

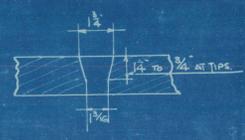
SECRET AND CONFIDENTIAL.

N^{OS} 1032-1034.
RUDDER FRAME.

SCALE 1/2" = 1 FOOT.

NOTES
 RUDDER FRAME IN 2 PIECES WITH COUPLING AS SHOWN.
 STOCK + MAINPIECE TO BE FORGED IN HOT STEEL PREFERRED BY ADMIRALTY WITH ARMS SHRUNK ON AND KEVED TO MAINPIECE.
 LOOSE STEEL PINTLES TO BE AS SHOWN IN DETAIL.
 RIVET HOLES 1 1/8 DIA FOR 1 1/2 RIVETS SPACED AS SHOWN AND COUNTERSUNK AS PER DETAIL.
 CENTRE LINE OF PINTLES + STOCK TO BE IN A PERFECTLY STRAIGHT LINE AND SQUARE TO BASE LINE.
 FREE SIDE OF MAINPIECE TO BE PARALLEL TO CENTRE LINE OF PINTLES.
 KEYWAYS FOR CROSSHEAD + TILDER TO BE ACCURATELY CUT TO DIMENSIONS GIVEN LATER.
 LENGTH OF STOCK TO BE CONFIRMED LATER.
 SPRING OF GUDGEONS TO BE CONFIRMED FROM STERN FRAME.
 ALL MACHINING AND DRILLING TO BE DONE BY MAKERS.
 RUDDER PLATE SUPPLIED AND FITTED BY S.H. + W.R. LTD.
 THE DIMENSIONS GIVEN ON THIS PLAN SHOULD BE CAREFULLY WORKED UP AS WE ONLY PAY ON CALCULATED WEIGHTS.
 ANY ALTERATIONS MADE TO BE NOTIFIED TO S.H. + W.R. LTD.
 FRAME TO LLOYDS SURVEY + TESTS
 FORGING NOT TO BE BLACKED BUT MAY RECEIVE A COAT OF OIL.

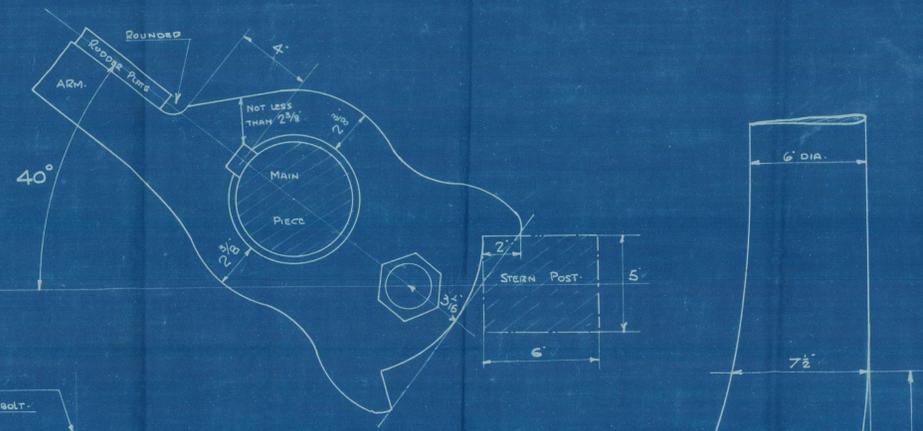
COUNTERSINKING OF RIVET HOLES



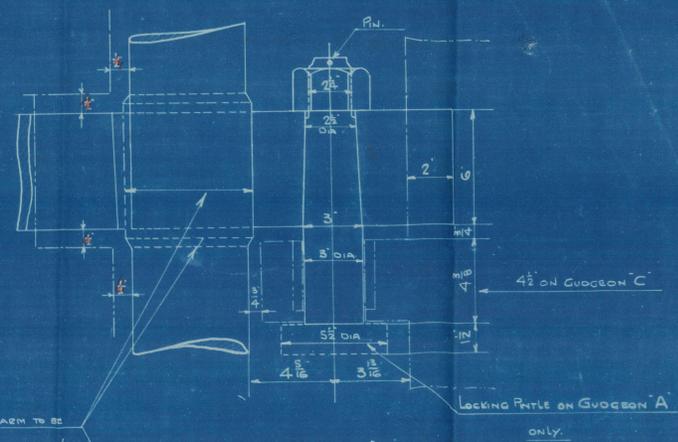
RIVET HOLES 1 1/8 DIA FOR 1 1/2 RIVETS SPACED 5" APART C TO C.

THE RUDDER HEAD + ALL GEAR IN CONNECTION WITH THE STEERING ARRANGEMENTS, INCLUDING STEERING CHAINS, RODS, ETC TO BE DESIGNED FOR A SPEED OF NOT LESS THAN 12 KNOTS, WHEN BEING TOWED.

