

**GENERAL NOTES:**

- ALL DIMENSIONS IN IMPERIAL UNITS, U.N.O
- THE FOLLOWING DENOTATIONS ARE USED: (N) =NEW, (E)=EXISTING, U.N.O= UNLESS NOTED OTHERWISE, I.W.O=IN WAY OF.
- ALL ITEMS REMOVED TO FACILITATE THE REPAIR TO REPLACED AS FOUND UPON COMPLETION OF WORK.
- ALL WELDING OF TEMPORARY STRUCTURE TO BE  $\frac{5}{16}$ " FILLET WELDS, U.N.O
- SURFACE OF W/T DOOR FRAME FLANGE CONTACT SURFACE TO BE MILLED SMOOTH AND EVEN ALL AROUND TO ENSURE A TIGHT SEAL BETWEEN SLIDING DOOR HALF AND FRAME UPON RE-INSTALL.
- W/T DOOR TO BE TESTED TO PROVE FUNCTIONAL UPON COMPLETION OF ALL WORK AND TO BE TO THE APPROVAL OF THE ATTENDING T.C.M.S SURVEYOR.
- BILGE SPACES IN AREA(S) OF DOOR REMOVAL AND RE-INSTALL TO BE GAS FREED PRIOR TO START OF WORK.
- ALL WORK TO BE SUBJECT TO VESSEL'S REPRESENTATIVE, MASTER AND CHIEF ENGINEER. ALL ACTIVITIES RELATED TO WORK SCOPE SUBJECT TO VESSEL'S WORK PERMIT SYSTEM.
- ALL COATINGS DAMAGED BY REMOVAL, REPAIR AND RE-INSTALL OF NOTED W/T DOOR TO BE REPAIRED AS PER VESSEL COATING SYSTEM
- REMOVAL AND REPAIR STEPS 1-10 OUTLINED IN DRAWING SHEETS No.'S 2-7

**REFERENCE DRAWINGS:**

1. EUROCANA MARKETING AND PRODUCTION Ltd.-DWG. NO. 558811 ENTITLED "WATER TIGHT DOORRIGHT HAND. ASSEMBLY 1100"
2. EUROCANA MARKETING AND PRODUCTION Ltd.-DWG. NO. D-22286-1 ENTITLED "MOUNTING INSTRUCTION WATER TIGHT DOOR 1100."

