

12.2.26

No 1220.SHIP

STERN FRAME & RUDDER

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

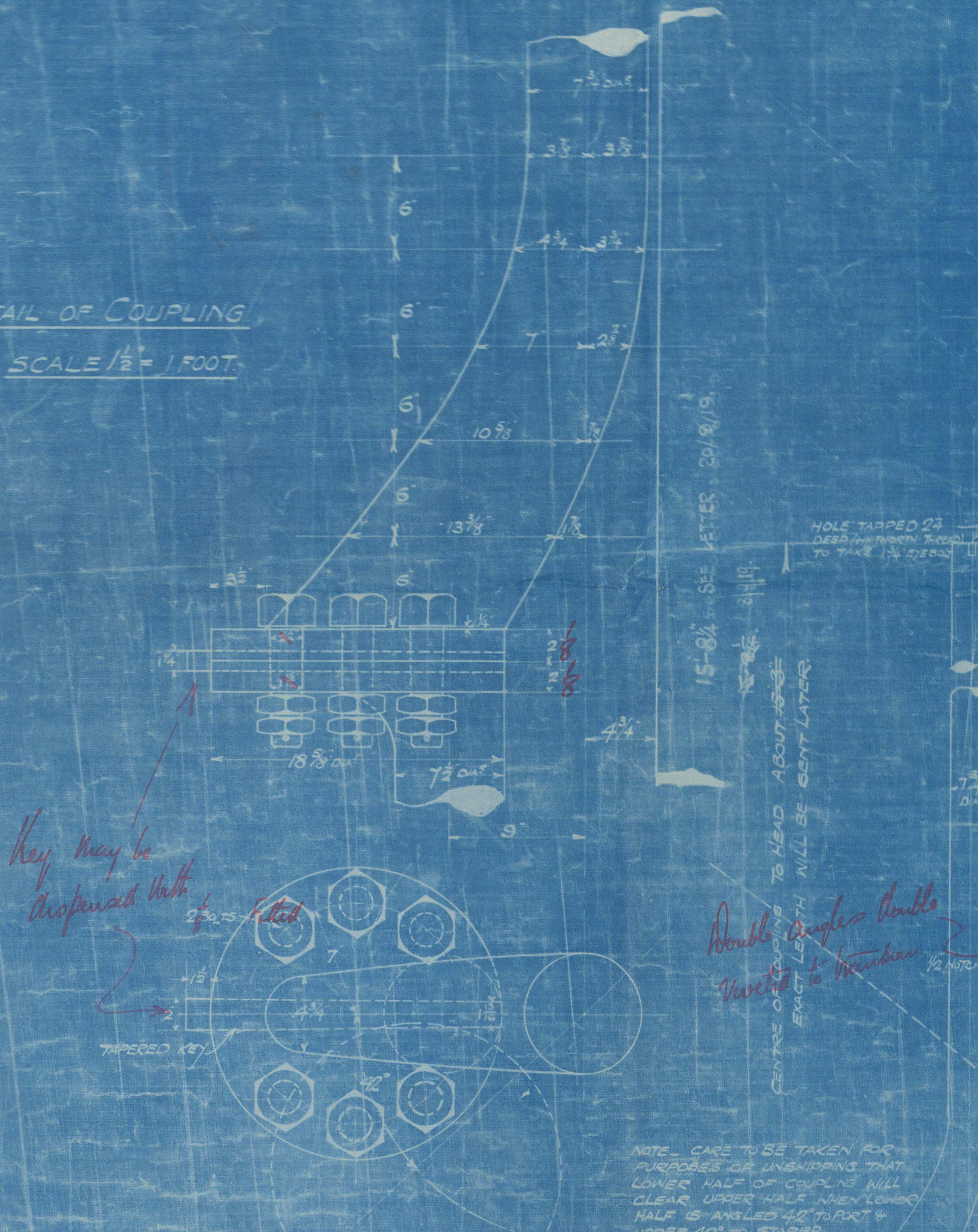
OF CAST STEEL.

TO PASS THE REQUIREMENTS OF LLOYDS CLASS. A.1.

