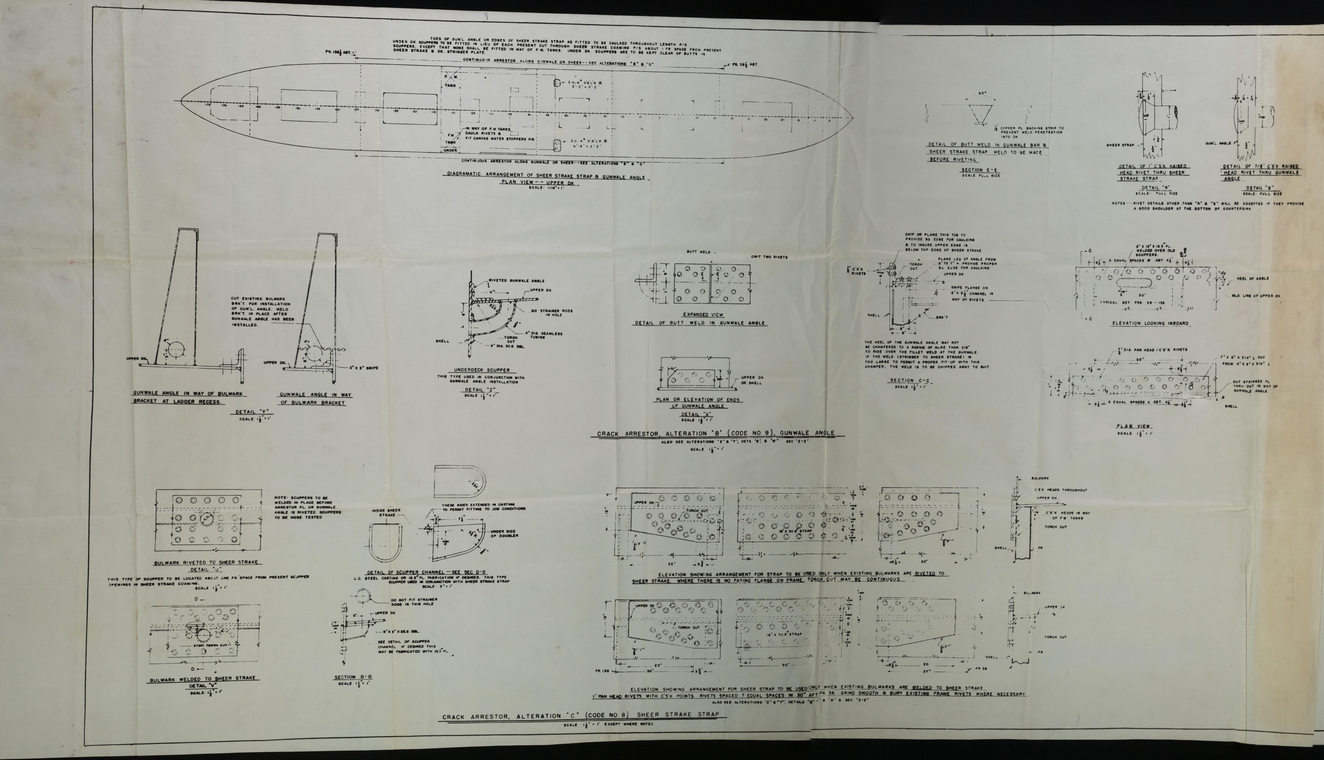

GENERAL NOTES ON CRACK ARRESTOR AT GUNWALE

1. SALT EDGES OF RUBBER STRAP & GUNWALE BAR.
2. DO NOT WELD TO SHELL EXCEPT AT EXTREME ENDS.
3. TORCH TO BE GUARDED FOR ALL CUTS.
4. TURSH CUTS TO BEVEL & END IN 1" DRILLED HOLE. TREATMENT AT W.T. BHDS. 34, 40, 46, 146, 146-1A, 146-1B IS SHOWN BELOW
5. FIT SCUPPERTER BENEATH STRAP AT BHDS. 146 & 1B.
6. GAGE SHOULD BE TAKEN NOT TO INCLUDE BEAMS & FRS IN BURNING SLOTS.
7. WELD STRAPS ON GUNWALE ANGLES BEFORE SHIFTING
8. ALL RIVET HOLES IN STRAPS OR GUNWALE ANGLES TO BE DRILLED OR PUNCHED
9. ALL RIVET HOLES IN EXISTING STRUCTURES TO BE DRILLED.
10. DO NOT BURN RIVET HOLES

DETAIL OF BUTT WELD IN GUNWALE BAR & SHEER STRAKE STRAP HELD TO BE MADE BEFORE RIVETING.

