

23/1/28.

# T.S.S. "ORONTES." No 637.

## RUDDER PLAN.

SCALE 1/2 INCH = 1 FOOT - DETAILS AS MARKED

- UPPER PORTION OF RUDDER - CAST STEEL
- LOWER - BUILT PLATES
- RUDDER STOCK - FORGED STEEL
- PINTLE - "
- APPROXIMATE WEIGHT OF CASTING - 22 TONS
- STOCK - 8 TONS 17 CWT
- AREA OF RUDDER - 260 SQ. FT.
- MAXIMUM SEA SPEED - 19 KNOTS

### TESTS

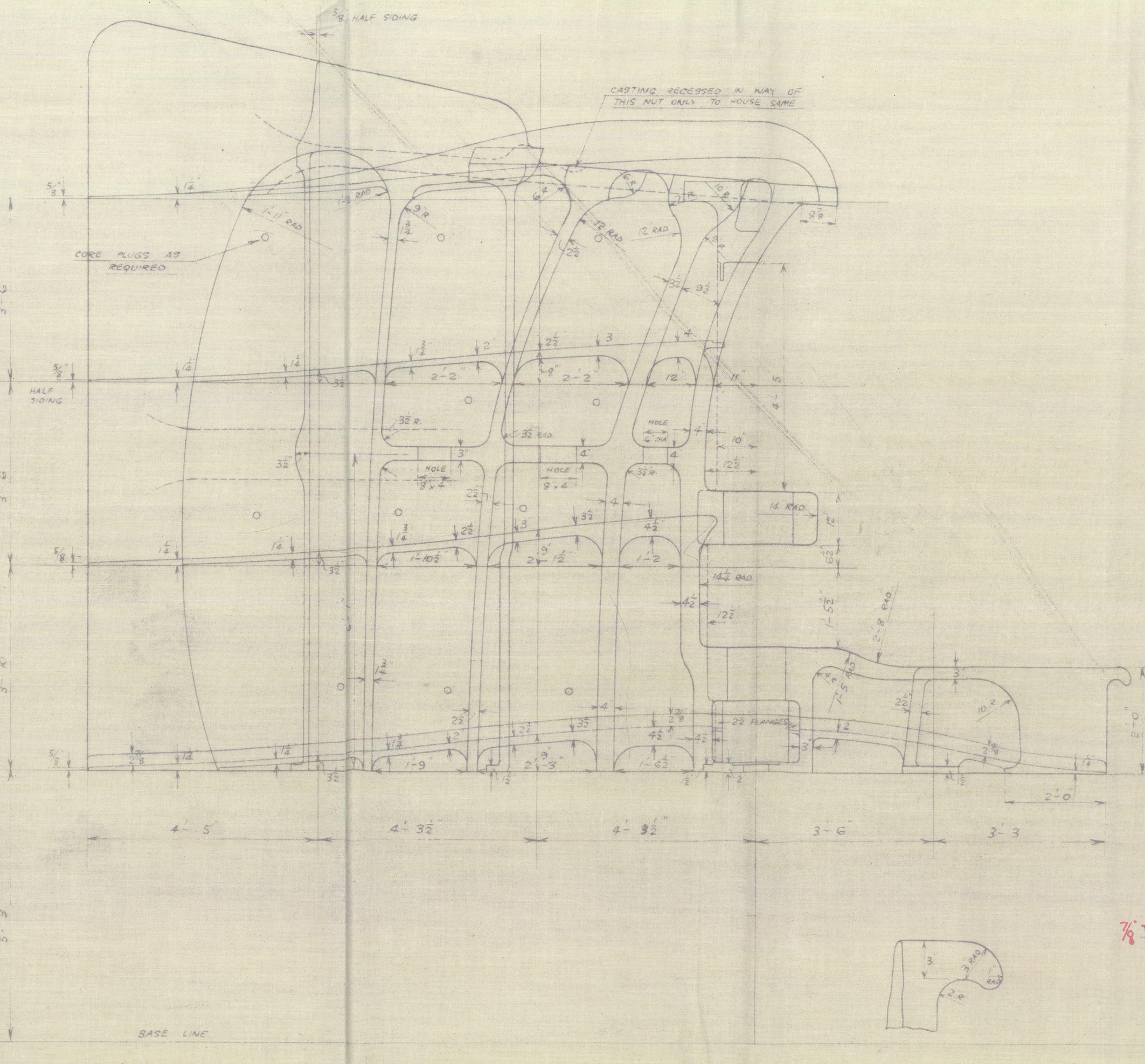
ALL FORGINGS AND CASTINGS TO PASS LLOYD'S AND BRITISH BOARD OF TRADE TESTS. THE TEST PIECES FOR LLOYD'S TESTS ARE TO BE ARRANGED BETWEEN CONTRACTORS AND THEIR LLOYD'S SURVEYORS. THE TEST PIECES FOR THE BRITISH BOARD OF TRADE TESTS ARE TO BE AS FOLLOWS:-  
1. TEST PIECE TO BE CAST ON RUDDER CASTING AS FAR AHEAD AS POSSIBLE.  
2. TEST PIECES ON RUDDER STOCK, ONE AT EACH END, PORTION OF THE TEST PIECE AT THE COUPLING END TO BE ARRANGED BY CONTRACTORS IN THE MOST SUITABLE POSITION TO ALLOW FOR THEIR MACHINING AND COMPLETING OF COUPLING.  
3. TEST PIECE ON RUDDER PINTLE IN POSITION AS SHOWN ON PLAN.  
THESE TEST PIECES MUST NOT BE CUT OFF BUT LEFT ON CASTING AND FORGINGS, AND WILL BE CUT OFF BY SHIPBUILDERS IN THE PRESENCE OF BOARD OF TRADE SURVEYORS WHEN ITEMS ARE DELIVERED.  
THE SECTIONAL AREAS OF TEST PIECES ARE SO MUCH AS TO PROVIDE FOR A NUMBER OF SEPARATE TESTS, BUT IN ANY CASE MUST BE LARGE ENOUGH TO PREVENT TEST PIECE BEING BROKEN OFF DURING TRAVEL.

