

PART	ITEMS	MATERIALS	NO	WEIGHT	MARKING SHEET
(1)	STEERN HEAD	CAST ST	1	15' 000"	9L 5F
(2)	RUDDER HEAD	FORGED ST	1	3' 000"	9L 5F
(3)	UPPER RUDDER FRAME	CAST ST	1	2' 500"	9L 5F
(4)	LOWER " "	CAST ST	1	7' 10"	9L 5F
(5)	UPPER RUDDER PIVOT WITH NUT	FORGED ST	1	1' 12"	9L 5F
(6)	LOWER RUDDER	FORGED ST	1	1' 80"	9L 5F
(7)	LIGAMENTS BUSH (UPPER) "	LIGAMENTS	1		9L 5F
(8)	(LOWER) "	"	1		9L 5F
(9)	GUNMETAL SLEEVE (UPPER) "	GUNMETAL	1		9L 5F
(10)	(LOWER) "	"	1		9L 5F
(11)	BOAT NUT FOR COUPLING	FORGED ST	6		9L 5F
(12)	FOR COVER BOX	MILD ST	1		9L 5F
(13)	SAULT PIN (3*)	"	2		5F
(14)	" (10*)	"	2		5F
(15)	" (5*)	"	6		5F
(16)	LINER	CAST ST	1		9L 5F
(17)	"	MILD ST	1		9L 5F
(18)	LINER FOR PIVOT SCREW	"	2		5F
(19)	DESK SCREW (1")	"	2		5F
(20)	WHITING EYE BEAT FOR RUDDER HEAD	FORGED ST	1		9L 5F
(21)	FOR PIVOT	"	1		9L 5F
(22)	COVER BOX	MILD ST	1		5F
(23)	ZINC PLATE	ZINC	26		9L 5F
(24)	SET SCREW FOR ZINC PLATE	BRASS	78		5F
(25)	ZINC PLATE CLIPS	MILD ST	26		5F
(26)	BASE PLATE	"	2		5F
(27)	BUSH CLIPS	BRASS	1		5F
(28)	SET SCREW FOR BUSH	BRASS	6		5F
(29)	WHITING EYE PLATE	MILD ST	1		9L 5F
(30)	KEY OF RUDDER HEAD	FORGED ST	1		9L 5F
(31)	RUDDER PLATE	MILD ST	1		5F
(32)	SET SCREW FOR RUDDER HEAD	BRASS	3		5F

TEST PIECE FOR WELDING AT THE RABBIT
MATERIAL ~ CAST STEEL

PHYSICALS OF RUDDER			
1	RUDDER AREA	A	15.147 16.505
2	RUDDER AREA ABOARD CL OF MIDDLE	A_m	10.785 11.609
3	" " BEFORE " " "	A_b	4.347 4.735
4	AREA RATIO	$A/L \times d$	$1/45.4$
5	BALANCE RATIO	A^2/A_1	2.47
6	MAX SEA SPEED		13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

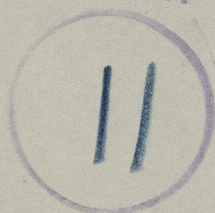
1. ALL MATERIALS TO BE QUALIFIED FOR RULES OF LLOYD'S REGISTER OF SHIPPING & NIPPON KAIKYO KAI AND MANUFACTURED UNDER THE SPECIAL SUPERVISIONS OF THESE SURVEYORS.
2. CRUST BE RUDDER TO BE PERFECTLY WATER TIGHT AND TIGHTNESS TO BE TESTED WITH WATER TO PRESSURE OF 149 cm^2 .
3. CHEMICAL PROPERTY OF CAST STEEL :-

FOR LAP WELDING OF SHELL PLATE TO STERN FRAME AND RUDDER PLATE TO RUDDER FRAME
CARBON CONTENT TO BE NOT OVER 0.23%

WORKING	SIGNS ~
<u>✓</u>	SMOOTH NOT TO BE MACHINED
<u>∇</u>	ROUGHLY TO BE MACHINED
<u>∇∇</u>	PERFECTLY " " " "
<u>∇∇∇</u>	EXACTLY " " " "

CONFERED WITH FITTING DESIGN BRANCH

RECORDS DEPT
LONDON



Tokyo Maru
Sternframe

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