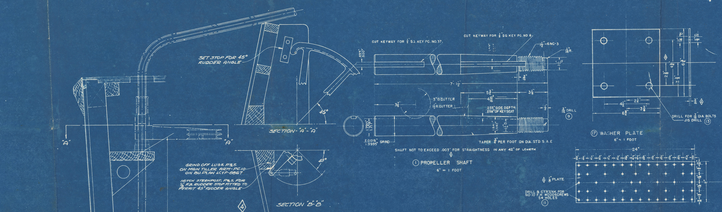

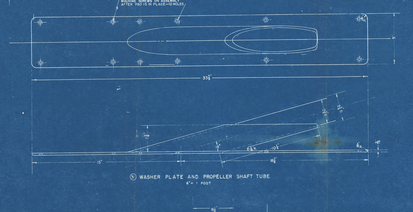

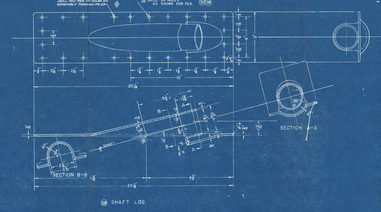

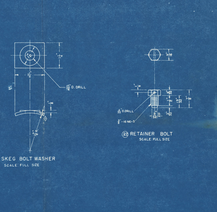

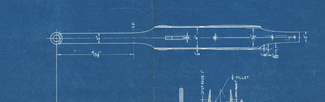

SET STOP FOR 45° RUDDER ANGLE
SECTION "A"-"A"
GRIND OFF LUGS. P&S. ON MAIN TILLER ARM-PC.10 ON BU. PLAN LCVP-8867
NOTCH STERNPOST, P&S. FOR 1½" F.B. RUDDER STOP FITTED TO PERMIT 45° RUDDER ANGLE
SECTION "B"-"B"
CUT KEYWAY FOR ½" SQ. KEY PC. NO. 37
CUT KEYWAY FOR ½" SQ. KEY PC. NO 6
1½"-6NC-3
3" D. CUTTER
1½" R. CUTTER
.255" SIDE DEPTH .258" OF KEYSEAT
GRIND
TAPER ¾" PER FOOT ON DIA. ST'D. S.A.E
SHAFT NOT TO EXCEED .007" FOR STRAIGHTNESS IN ANY 42" OF LENGTH
① PROPELLER SHAFT
6" = 1 FOOT
DRILL FOR 7/16" DIA. BOLTS JIG DRILL ⑬
⑰ WASHER PLATE
6" = 1 FOOT
⅛" PLATE
DRILL & CTR'SNK. FOR NO 10 F.H WOODSCREWS 54 HOLES ⑪
⑩ PROTECTION PLATE
3" = 1 FOOT
DRILL & CTR'SNK FOR ¼" D.O.H. MACHINE SCREWS ON ASSEMBLY AFTER PAD IS IN PLACE-12 HOLES
㉛ WASHER PLATE AND PROPELLER SHAFT TUBE
6" = 1 FOOT
DRILL THIS PAIR OF HOLES ON ASSEMBLY THROUGH PC. 23
17/64" DRILL-24 HOLES AS SHOWN FOR PCS. ㉚㊳
SECTION A-A
SECTION B-B
SHAFT
㉙ SHAFT LOG
㉗ SKEG BOLT WASHER
SCALE: FULL SIZE
D. DRILL
㉒ RETAINER BOLT
SCALE: FULL SIZE
3/32" D. DRILL
⅜"-16 NC-3
6'-1¾" CHECK WITH LOFT
TOWING BIT STEP
CHINE
FOR STRUT ARRANGEMENT AND DETAILS SEE BU. PLAN LCVP-8997
ASSEMBLY
3" = 1 FOOT
NOTE: TAPER KEEL FROM 1¼" THICKNESS TO 1" BETWEEN FR. 19½" AND 21
BASE LINE
NOTE: FINISH ALL OVER
㉜ GLAND
㉝ LOCK NUT
㉞ PACKING NUT
SHAFT LOG STUFFING BOX
2¼"-12 N-3
T.P.
SPOT FACE 1"
FILLET
A-A
B-B
C-C
SECTIONS
2¼" SPOT FACE
1.312" ± .005" DRILL
REAM FOR PC. 28
DRILL & SPOT FACE FOR ½" D. HEX. HEAD BOLT, PC. 19
½" DRILL-CTRSNK FOR ½" D. O.H. MACH. BOLT-1 HOLE ⑳
DRILL & CTRSNK FOR NO. 10 F.H. WOOD SCREWS ㉕
FR. 24
FR. 25
FR. 27
FR. 28
㉔ SKEG SHOE
3" = 1 FOOT

