

N^o 779-B1 **RUDDER PLAN.**

DIMENSIONS- 40'-0" B.F. x 56'-0" MLD. x 30'-1" D. MLD.

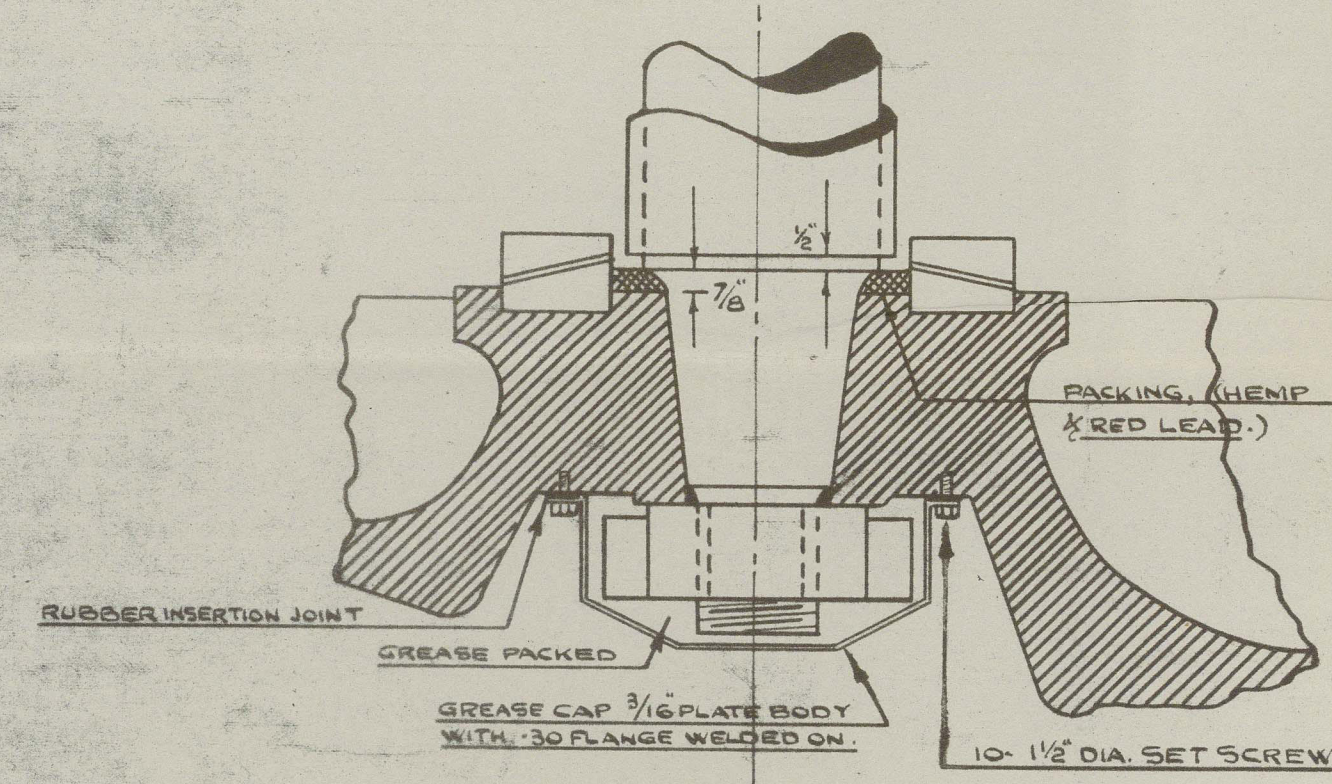
TO PASS LLOYD'S SURVEY & TESTS CARRYING PETROLEUM IN BULK
 RUDDER FRAME OF CAST STEEL
 RUDDER AREA = 142.7 sq. ft.
 LLOYD'S A & D = 273
 SERVICE SPEED 11 KNOTS
 RUDDER ANGLE MAXIMUM 40°

RUDDER STOCK OF FORGED STEEL
 RULE DIA. OF RUDDER STOCK = 8 1/2"
 + 10% FOR TANKERS = 9 1/4"
 + OTHERS EXTRA = 1"
 DIA. OF RUDDER STOCK FITTED = 10"

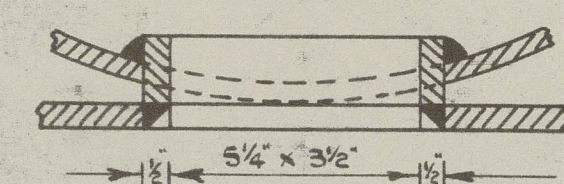
DIMENSIONS ON THIS PLAN SHOULD BE CAREFULLY WORKED TO AS ANY EXCESS
 OVER ESTIMATED WEIGHT WILL NOT BE PAID FOR.
 UPPER STOCK SUGGESTS 3/4" DIA. TO BE IN A PERFECTLY VERTICAL LINE.
 INSIDE OF BUSH TO BE WITHIN STANDARD.
 ALL RIVET HOLES TO BE DRILLED BY HAND.
 RUDDER NOT TO BE PAINTED, BUT GIVEN A COAT OF OIL BEFORE LEAVING MAKERS.
 WEIGHT TO BE PAINTED ON RUDDER BEFORE DISPATCH.

SEE NOTES AT END OF PLAN.