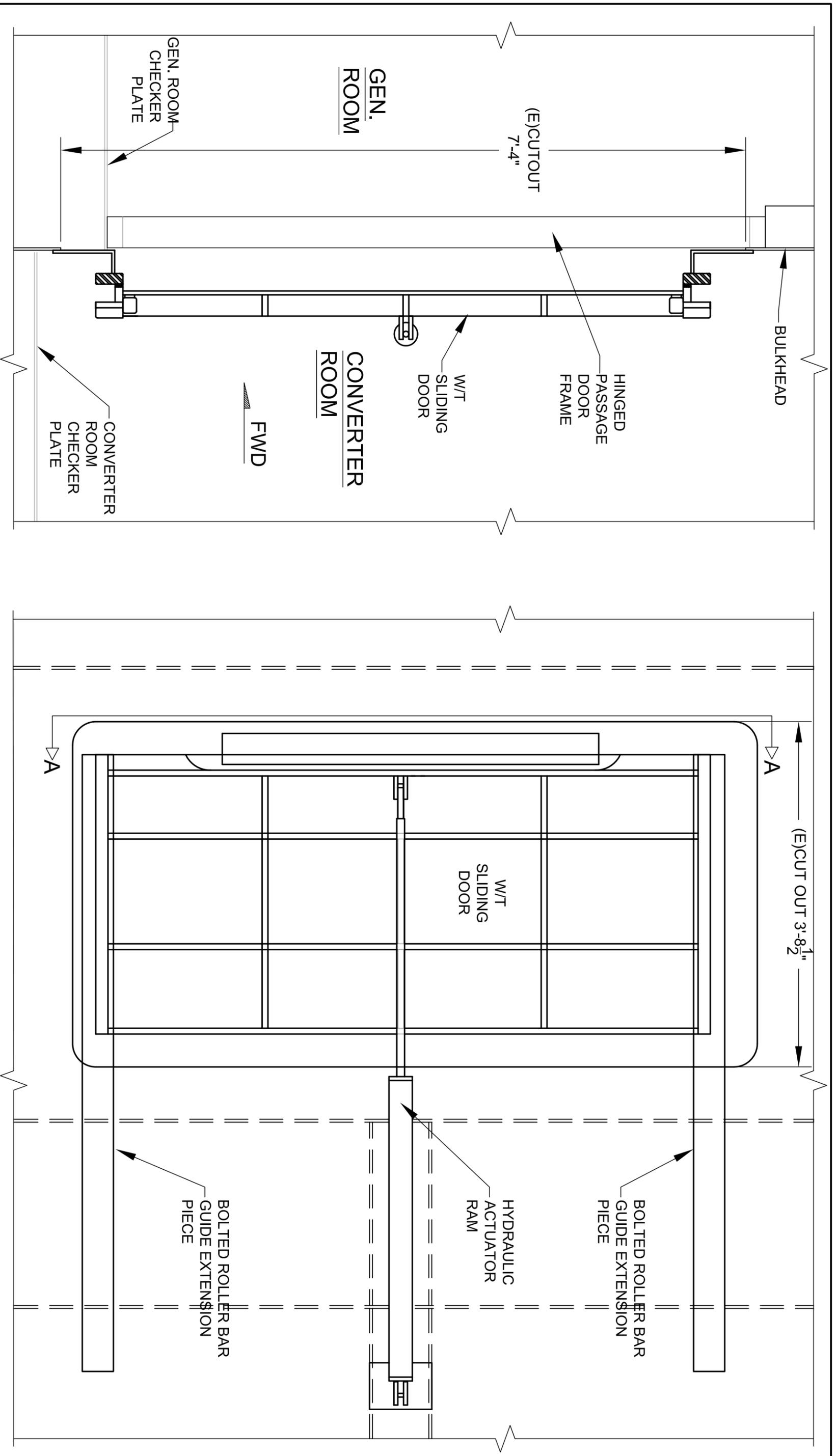
**LIST OF REMOVALS**

1. HINGED DOOR AND FRAME
2. ELECTRICAL WIRING, LIMIT SWITCH, HYDRAULIC PIPING, HYDRAULIC ACTUATOR RAM AND CONTROL.
3. BOLTED ROLLER BAR GUIDE EXTENSION PIECES
4. EMERGENCY HAND PUMP.
5. STROBE LIGHT AND BRACKET

**REV. HISTORY**

1-OCT. 18/16- $\frac{3}{16}$ " FILLET WELD SIZE ADDED ON SH.7 FOR RE-INSTALL OF WATERTIGHT DOOR FRAME.

 <b>MSI</b> International (2008) Ltd.	<b>Marine Services</b>	TITLE: <b>CCGS GEORGE R PEARKES W/T DOOR REMOVAL AND REPAIR</b>	DRAWN BY: PAL	DATE DRAWN: OCT. 2016
	197A Major's Path P.O.BOX 29132 St. John's, NL Canada A1A 5B5 Telephone 709 782 2700 Facsimile 709 782 2707 www.msintl.com	CLIENT: <b>D.F BARNES SERVICES</b>	CHECKED BY: MSI	SCALE: N.T.S
		PROJECT NO.: 2830	DRAWING NO.: 2830-01-01	SHEET NO.: 1 OF 7



