

METHOD OF UNIT CONSTRUCTION, FABRICATION AND WELDING REQUIREMENTS TO THE SOCIETY'S SATISFACTION.

SCALLOPS AS DETAILED TO BE USED FOR ALL DRAIN AND AIR HOLES I.W.O INTERSECTIONS OF MAIN MEMBERS ETC. 'SNIPE OFFS' ARE NOT PERMITTED.

SCALLOPS IN FRAMING OR STIFFENERS CROSSING JOINTS IN PLATING TO BE OMITTED WHEN SUCH JOINTS ARE COMPLETED BEFORE MEMBER IS APPLIED. WELD AT MEMBER TO BE MADE FLUSH.

LOW HYDROGEN ELECTRODES OR PROCESS TO BE USED FOR ALL WELDING TO EH 36 MATERIAL. TO BE APPROVED FOR USE IN SHIP CONSTRUCTION.

ALL MEMBERS, VERTICAL OR HORIZONTAL, TO BE LEFT
LOOSE FROM EDGE OF UNIT BEING FITTED FOR
ALIGNMENT AT SHIP.

ALL WELD SIZES ARE THROAT THICKNESS, IN MILLIMETRES.

ALL WELDS ARE FILLET WELDS AND DOUBLE CONTINUOUS EXCEPT AS NOTED.

1. ALL MATERIALS TO BE LLOYDS GRADE A OR EQUAL, EXCEPT WHERE NOTED GRADE E OR THUS IF.
2. # INDICATES GRADE - MODIFIED ENJG LUKENS FROSTLINE STEEL OR EQUIVALENT.
3. ALL DIMENSIONS ARE IN MILLIMETRES.
4. PLATE NO. DENOTED THUS ○
5. MATERIAL ALLOCATED ON UNIT DWGS.