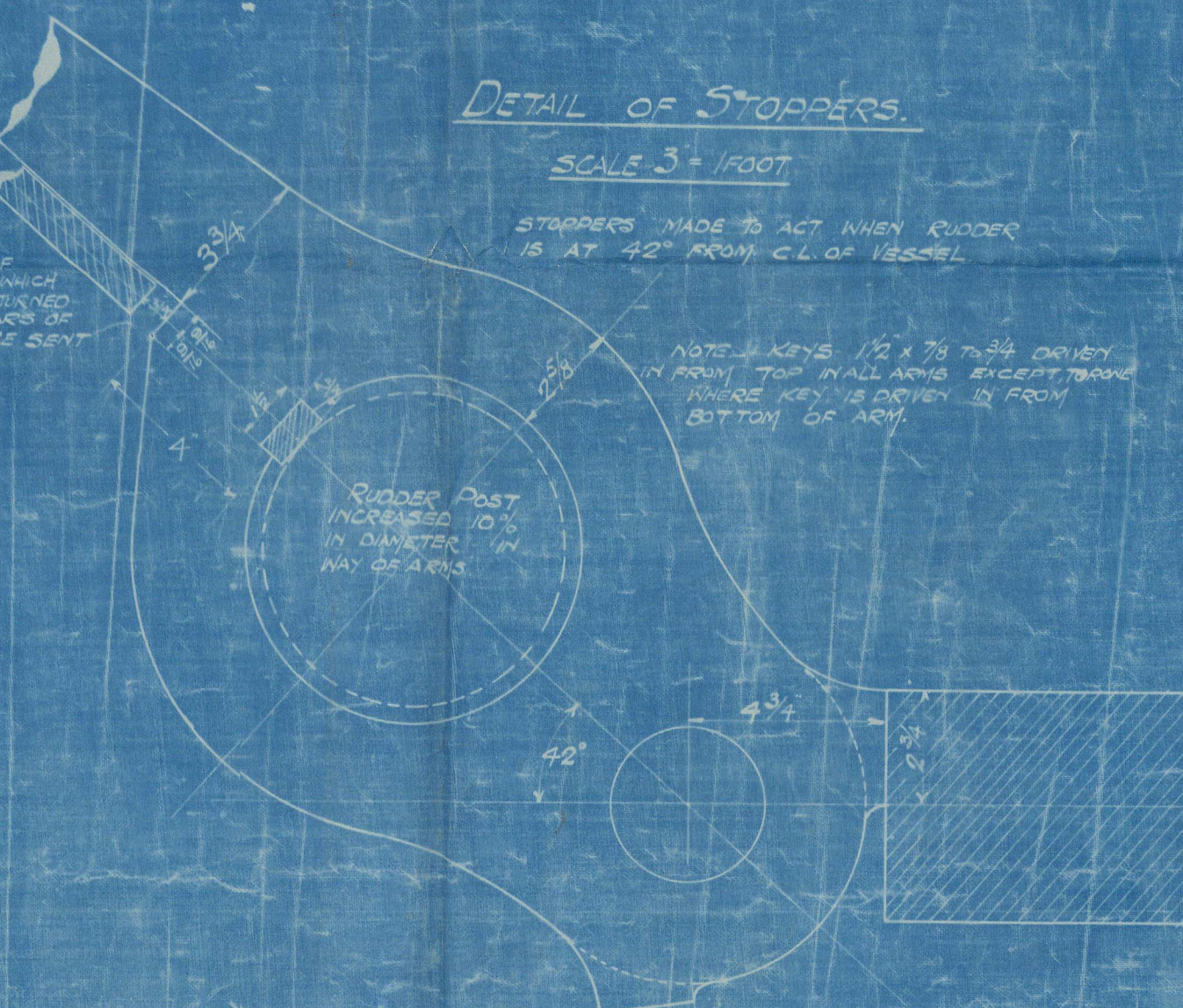
Speed not to exceed 12 knots

CENTRE LINE THRO' GUDGEONS TO BE PERFECTLY STRAIGHT.
EXACT POSITION OF BRACES TO BE TEMPLATED FROM STERN POST
CARE TO BE TAKEN THAT THE FRAMES ARE CAST TO DIMENSIONS
GIVEN AS NE ONLY PAY ON WEIGHTS CALCULATED FROM THESE DIMENSIONS.

DETAIL OF COUPLING
SCALE $\frac{1}{2}$ " = 1 FOOT.