SECTION A-A

SECTION @ FR. 70 LOOKING FWD

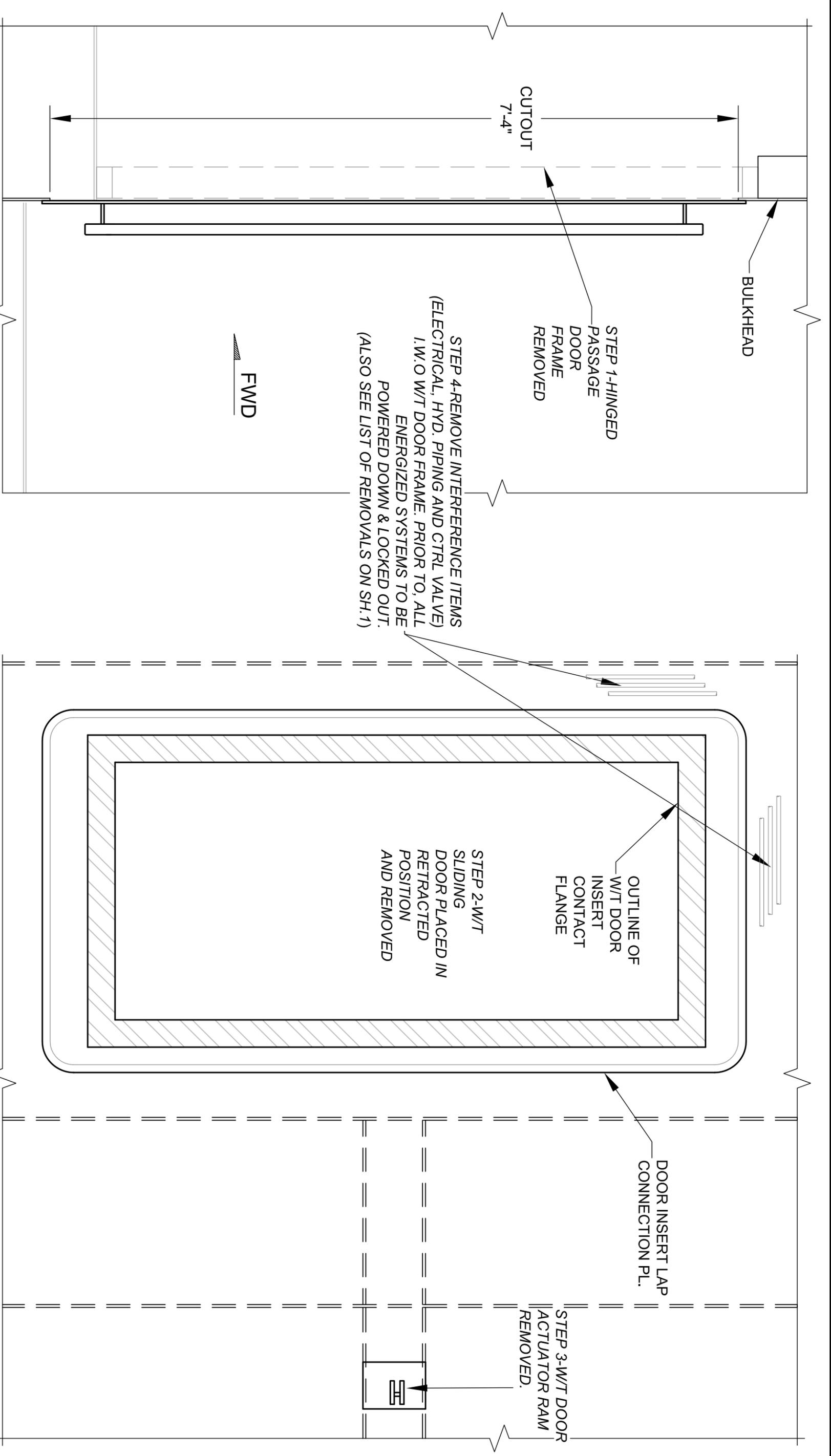
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