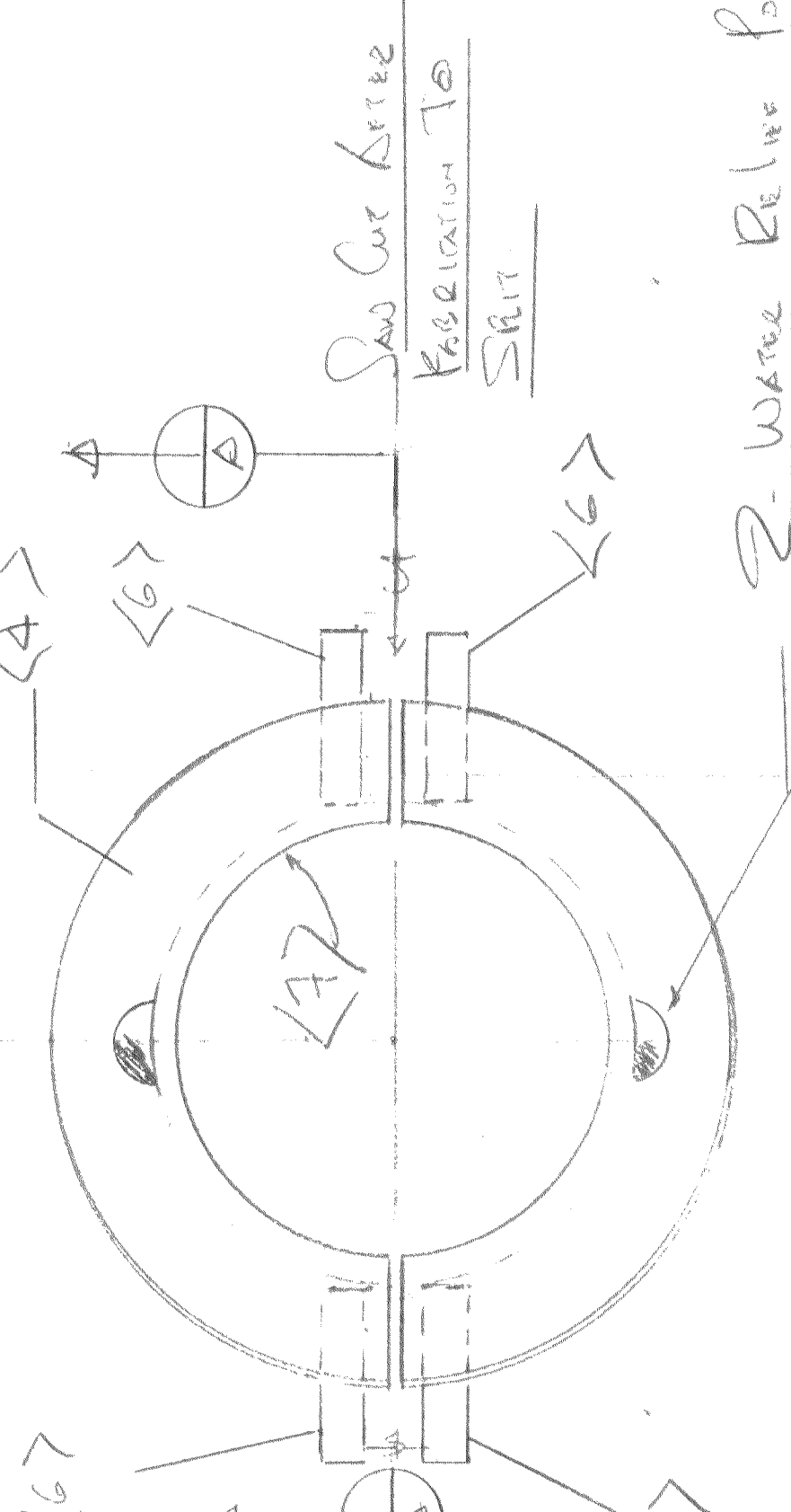


5" Rudder Stock
No Reinforcement
Required on Top
Side



Remove
Adhesive From
Flange, Fit
Some Welding
Force

Reinforce
Under Side To
Transition From
Flange To Stock