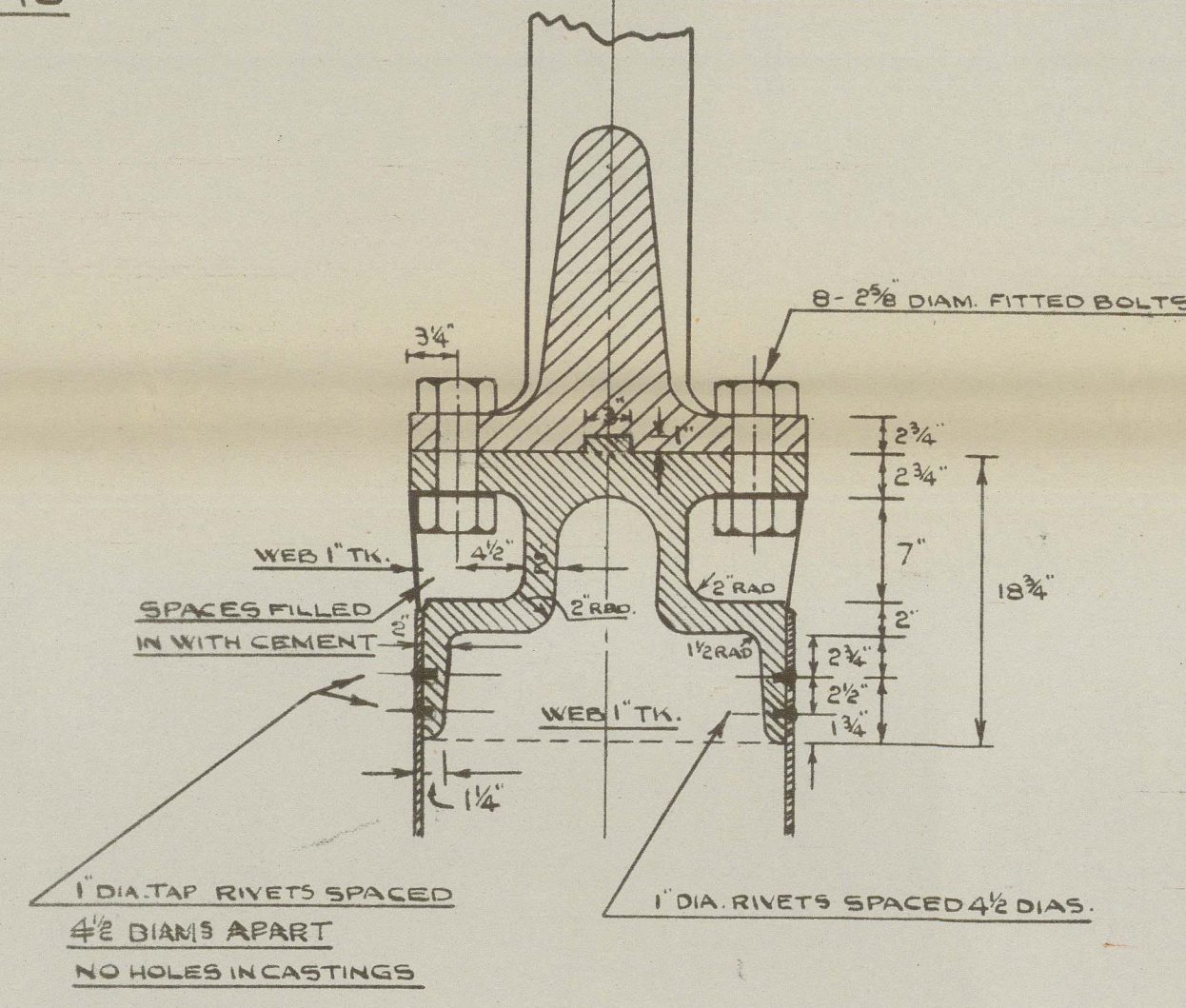
WATERTIGHT PACKING ARRANGEMENT
 IN WAY OF MAIN PIECE CONE END.



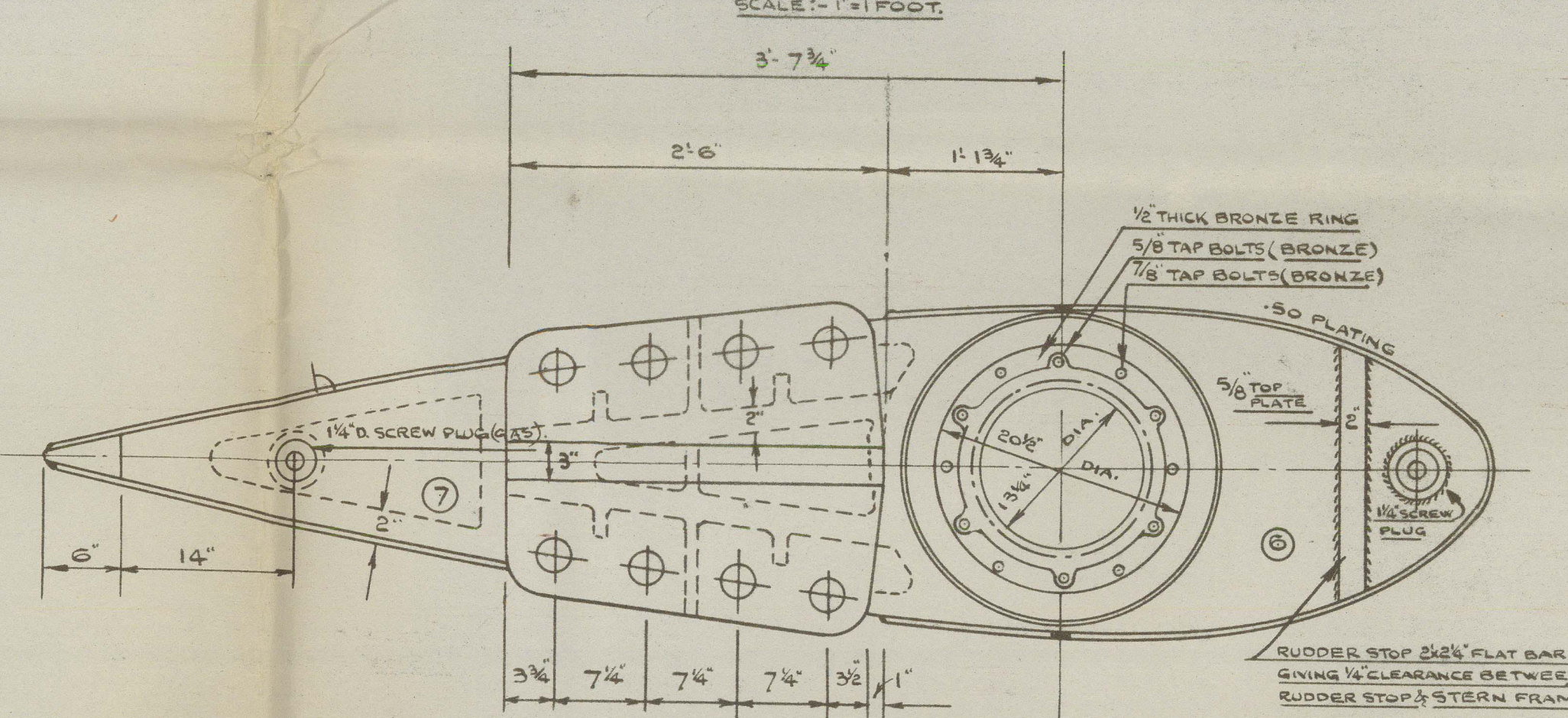
DETAIL OF HANDHOLE
 SCALE: 1/2" = 1'