SECTION E-E
SCALE 1/2"=1'

DETAIL OF 1/2" C'S'K RAISED HEAD RIVET THRU SHEER STRAKE STRAP.

DETAIL "A"
SCALE: FULL SIZE

DETAIL OF 7/8" C'S'K RAISED HEAD RIVET THRU GUNWALE ANGLE

DETAIL "B"
SCALE: FULL SIZE

NOTES: RIVET DETAILS OTHER THAN "A" & "B" WILL BE ACCEPTED IF THEY PROVIDE A GOOD SHOULDER AT THE BOTTOM OF COUNTERSINK

THE HEEL OF THE GUNWALE ANGLE MAY NOT BE LENGTHENED TO TERMINATE ON WEB THIS LINE TO ROOE OVER THE FILLET WELD OF THE GUNWALE OF THE HELD (STRINGER TO SHEER STRAKE) & THIS LENGTH TO PERMIT A PROPER FIT-UP WITH THIS CHANGE. THE WELD IS TO BE CONTINUE ABOUT TO MUT

GENERAL NOTES ON HATCH REINFORCEMENTS.

1. SOME OF THE VESSELS HAVE HAD HATCH CORNERS REINFORCED WITH OTHER APPROVED TYPES OF REINFORCEMENT SUCH AS GUSSETS NOS. 1, 2, 3, & 4. NO ADDITIONAL REINFORCEMENT IS REQUIRED FOR VESSELS HAVING THESE TYPES OF GUSSETS. ONE OF THE APPROVED TYPES OF REINFORCEMENT SHOULD BE FOUND IN OR PLACED IN THE CORNERS OF NOS. 5, 6, & 7 HATCHES OF EVERY ECL(8-0). IN THE CORNERS OF NOS. 8, 9, 10, & 11 TRUNKS OF EVERY DET(11-0)8, 9-NO. 2 & 3 HATCHES OF ALL ECL(2-0)12-0.
2. NOTE THAT DET. NO. 1 FOR TANKERS IS SLIGHTLY DIFFERENT & IS SHOWN ON DWG. NO. 2 ECL(1-0)12, 5(4-0)13. THERE IS NO DET. NO. 2 ON TANK VESSELS (INSTALLATION CODE NO. 8).
3. IN THE ECL(2-0)12 TANK CARRYING, 2 TO 1.5 OR (NO. (INSERT PL. CAN BEEN APPROVED IN 1.0(0) OF THE ECL 1.8 (N. (NODE) PL. WITH 6) 1.8. DOUBLER AS SHOWN IN ALTERATION "A"
4. REMOVAL OF INSERT PLATES AT HATCH CORNERS SHOULD BE AVOIDED ON EXISTING VESSELS EXCEPT WHEN PERMANENT DAMAGE CANNOT EXISTING IN INSERT PL. AT THE OF CORNER REINFORCEMENT SHOULD BE REPAIRED BY WELDING OR REPLACEMENT.
5. IF IN REPAIR IT BECOMES NECESSARY TO REMOVE THE 31 1.8 DOUBLER IT ORIGINAL HATCH CORNERS, IT NEED NOT BE REPLACED IN REINFORCING THE CORNERS.