### NOTES

PATTERN WILL BE SUPPLIED BY CONTRACTORS - ALL THE NECESSARY INFORMATION BEING SUPPLIED BY SHIPBUILDERS. PATTERN WILL BE CHECKED AND ALL RIVET HOLES MARKED ON PATTERN BY SHIPBUILDERS REPRESENTATIVE. RIVET HOLES TO BE DRILLED BY CONTRACTORS - 1/8" LARGER IN DIAMETER THAN RIVETS.  
CONTRACTOR TO MACHINE RUDDER STOCK TO DIMENSIONS GIVEN ON THIS PLAN AND TO SUPPLY POINT GAUGE FOR DIAMETER OF STOCK IN VIEW OF CROSSHEAD TOGETHER WITH GAUGE FOR SIDE AND POSITION OF KEYWAYS.  
CONTRACTOR TO SUPPLY STEEL WEDGE SLIGHTLY LARGER FOR FITTING PURPOSES AND KEYS, SIMILARLY LARGER WHEN TAID, SUPPOSED TO BE MACHINED BY CONTRACTOR. SHIPBUILDERS WILL SUPPLY AND FIT LIQUID VITRE STRIPS AND SELL AND THE HOLES FOR LIFTING EYES.  
BROWN DRYS TO SUPPLY CROSSHEAD TURNED, MACHINED AND CUT KEYWAYS ALSO TO SIDE CROSSHEAD TO GAUGE MADE BY RUDDER CONTRACTORS AND SUPPLIED THROUGH SHIPBUILDERS. CROSSHEAD TO BE BEARER SIDE TO SIDE WITH STOCK - NO ALLOWANCE - AND TO BE BEARER.  
1. SHIPBUILDERS AND CONTRACTORS WHEN ORDERED KEYS FITTER BY SHIPBUILDERS LOWER PORTION OF RUDDER WILL BE SUPPLIED AND FITTED BY SHIPBUILDERS INTERIOR OF LOWER PORTION OF RUDDER TO BE WELL COATED WITH BITUMEN. THE BOTTOM BEING FILLED SOLID AS SHOWN.  
TAPERED LINE TO BE FITTED IN LOWER PORTION WHERE THERE IS A DISCONTINUITY FROM TO AND RIVETS AND ALL THROUGH RIVETS.