Remove
Adhesive From
Flange, Fit
Some Welding
Force

Remove
Adhesive From
Flange, Fit
Some Welding
Force

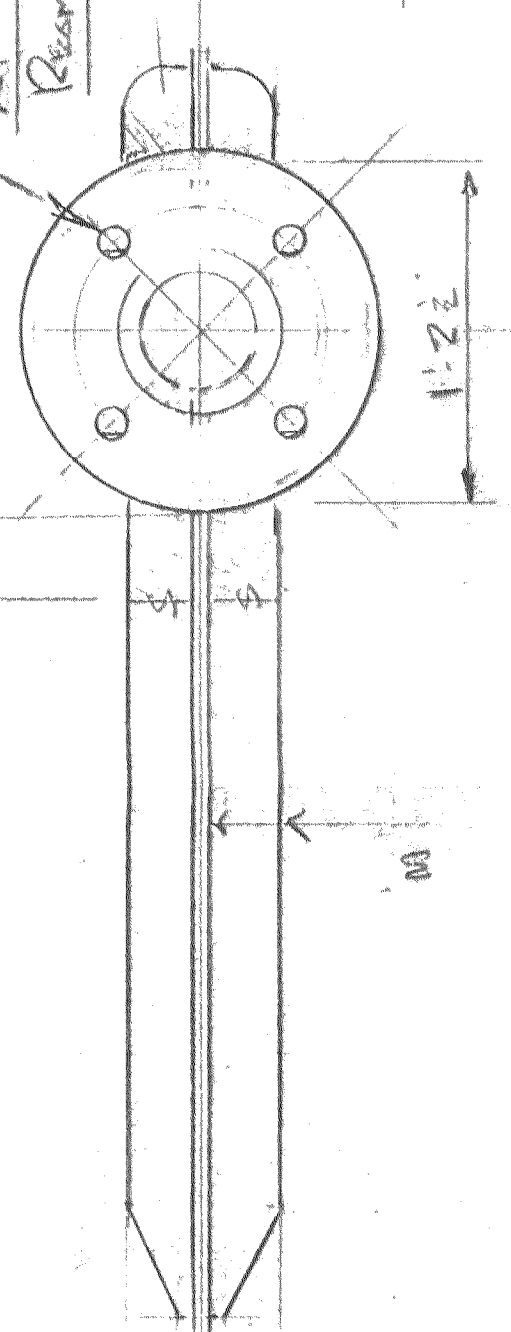
Remove
Adhesive From
Flange, Fit
Some Welding
Force