SCHEDULE OF MATERIAL

QUANTITY REQUIRED FOR ONE BOAT

Pc No.	NAME	PCS	SPEC.	MATERIAL	DIE	REMARKS
1	SHAFT	1	46B6	COMP. NR.		2" DIA. x 7' - 1½"
2	PIN	1	46S1	GR. "M" STL.		½" DIA. X 3¾" WITH ENG.
3	KEY	1	46S1	GR. "M" STL.		½" SQ. X 3¾" " "
4	COUPLING	1	COM'L.	STEEL		FURNISHED WITH ENG.
5	PROPELLER	1	49B3	COMP. Mn-c		22" X 20" R.H.
6	KEY	1	MIL-B 895	BRASS ROD		½" SQ. X 4⅜"
7	STANDARD NUT	1	43B11	BRASS		1½"-6NC-3
8	JAM NUT	1	43B11	BRASS		1½"-6NC-3
9	COTTER PIN	1	42P7	BRASS		⅛" X 2"
10	PROTECTION PLATE	1	MIL-B 895	BRASS		8" X 24" - ⅛" PLATE
11	WOOD SCREWS	54	42S1 46B27	COP. SIL.		1½" - NO. 10 F.H.
12	STRUT, SHAFT	1	49B3	COMP. MN-c		SEE LCVP - 8997
13	STRUT BOLT	12	43B11 46B27	COP. SIL.		7/16" X 4½" O.H.
14	STRUT BOLT	2	43B11 46B27	COP. SIL.		7/16" X 8½" O.H.
15	WASHER	6	MIL-W 1165	BRASS		7/16" FLAT
16	WASHER	2	MIL-W 1165	BRASS		½" FLAT
17	WASHER PLATE	1	49B3	COMP. Mn-r		
18	NUT	29	43B11	BRASS		7/16" HEX.
19	BOLT, HEX. HEAD	4	46B27	COP. SIL.		½" D. L'GTH TO SUIT
20	NUT	4	43B11	BRASS		½" FOR PC. 19
21	2" DIA. SHAFT STRUT BEARING	1	COML.	RUBBER		GOODRICH CUTLESS AKERITE, OR EQUAL
22	RETAINER BOLT	4	MIL-B 895	BRASS		
23	WIRE	1	22W9	COPPER		NO. 15 BARE
24	SKEG SHOE	1	49B3	COMP. MNc		
25	WOOD SCREW	2	46B27	COP. SIL.		3½" - #16
26	STRUT BOLT	1	46B27	COP. SIL.		[illegible]
27	SKEG BOLT WASHER	1	49B3	COMP. MN-c		
28	PIN	1	MIL-B 895	BRASS ROD		7/16" DIA. X 2⅜"
29	SHAFT LOG	1	49B3	COMP. MN-c		
30	WOOD SCREW	18	42S1	BRASS		1½"-14 R.H.
31	SHAFT TUBE & WASHER PL.	1	49B3	COMP. Mn-c		
32	STUFF'G. BOX GLAND	1	49B3	COMP. Mn-c		
33	STUFF'G. BOX LOCK NUT	1	49B3	COMP. Mn-c		
34	STUFFG. BOX PACK. NUT	1	49B3	COMP. Mn-c		
35	PACKING	1	HH-P 106	FLAX OR HEMP		¼" SQ. X 26"
36	HOSE	1	COM'L.	RUBBER		2¼" I.D. X 3¼" X 4 PLY.
37	HOSE CLAMPS	2	COM'L.	BRASS		TO SUIT PC. NO. 36
38	MACHINE BOLT & NUT	6	43B11 46B27	COP. SIL.		¼" D. LG. TO SUIT.
39	RUDDER STOP	2	46S1	GR. "M" STL.		1½" X 1" X ¼" F.B. GALV.
40	WOOD SCREW	2	42S1	STEEL		1½" - NO. 10 F.H. GALV.
41	STRUT, VEE, SKEG	1	49B3	COMP. Mn-c		SEE LCVP-8997
42	WASHER PLATE	2	49B3	COMP. Mn-c		6¼" X 7" X 3/16" DRILL ON ASSEMBLY

ALTERATIONS

No. ALT.	DATE	DESCRIPTION	APPROVED
1	10/6/44	SHAFT STRAIGHTNESS TOLERANCE CHANGED. DIMENSION CORRECTED.	E.L.
2	12-5-44	PC10 INCREASED TO ⅛" PLT. PC.17 INCREASED TO 3/16" THK	E.L.
3	1/5/45	SHAFT & SKEG STRUTS ALTERED. PCS 13, 14 & 18 ALTERED. PCS 41 & 42 ADDED.	E.L.
4	2/3/45	SECTIONS "A-A" & "B-B" ADDED. PCS. 39 & 40 ALTERED.	E.L.
5	4/5/45	FINISH NOTES ON PC. 32 DELETED. NOTE ADDED ON PC. 25.	E.L.
6	5/17/45	PC. 19 CHANGED FROM MACH. SCREW TO HEX. HEAD BOLT. NOTES CHANGED ACCORDINGLY.	E.L.
7		SCHEDULE OF MATERIAL SPEC. COL. CHANGED TO CONFORM WITH LATEST REVS. APPEARING IN INDEX OF SPECS. OF 7.1.50	

REFERENCE DRAWINGS: BUREAU No.

LINES & OFFSETS ------------ LCVP - 8509
GENERAL ARRANGEMENT ---------- LCVP - 8510
STEERING SYSTEM ----------- LCVP - 8867
RUDDER FITTINGS & DETAILS --------- LCVP - 8868
SKEG & SHAFT STRUTS ARRANGEMENTS & DETAILS - LCVP - 8997

THIS PLAN SUPERSEDES LCVP-8866 & LCVP-8869

FINISHES
F_5 = MACHINE FINISH SMOOTH
F_7 = MACHINE FINISH ROUGH
B = BUFF
F_9 = FINISH GROUND
F_4 = FINISH FILE

DRAWN BY C.E. WERDACK
TRACED BY C.H. MORGAN
EXAMINED BY Kohr
R.A. Fyfe PRINCIPAL ENGINEER
IN CHARGE OF WORK Neill DATE 8/7/44

5981

36 FT. LANDING CRAFT
LCVP
SKEG & UNDERWATER FITTINGS
ASSEMBLY & DETAILS

SCALE: AS SHOWN

NAVY DEPARTMENT
BUREAU OF SHIPS
WASHINGTON, D.C. AUGUST 7 1944

W.H. Leahy
FOR CHIEF OF BUREAU

BUREAU OF SHIPS NUMBER			
LCVP		8981	ALT. 7