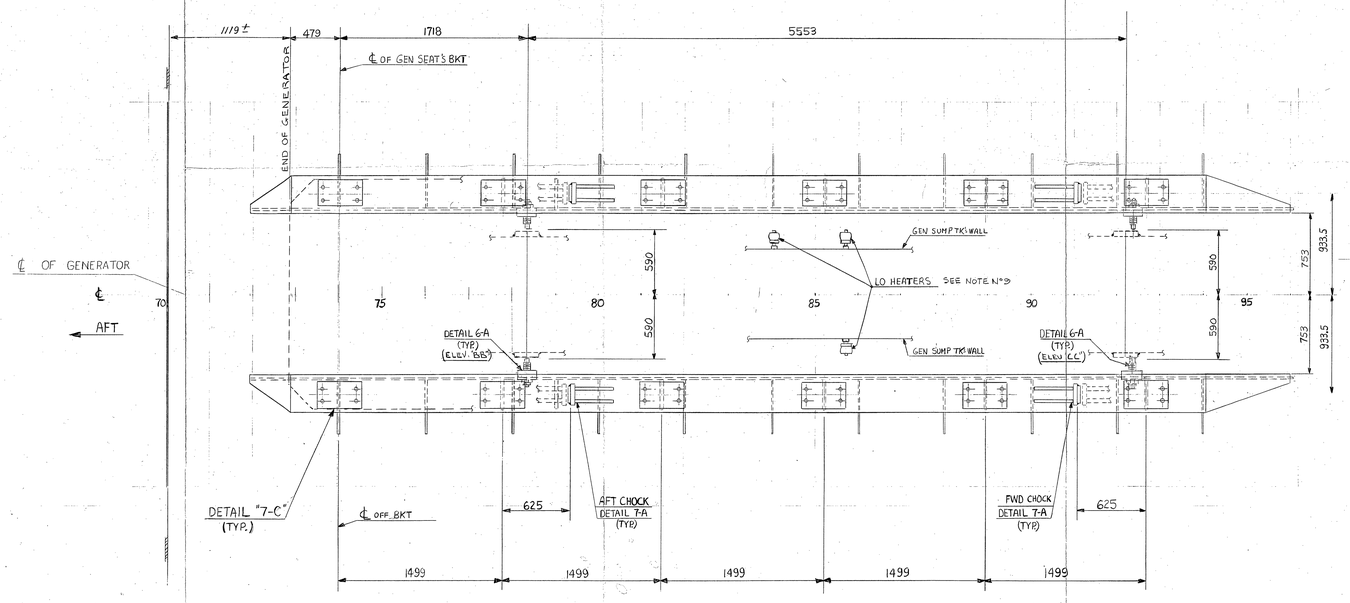
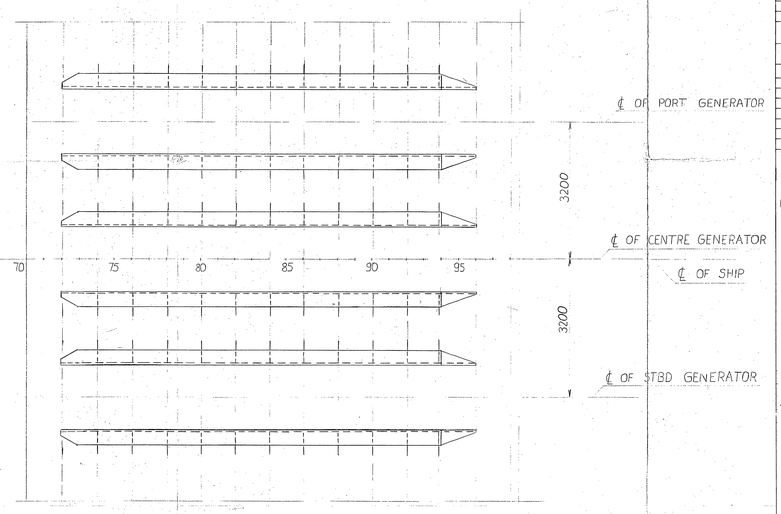
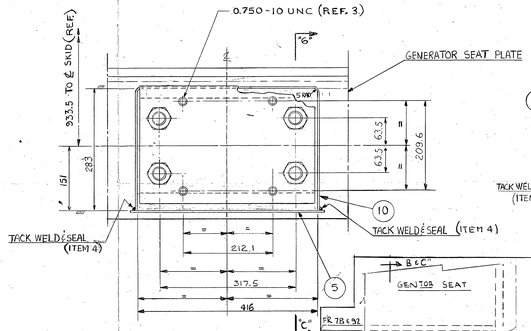


