

BALANCED STREAMLINE RUDDER.

S.S. Nos 917-918.-927

SCALE 1" = ONE FOOT.
DETAILS = SCALE AS INDICATED.

RUDDER POST & STOCK - BEST QUALITY FORGED STEEL.

RUDDER NOSE PIECE - BEST QUALITY STEEL CASTING.

DIMENSIONS: - 44' 9" B.P. x 56' 6" EXT. x 32' 8" ALD. TO UPPER DECK.
TO CLASS 100 A.I. AT LLOYDS. LOAD DRAFT 25' 10". SPEED 14 1/2 KNOTS.
IMMERSED AREA OF RUDDER AFT OF STOCK OR = 123' 2" SQ. FT. CS = 330 FT. A & D = 433.
IMMERSED AREA OF RUDDER FWD OF STOCK OR = 36' 8" SQ. FT. CS = 1048 FT. A & D = 38.
MODIFIED A & D = (433 + 38) = 395. 1/4 IN. RULE DIA. STOCK - FITTED 10 1/2" DIA. (QUER)
KEYWAYS ETC. CUT IN RUDDER STOCK, BY RUDDER MAKERS, TO PARTICULARS GIVEN.
RUDDER POST & STOCK TO BE ACCURATELY MACHINED TO DIMENSIONS GIVEN.
RIVET HOLES TO BE BORED & TAPPED INTO RUDDER POST, BY RUDDER MAKERS.
RUDDER NOT TO EXCEED GIVEN QUANTITIES, EXCESS OVER EST. WEIGHT WILL NOT BE PAID FOR.
PATTERN OF NOSE PIECE & FINISHED RUDDER POST TO BE APPROVED BY SHIPBUILDERS DESIGNER.
FORGED & CASTINGS TESTED AS PER RULE.

NOTE: KEYWAYS TO BE CUT SQUARE ENDS.
DEPTH OF KEYWAYS MEASURED
AT CENTRE LINE OF RUDDER STOCK.

DETAIL OF KEYWAYS

DOUBLE RIBS 3/16" x 1/2" THICK
LEFT LOOSE WITH RUDDER SHIPPED
RIBS PLATING 1/4" THICK

BASE OF RUDDER CARRIER
MACHINED TO SHIP OF STOCK

RUDDER STOCK SHAPE
ACCORDING TO THIS BETWEEN
TOP OF RUDDER NOSE
& BOTTOM OF LIVER

DETAIL OF STOCK TURNED DOWN TO FORM BOTTOM PIVOT
SCALE 1 1/2" = 1 FOOT.

APPROVED FOR 924

LLOYD'S REGISTER OF SHIPPING

APPROVED

LLOYD'S REGISTER OF SHIPPING

DATE 19/4/22

CO2410-CO2411-0004

SPECIAL RIVETING & WELDING NOTE:-
WHERE TAP RIVETS ARE USED, THESE ARE TO BE RIVETED UNDER
FLUSH & THE HEADS WELDED OVER. (SEE SKETCH)
HEADS & POINTS OF THRO. RIVETS TO BE JUST OVER FLUSH.
WELDING ELECTRODES TO BE "IRONER" OR EQUIVALENT, EXCEPT ATTACHMENTS
TO NOSE PIECE, WHERE "CAST STEEL" MUST BE USED.
WELDING CONTINUOUS UNLESS OTHERWISE STATED, N710 GRADE FIRST RUN, N85 REMAINDER.

CONSTRUCTION NOTE:-
VERTICAL GIRDER ANGLES RIVETED TO PORT & STARP SHELL PLATES.
FORE & AFT GIRDERS RIVETED COMPLETE (ING STARP ANG & PLAT BAR) TO PORT SHELL PLATE.
TOP & BOTTOM PLATE & ANGLES RIVETED COMPLETE (EXCEPT FILLING PLATES) TO PORT SHELL PLATE.
FORCED PIECES TACK WELDED & ALL INTERIOR RIVETING & WELDING COMPLETED.
ALL INSIDE SURFACES OF RUDDER COATED WITH TWO COATS OF THICK BITUMASTIC SOLUTION.
GIR & BITUMASTIC SOLUTION FILLED INSIDE RUDDER TO TOP PLATE LEVEL.
STARP SHELL PLATE LAID ON POSITION, ALL RIVETING & WELDING COMPLETED & SEAMS CAULKED.
TOP & BOTTOM ENDS FILLED WITH GORK MIXTURE & FILLING PLATES WELDED IN POSITION.
BITUMASTIC SOLUTION POURED INTO EACH COMPARTMENT UNTIL FULL, DRASS WELDED INTO FILLING HOLES.