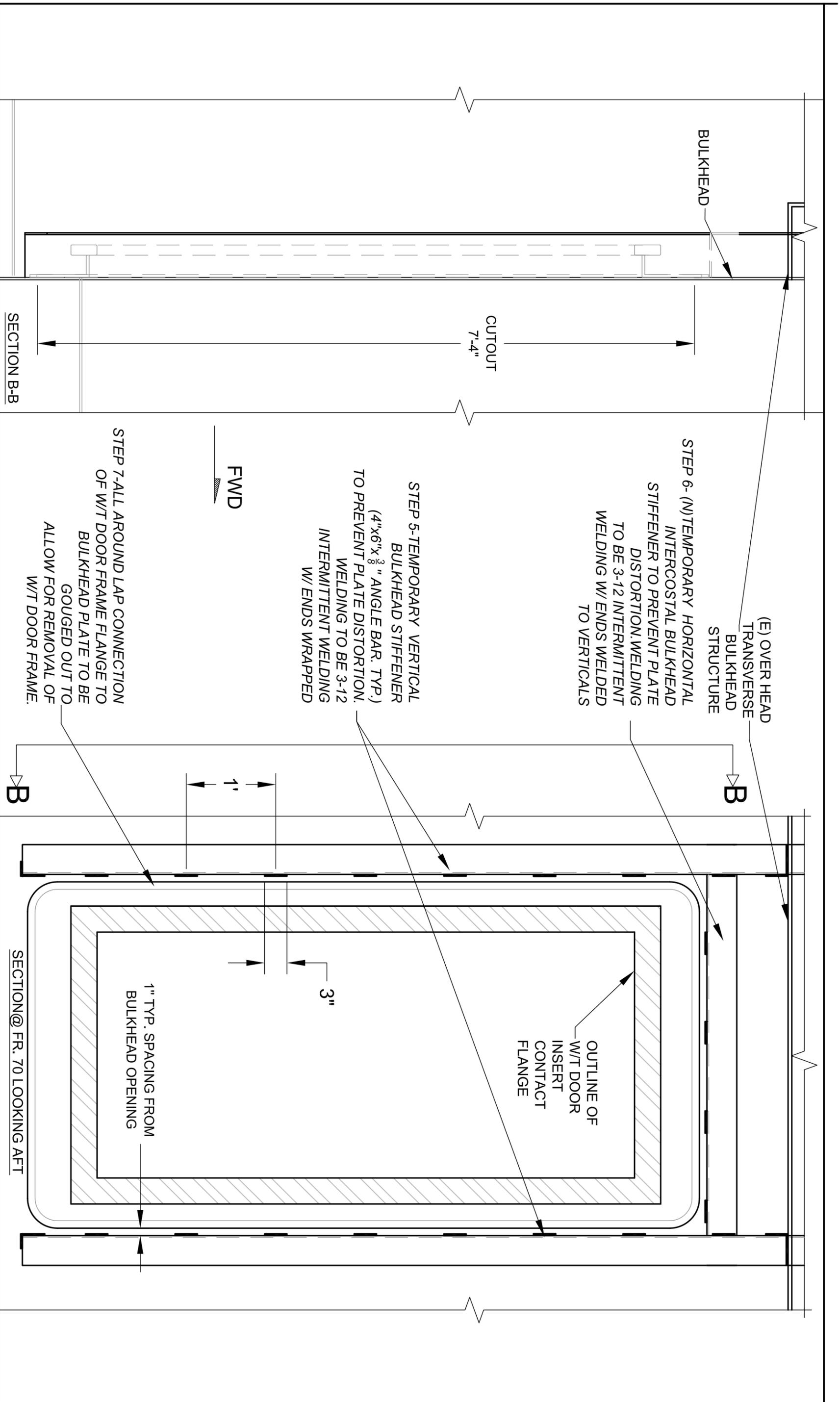
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BULKHEAD

