



REFERENCES			
NO.	AUTEUR/AUTHOR	TITRE / TITLE	ID DOCUMENT
1	CCG	UPPER DECK PLATING	CMG05-102-DE
2	CCG	STEEL PROFILE & BULKHEAD & SCANTLING	CMG05-108-ST
3	CCG	GENERAL ARRANGEMENT	CMG05-111-GA
4	CCG	CONSTRUCTION SECTION	CMG05-140-SE
5	CCG	FLIGHT & BOAT DECK MINOR BULKHEAD UNDER	CMG05-180-AS

REVISIONS			
NO.	DATE	DESCRIPTION	PAR / BY
0	2016-04-21	FIRST ISSUE	JP HERNANDIZ
1	2016-05-05	CCG COMMENTS	JP HERNANDIZ

- NOTES
- THE TILLER ARM DISASSEMBLY MAINTENANCE AND ASSEMBLY ARE NOT COVERED IN THIS DRAWING. PROCEDURE SHALL FOLLOW THE MANUFACTURER RECOMMENDATION.
 - THE LIFTING LUGS IN THE STEERING GEAR COMPARTMENT HAVE A SAFE WORKING LOAD OF 1.5 TONNES UNDER THESE CONDITIONS:
 - THE LUGS WELDING LEG IS AT LEAST 5mm.
 - THE LUG AND SUPPORTING STIFFENER SHOWS NO SIGN OF WEAR.
 - WHERE THE WELDING DOES NOT MEET THIS MINIMUM REQUIREMENT THE LUG SHALL BE GAUGED AND REINSTALLED PROPERLY BEFORE ANY LIFTING.
 - CONTRACTOR MUST ENSURE THAT WELDING IS PERFORMED BY A WELDER CERTIFIED BY THE CANADIAN WELDING BUREAU (CWB) IN ACCORDANCE WITH THE REQUIREMENTS OF THE FOLLOWING CANADIAN STANDARDS ASSOCIATION (CSA) STANDARDS:
 - CSA W47.1, CERTIFICATION FOR COMPANIES FOR FUSION WELDING OF STEEL STRUCTURES (MINIMUM DIVISION LEVEL 2.0); AND
 - CSA W47.2-M1987 (R2003), CERTIFICATION FOR COMPANIES FOR FUSION WELDING OF ALUMINUM (MINIMUM DIVISION LEVEL 2.1).
 - ALL ALUMINUM SHALL BE GRADE 5083-H116 OR 6061-T6.
 - ALL DIMENSIONS ARE IN mm UNLESS NOTED OTHERWISE.
 - WHEN LOADING ON TYPE 1 LIFTING LUG HAVE A LATERAL COMPONENT, SWL SHALL BE LIMITED TO 0.5 TONS PER LUG.
 - ALL WELDS SHALL BE INSPECTED WITH MAGNETIC PARTICLE OR PENETRANT LIQUID TO DETECT ANY DEFECT.
 - THE USE OF LIFTING EQUIPMENT SHALL FOLLOW MANUFACTURER RECOMMENDATION AND LIFTING GOOD PRACTICES.
 - STEEL SCHAKLES SHALL BE REMOVED FROM ALUMINUM LUGS AFTER LIFTING TO PREVENT GALVANIC CORROSION.
 - LIFTING LUGS SHALL BE TESTED AT 1.25xSWL

- TILLER ARM REMOVAL PROCEDURE
(ONE HALF AT A TIME)
- USING THE EXISTING LUGS (TYPE 1) LIFT FROM THE RUDDER STOCK,
 - MOVE TO STARBOARD UNDER THE TEMPORARY DECK OPENING,
 - ROTATE THE TILLER ARM,
 - LIFT THE TILLER ARM OVER THE POOP DECK USING A NEW ALUMINUM LUG (TYPE 2) BELOW FLIGHT DECK, MOVE FORWARD TO THE NEXT TYPE 2 LUG,
 - SWITCH TO TYPE 3 LUG, ROTATE BACK AND MOVE TO PORTSIDE BULKWARK,
 - LIFT FROM SHORE.



CLIENT:
CANADIAN COAST GUARD

PROJET/PROJECT:
CCGS GRIFFON
NAVAL ARCH. & ENG. REFIT 2016

TITRE/TITLE:
TILLER ARM REMOVAL

ECHELLE/SCALE: 1:50
FEUILLE NO./SHEET NO.: 1 / 1

NOTES LIMITATIVES / RESTRICTIONS

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