Rudder Flange Weld Detail

Scale: 1:1

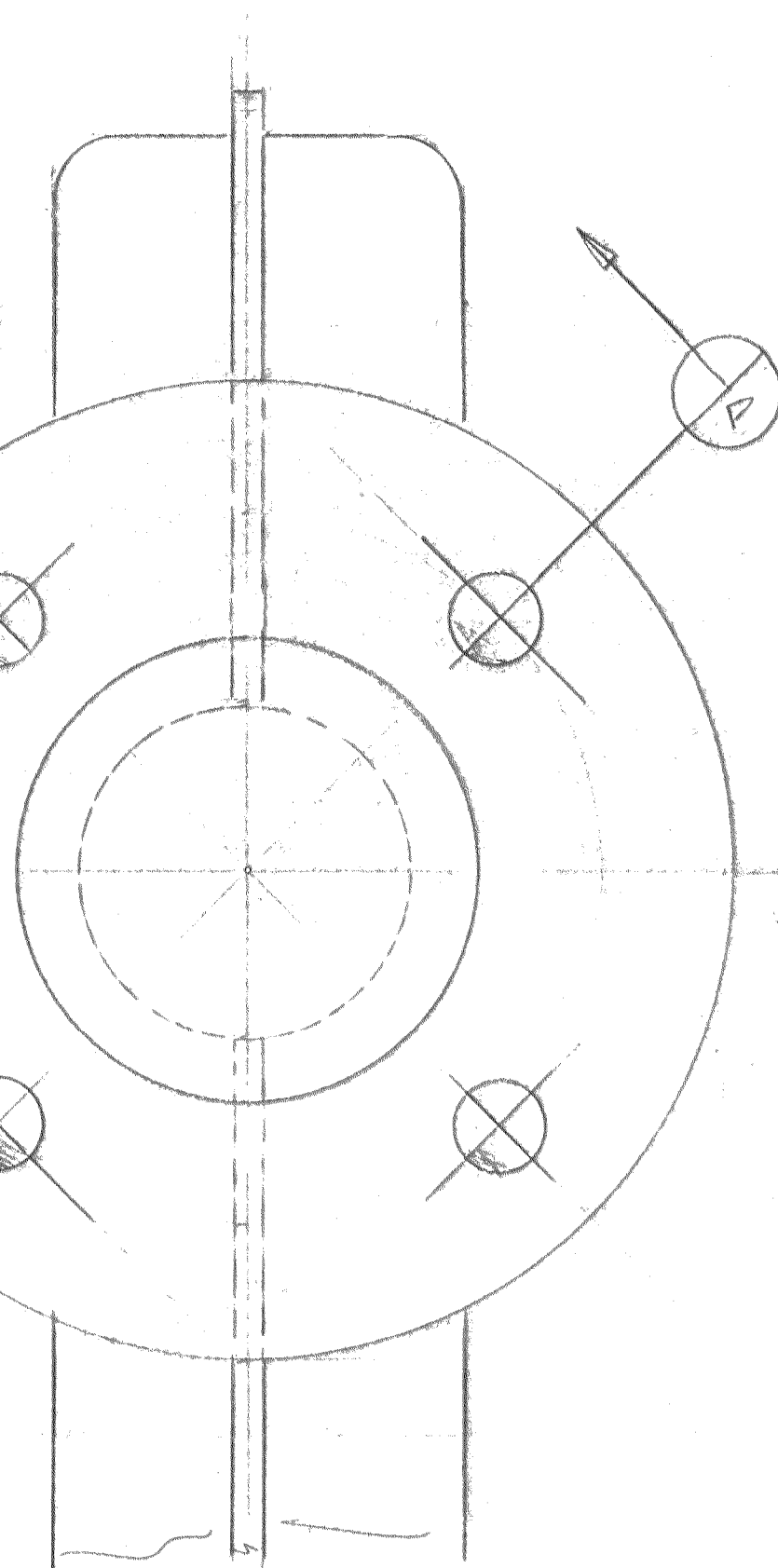
Use Staggered Bolts And Alternate
Position To Minimize Distortion

Drill 4 Holes At 1 1/2" Dia
At 10.500" P.C.D. And
Run To 1.375" Dia.

