

- # REMOVAL PROCEDURES
- RUDDER
1. REMOVE COUPLING BOLTS & KEY.
 2. POSITION DITCH 37 1/2" OVER ONE SIDE.
 3. BUDDER 62 1/2" OVER.
 4. FIT LIFTING EYES TO SHIP.
 5. RIG LIFTING TACKLES.
 6. LIFT RUDDER & PINTLES CLEAR. GUESS-ONE / MOVE CLEAR OF STERN FRAME.
 7. LOWER RUDDER ON TO SUITABLE TRANSPORT DEVICE FOR REMOVAL FROM DEYDOCK.
- PINTLES
- TO REMOVE BOTTOM PINTLE. REMOVE RUDDER FIRST.
- GUESS-ON BUSHINGS
- REMOVE RUDDER FIRST.
- RUDDER STOCK
1. LEAD DOCK CRANE WIRE THROUGH HATCHES IN FLIGHT UPPER DECK & SECURE TO STOCK LIFTING EYE.
 2. REMOVE TIEWIRE.
 3. BUDDER.
 4. LOWER THE STOCK UNTIL JUST CLEAR OF GUESS-ON. SUPPORT FROM DECK FLOOR & RELEASE CRANE WIRE.
 5. REMOVE STEERING GEAR.
 6. MAIN BEARING & ISLAND.
 7. STEADY BEARING CAP.
 8. RE-ATTACH CRANE WIRE.
 9. LOWER THE STOCK ON TO SUITABLE TRANSPORT DEVICE FOR REMOVAL FROM DEYDOCK.

TESTING:

AFTER COMPLETION THE RUBBER IS TO BE TESTED BY A HEAD OF WATER OF 2.44M (8 FT) WHILE SAID ON ITS SIDE TO THE DATE PORTION OF FLOODS, C.S. & OWNER.

INTERNAL TREATMENT:

FOLLOWING TREATING THE INTERNALS ARE TO BE COATED, WITH A SYNTHEMATIC COMPOSITION BY MEANS OF FILLING & DRAINING.

REFERENCE:

- 47 RUBBER STOCK
- 48 RUBBER- AND STEEL FRAME CASTINGS
- 49 ICE GUARD TIME STEERING
- 50 STEERING CLEAR AIR

CONCLUS:

STRUCTURAL GROUP G

MATERIAL REQUISITION 22/2-58-N2

RUBBER TUNING: (STRUCTURAL)

