

SHIP N<sup>o</sup> 67.

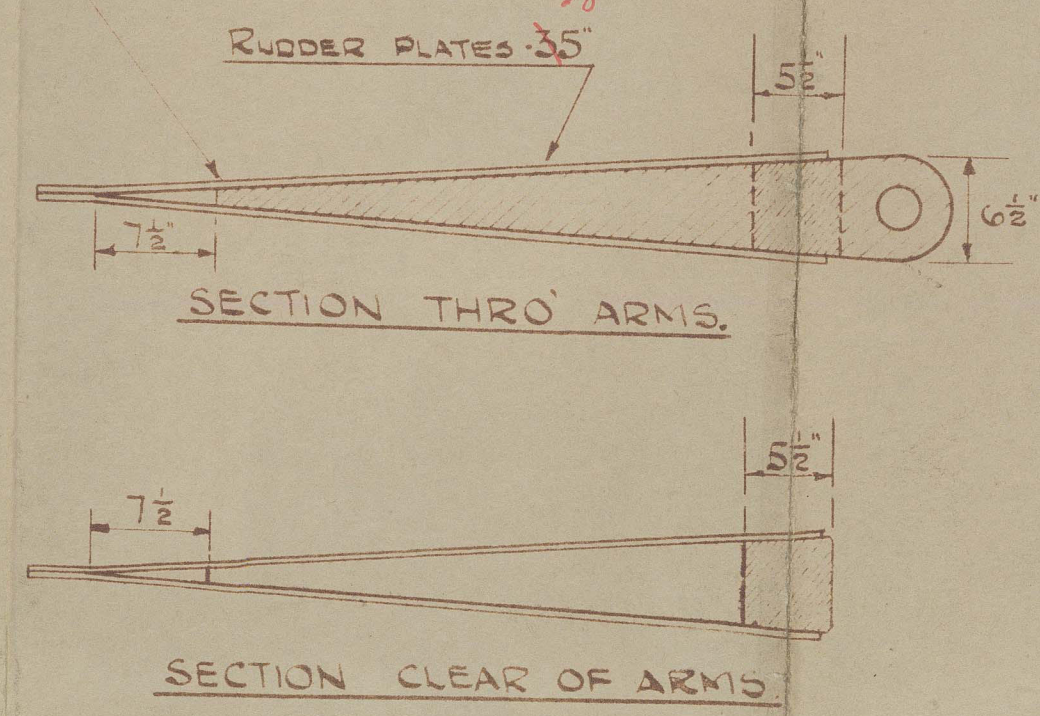
## RUDDER AND STERNFRAME.

SCALES: 1" = ONE FOOT & AS MARKED.

DIMENSIONS 190" x 35" x 30" L.M.D. 4' x 4' O.D. MILD. TO CLASS 100. ALL AT 110,000 PSI  
FIRST LONGITUDINAL NUMBER L.M.D. 2996. *Random Test* RULE STERNFRAME  $\frac{1}{4}" \times 4"$   
STERNFRAME TO BE A FORGING TO SCANTLING GIVEN.  
STERNFRAME TO BE RIVET HOLE BORED, SIZE & SPACING OF HOLES AS INDICATED  
RUDDER FRAME TO BE A FORGING  
RUDDER STOCK TO BE A FORGING  
SIZED UNDER 12 KNOTS  
TOTAL AREA OF RUDDER IMMERSED FROM FORE SIDE OF POST  
OR OF GRAVITY OF AREA FROM CR. OR LINE OF PIVOTS =  
 $1 \times 0.43 \times 0.2 \times 3 = 0.258 = 4.8 \times 0.104 \times 0.558 = 0.276$   
RUDDER STOCK TO BE ACCURATELY TUNED TO DIMENSIONS GIVEN.  
RUDDER & STERNFRAME NOT TO EXCEED SCANTLING GIVEN.  
BASED ON ONE ESTIMATED WEIGHT WILL NOT BE PAID FOR  
ALL CORNERS OF STERNFRAME & RUDDER TO BE SLIGHTLY ROUNDED  
CENTRE LINE OF STERNFRAME TO BE NICKED ALL ROUND FORGING

RIVETING  
STEELFRAME  
THROUGH RIVET HOLES TO BE BORED PLAIN THRO POST. BOSS TO BE LEFT UNDRILLED.  
POINTS OF RIVETS CONNECTING SHELL PLATING TO STERNFRAME TO BE LEFT FULL.  
RUDDER  
RIVET HOLES TO BE BORED RIGHT THRO POST, SIZE NOT LESS THAN GIVEN.

FILLING STRIP SUPPLIED  
BY RUDDER MAKER.



*Thoyers*

Byrneswood Shipbuilding Co. Ltd.  
17 OCT 1940  
DRAWING OFFICE  
Scotstoun, Glasgow.

APPROVED  
LLOYD'S REGISTER OF SHIPPING  
James K Clark 22/10/40  
DATE



(3)

D.S. 393

Blythwood S.Bloo. Ltd.

No. 64.

Rudder & Stemframe.

64 "Empire Bairn"   
GLASGOW REPORT No. 64862



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Foundation

009222-009231-0170