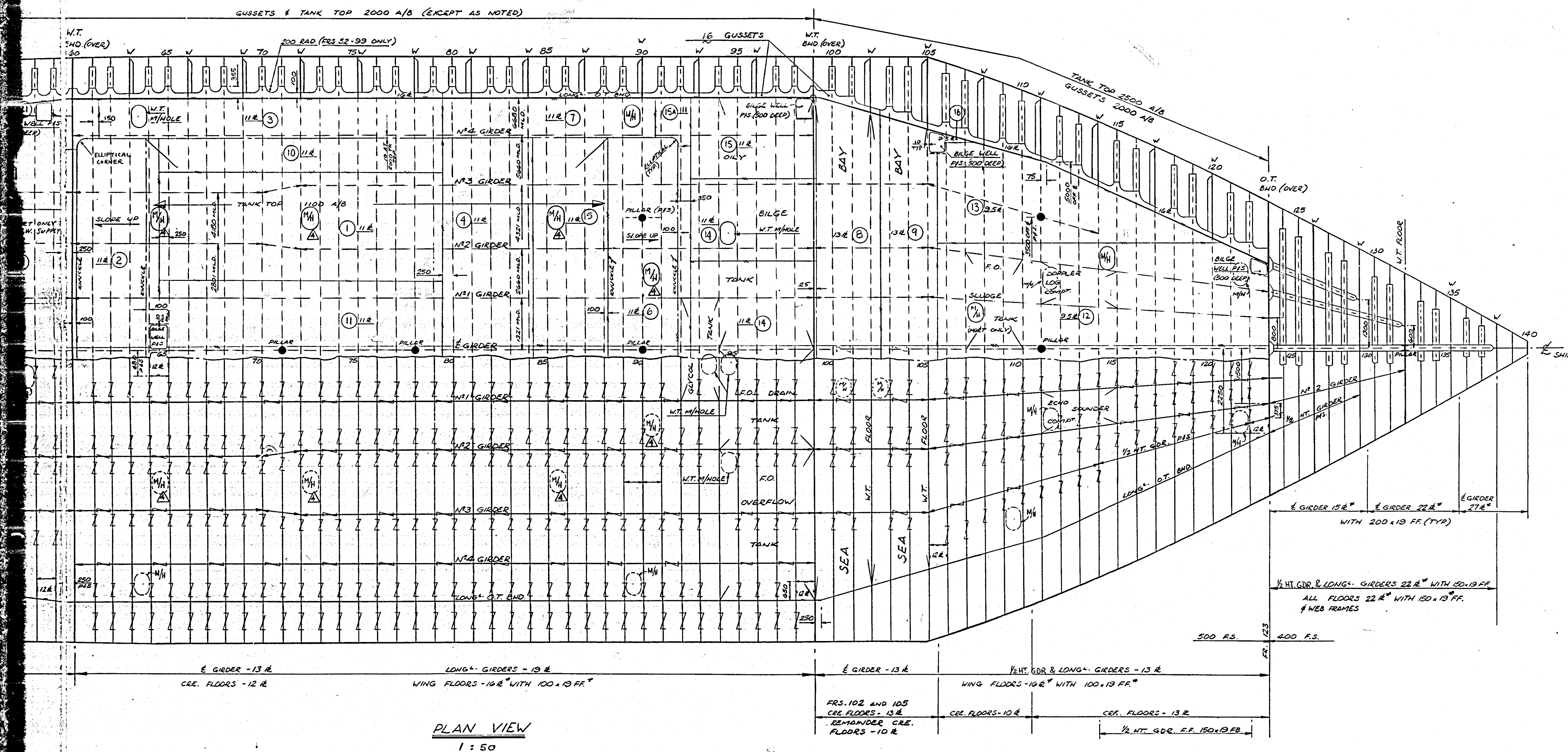
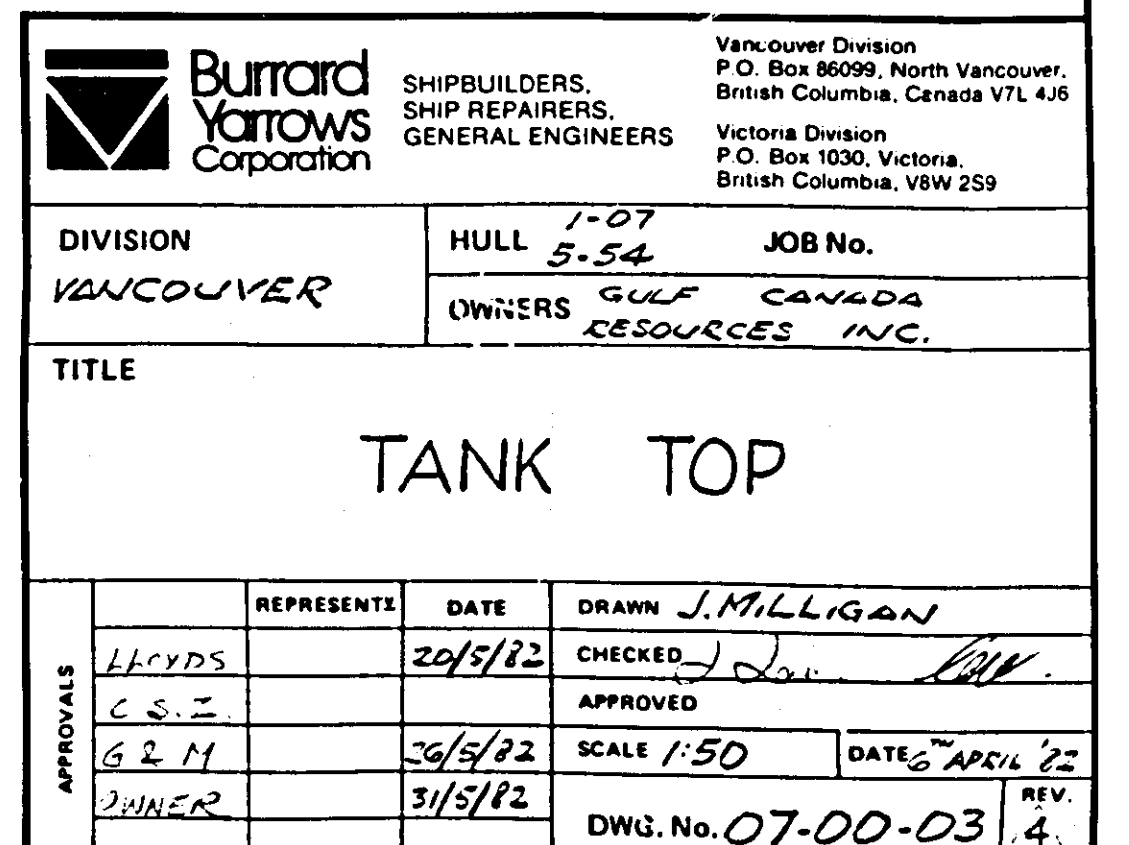
REF. No.	DRAWING TITLE	DWG. No.
1.	AFT UNIT FCS.9-23 CR5.	07-12-07
2.	" " " " P15	07-12-05/4
3.	D.B. UNIT FCS.24-47 P15	07-07-01/02
4.	" " FCS.48-59 CR5	07-07-03
5	D.B. UNIT FCS.60-79 P15	07-07-04/05
6	" " FCS.80-99 P15	07-07-06/07
7	" " FCS.100-123 P15	07-07-08/09
8.	FWD UNIT FCS.124-STEAM L.C.	07-14-1

④	ADDITIONAL M/Hs IN T.T. AT OWNERS REQUEST	AYC.	3, DEC, 82
③	GENERAL REVISION TO M/H POSITIONS IN TANK TOP	E.D.O	27, JULY, 82
②	DWG. MODIFIED TO SUIT APPROVALS	W.H.	4 TH JUNE 1982
①	DRAWING RE-DRAWN	W.H.	12 TH MAY 82

No.	REVISION						BY	DATE
DISTRIBUTION								
DEPARTMENT	QTY.	DEPARTMENT	QTY.	DEPARTMENT	QTY.	DEPARTMENT	QTY.	
OWNERS	2	OPERATIONS MANAGER	1	LOFT		PIPE FITTER		
CLASSIFICATION	4	NEW CONST. SUPT.		PLATER		MACHINE SHOP		
C.C.G.S.S.B.	3	REPAIR SUPT.		WELDER		ENGINE FITTER		
SEAMAN - MILNE	3	STEEL SUPT.		SHIPWRIGHT		SHEET METAL		
		WELDING ENGINEER		RIGGER		ELECTRIC SHOP		
				JOINER				
HAUL D.O.								
MACHINERY D.O.								
ELECTRICAL D.O.								

1st ISSUE JULY 6/82

AS FITTED



PLAN VIEW
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