CUTOUT  
7'-4"

SECTION B-B

(E) OVER HEAD  
TRANSVERSE  
BULKHEAD  
STRUCTURE

STEP 6- (N) TEMPORARY HORIZONTAL  
INTERCOSTAL BULKHEAD  
STIFFENER TO PREVENT PLATE  
DISTORTION. WELDING  
TO BE 3-12 INTERMITTENT  
WELDING W/ ENDS WELDED  
TO VERTICALS

STEP 5- TEMPORARY VERTICAL  
BULKHEAD STIFFENER  
(4"x6"x 3/8" ANGLE BAR. TYP.)  
TO PREVENT PLATE DISTORTION.  
WELDING TO BE 3-12  
INTERMITTENT WELDING  
W/ ENDS WRAPPED

STEP 7- ALL AROUND LAP CONNECTION  
OF W/T DOOR FRAME FLANGE TO  
BULKHEAD PLATE TO BE  
GOUGED OUT TO  
ALLOW FOR REMOVAL OF  
W/T DOOR FRAME.

FWD

OUTLINE OF  
W/T DOOR  
INSERT  
CONTACT  
FLANGE

1" TYP. SPACING FROM  
BULKHEAD OPENING

SECTION @ FR. 70 LOOKING AFT

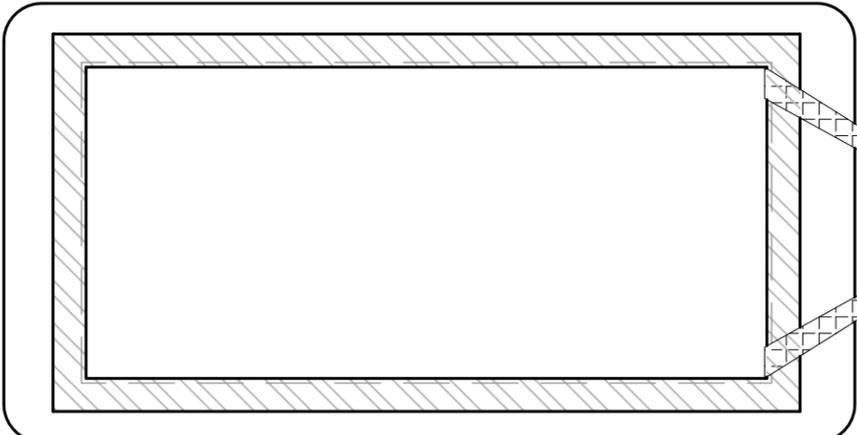
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W/T DOOR  
FRAME TO BE  
ROTATED UPRIGHT  
& BE LIFTED  
ASHORE THROUGH  
GEN. ROOM  
STORES HATCH



STEP 8 - W/T DOOR FRAME AND DOOR  
REMOVED FROM SHIP.

(E) SHIP'S 1000 KG  
S.W.L OVER HEAD  
MONORAIL  
AND TROLLEY  
SYSTEM

CHAIN FALL  
AND SUITABLE  
RATED STRAPS  
FOR INTENDED  
LOAD.