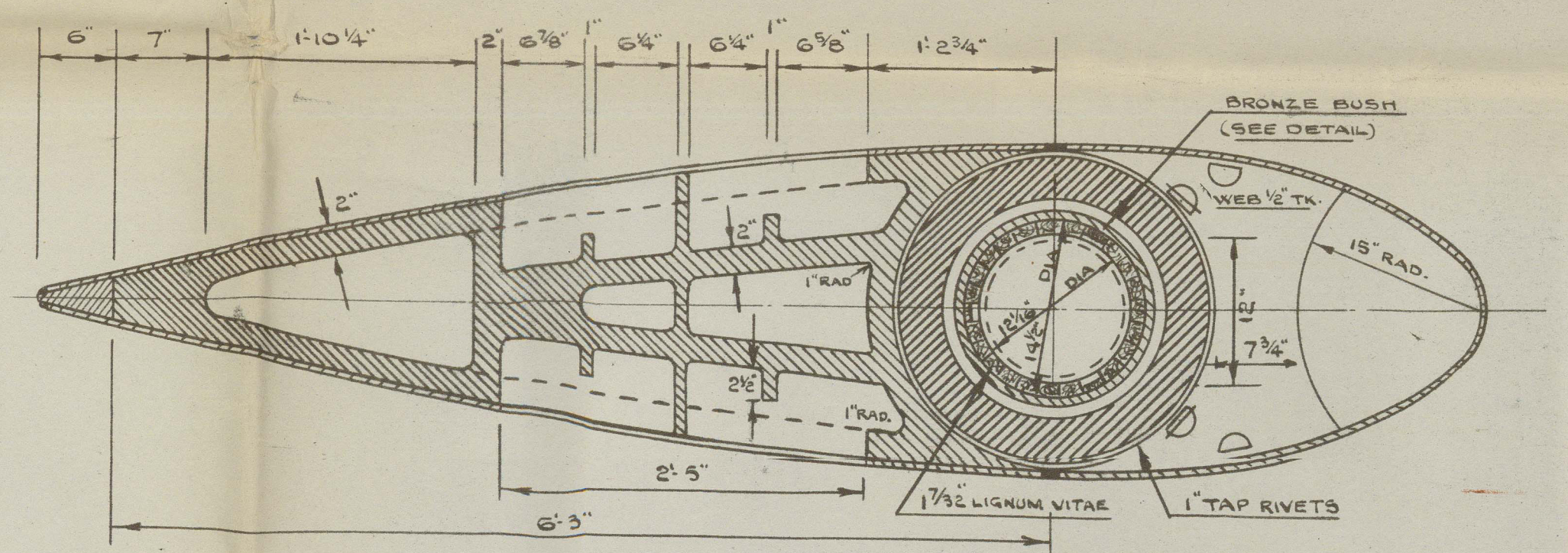
SECTION THRO' COUPLING



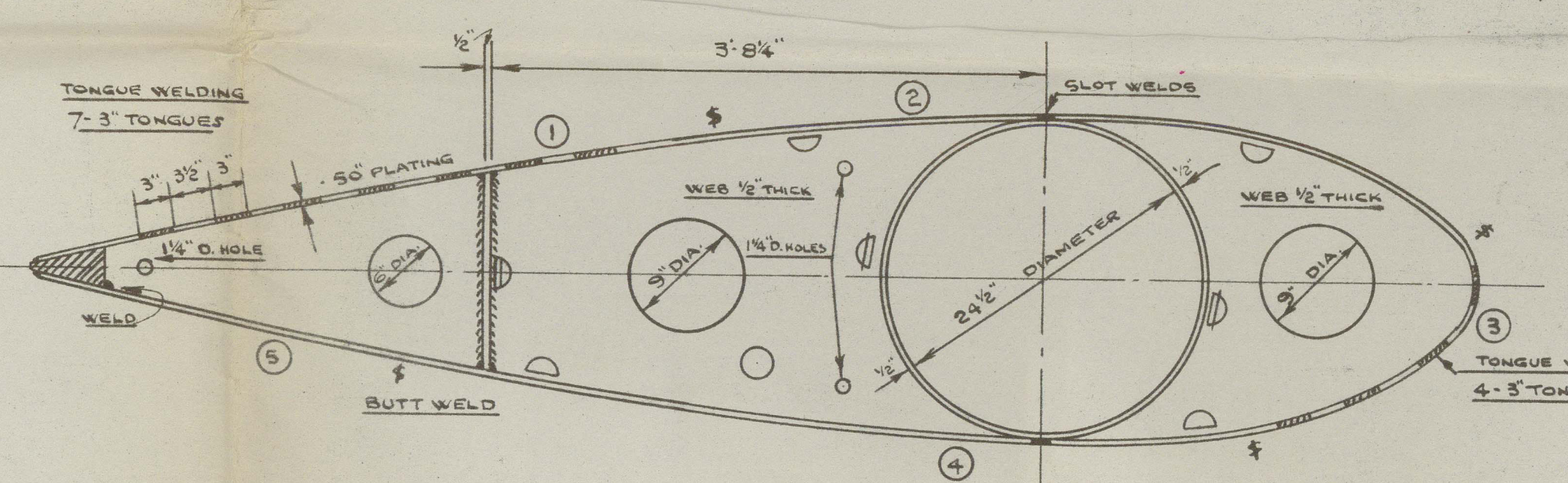
SECTION AT B-B



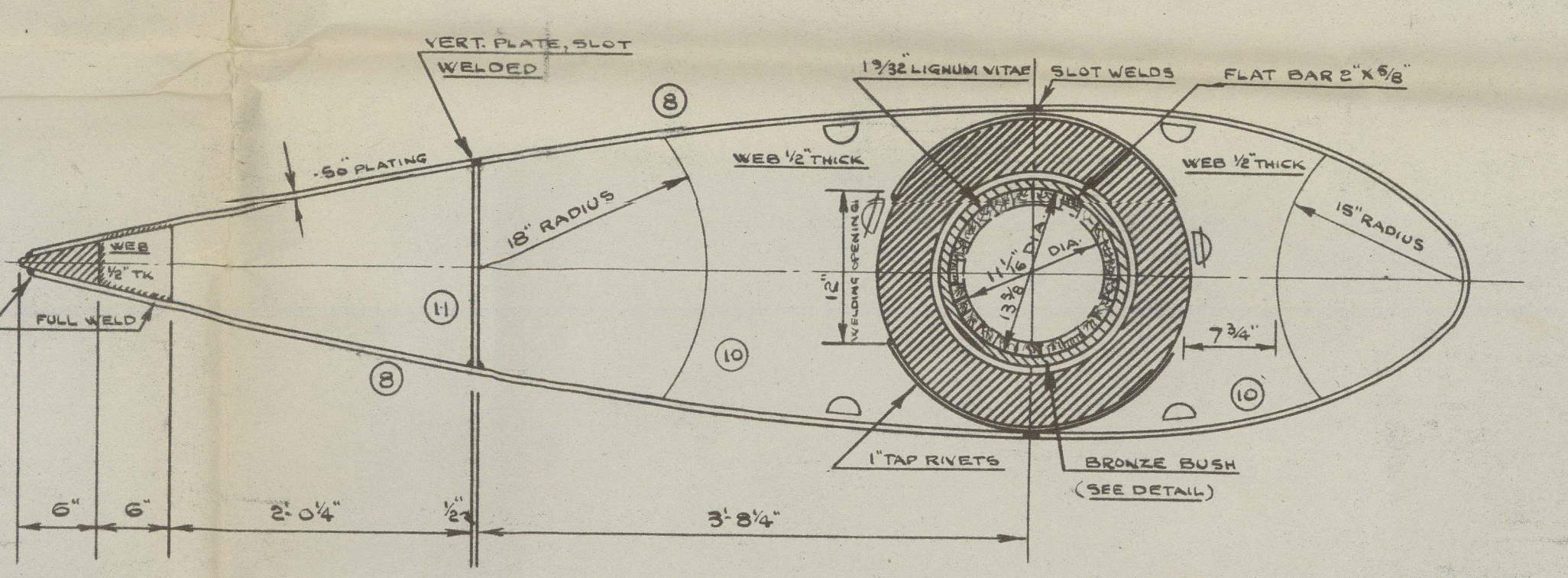
SECTION AT C-C



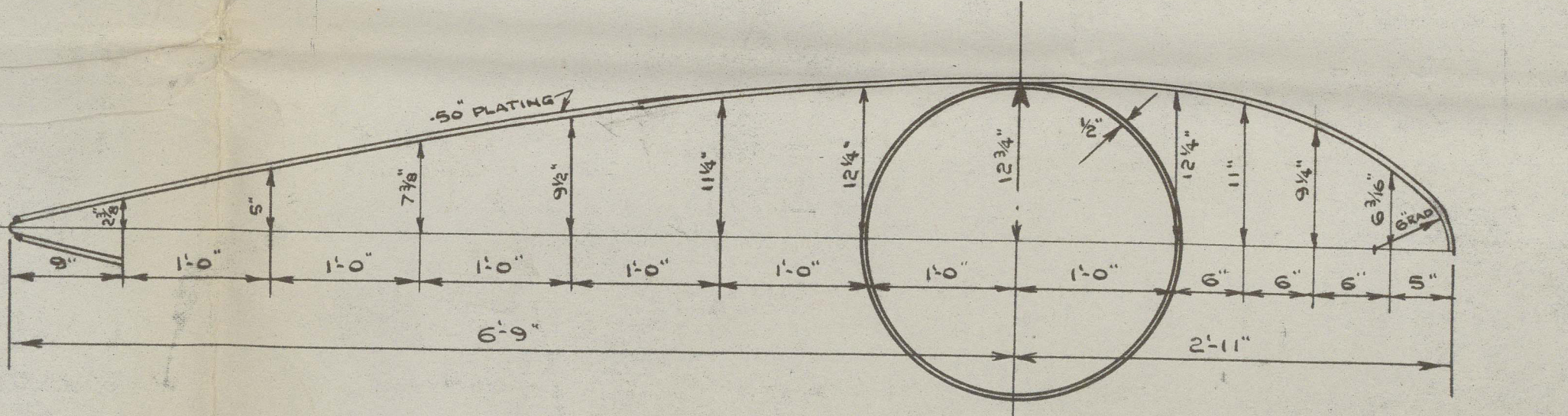
SECTION AT D-D



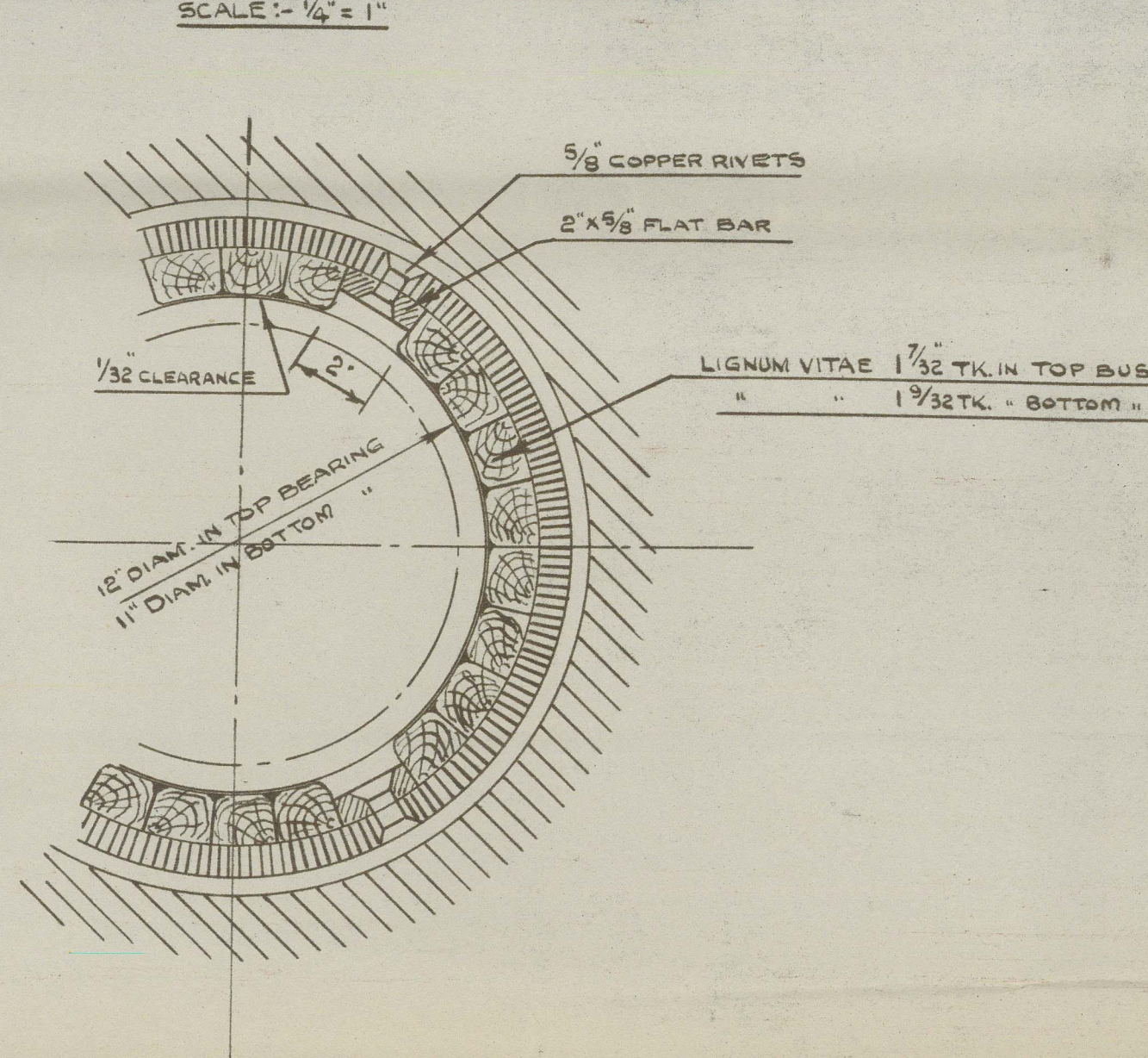
