

SHIP No. 481.
STERNFRAME & RUDDER.

SCALE: ~ 1"=1 FOOT & AS MARKED.

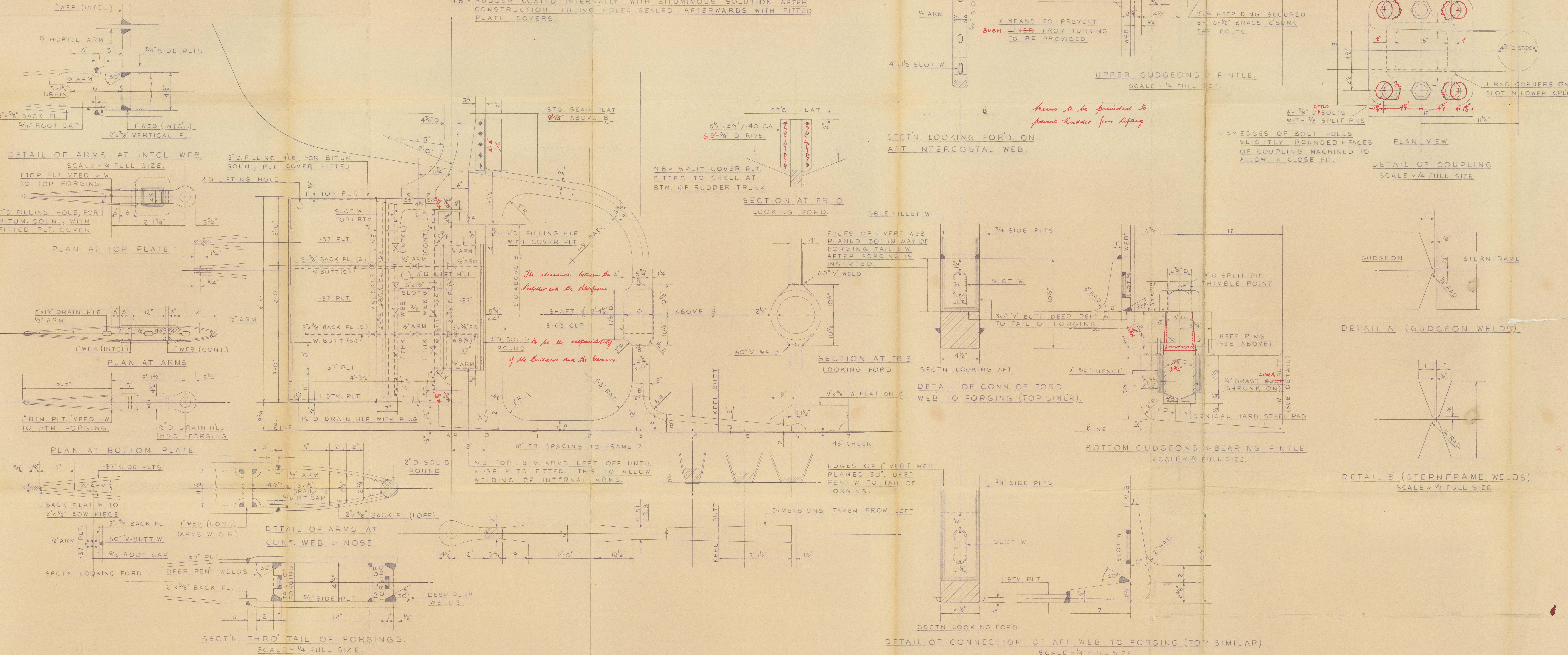
MOULDED DIMS. ~ 16'-6" x 33'-0" x 10'-6".
LOAD DRAFT ~ 9'-3".
AREA OF RUDDER ~ 31.0 SQ.FT.
CENTROID ABAFT PINTLES ~ 2.12'.
NUMERAL A x D ~ 65.72.
SERVICE SPEED ~ 9.5 KNOTS.
DIAM. OF RUDDERSTOCK ~ 4 3/4". (BOUGHT IN).
STERNFRAME TO BE FABRICATED FROM BEST MILD STEEL
BILLET IN ACCORD'CE WITH LLOYDS' REQUIREMENTS & TESTS.



FABRICATION NOTES ~
3/4" PORT SIDE VERTICAL PLATE LAID DOWN & FORD 1" VERT WEB
CONNECTED. 1/2" HORIZL. ARMS W. TO 3/4" PORT SIDE PLT. & FORD WEB.
3/4" STBD. SIDE VERT. PLATE W. TO ARMS & FORD WEB. TOP & BOTTOM
FORGINGS W. INTO PLACE IN CENTRE BOX. DEEP PENETRATION W.
OF FORD. WEB TO FORGING TAILS NOW COMPLETED. 1" AFT VERT.
WEB W. INTERCOSTALLY BETWEEN HORIZ. ARMS. CENTRE BOX
PORTION NOW COMPLETE. FORD ARMS (EXCEPTING TOP & BTM. ARMS)
W. TO FORD VERT. WEB. PORT NOSE PLATE W. IN POSITION ALONG
WITH 2" D. SOLID ROUND. STBD. NOSE PLATE ADDED IN SECTIONS
& W. IN PLACE. TOP & BTM. FORD ARMS NOW CONNECTED. 37" PORT
AFT SIDE PLATE CONNECTED TO ARMS ETC. 1" TOP & BTM. PLATES
POSITIONED. BOWPIECE & BACK FLATS W. IN PLACE. 37" STBD. SIDE
PLATES ADDED IN SECTIONS & WELDED.

WELDING PROCEDURE ~
CARE TO BE TAKEN TO AVOID UNDERCUTTING AT WELD BOUNDARIES.
& WELDS TO PENETRATE FULL THICKNESS OF MATERIALS.
PREHEATING TO ABOUT 200°C TO PRECEDE WELDING. WELDING TO
BE CARRIED OUT WITH LARGE ELECTRODES USING HIGHEST
CURRENTS SUITABLE TO SIZE & TYPE, & ONCE COMMENCED TO
PROCEED, WITHOUT INTERRUPTION, ON BOTH SIDES SIMULTANEOUSLY
TO MINIMISE DISTORTION, UNTIL COMPLETE WITHOUT ALLOWING WORK
TO COOL. FINISHED WELDS BLANKETED TO ENSURE SLOW COOLING.

N.B. ~ RUDDER COATED INTERNALLY WITH BITUMINOUS SOLUTION AFTER
CONSTRUCTION. FILLING HOLES SEALED AFTERWARDS WITH FITTED
PLATE COVERS.



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STERNFRAME & RUDDER.

HENRY ROBB LIMITED

YARD No. 481.

M.T. "TORO".

LEITH RPT. No. 25047.



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Lloyd's Register
Foundation

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