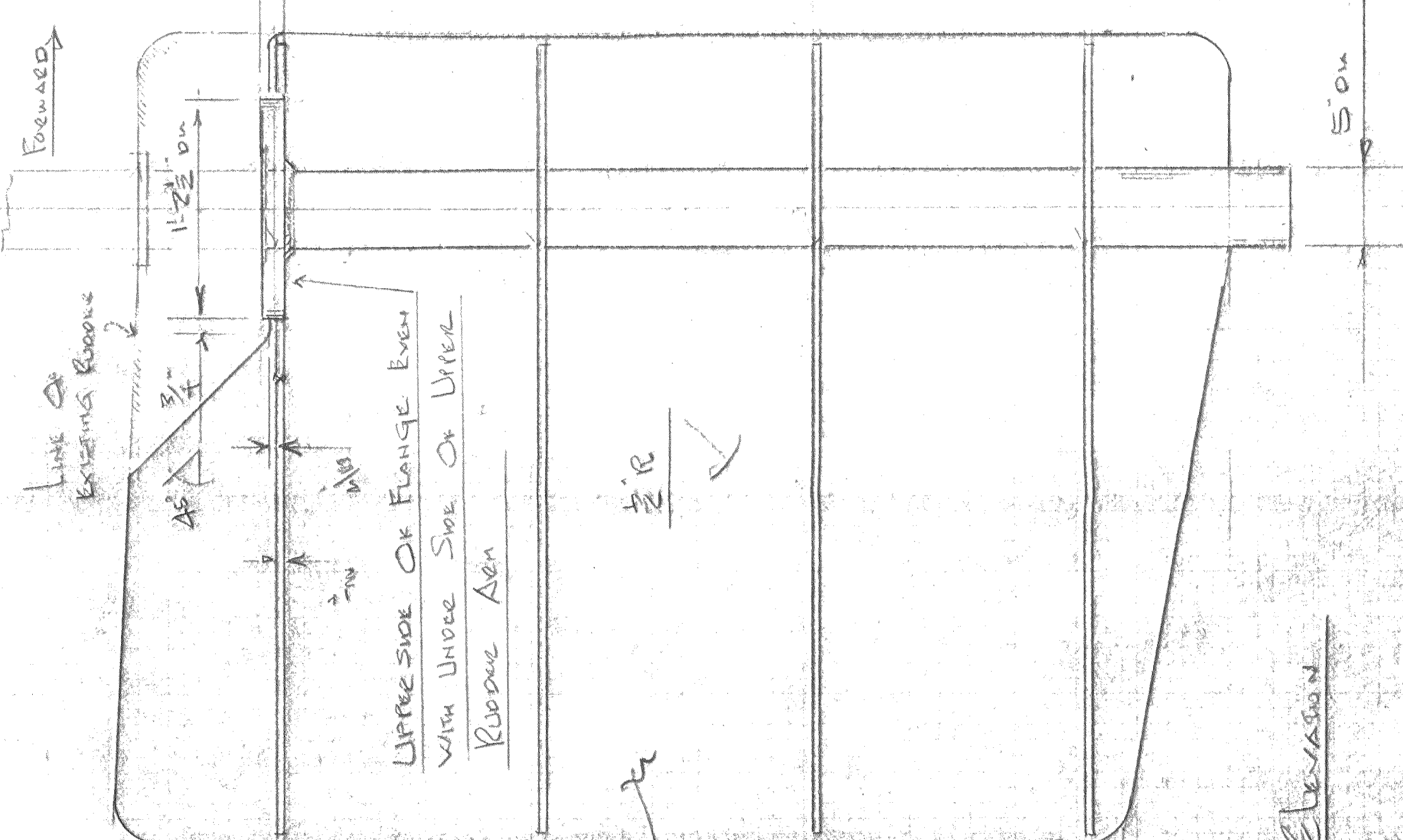


Plan View

Drill 4 1 1/2" Dia. Holes - On
10 1/2" P.C.D. Run To 1.375"
Dia. For Fitted Bolts