SECTION AT E-E



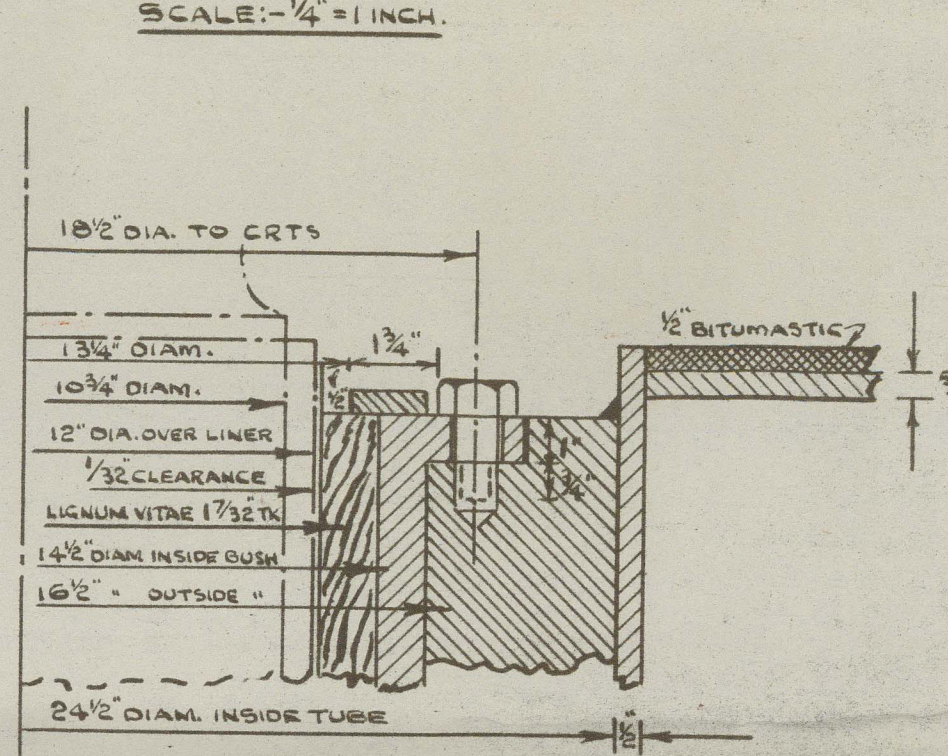
PROFILE OF RUDDER



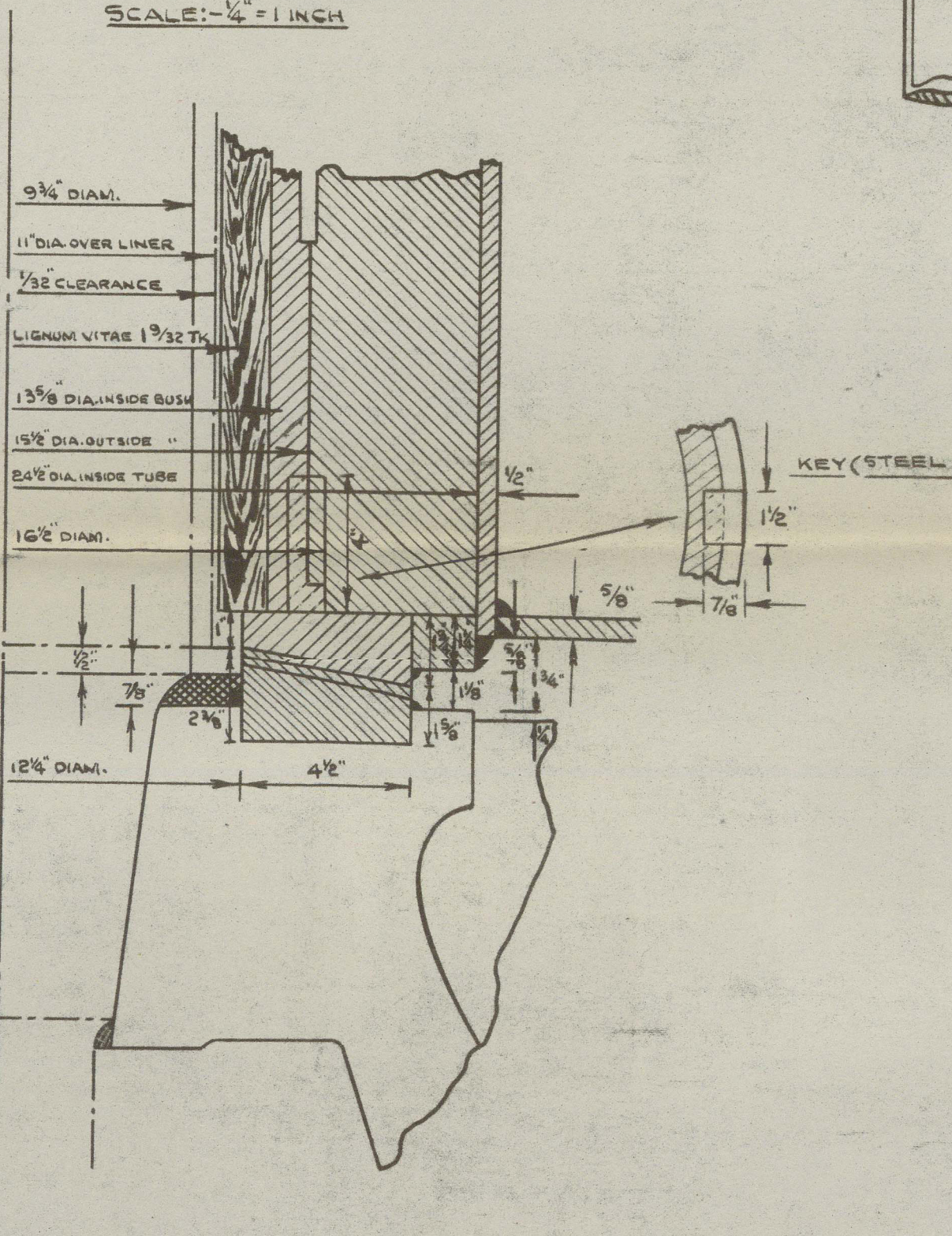
DETAIL OF LIGNUM VITAE BUSHES



ARRANGEMENT OF BRONZE RING



ARRANGEMENT OF BEARING RINGS



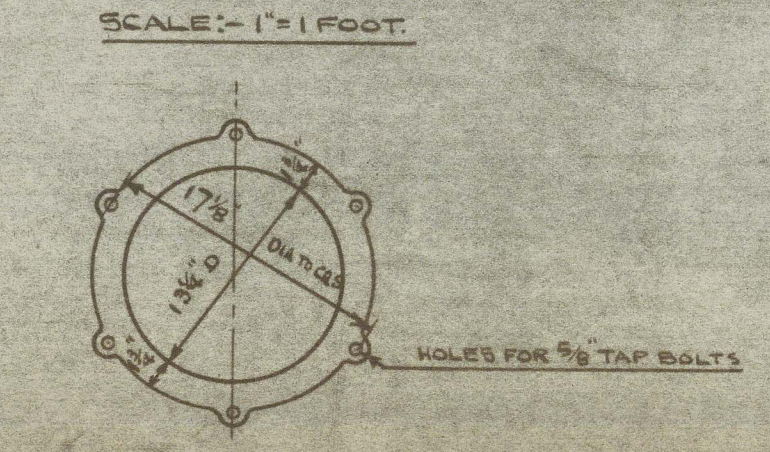
RUDDER PLATES

1	15'-0"	57"	50"
