



RUSSIAN MARITIME REGISTER OF SHIPPING

CIRCULAR LETTER

No. 311-05-1934c

dated 18.05.2023

Re:

amendments to the Rules for Technical Supervision during Construction of Ships and Manufacture of Materials and Products for Ships, 2023, ND No. 2-020101-175-E

Item(s) of supervision:

ships in construction

Entry-into-force date:

01.07.2023

Cancels / amends / adds Circular Letter No.

dated

Number of pages: 1 + 3

Appendices:

Appendix 1: information on amendments introduced by the Circular Letter

Appendix 2: text of amendments to Section 5 "Machinery" of Part IV "Technical Supervision during Manufacture of Products"

Director General

Sergey A. Kulikov

Text of CL:

We hereby inform that the Rules for Technical Supervision during Construction of Ships and Manufacture of Materials and Products for Ships based on the experience in application of the Rules and in connection with revision of IACS Unified Requirements M42 (Rev.6 Mar 2022) shall be amended as specified in the Appendices to the Circular Letter.

It is necessary to do the following:

1. Bring the content of the Circular Letter to the notice of the RS surveyors, interested organizations and persons in the area of the RS Branch Offices' activity.
2. Apply the provisions of this Circular Letter during review and approval of technical documentation for the ships contracted for construction or conversion on or after 01.07.2023, and in the absence of a contract, during review and approval of the technical documentation on ships requested for review on or after 01.07.2023.

List of the amended and/or introduced paras/chapters/sections:

Table 5.10.1

Paras 5.10.2.1, 5.10.2.4.2, 5.10.2.8, 5.10.2.8.1, 5.10.2.8.4, 5.10.2.8.5 and 5.10.2.8.9

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**Information on amendments introduced by the Circular Letter
(for inclusion in the Revision History to the RS Publication)**

Nos.	Amended paras/chapters/ sections	Information on amendments	Number and date of the Circular Letter	Entry-into-force date
1	Table 5.10.1	Terminology has been amended in compliance with 1.2.9, Part III "Equipment, Arrangements and Outfit" of the Rules for the Classification and Construction of Sea-Going Ships	311-05-1934c of 18.05.2023	01.07.2023
2	Para 5.10.2.1	Terminology has been amended in compliance with 1.2.9, Part III "Equipment, Arrangements and Outfit" of the Rules for the Classification and Construction of Sea-Going Ships	311-05-1934c of 18.05.2023	01.07.2023
3	Para 5.10.2.4.2	Requirements for testing steering gear have been specified	311-05-1934c of 18.05.2023	01.07.2023
4	Paras 5.10.2.8 and 5.10.2.8.1	Requirements for testing steering gear have been specified	311-05-1934c of 18.05.2023	01.07.2023
5	Paras 5.10.2.8.4 and 5.10.2.8.5	Requirements for testing steering gear have been specified	311-05-1934c of 18.05.2023	01.07.2023
6	Para 5.10.2.8.6	Para 5.10.2.8.6 has been deleted. Paras 5.10.2.8.7 – 5.10.2.8.9 have been renumbered 5.10.2.8.6 – 5.10.2.8.8, accordingly	311-05-1934c of 18.05.2023	01.07.2023
7	Para 5.10.2.8.9	Requirements for testing steering gear designed to avoid hydraulic locking have been introduced in compliance with IACS UR M42 (Rev.6 Mar 2022)	311-05-1934c of 18.05.2023	01.07.2023

**RULES FOR TECHNICAL SUPERVISION DURING CONSTRUCTION
OF SHIPS AND MANUFACTURE OF MATERIALS
AND PRODUCTS FOR SHIPS, 2023,**

ND No. 2-020101-175-E

PART IV. TECHNICAL SUPERVISION DURING MANUFACTURE OF PRODUCTS

5 MACHINERY

- 1 **Table 5.10.1.** Item 1 of the second line is replaced reading as follows:

"Table 5.10.1

Nos.	Item of technical supervision	Examination of materials, blanks, assemblies, components	Verification of accompanying documents ¹	Flaw detection	Hydraulic tests	Special tests	Bench tests
1	Steering gear (engine):						+
	tillers of main and auxiliary steering gear	+	+	+			

- 2 **Para 5.10.2.1** is replaced by the following text:

"5.10.2.1 Tillers of the main and auxiliary gear.

During external examination of the finished tillers, it is necessary to make sure that:
treated surfaces for mounting on the rudder stock, interference fits and key ways comply with the technical documentation;
perpendicular position of the axis of bore for mounting to the end face;
compliance with the approved technical documentation on perpendicular position of the axis of bore for mounting to the end face, parallelism of the key way axes one to another and to the mounting bore axis, and for the hydraulic steering gear – perpendicular position of the tiller axis to the mounting bore axis."

- 3 **Para 5.10.2.4.2** is replaced by the following text:

"5.10.2.4.2 The cylinders, fittings and piping shall be subjected to hydraulic test in accordance with the requirements of 5.1.10."

- 4 **Paras 5.10.2.8 and 5.10.2.8.1** are replaced by the following text:

"5.10.2.8 When conducting bench tests of the steering gear the tests shall be performed according to 5.10.2.8.1 — 5.10.2.8.11 and 5.12.

5.10.2.8.1 The pump test bench shall ensure the operation of the unit at idle and under load, and, at least, under following conditions:

pumps and stroke control devices (or flow control valve) shall operate continuously at idle from full flow and relief valve set pressure in one direction to full flow and relief valve set pressure in the opposite direction;

the passage from one condition to another shall occur at least as quickly as on board;
the minimum expected suction head of the pumps shall be simulated."

5 **Paras 5.10.2.8.4 and 5.10.2.8.5** are replaced by the following text:

"5.10.2.8.4 A power unit pump shall be subjected to a type test. The type test shall be for a duration of not less than 100 hours, the test arrangements shall be such that the pump may run in idling conditions, and at maximum delivery capacity at maximum working pressure. During the test, idling periods shall be alternated with periods at maximum delivery capacity at maximum working pressure. The passage from one condition to another should occur at least as quickly as on board. During the whole test no abnormal heating, excessive vibration or other irregularities are permitted. After the test, the pump shall be disassembled and inspected. Type tests may be waived for a power unit which has been proven to be reliable in marine service.

5.10.2.8.5 In case of a single approval of the steering gear, the tests shall be performed to the extent of the prototype."

6 **Para 5.10.2.8.6** is deleted. Existing paras 5.10.2.8.7 – 5.10.2.8.9 have been renumbered 5.10.2.8.6 – 5.10.2.8.8.

7 New para **5.10.2.8.9** is introduced reading as follows:

"5.10.2.8.9 Where steering gear is designed to avoid hydraulic locking this feature shall be demonstrated."