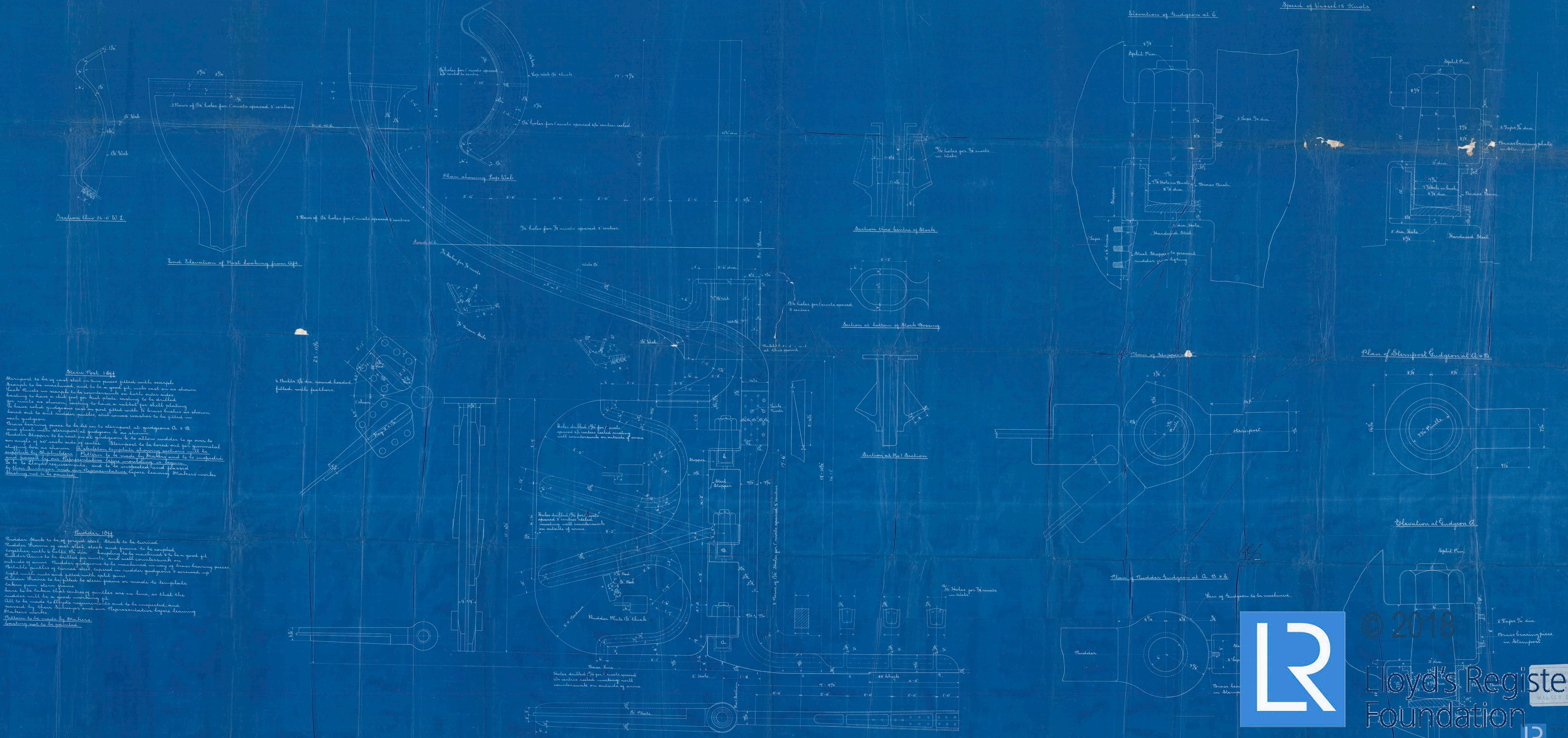


No 905 Ship
 Cast Steel Sternpost and Cast Steel Rudder with Forged Steel Stock
 Scale 1" = 1 Foot
 Speed of Vessel 15 Knots



Stern Post 1 Off
 Sternpost to be of cast steel in two pieces fitted with scarf. Length to be machined, and to be a good fit, with cast on as shown. Both flanges on scarf to be counterbored on both outer sides, leaving to show a half inch for each side, making to be drilled for rivets as shown, making to have a ribbed for steel plating. To have solid gudgeons cast on post fitted with 12 brass bushes as shown. Brass cast on to steel rudder pinholes steel cones washer to be fitted in each gudgeon. Brass bearing piece to be cast on to sternpost at gudgeons A & B. One flange with sternpost at gudgeon to be as shown. Rudder stopper to be cast on to gudgeon to allow rudder to go over to an angle of 15° each side of center. Sternpost to be bored out for gunmetal stuffing box as shown. Attention to be made by Marking and to be inspected. To be to 2 days requirements, and to be inspected and passed by their Surveyor and our Representative before leaving Markers works. Painting not to be painted.

Rudder 1 Off
 Rudder Stock to be of forged steel. Stock to be turned. Rudder frame of cast steel stock and frame to be completed together with 6 bolts 7/8" dia. Rounding to be machined to be a good fit. Rudder frame to be drilled for rivets, and well counterbored on outside of arms. Rudder gudgeons to be machined in way of brass bearing pieces. Rivets of frame steel, tapered on rudder gudgeons to be secured up. Rudder frame to be fitted with split pins. Rudder frame to be fitted to stem frame or made to template. Care to be taken that centers of pinholes are in line, so that the rudder will be a good working fit. All to be made to 2 days requirements and to be inspected and passed by their Surveyor and our Representative before leaving Markers works. Attention to be made by Markers. Painting not to be painted.



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 WALKER SHIPYARD

(3)

Armstrong, Whitworth & Co. L^{ds}

No 905-

Cast Steel Stern Frame
of

Rudder Frame.

Forged Steel Stock.

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