2	1	65"	
3	1	28"	
4	1	70"	
5	1	32"	
6	1	3'-0"	26"
7	1	2'-8"	18'-3"
8	1	2'-8"	18'-3"
9	1	2'-8"	18'-3"
10	1	2'-8"	18'-3"
11	1	2'-8"	18'-3"

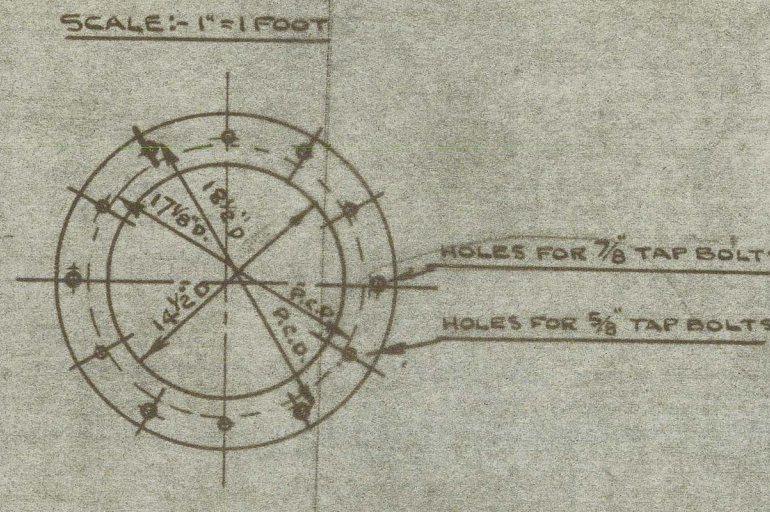
NOTES:-

1. THE FORWARD & AFTER PART OF THE RUDDER IS TO BE FILLED WITH SOLUTION & SUBJECTED TO A PRESSURE OF 14 LBS PER SQ. INCH IN WHICH CONDITION THE SAME WILL HAVE TO BE ACCEPTED BY LLOYD, AFTER THAT THE SOLUTION WILL HAVE TO BE REMOVED & THE SCREW PLUGS INSERTED.
2. UNDER FIVE IN THE RUDDER IS TO BE COVERED WITH SOLUTION.
3. THE ELECTRIC WELDING SHOULD BE CARRIED OUT TO THE SATISFACTION OF THE SOCIETY'S SURVEYORS & THE REGULATIONS FOR THE APPLICATION OF ELECTRIC ARC WELDING TO SHIP CONSTRUCTION SHOULD BE COMPLIED WITH.
4. CARE SHOULD BE TAKEN THAT THE RUDDER STOCK IS PLUSH WITH THE RUDDER BEARINGS (OR THE CYLINDRICAL RUDDER-POST).
5. FOR STEER FRAME SEE SEPARATE PLAN.