X To be an approved standard
See letter re Electric Welding

RUDDER SHELL PLATES 50" THICK.

FORGED STEEL TAIL PIECE
SUPPLIED BY RUDDER MAKERS.

FLANGE OF ANGLES
BUTTED & WELDED.

50" GIRDER PLATE.

3/8" x 3/8" x 50" ANGLES,
7/8" TAP RIVETS, BORED
& TAPPED 2" INTO POST.

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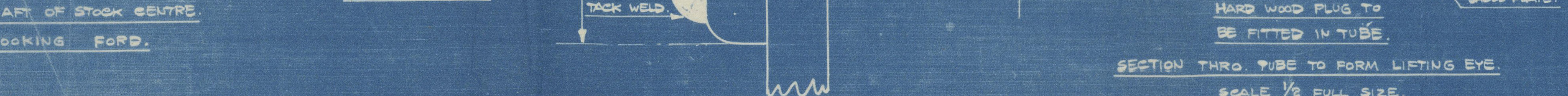
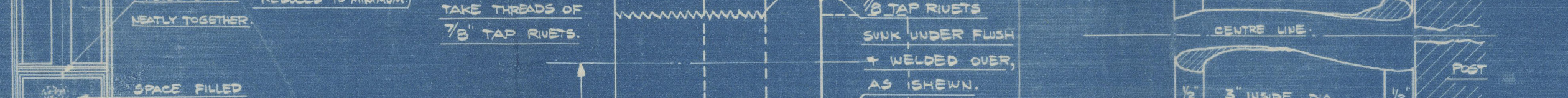
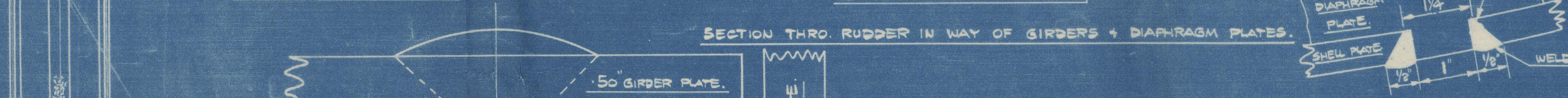
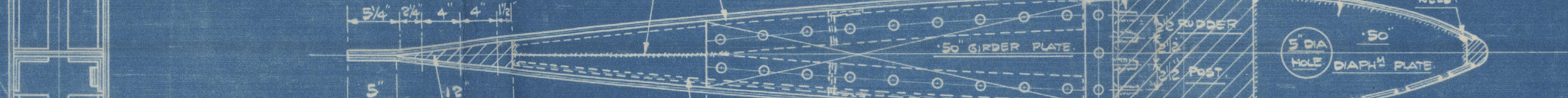
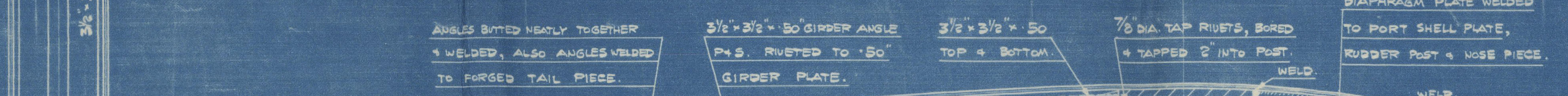
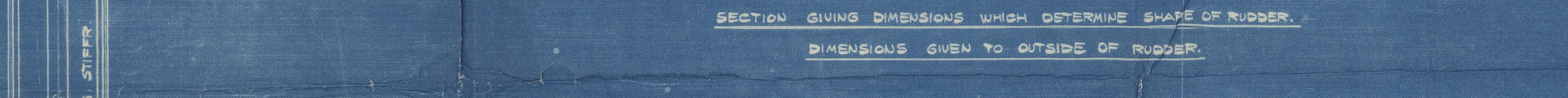
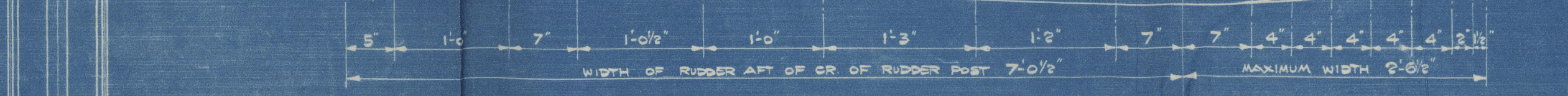
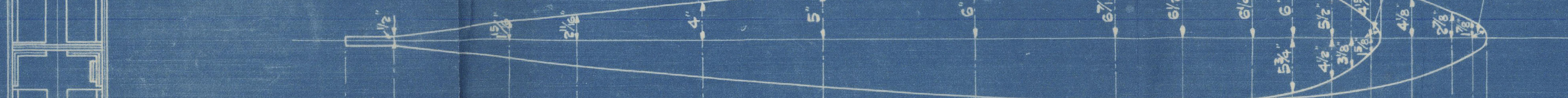