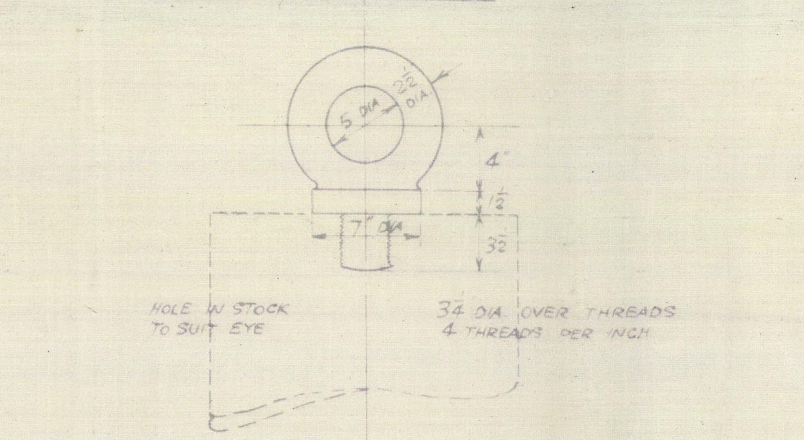
### CONTOURS

SCALE 1/2 INCH = 1 FOOT



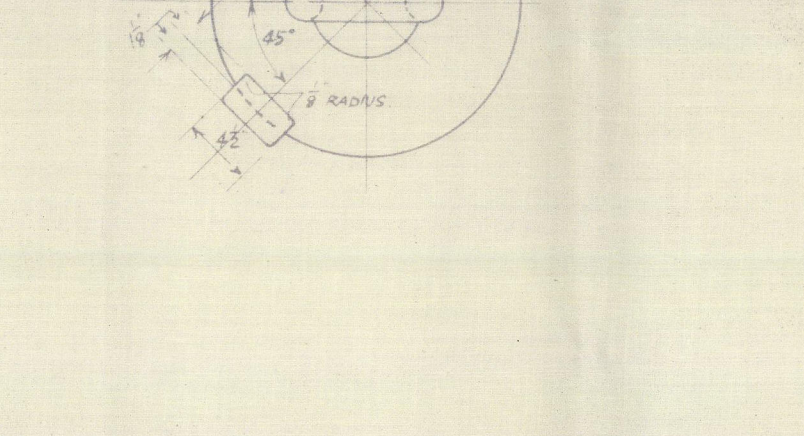
### DETAIL OF RUDDER STOCK LIFTING EYE

SCALE 1/2 INCH = 1 FOOT



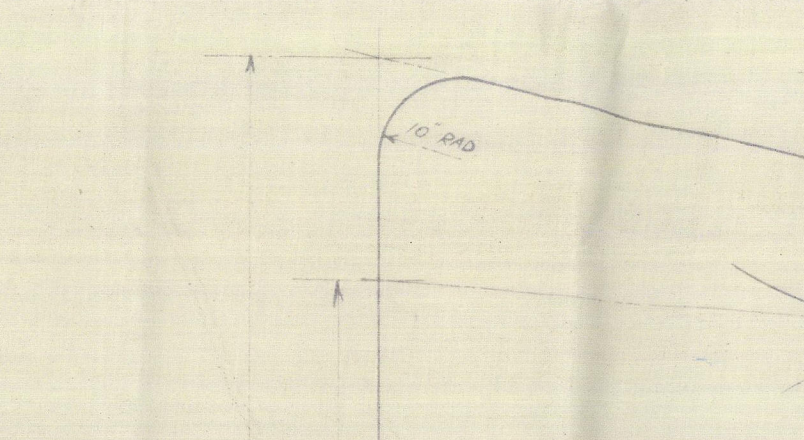
### DETAIL OF PINTLE

SCALE 1/2 INCH = 1 FOOT



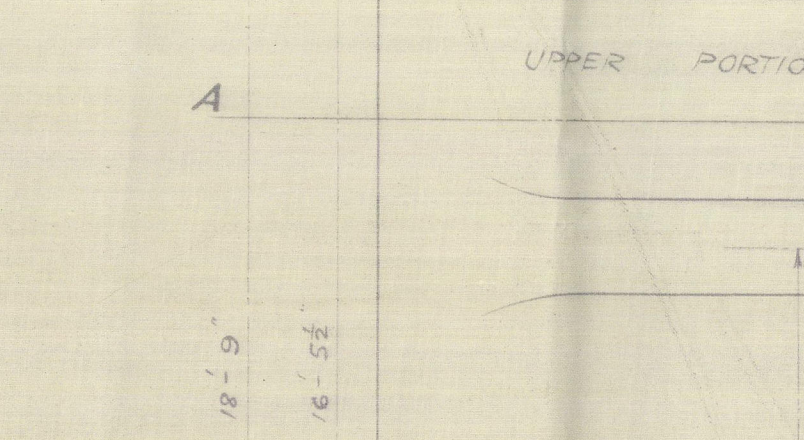
### DETAIL OF FLANGE ON G.M. BUSH

SCALE 1/2 INCH = 1 FOOT



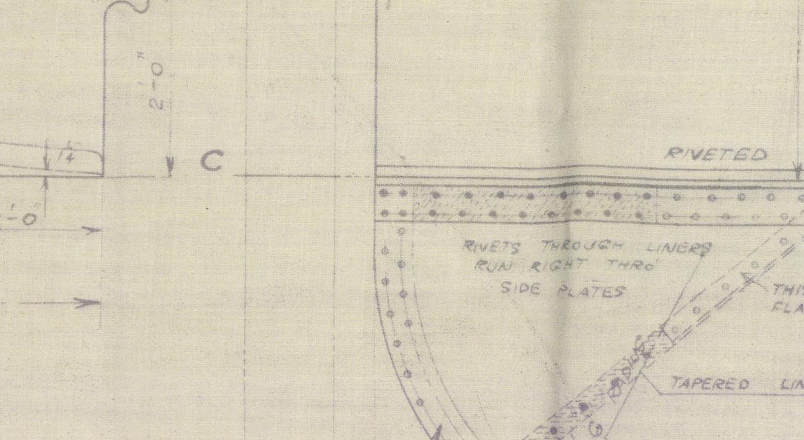