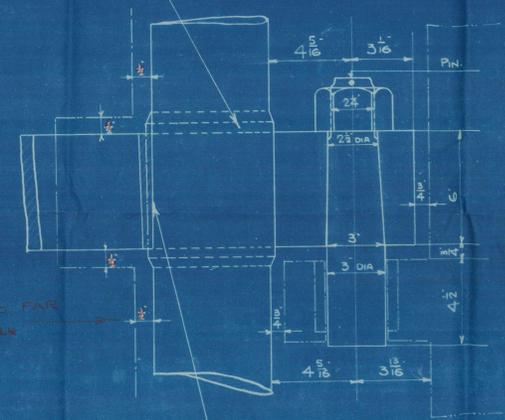
DETAIL OF STOPPER AT A + C
 SCALE 3" = 1 FOOT.



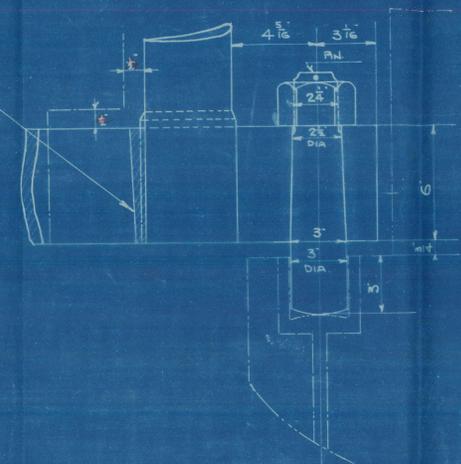
DETAIL OF GUDGEON A + C
 SCALE 3" = 1 FOOT.



DETAIL OF GUDGEON B
 SCALE 3" = 1 FOOT.



DETAIL OF GUDGEON D
 SCALE 3" = 1 FOOT.

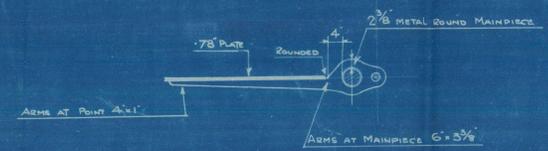
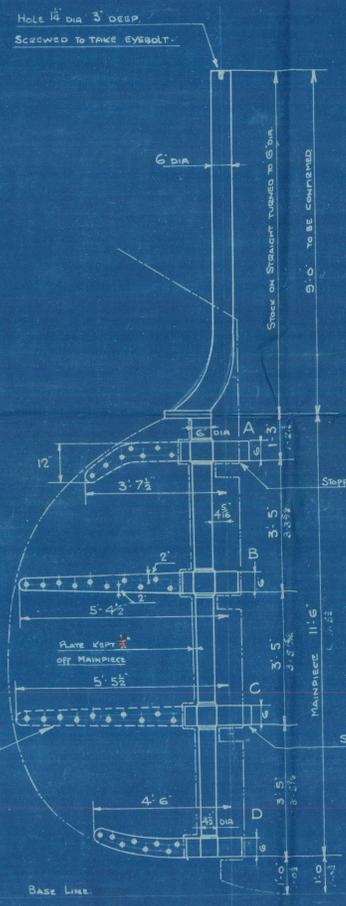
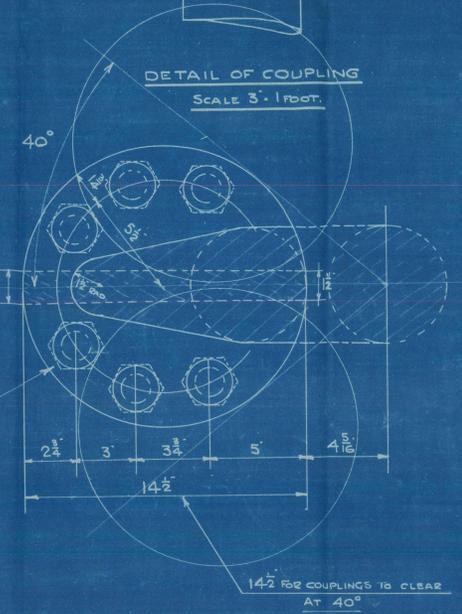


MAINPIECE IN WAY OF EACH ARM TO BE INCREASED 10% IN DIA. EXTENDING ABOVE + BELOW FOR A DISTANCE EQUAL TO THE INCREASE IN DIAMETER THENCE GRADUALLY TAPERED INTO MAINPIECE IN A SIMILAR DISTANCE.

REDUCED SO FAR AS PRACTICABLE

KEYWAYS TO HAVE A BREADTH OF 20% OF THE DIA. OF THE MAINPIECE AT EACH RESPECTIVE ARM. THE THICKNESS OF KEYWAYS TO BE EQUAL TO HALF THAT BREADTH AT THE BOTTOM AND INCREASED 1/4" AT THE TOP.

DETAIL OF COUPLING
 SCALE 3" = 1 FOOT.



N^o 10537
 28-10-16



Pindder frame

GLASGOW REPORT NO 34583
Hickorol.



011805-011812-0230

011805-011812-0230