TO ACCESS  
HATCH IN  
GEN. ROOM  
CASING

NOT TO EXCEED 45°

GEN. ROOM  
THREAD PL. W/T DOOR FRAME  
IN INVERTED POSITION

W/T DOOR FRAME  
TO BE ROTATED AFT &  
INVERTED TO A  
HORIZONTAL  
POSITION AS SHOWN IN  
GEN. ROOM

FWD

CONVERTER ROOM

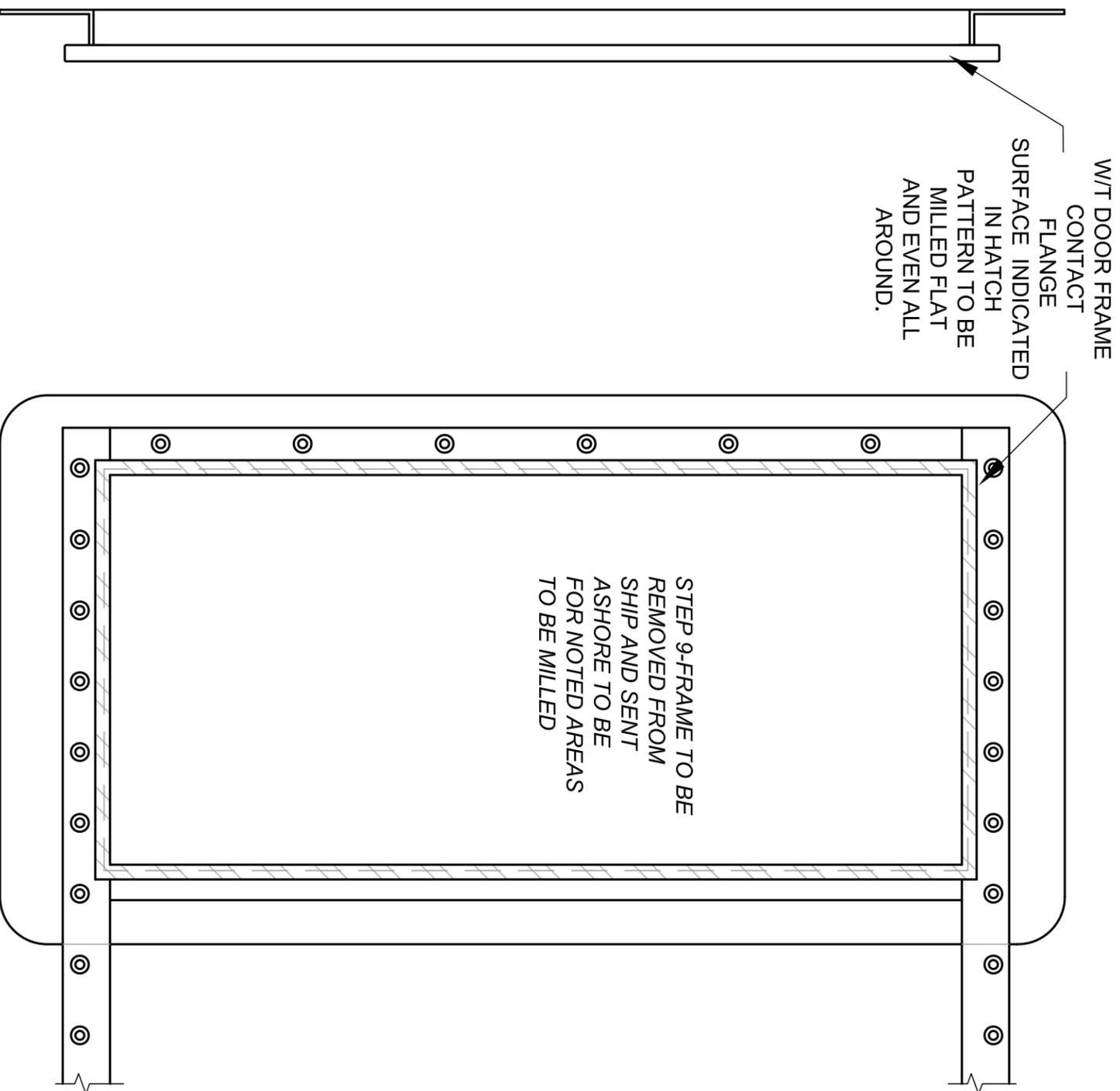
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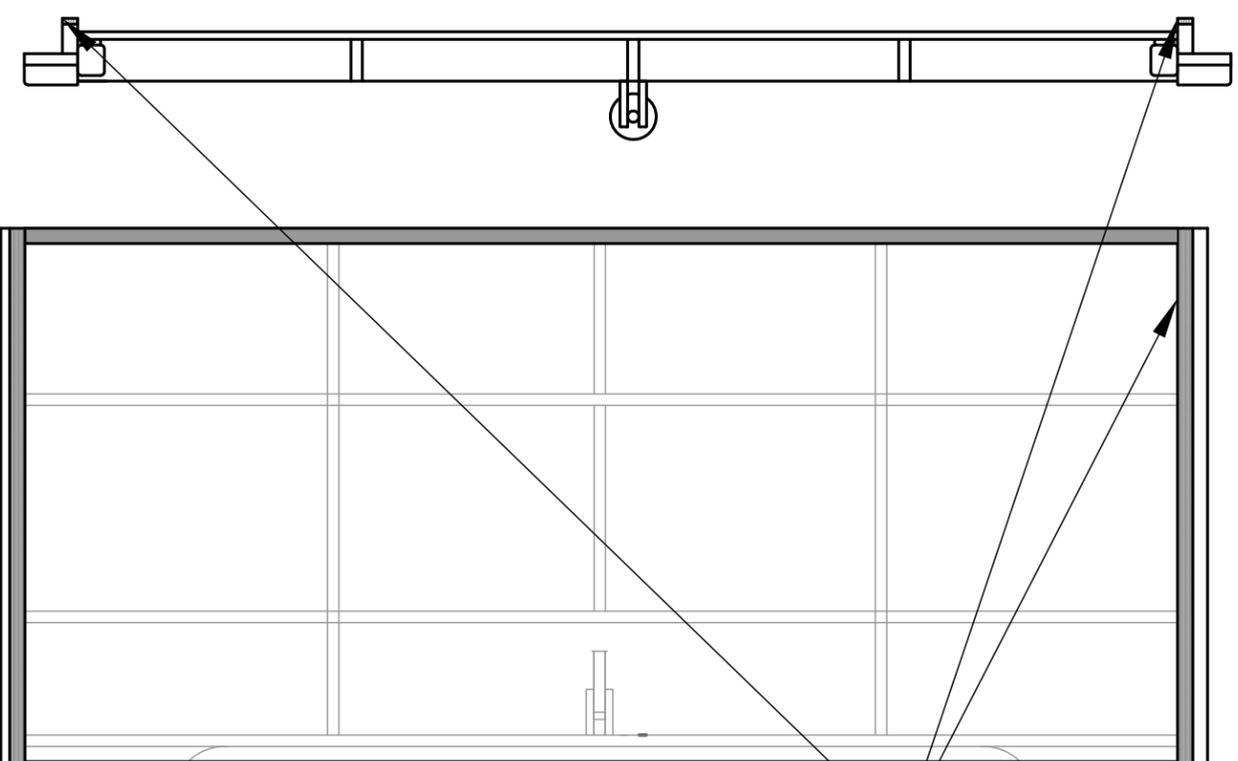
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**DOOR FRAME**



**DOOR**



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6 OF 7

DOOR FRAME TO BULKHEAD WELDING PLAN  
 THE FIGURES SHOWS IN WHICH CON-  
 SECUTIVE ORDER THE WELDING SEAMS  
 ARE TO BE WELDED.

