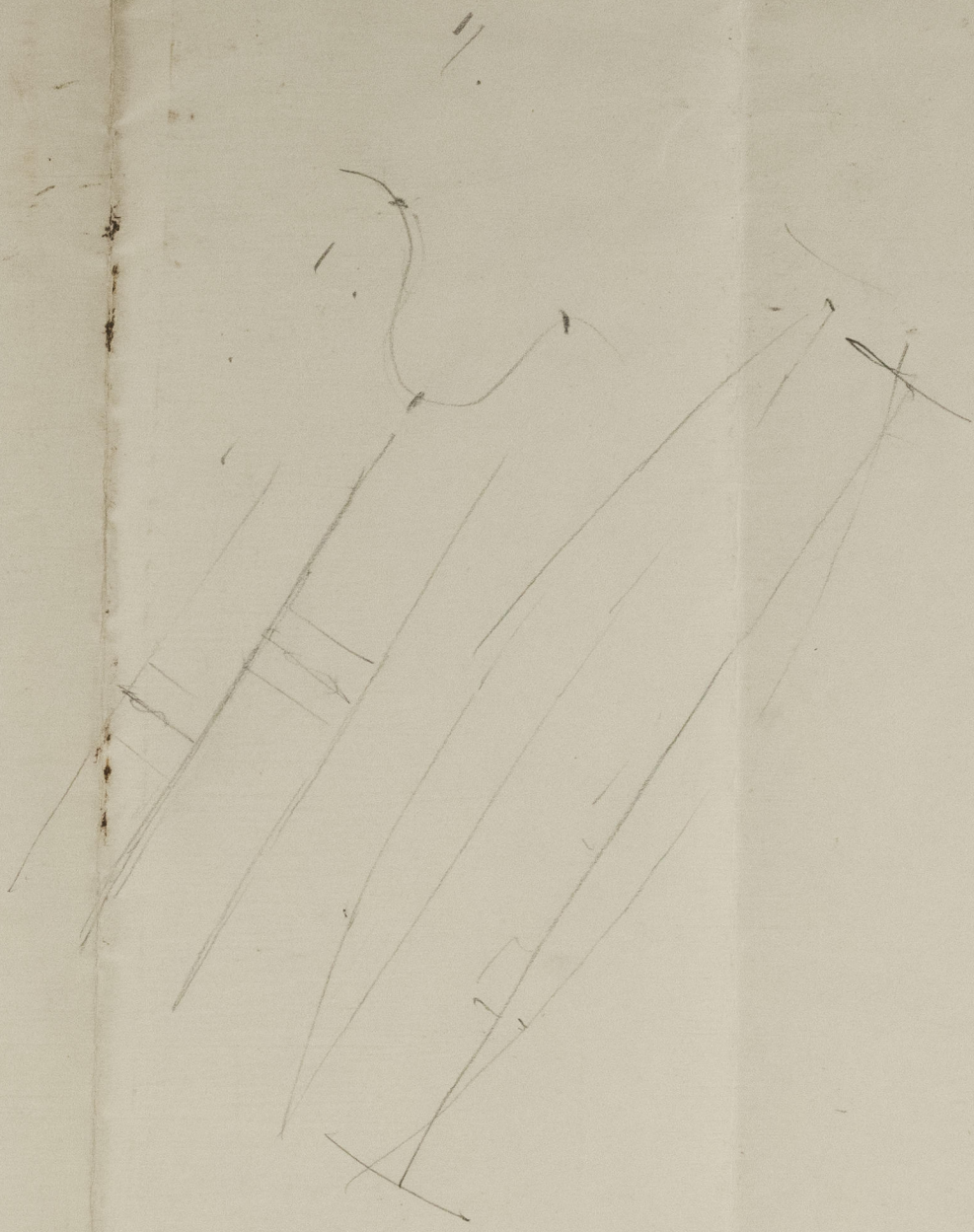
PLANS TRANSFERRED
TO SISTER VESSEL

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