

Keels and Rudders: Engineering and Construction

by Eric W. Sponberg

Editor's note: This article is the second of a two-part series, based on an IBEX 2004 session titled "Practical Methods for Keel and Rudder Design," presented by David Vaccant, (Renton, Washington), naval architect; Eric Sponberg (St. Augustine, Florida), and Kevin Milne, president of Mars Metal Company (Burlington, Ontario, Canada). In the last issue, Vaccant discussed the science of foil sections, planform shapes, lift and drag characteristics, and bulb and winged keels. Here, Eric Sponberg looks at keel and rudder engineering and construction, including calculating keelbolt sizes and rudderstock diameters. And, Milne shows examples of his company's manufacturing processes.

Figure 1—The ABS Guide for Building and Classing Offshore Racing Yachts assumes that the largest load on a keel is in a knockdown situation. The keel can be seen as trying to bend off the hull; that force is resisted by the pull of the keelbolts on the high side.

Engineering Fixed Keels

Keel engineering is relatively simple, and can be done with calculations and scantlings from the American Bureau of Shipping's *Guide for Building and Classing Offshore Racing Yachts*, last published in 1994. (When I mention the *Guide* in this article, it's to that publication that I'm referring.) ABS no longer classifies recreational vessels below 79' (Class LOA), but still publishes the *Guide*. (To obtain a copy, see the contact information on page 95.) ABS's calculations for keels and rudders follow first-principles engineering quite closely, so be assured that if you meet these criteria, your structures will be sound. If you do engineer keels and rudders directly from first principles, it's wise to check your work against the *Guide* to make sure its requirements are satisfied.

• **Keelbolts.** Section 6 of the ABS *Guide*, "Details and Fastenings," focuses on two areas of concern for keels: the strength of the keelbolts to hold the ballast-keel casing onto the hull, and the strength of those bolts to resist grounding. The following equation calculates the diameter of the keelbolts for a given keel. It presumes all bolts to be the same diameter and material.

$$d = \sqrt{\frac{2.55 W_k Y_s}{\sigma_y Z.6}}$$

inches, millimeters

Where:

W_k = the total weight of the ballast keel, in pounds, kilogram-force, or newtons

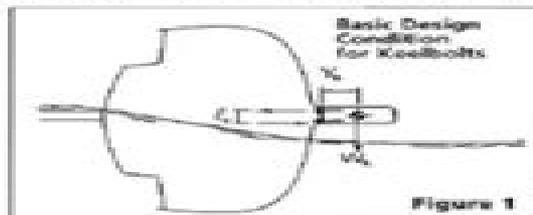
Y_s = is the vertical distance from the keel's center of gravity to the bearing surface of the bolt connection, in inches or millimeters

σ_y = the minimum yield strength of the keelbolt material, in psi, kgf/cm², or N/mm²

Z = the summation of transverse distances at each bolt from the center of the bolt on one side of the keel to the edge of the keel on the other side, in inches or millimeters.

Figure 1 is a graphical representation of these variables in the load situation that ABS assumes. The greatest load on the keelbolts is when the sailboat is knocked down flat in the water—an occurrence that is rare but possible. The keel tries to bend off the hull, but is resisted by the keelbolts on the high side. The values of all the variables are easy to determine, and so the engineering is simple.

The term " Z " is illustrated in **Figure 2**. The keelbolts should be arranged in two to three rows along the top of the keel and as far outboard as practical, usually within 1" (25mm) of the keel's side surface. The distance " Y_s " is calculated for each



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