PLAN VIEW OF CENTRE GENERATOR SEAT
(PORT AND STBD SEATS IDENTICAL)
1:20

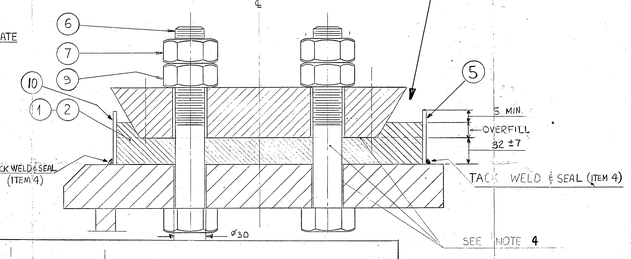


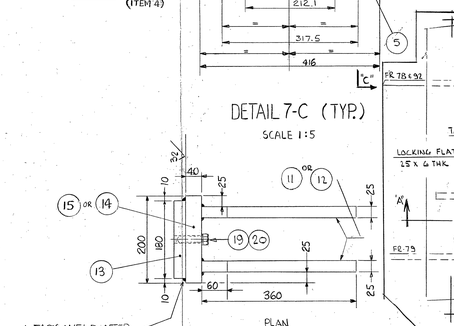
PLAN VIEW OF GENERATOR SEATS
1:50

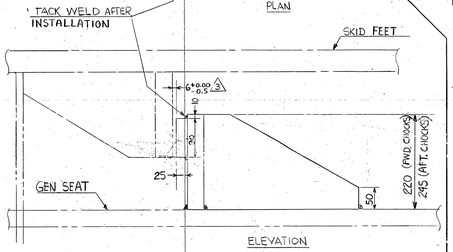
SEE NOTE 9



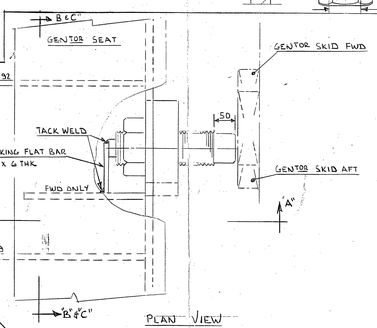
DETAIL 7-C (TYP.)
SCALE 1:5

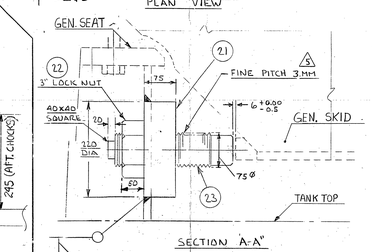




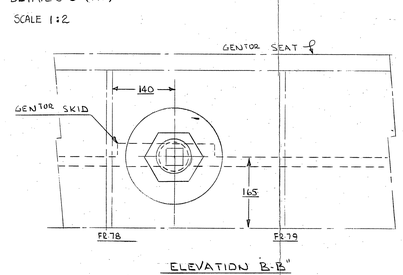


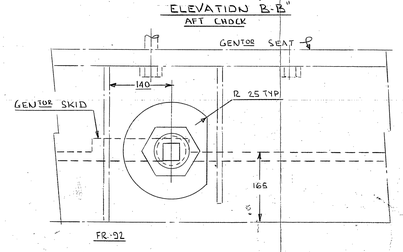
DETAIL 7-A
FORWARD AND AFTER COLLISION CHOCKS (QTE 12)
SCALE 1:5



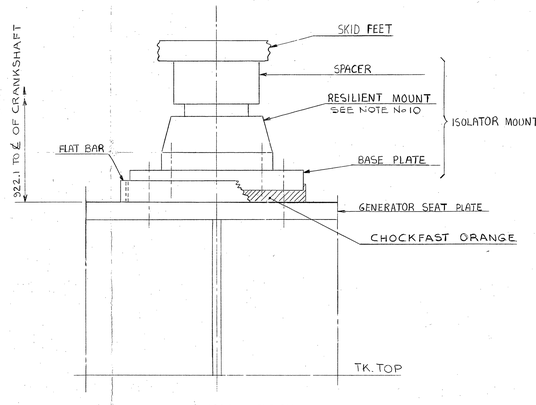


DETAIL 6-C (TYP)
SCALE 1:2





DETAIL 6-A LATERAL CHOCKS (QTE 12)
SCALE 1:5



COMPLETED SUPPORT - TYPICAL
SCALE 1:5

LIST OF MATERIAL

REV.	ITEM	QTE/QTY	SIZE	DESCRIPTION	MAT'L	SERVICE - REMARQUES / REMARKS	REQUISITION
	1	600 Lbs		CHOCKFAST ORANGE	PR-610TCF		462-1-19
	2	TO SUIT		HARDENER (FOR ITEM 1)	—		"
	3	1 GAL.		NON-MELT GREASE	—	SEE NOTE 4	"
	4	18 TUBES		SEALING COMPOUND	—	TO USE ON OUTSIDE OF MOLDS	"
	5	36	3×50×450	FLAT BAR	MILD STEEL	TO FABRICATE MOLD SHAPE	"
	6	144	M27-170	HOLDING DOWN BOLT STEEL	GRADE 8.8	ACC. TO DIN 960	"
	7	144	M27	SELF LOCKING NUT STEEL	GRADE 8.8	ACC. TO DIN 934	"
