

SCALE 1" = ONE FOOT.
DETAILS:- SCALES AS INDICATED

RUDDER STOCK OF BEST QUALITY FORGED INGOT STEEL.

DIMENSIONS: 41'-0" L.P. (ON LAND LIE) x 54'-6" W.P. x 33'-6" H.P. TO UPPER DECK.
TO CLASS 100 A1' WITH FREEBOARD. WOODS SPECIAL SURVEY.

LOAD DRAFT	24'-0"	SPEED	16 KNOTS.
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TOTAL IMMERSED AREA OF RUDDER FROM FORE SIDE OF POST = 136.55 FEET.
CENTRE OF GRAVITY OF AREA, FROM CENTRE LINE OF PULSES = 4.66 FEET.
 $A \times D = 634. = \text{DISPLACED RUDDER STOCK} = 12\frac{1}{2} \text{ INCHES.}$
KEYWAYS TO BE CUT IN RUDDER STOCK TO PARTICULARS GIVEN LATER.
RUDDER STOCK TO BE ACCURATELY TURNED TO DIMENSIONS GIVEN.
RUDDER FRAME TO BE CAST TO SHAPE, AS PER DETAILS.
ANY EXCESS ON THE GIVEN SCANTLINGS WILL NOT BE PAID FOR.
RIGID HOLES TO BE BORED PLUMB THRU, POST, SIZE NOT LESS THAN GIVEN.
PATTERN OF RUDDER FRAME TO BE TESTED BY SHIPBUILDERS REPRESENTATIVE BEFORE CASTING.

RUDDER COUPLING TO BE SUPPLIED
COMPLETE BY RUDDER MAKERS.
COUPLING FAYING SURFACES TO BE MACHINED

COUPLING KEY $3 \times 1\frac{1}{4}$ AT AFT END.
TAPERING TO $2\frac{1}{2} \times 1\frac{1}{4}$ AT FORE END.
DRIVEN FROM AFT END.
 $\frac{3}{4}$ " DIA. SET SCREW TO KEY.
(KEY NOT REQ. BY RULE)

DETAIL OF RUDDER COUPLING.
COUPLING 31" DIA.
COUPLING FLANGES 3 5/8" THICK.
SIX- 3 3/8 DIA. "FITTED" STEEL BOLTS.
EFFICIENTLY LOCKED WITH COTTER PIN.
BOLTS 22" PITCH CENTRE DIA.
CARE TO BE TAKEN THAT NUTS DO NOT FOUL.

CONSTRUCTION NOTE:-
RUBBER FRAME TO BE LAID ON TOP OF BOTTOM PLATE.
GORK MIXTURE TO BE FILLED IN THE THREE COMPARTMENTS, TO TOP PLATE LEVEL.
TOP PLATE LAID ON POSITION & ENTIRE RUBBER RIVETED COMPLETE.
BITUMINOUS SOLUTION POURED INTO THE THREE COMPARTMENTS UNTIL FULL.
CLOSING DISCS WELDED INTO FILING HOLES.

HEIGHT TO UNDERSIDE OF DECK PLATING	—	28'-10"
LENGTH OF STOCK ABOVE DECK	—	
TOTAL HEIGHT OF STOCK	—	
HEIGHT TO CENTRE OF COUPLING	—	19'-0"
TOTAL LENGTH OF RIGGER STOCK	—	

NOTE:- ALL PINTLES TO BE SUPPLIED COMPLETE BY RUDDER MAKERS
PINTLES TO BE OF STEEL, EFFICIENTLY MADE + FITTED AS PER DETAILS.

$\frac{1}{2}$ LIGNUM-VITAE LINER IN
 GUDGEON BY SPHERICAL BALL
 WITH LONG L.P.
 8 1/4"
 FORE SIDE OF RUBBER POST
 PARALLEL TO GR. LINE OF PINTLE
 3/4" DIA. PINTLE
 7/8 DIA. OVER G.M. BUSH
 1/16" CLEARANCE
 7/8 DIA. TO LG. VIT
 3/8" GUN METAL BUSH ON PINTLE
 BY RUDDER MAKER

NOTE:- CORRECT SPACING OF RUDDER
GUDGEONS TO BE LIFTED FROM STERNFRAME
BY LITHGOW'S LTD & SENT TO
RUDDER MAKERS.

[illegible]

DETAIL OF BOTTOM GUDGEON & BEARING PINTLE
SCALE 1/4" FULL SIZE
ALL DETAILS NOT INDICATED, SIMILAR TO SKETCH A

NOTE: - WHEN FITTING RUDDER,
A SLIGHT CLEARANCE TO BE LEFT BETWEEN
THE BOTTOM OF THE BOTTOM PINCLE & THE
BEARING DISC, TO ENSURE THAT THE CARRIER
IS BEARING THE ENTIRE WEIGHT OF THE RUDDER

APPROVED
WIDE REGISTER OF SHIPPING
H. Becker 6-933

LITHGOWS LTD

Nº 868.

RUDDER.

S. S. "JAMAICA PRODUCER"

GRK. FIRST ENTRY REPORT Nº 19464.

RECORDS DEPT.,
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