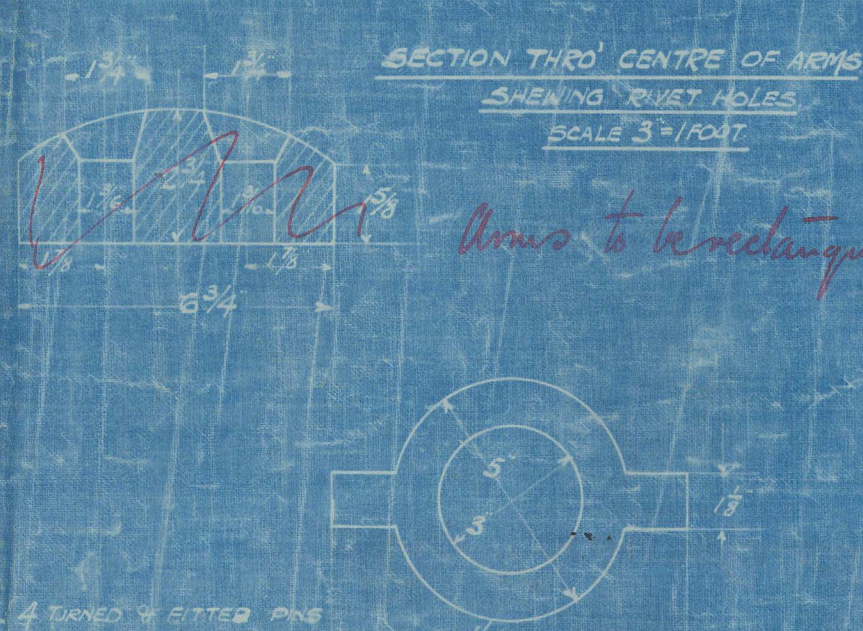
DETAIL OF STOPPERS
SCALE $\frac{1}{2}$ " = 1 FOOT.



NOTES — CORRECT LENGTH OF TOP PINTLE IS TO BE MEASURED WHEN RUDDER IS COMPLETE, & BOTH ENDS TO BE KEPT $\frac{1}{4}$ " CLEAR OF GROUND. BOTTOM PINTLE TO BE KEPT SHORT AS NECESSARY FOR HARD STEEL DISC WHICH IS TO BE SUPPLIED BY STEEN FRAME MAKER. MAIN POST TO BE TURNED WITH ARMS SHIRKINLY KEVED ON. CENTRE LINE OF PINTLES TO BE IN A PERFECTLY STRAIGHT LINE WITH CENTRE OF STOCK.

COUPLING BOLTS TO BE TAPERED TO $\frac{1}{2}$ " DIA. THREADS OF COUPLING BOLTS TO BE HAVE SHAPED THUS: $\frac{1}{2}$ " DIA. CHECK NUTS TO BE KEPT WITH TAPERED DISC. BOLTHEADS TO BE $\frac{1}{4}$ " CLEAR OF COUPLING WHEN SCREENED UP. KEY $2 \times \frac{1}{2}$ " TAPERED TO $\frac{1}{2}$ " DIA. & TO BE $\frac{1}{8}$ " LONGER THAN COUPLING WITH SQ. END FOR DRIVING UP ALSO A STICK TO BE FITTED OVER AFTER END OF KEY TAPPED TO FLANGE TO KEEP KEY IN POSITION STRAP SUPPLIED BY SHIRKIN/DEGS. SPECIAL CARE TO BE TAKEN TO ARRANGE SPACING OF COUPLING BOLTS SO THAT NUTS & CHECK NUTS MAY BE TIGHTENED UP WITHOUT POULING STOCK. KEY TO GO IN TIGHT FROM AFTER END WHEN COUPLING SERVED IN ENDS OF PINTLES & COUPLING BOLTS TO BE REQUIRED IN DIAMETER BY TWICE DEPTH OF THREAD BEYOND THE NUT. RUDDER STOCK INCREASED 10% IN DIAM. & TURNED PARALLEL IN WAY OF ARMS. THE INCREASES TO BE UNIFORM ALL ROUND MAIN PIECE & TO EXTEND AROUND EACH ARM EQUAL TO THE INCREASE IN DIA. THEN TAPERED OVER A SIMILAR DISTANCE INTO THE ORIGINAL DIA. OF MAIN PIECE.