THE ARROWS INDICATE WELDING DIRECTION  
 DO NOT USE WELDING ROD THICKER  
 THAN 1/8" &

THE LENGTH OF EACH WELDING SEAM  
 MUST NOT EXCEED 4"

WELDING MUST BE DONE WITH CARE  
 TO AVOID POSSIBLE DEFORMATION OF  
 THE DOOR FRAME

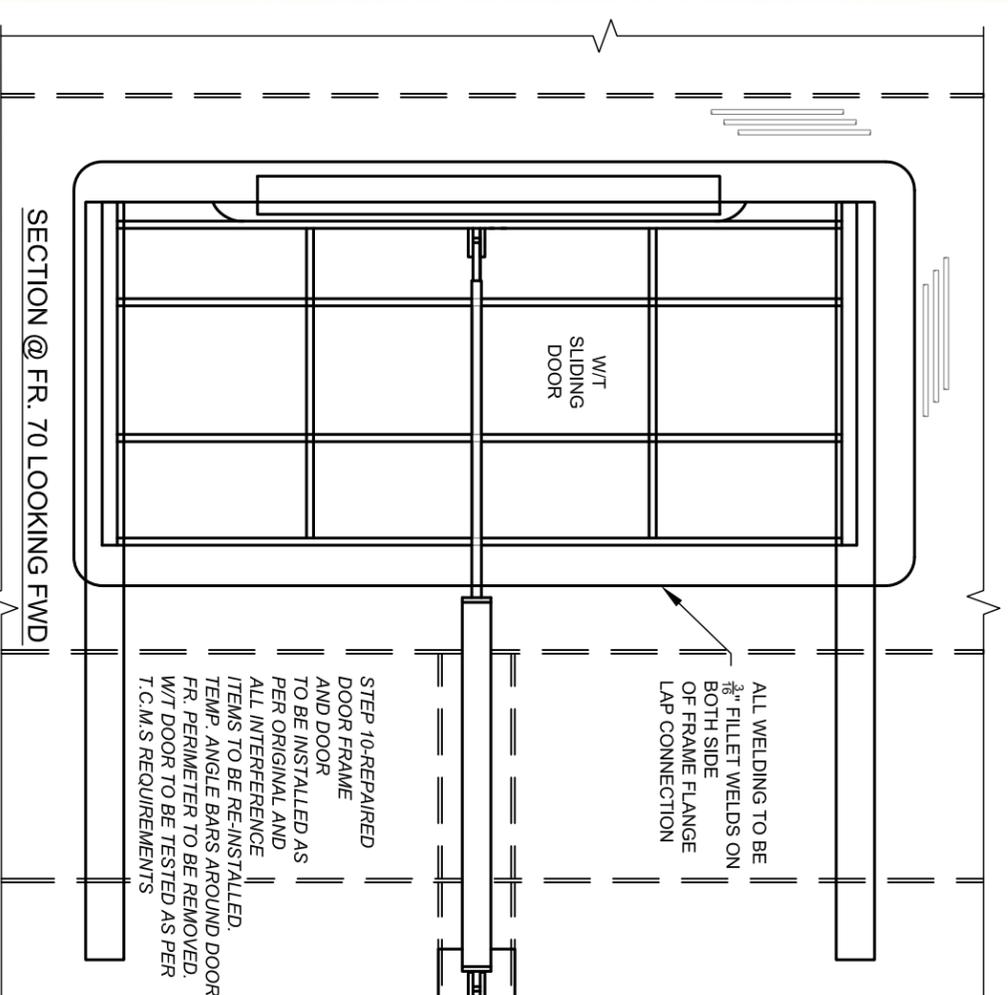
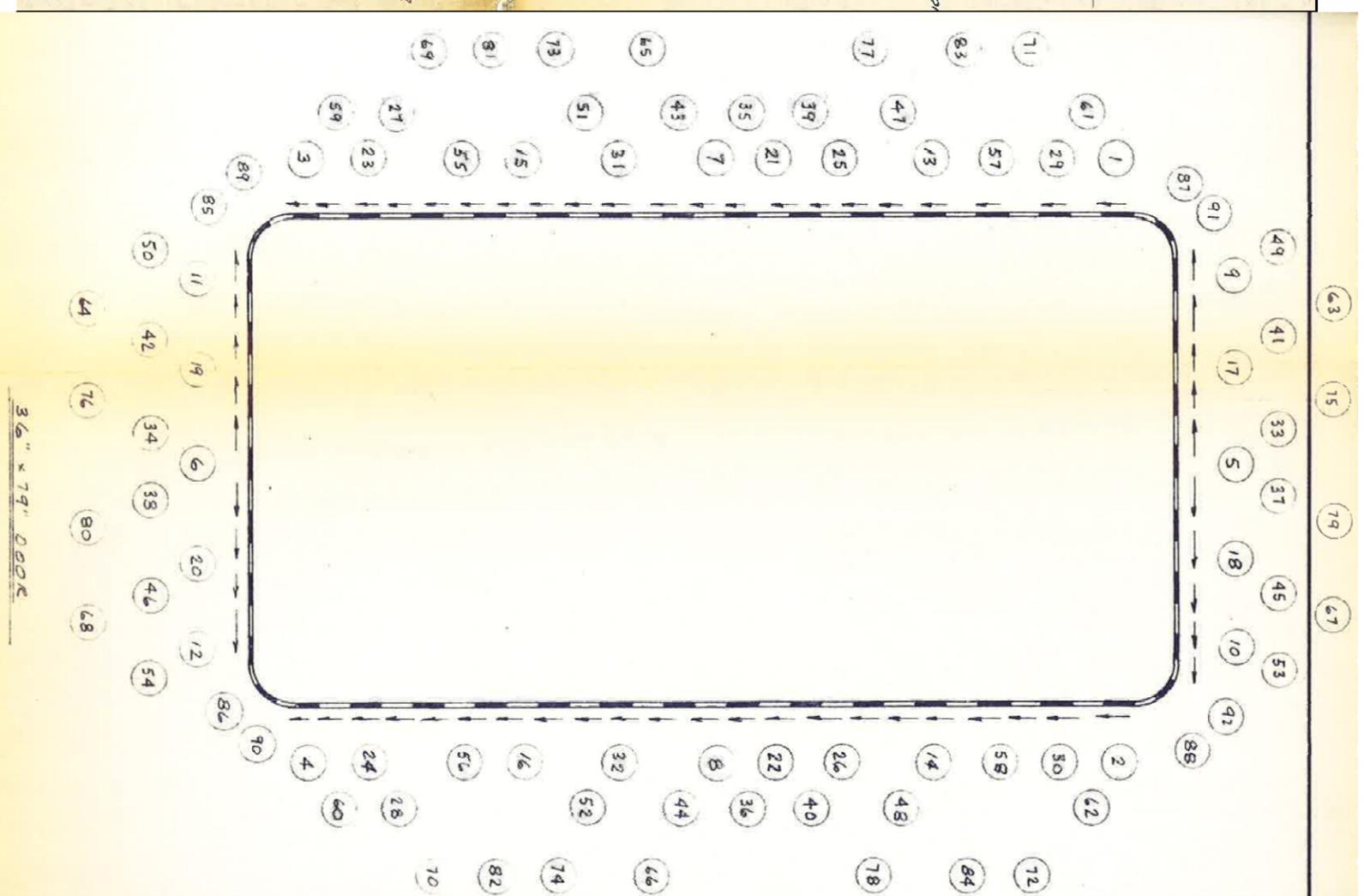
THE CORNERS MUST BE THE LAST  
 WELDING OPERATION TO BE DONE

THE DOOR MUST BE OPENED & CLOSED  
 BY HAND TO ENSURE THAT THE DOOR  
 FRAME DOES NOT BECOME DEFORMED  
 WHILE WELDING.

WELDING PROCEDURE TO BEGIN WITH  
 FIRST 4 STEPS ON SIDE "A". REPEAT  
 FIRST 4 STEPS ON SIDE "B". CARRY  
 ON WITH NEXT 4 STEPS ON SIDE "A"  
 & REPEAT ON SIDE "B". PROCEED IN  
 THIS MANNER THRU-OUT.

TACKLING OPERATION - FIRST 6 STEPS

WELD GUIDANCE AND SEQUENCE FOR RE-INSTALL OF DOOR FRAME (AS PER REF. DWG.2 FROM W/T DOOR MANUFACTURER)



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