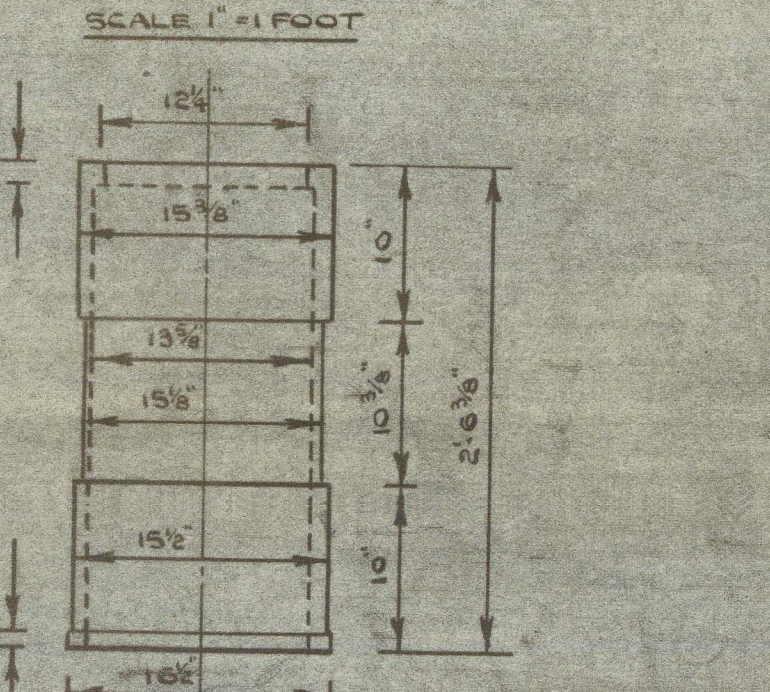
1/2" THICK BRONZE RING



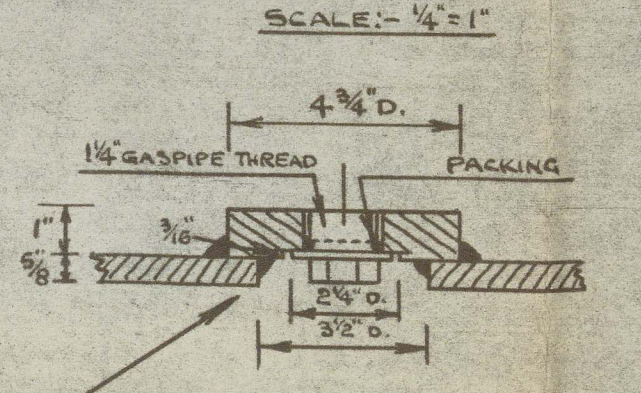
UPPER BRONZE BUSH



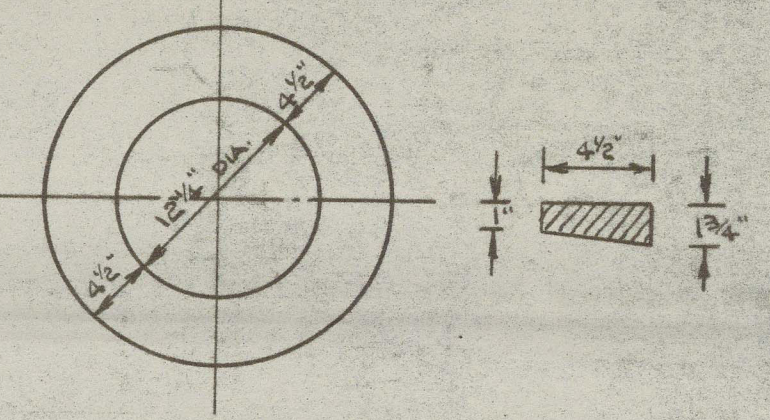
LOWER BRONZE BUSH



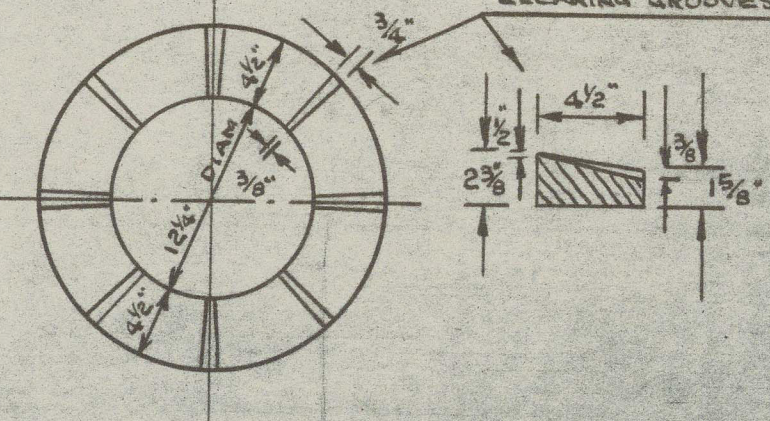
DETAIL OF SCREW PLUG



UPPER BEARING RING



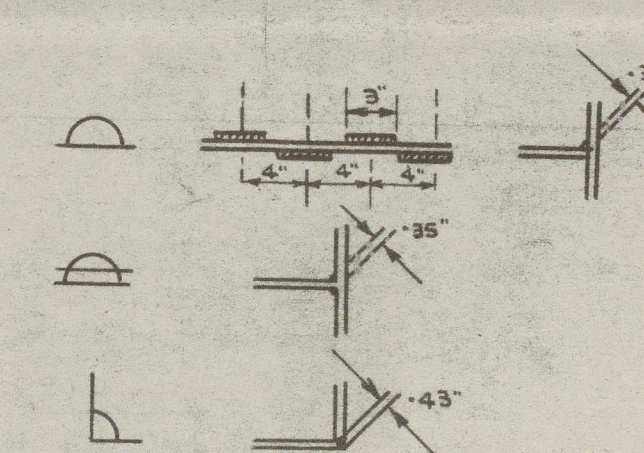
LOWER BEARING RING



NO.	ITEM	MATERIAL	SUPPLIED BY
1	RUDDER BODY	MILD-STEEL	SHIPBUILDER
1	COUPLING PIECE	CAST-STEEL	RUDDER MALEERS
1	UPPER BEARING	"	"
1	LOWER BEARING	"	"
1	UPPER BRONZE BUSH	BRONZE	"
1	LOWER BRONZE BUSH	BRONZE	"
2	KEY	"	"
3	FLAT BAR	"	"
1	BRONZE RING	"	"
6	1/2" TAP BOLT LENGTH 1 1/2"	"	"
5	1/2" TAP BOLT LENGTH 1 1/2"	"	"
4	SCREW PLUG (NECESSARY THREAD)	"	SHIPBUILDER
24	5/8" DIA. RIVET	COPPER	RUDDER MALEERS
2	LIGNUM VITAE BUSH	LIGNUM VITAE	"
1	UPPER BEARING RING	HARD-STEEL	"
1	LOWER BEARING RING	SOFT-STEEL	"
1	NOSE PIECE	MILD-STEEL	"

WELDING:-

- FULL THROAT INTERMITTENT WELDING
 ALTERNATE SIDES WHERE MARKED.
- FULL THROAT WELDING BOTH SIDES
 CONTINUOUS WHERE MARKED.
- FULL THROAT WELDING ONE SIDE
 CONTINUOUS WHERE MARKED.



DOXFORDS 779-781

PLAN OF RUDDER

(AS APPROVED FOR 763)

SUNDERLAND RPT. NO. 35440

"British diplomat" ★

RECORDS DEPT.
LONDON

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