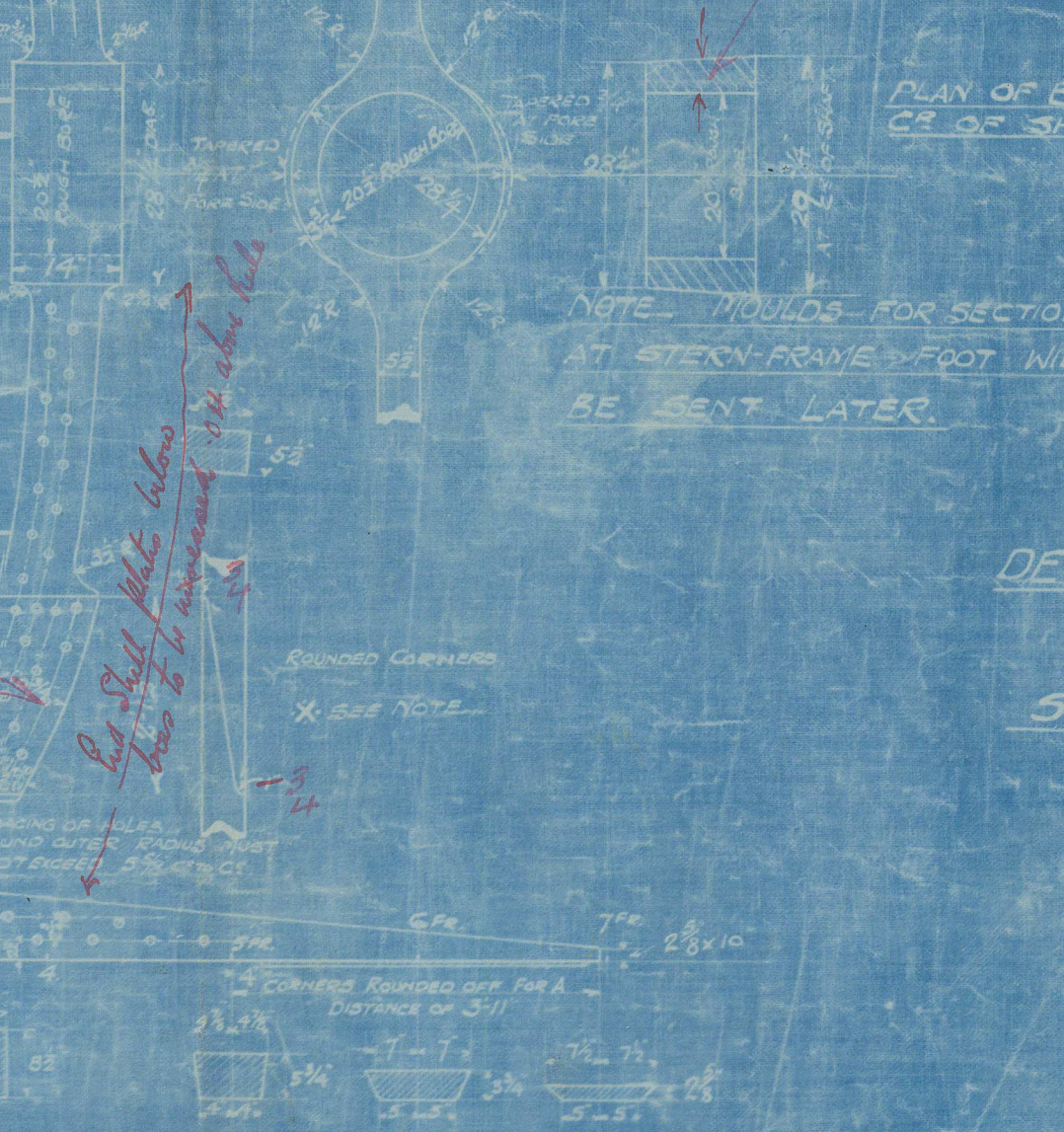
SECTION THRO' CENTRE OF ARMS
SHOWING RIVET HOLES
SCALE $\frac{1}{2}$ " = 1 FOOT.



DETAIL OF ALL GUDGEONS
EXCEPT BOTTOM
SCALE $\frac{1}{2}$ " = 1 FOOT.



DETAIL OF BOTTOM
GUDGEON
SCALE $\frac{1}{2}$ " = 1 FOOT.



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WALKER
NEWCASTLE-ON-TYNE

Ant. L. R.

16.2.26

29.1.19
33
199.3

J. Robinson & Co.
Southack Yard

Swan Hunter 1220

Messrs Swan Hunter & Wigham Richardson Ltd

No 1220

Plating Stern Frame & Rudder Plate

No 3

S. S. MERRYCO

NEWCASTLE ON TYNE.

Report No. 80611