	8	9 BOT.		AEROSOL RELEASE AGENT	PR-225	TO EASE REMOVAL OF FLAT BAR & BOLTS	"
	9	144	M27	HEXAGONAL NUT STEEL	GRADE 8.8	ACC. TO DIN 934	"
	10	36	3×50×1028	FLAT BAR	MILD STEEL	TO FABRICATE MOLD SHAPE	"
	11	12	25×220×360	STEEL PLATE.	MILD STEEL	FOR FWD CHOCKS (COLLISION)	"
	12	12	25×245×360	" "	" "	FOR AFT " "	"
	13	12	25×90×180	" "	" "	TO BE MACHINED AFTER CHOCK'S INSTALLATION	"
	14	6	40×200×220	" "	" "	FOR FWD CHOCKS (COLLISION)	"
	15	6	40×200×245	" "	" "	FOR AFT " "	" /
4	16	24	25×128×210	" "	" "	FOR LATERAL CHOCKS	"
4	17	12	40×210×280	" "	" "	" "	"
4	18	12	30×90×280	" "	" "	TO BE MACHINED TO SUIT GEN'S INSTALLATION	"
4	19	36 24	M12 FINE x 60	HEX. CAP. SCREWS STEEL	GRADE 8.8	ACC. TO DIN 960	"
4	20	36 24	M12	LOCK WASHER	STEEL	" " " 7980	"
4	21	12	220 DIA x 75 Lg	STEEL PLATE	MILD STEEL	FOR LATERAL CHOCKS (SEE DET. 6A)	462-1-19
4	22	12	75 DIA	SELF LOCKING NUT SCREWS STEEL	GRADE 8.8	" "	"
4	23	12	75 DIA x 300 Lg	STEEL ROD	MILD STEEL	" "	"

IMPUTATION DES COUTS/COST CHARGES

GR	IT	DESCRIPTION
462	1	MATERIAL AND LABOUR

REFERENCES

NO	TITRE/TITLE	DESSIN/DWG	F/SH
1	SEATS FOR GENERATORS	218-01	1
2	ISOLATOR MOUNTING ASSY	460-1-1-P1/22	
3	BASE PLATE	460-1-1-P1/22	