Forward

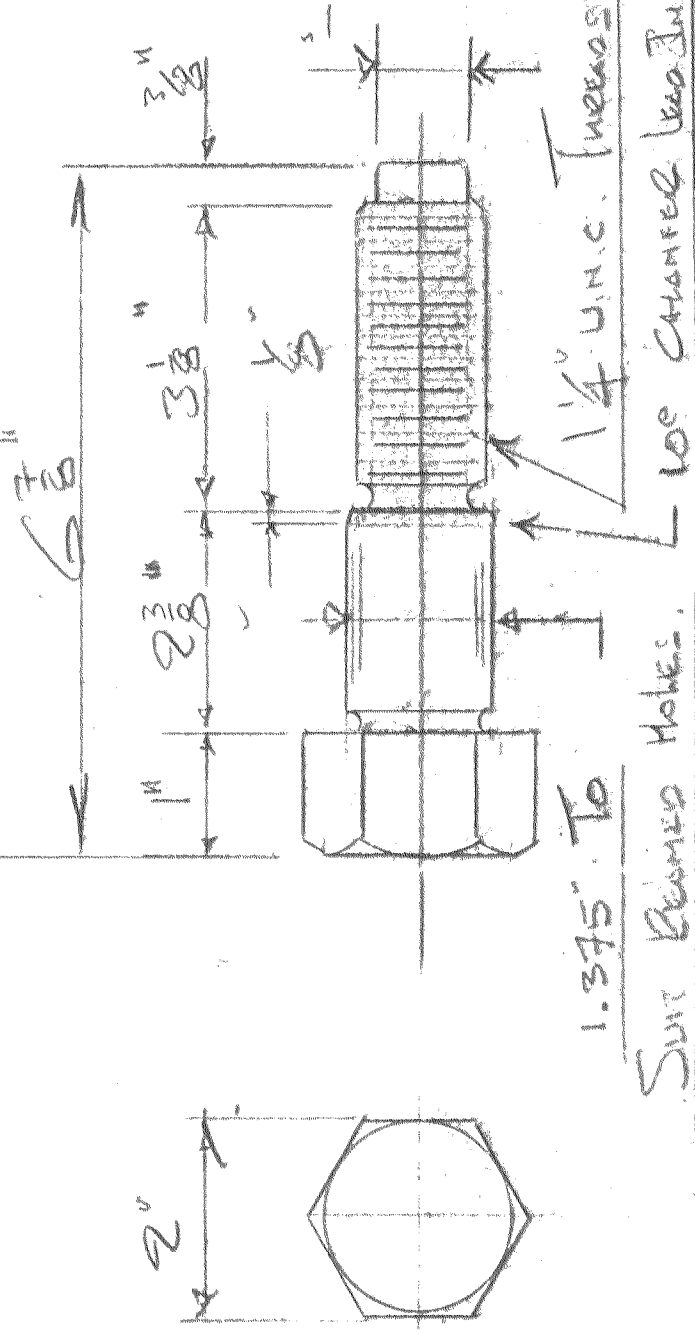


Elevation

Rudder Assembled
Scale 1/2" = 1 Foot

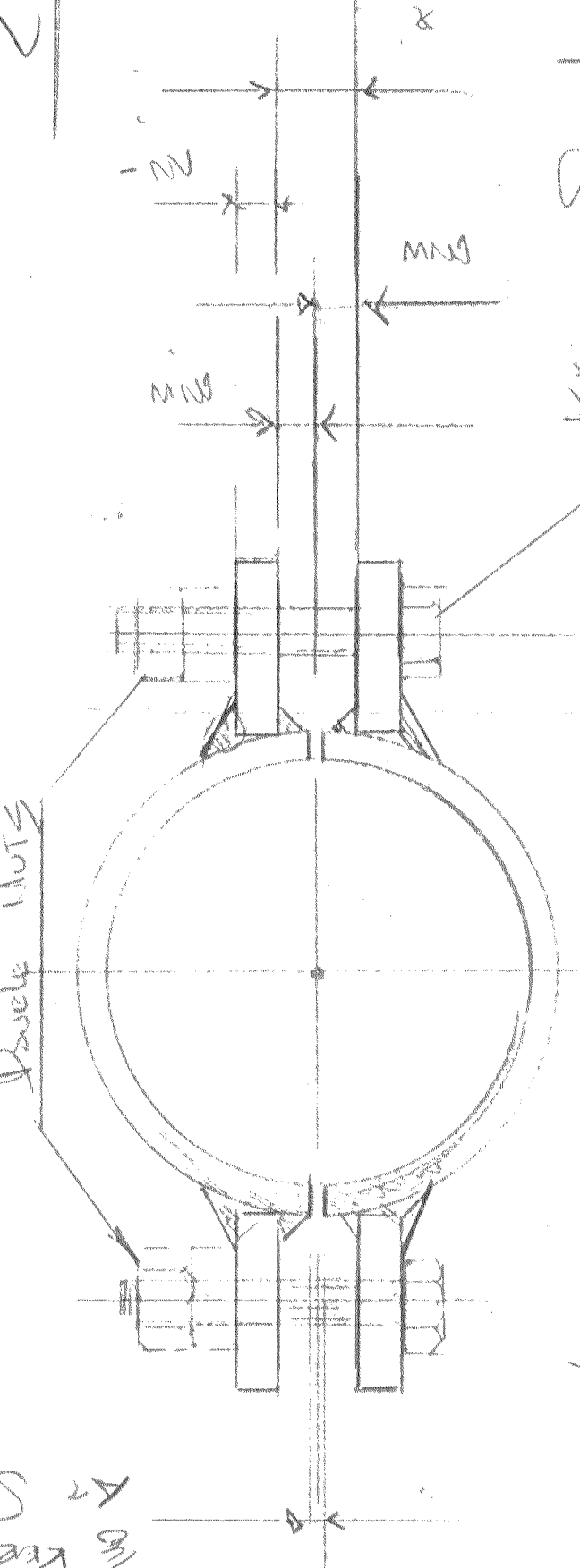
Rudder Top Flange Machining Detail

Holes Shown Enlarged

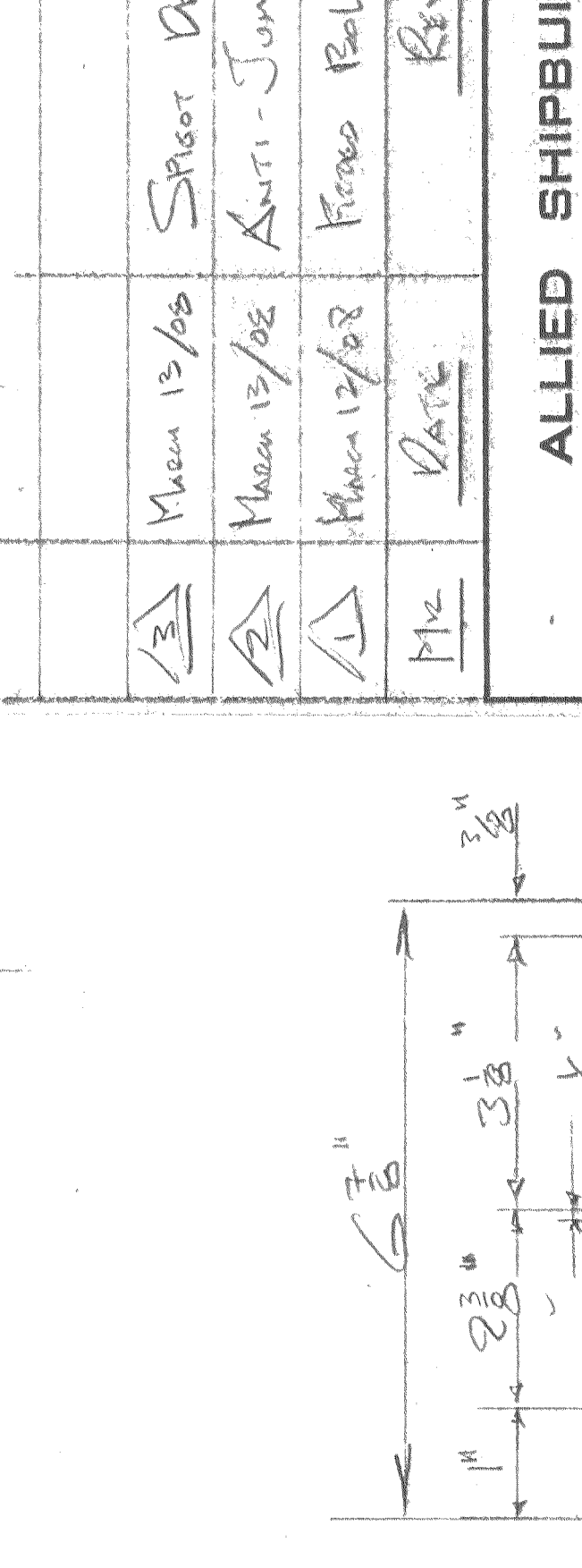


Rudder Coupling Bolts - 8 Required
Material: A36 Annealed

View A-A