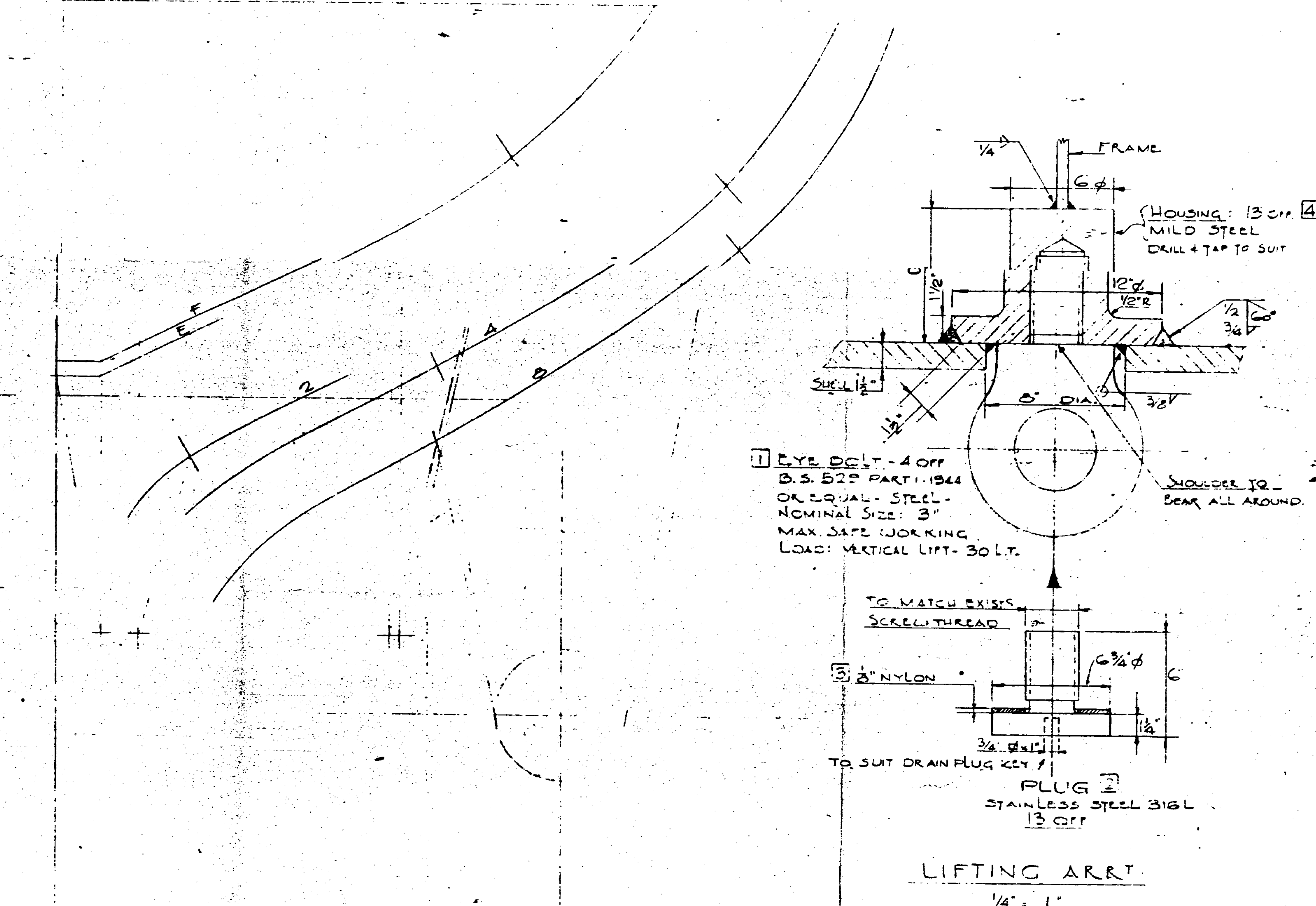
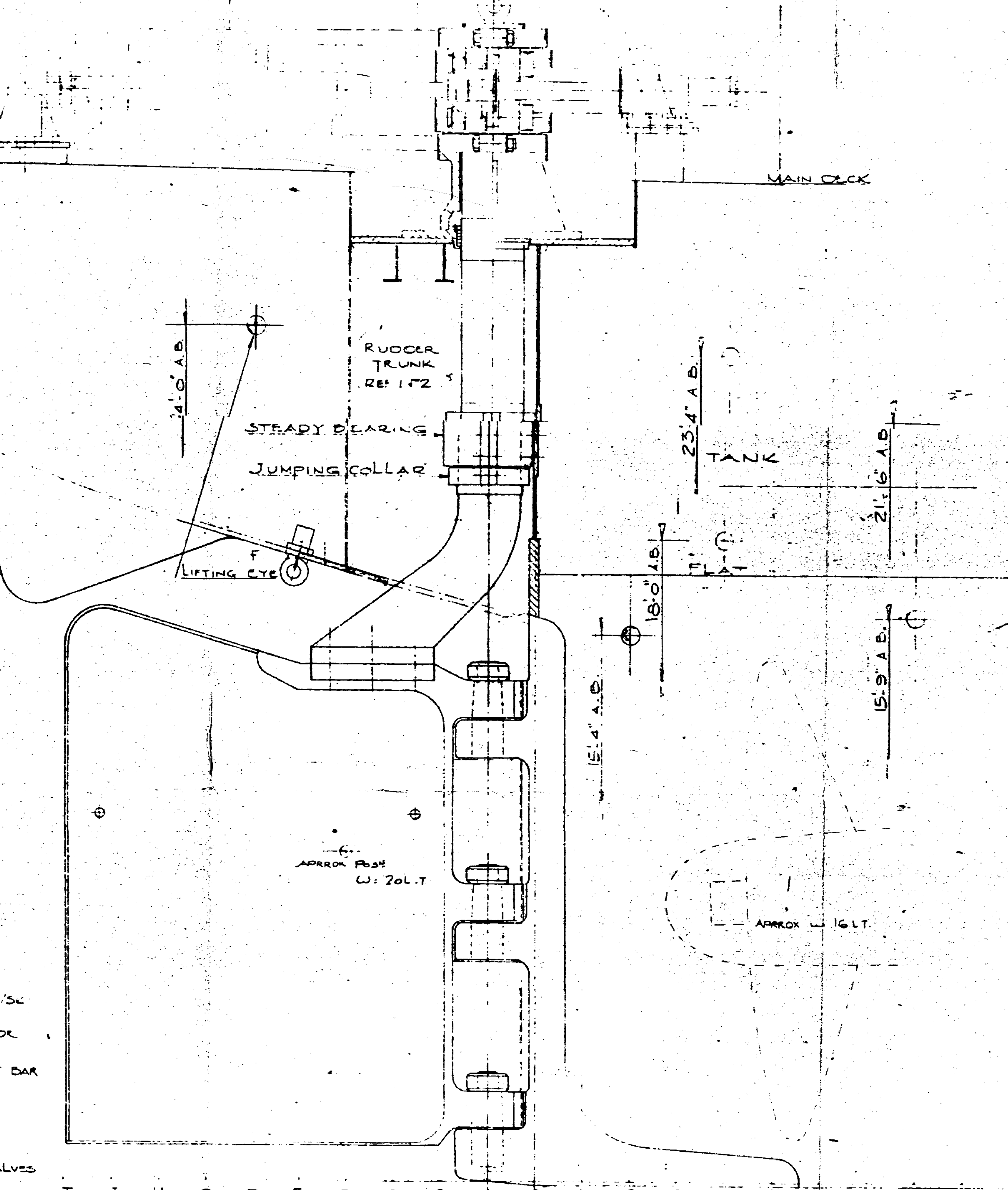
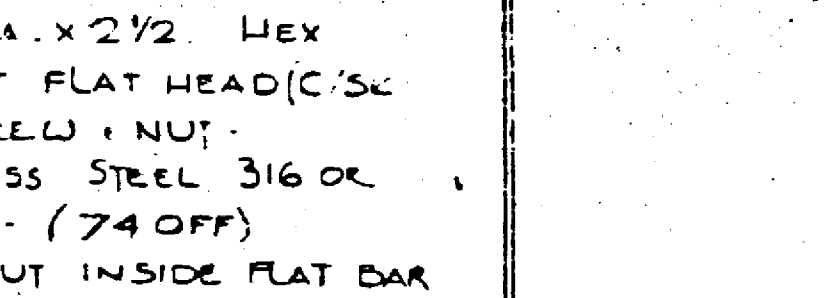
REF. FLOORS REL. TO AIR DUNE V

- 2 HELICOPTER FUEL & T.W. 1

FOR COORDINATES

PRO. 28 DUNE V

NOTE:
STEAM DE-ICING CONNECTION
209° FOR RUDDER TRIM



CASTINGS AND/OR FORGINGS TO BE OF WELDABLE QUALITY CONTAINING NOT MORE THAN 0.23% CARBON AND TO COMPLY WITH PART 2 OF THE RULES.