

SMITH'S DOCK COMPANY, LIMITED.

NORTH SHIELDS

Name of Ship T.E.S. "THORUNN". 9. 9/2/53.

Instructions by Smith's Dock Co. Ltd., to foremen of departments. For the information of Smith's Dock Co. Ltd., and their foremen.

REF: J.T.

Structural Modifications.Bottom Girders.

4 longitudinal girders of transverse depth to make & fit in cargo tanks, 10'0" & 25'0" from P. & S. Girders to have welded 10" x $\frac{5}{4}$ " rider plate extending from aft bulkhead of tank to face plate of forward bulkhead web. Girders to rivet to existing bottom longitudinals in way. New .50" bracket to make & fit at aft bulkhead of tanks connecting bottom girder & bulkhead. Forward bracket at bottom girder in way of forward bulkhead web to crop & remove, and refit after welding of girder rider plate. Bottom girders to extend for two after transverse spaces in each tank. End brackets to taper off bottom girders to extend for two transverse spaces and fit with 6" face flat sniped at ends. Bottom girders to run from 50 bulkhead to 65 bulkhead P. & S. and brackets from 48 transverse to 50 bulkhead aft, and 65 bulkhead to 67 transverse forward. All in accordance with plan approved by Norske Veritas.

Deck Straps.

Deck straps to make & fit on upper deck, 4 in number. Outboard (welded) strap P. & S. 33" x 1", to position on two outboard deck longitudinals. Straps to weld with $\frac{1}{2}$ " continuous weld all round edges, & two rows of 3" x 2" welded plugs, flushed off with spacial composition. Inboard (riveted) strap P. & S. to position approx. 1 $\frac{1}{2}$ " outboard of welded deck seam between 4th. & 5th. deck longitudinals from centreline. Straps to rivet, 1" edge riveting all round spaced 3 $\frac{1}{4}$ ", & two rows of staggered rivets as per plan. Riveted deck straps 30" x 1" Straps to extend from 10' forward of 50 to 10' aft of 68 (outboard) & 2' forward of 50 to 2' aft of 68 (inboard). Deck to scale in way. Deck straps to reeve through midship deckhouse bulkheads as per plan. All removals in way of deck straps to replace on completion. Cargo lines in way to jack up or otherwise support during work. Midship domestic tanks to drain & strip of bottom plating to burn out to facilitate access to riveting in centre castle. Plating to weld back on completion.

Brackets in Wing Tanks.

Welded brackets, 12" x 12" x $\frac{5}{8}$ " to fit in wing tanks, at longitudinal bulkhead webs in way of bottom transverses.

All above work as per plan approved by Det Norske Veritas. Staging to rig & unrig on completion.

Treatment of Bulkhead Fractures.

Bulkhead fractures to cut out & welded spigot plate fitted. In addition, riveted doubling plate to fit over new plate.

Accommodation Ladder.

Modifications to side rails for accommodation ladder to be on starb'd. side.

Bridge Top.

Two morse lamps to remove.

Cargo Tanks.

Top platforms to renew in No. 1 Port & Starb'd. & No. 9 Port.



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B. T.

77. 3. 21

75. 2. 21

76. 3. 0

230. 1. 14

1. 2. 14.

77. 1. 7.

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