### DETAIL OF COUPLING

SCALE 1/2 INCH = 1 FOOT



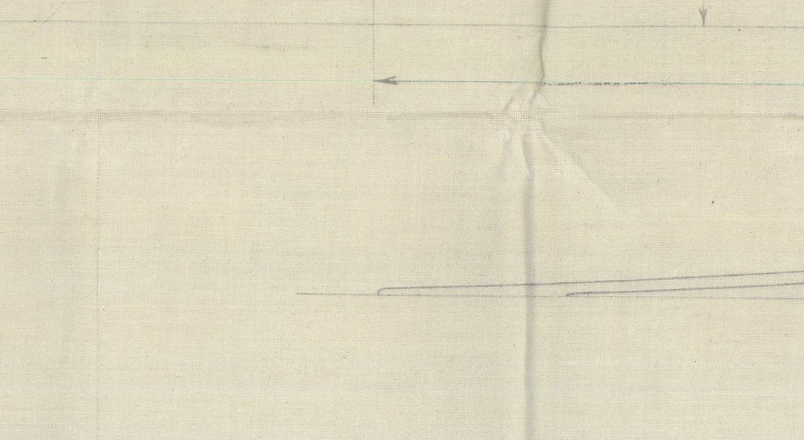
### DETAIL OF JOINT RIVETING

SCALE 1/2 INCH = 1 FOOT



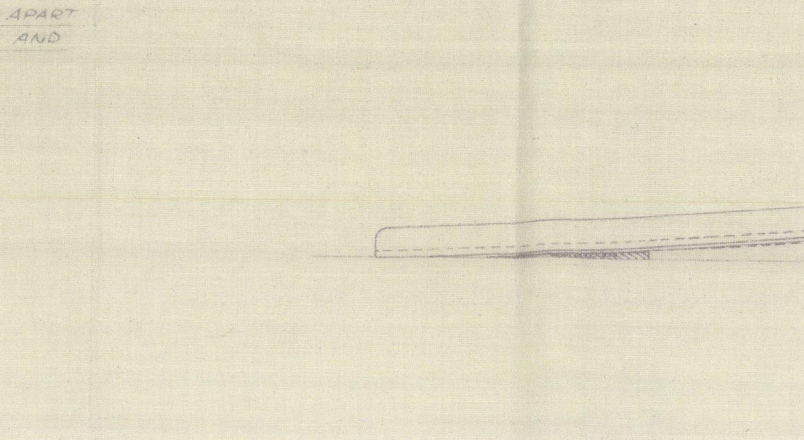
### DETAIL OF RUDDER STOP

SCALE 1/2 INCH = 1 FOOT



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T. S. S. "ORONTES"

Messrs Vickers No 637

Rudder Plan

Bowen J. E. Rpt No 2331



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003626-003624-0060