

SHIPS 8 & 9
STEEL RUDDER

SCALES AS SHOWN

PLAN № 19.

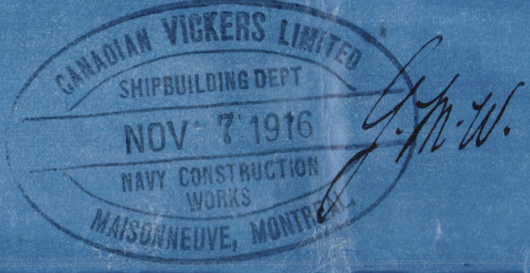
ONE OFF COMPLETE AS DRAWN FOR SHIP NO 8
NO 9

NOTES

RUDDER FRAME TO BE OF CAST STEEL

STOCK FORGED

FRAME & STOCKS BE TESTED TO LLOYDS REQUIREMENTS. CASTING TO BE CLEAN, SOUND & FREE FROM TWIST, AND AS FREE AS POSSIBLE FROM BLOW HOLES & OTHER DEFECTS. DEFECTS IN CASTING NOT TO BE MADE GOOD BY BURNING, WELDING OR PATCHING. TEST PIECES TO REMAIN ON CASTING UNTIL REMOVAL IS AUTHORISED. RUDDER GUDGEONS TO BE IN TRUE ALIGNMENT WITH EACH OTHER & WITH RUDDER STOCK. RUDDER PINNILES OF FORGED STEEL TOGETHER WITH 2 BRASS BUSHES SUPPLIED & FITTED BY MAKER. RUDDER PLATE SUPPLIED & FITTED BY SHIPBUILDER. RIVET HOLES TO BE COUNTERSUNK ON OUTSIDE OF ARM. ALL RIVETS TO HAVE FULL HEADS & POINTS. SHIPBUILDER'S REPRESENTATIVE WILL LINE OFF ALL DRILLING & MACHINE WORK.



| | | | |
|---|---|---------|----------|
| SPEED OF VESSEL UNDER 10 KNOTS PER HOUR | | | |
| AREA OF IMMERSSED PORTION OF RUDDER FROM AXIS 187 SQ FEET | | | |
| CALCULATED WEIGHT OF CASTING = 9800 LBS | | | |
| " | " | FORGING | = 5225 " |
| " | " | PLATE | = 3045 " |

Rudder.

849.

"
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Mtl 1522."



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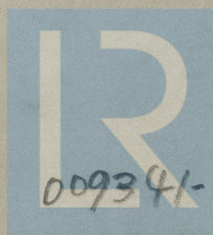
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Rudder.

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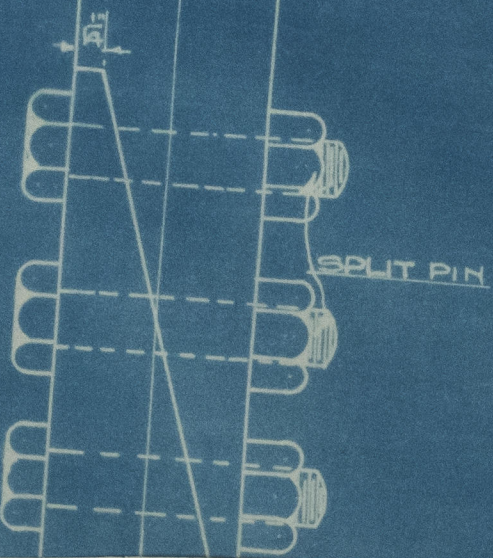
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SPEED OF VESSEL UNDER 10 KNOTS
 AREA OF IMMERSSED PORTION OF RUDD
 CALCULATED WEIGHT OF CASTING =
 " " FORGING =
 " " PLATE =



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