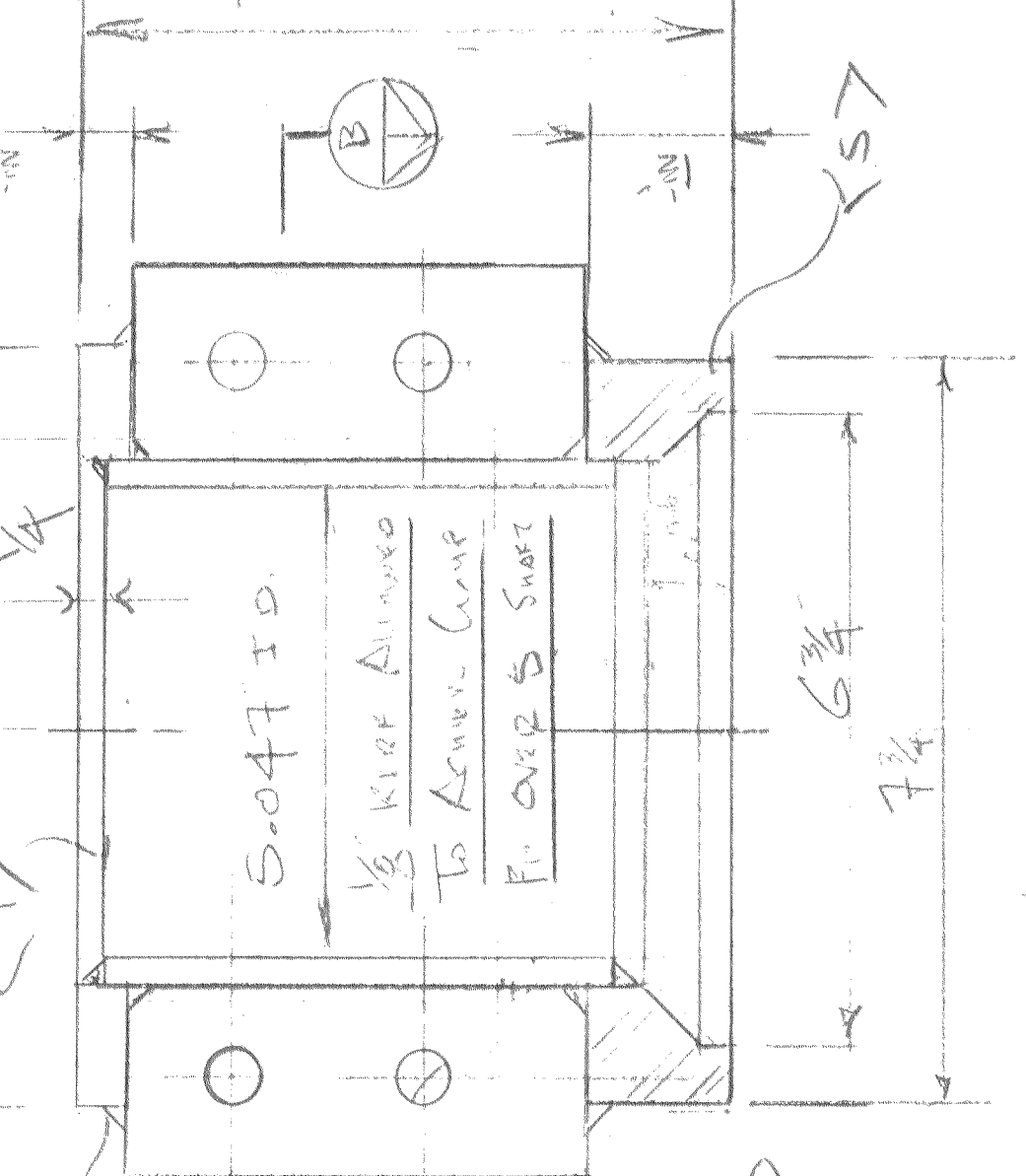


View B-B



Anti-Jump Collar Detail
2 Bolts - Mild Steel

Clearance To Acquire
Stock Flange Fit Lower
Top Side Of Rudder
Or Rudder Tack
Between Under Side
Heads Of Detent
6" Min Normal Height
1" Min



1/2" UNC Stainless Steel Bolt - 3' Long
c/w Dangle Nuts

ISSUED
MAR 19 1988

13	March 13/88	Sharon Depp	Checked
12	March 13/88	Anti-Jump Collar Added	
11	March 12/88	Fixed Bolts Added	
10	DATE	REVISIONS	

ALLIED SHIPBUILDERS LTD.
NORTH VANCOUVER, CANADA

ALASKA DEPARTMENT OF FISH & GAME
JUNEAU, ALASKA

R.V. "Medea"

Drawn By	CHK	Approved By	
Date	March 6, 1988	Approved By	
Scale	As Noted	Approved By	
Design No.	1331	Doc. No.	1331-2 Rev 3