

FR D SEC.
LOOKING FORWARD

FR C SEC.
LOOKING FORWARD

FR B SEC.
LOOKING FORWARD

FR A SEC.
LOOKING FORWARD

PLAN OF UPPER CASTING

A.P. SEC.
LOOKING FORWARD

FB O SEC.
LOOKING FORWARD

BILL OF MATERIAL

MARK	NAME	MATERIAL	QUANTITY	SHOP	WEIGHT (KG)	NOTE
1	STERN FRAME (UPPER PART)	CAST STEEL	1	外注	ABOUT 22'5"	
2	STERN FRAME (LOWER PART)	CAST STEEL	1		ABOUT 23'0"	
3	RUDDER STOCK	FORGED STEEL	3			

REMARKS

FOR S.N. 972
JAN. 11 1918
PREPARED FOR S.N. 972
MAR. 3 1953
APPROVED BY L.R.
MAR. 29 1958
APPROVED BY H.K.
MAY 12 1958
APPROVED BY SUMNER
MAY 12 1958
PARTIALLY ALTERED AND ISSUED THE TARD B
2 17000

OCT. 2 1959
THE FOLLOWING ALTERATION DWG'S
INCORPORATED AND ISSUED
(FOR S.N. 972) AS FINISHED PLAN.
PARTIAL ALTERATION (DWG. 5)
ENTERED: T.M.
H.K. Y.H.

PARTICULARS

RUDDER AREA : A 339.6* (31.45)
SEA SPEED MAX. CONT. AT FULL LOADED CONDITION 17.2 (13.9 K)
MAIN ENGINE DOUBLE REDUCTION GEARED TURBINE
MAX. CONT. OUTPUT 1,650 HP AT 110 RPM

NOTES

1. CAST STEEL TO BE THOROUGHLY ANNEALED.
2. MATERIALS OF STERN FRAME AND REAMER BOLTS & NUTS TO COMPLY WITH THE JIS AND A.S.T.M. REQUIREMENTS.
3. CARBON CONTENT OF THE CASTING IS NOT TO EXCEED 0.23%.
4. MAGNETIC PARTICLE INSPECTION & SUPER-SONIC INSPECTION TO BE CARRIED OUT FOR THE CASTING.
5. FINAL BORINGS OF PROPELLER BOSS & GUDGEONS TO BE PERFORMED AFTER WELDING IN WAY OF COUPLING JOINT BETWEEN THE BOLTED CASTINGS.
6. WELDING NOTICE FOR COUPLING JOINT
LOW HYDROGEN ROD OF THE DIAMETER AS LARGE AS POSSIBLE TO BE USED TO BE CLEANED EACH PASS & BEENING NOT TO BE APPLIED TO BE PREHEATED ABOUT 150°F (66°C) TO BE SLOWLY COOLED BY ASBESTOS SLAB PROTECTION AFTER WELDING.
7. REFERENCE PLANS
RUDDER & RUDDER STOCK J7-3
BOSS SCREW APERTURE & RUDDER LINES C1-2
8. AS TO THE PROTECTION PLATE FOR GALVANIC CORROSION SEE RUDDER PLAN (J7-3).
9. ALL DIMENSIONS GIVEN ON PLAN ARE ALREADY PAIRED AT MOLD LIFT EXCEPT * MARK DIMENSIONS.

MARK OF MACHINING

▽	SMOOTHED
▽	ROUGH TURN
▽	NORMAL FINISH

FINISHED PLAN

GEKKO MARU
月興丸

TITLE

STERN FRAME

SCALE 1/25 JOB NO. 7-7

KAWASAKI DOCKYARD CO. LTD.
KOBE JAPAN
SHIPDESIGNING DEPARTMENT

CHIEF OF DEPARTMENT
CHIEF OF SECTION
CHECKED BY
DRAWN BY
DATE
SECTION NO.

TO LLOYDS REGISTER OF SHIPPING

101

RECORDS DEPT.
LONDON.

9

CERTIFIED COPY OF APPROVED PLAN	
PLACE OF APPROVAL Kobe JAPAN.	DATE 3-3-58.
CERTIFIED BY W. N. Howells	DATE 28-11-59.

Kobe Rpt. No.	FE 6715
Port of Survey	K O B E
Name of Ship.	SEKKO MARU
Title of Plan.	STERN FRAME



© 2021

Lloyd's Register
Foundation

013735-013739-0011