POUR MATERIEL VOIR/FOR MATERIAL REFER TO: LIST OF MATERIAL BELOW

NOTES:

1. CHOCKFAST ORANGE AND HARDENER TO BE STORED AT 20-25°C FOR 12 HOURS PRIOR TO MIXING.
2. TEMPERATURE IN CHOCKING AREA TO BE MAINTAINED AT NOT LESS THAN 16°C DURING POURING AND CURING OF CHOCKS.
3. SEATS, PLATES OF MOUNTING ASSY AND HOLDING BOLTS TO BE PERFECTLY CLEANED FREE FROM PAINT ETC. AND COATED WITH RELEASING AGENT (ITEM 8) PRIOR TO POURING.
4. ALL HOLES TO BE FILLED WITH RECOMMENDED GREASE PRIOR TO POURING.
5. PRIOR TO POURING, BOLTS TO BE HAND TIGHTENED (ITEM 6 AND 9).
6. AFTER EPOXY CURING BOLTS TO BE TIGHTENED (TORQUE 288 lbs ft) ENSURE THE CHOCKS ARE BELOW 38°C BEFORE TIGHTENING.
7. THE WORK SHOULD BE CARRIED OUT TO LLOYD'S SATISFACTION. THE WORK SHOULD ALSO BE SUPERVISED BY CHOCKFAST AGENT REPRESENTATIVE AND A WORK INSTALLATION CERTIFICATE MUST BE SUPPLIED.
8. ALL WELDING TO BE : TYP 5
9. AFTER LEVELLING AND BEFORE CHOCKING, PLEASE CHECK WITH OWNER'S REPRESENTATIVE THE REMOVAL OF L.O HEATERS (3 PER GEN) AND THE CLEARANCE OF LATERAL CHOCKS.
10. POSITION OF RESILIENT MOUNTS SHOULD BE CONFORM TO BOMBARDIER DWG C-14-037435 "ISOLATOR POSITION".

NO	ZN	CODE	DESCRIPTION	PAR/BY	DATE
5			AS FITTED UP TO 450	DB	86/7/3
			DETAIL 6A ITEM 4 3 FINE PITCH	YG	85-11-29
			3 MM INSTEAD OF 2mm		
			NOTE # 6 138 LBS FT INSTEAD OF 81.5		
4			DETAIL 6A' MODIFIED	YG	85-11-12
			LIST OF MAT'L LINE 16-17-18 CANCELLED		
			" " " 19-20 GEN MODIFIED		
			" " " 21-22-23 ADDED		
3	B-B		DETAIL 7-A CLEARANCE WAS 8MM		
			REVISED AS PER BOMBARDIER		85-7-3
			DWG. C 30-037073		
2			MATERIAL LIST MODIFIED	GM	85-2-25
			NOTE 5, 9, 10 ADDED AND 3 & 4 MODIFIED		
			COLLISION AND LATERAL CHOCKS ADDED		
			MOLDS' FABRICATION MODIFIED		
1			GENERAL REVISION	RG	84/12/6

REVISIONS

APPROBATIONS/APPROVALS

	SOU/SUB	APP	S. REV 2	X REV 2	REV	REV	REV
CLASS'N							
GCC/CCG							
PROP/OWN			85.05.13	85.07.22			
BOMBARDIER	17.5.84		85.05.13				

MARINE INDUSTRIE LIMITEE
SOREL, P.Q., CANADA

TYPE 1100 NAVAIDS TENDER / LIGHT ICEBREAKER

CHOCKS AND BOLTS FOR MAIN GENERATORS

PAR/BY	APPR	CONT NO	DESSIN DWG	REV
K KMIEC	P.O. MARION	450/451	460-10	5
VER/CK	ECH/SC 1:20			F/SH
	DATE JAN 31, 84			1/1

FORMAT ISO-A0