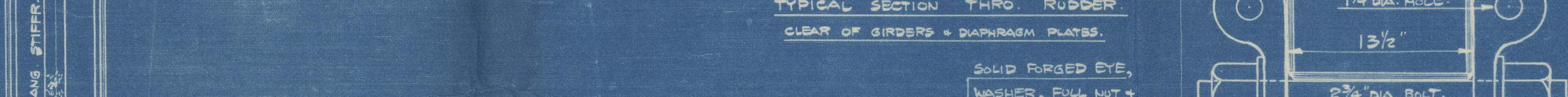
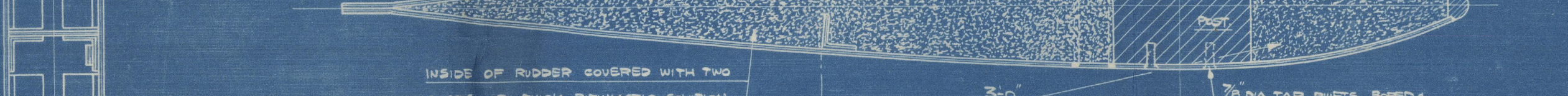
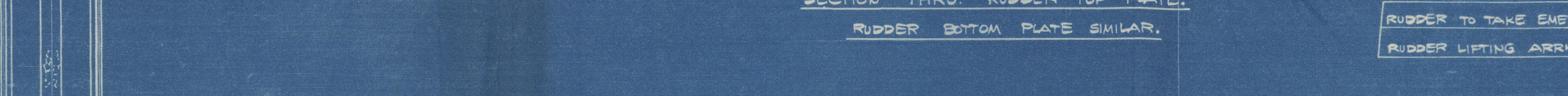
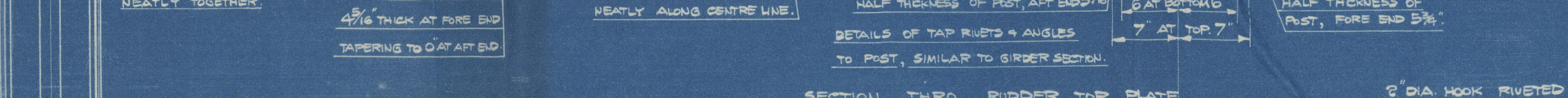
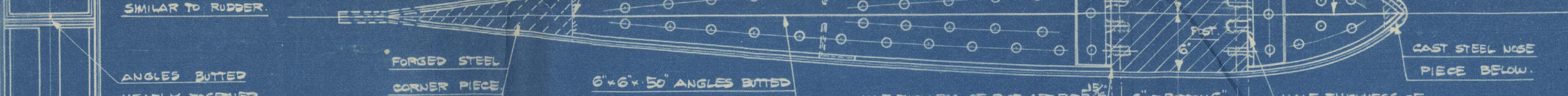
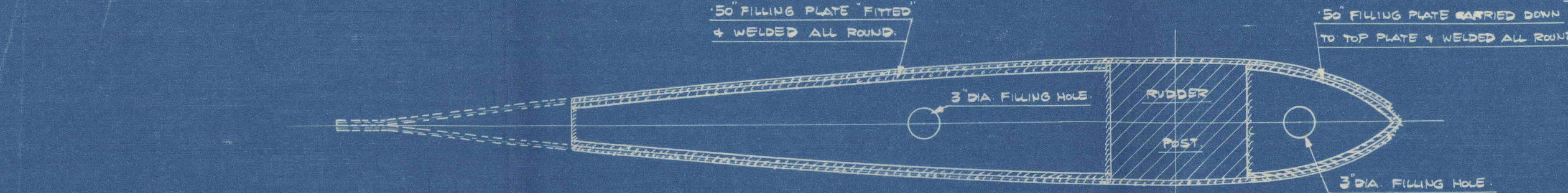
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LITHGOWS LTD

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N° 917-18 & N° 927

RUDDER.

N° 914

"ADVISEE"



GRK. 1ST ENTRY REPORT N° 20424

N° 918

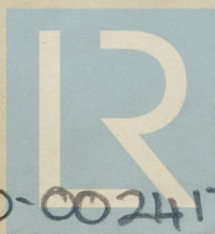
"BARRISTER"

GRK. 1ST ENTRY REPORT N° 20465

N° 924

"DALESMAN"

GRK. 1ST ENTRY REPORT N° 21013.



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