GENERAL NOTES ON STRUCTURAL ALTERATIONS

1. THIS PLAN SUPERSEDES PLAN 41-14-00-17-1 & APPLIES ON VESSELS WHEN ON BOT ALREADY INCLUDE ALL THE ALTERATIONS SET FORTH IN NOTE 2 BELOW. APPROVED ALTERATION ITEMS PREVIOUSLY PERFORMED ARE NEEDED NOT TO BE APPEARED BY THIS PLAN.
2. THE VESSELS COVERED BY THIS PLAN SHALL BE REINFORCED WITH ALL THE ITEMS SHOWN EXCEPT AS FOLLOWS:
   (A) EITHER ALTER. "A" OR ALTER. "C" SHOULD BE FITTED BUT NOT BOTH; IT IS LEFT TO THE LOCAL AUTHORITIES TO DETERMINE ON THE BASIS OF ECONOMY OF TIME, DIRECT & AVAILABILITY OF MATERIALS WHICH VESSELS TO DETERMINE ON THE BASIS OF ECONOMY OF TIME, DIRECT & AVAILABILITY OF MATERIALS WHICH VESSELS WITH RIVETED SHELL SEAMS ARE NOT REQUIRED TO HAVE STRAKE RIVETED HOWEVER WHEN MILITARY URGENCY DOES NOT ALLOW TIME FOR THE INSTALLATION OF ALTER. "A".
   (B) EITHER ALTER. "B" OR ALTER. "F" SHOULD BE FITTED BUT NOT BOTH; IT IS LEFT TO THE LOCAL AUTHORITIES TO DETERMINE ON THE BASIS OF ECONOMY OF TIME, DIRECT & AVAILABILITY OF MATERIALS WHICH VESSELS WITH RIVETED SHELL SEAMS ARE NOT REQUIRED TO HAVE STRAKE RIVETED HOWEVER WHEN MILITARY URGENCY DOES NOT ALLOW TIME FOR THE INSTALLATION OF ALTER. "A".
3. ALL VESSELS MUST HAVE ALL THE REQUIRED ALTERATIONS COMPLETED AS SOON AS POSSIBLE. VESSELS UNDERGOING EXTENSIVE REPAIRS SHOULD HAVE ALL THE REQUIRED ALTERATIONS MADE AT THE TIME OF REPAIRS. DUE TO THE AVAILABILITY OF THE SHOP IS LIMITED DUE TO MILITARY REQUIRED, THE ORDER OF PRECEDENCE OF DOING ALTERATIONS SHOULD BE ESTABLISHED AS:
   (A) THE HATCH CORNERS SHOULD BE REINFORCED BEFORE THE NEXT INTENDED ALTERATION "A" SHOULD BE PERFORMED AT THE SAME TIME. ALSO EITHER ALTERATION "A" OR ALTERATION "B" (BUT NOT BOTH) SHOULD BE PERFORMED ON THIS OCCASION. ALTERATION "A" IS TO BE USED AS PRECEDENCE ITEM WHEN TIME DOES NOT PERMIT THE ALTERATION "F" INSTALLATION. ALTERATION "F" SHOULD BE PERFORMED BEFORE THE GUNWALE OR SHEER STRAKE IS REPAIRED OR REPLACED AS THE ALTERATION "F" CANNOT BE INSTALLED LATER.
   (B) THE ALTERATION "F" OR ANY OF BLGE. KEEL BUTTS SHOULD BE MADE AT THE FIRST OPPORTUNITY.
   (C) ALL REQUIRED REINFORCEMENTS SHOULD BE COMPLETED ON VESSELS SCHEDULED TO LEAVE PORT WITH MORE THAN 200 TROOPS ABOARD.
4. DETAILED STRUCTURAL ALTERATIONS FOR LIBERTY TROOPSHIPS CARRYING MORE THAN 1000 TROOPS & FOR HOSPITAL SHIPS WHICH HAVE BEEN PREPARED BY THE ENGINEERING DEPARTMENT WITH 41-14-00-17-1 & 41-14-00-17-1 RESPECTIVELY, PLAN AUTHORIZED MODIFICATIONS THERETO.
5. NO DOUBLE BOTTOM BINDERS OR DECK STRAPS WILL BE REQUIRED FOR VESSELS OWNED BY THIS PLAN. HOWEVER, IF THE VESSEL IS TO BE USED FOR TRANSPORTING TROOPS, THE DECK STRAPS MUST BE PROVIDED IN THE VESSEL, BE BALLASTED SO THAT THE DRAFT IN AN 8 KNOTS SEASTAL PROTECTION FROM THE STANDPOINT OF LONGITUDINAL BENDING.
6. THE SCUPPERS MADE IN THE ALTERATIONS SHOULD BE GAGEFUL NOT TO HAVE TOO GREAT A LENGTH OF OUT AT THE BULWARK OR IN THE SHEER STRAKE IN ANNOUNCE OF FITTING THE REQUIRED STRAP.
7. THE ALTERATIONS SHOWN ON THIS PLAN ARE TO BE CARRIED OUT IN ACCORDANCE WITH THE SHOP GUARD BOOKLET ENTITLED "STRUCTURAL ALTERATIONS ON LIBERTY SHIPS" (1-0A(8)-1(4)-1)(REVISED APRIL, 1945).

FOR ALTERATIONS SHOWN AT U.J.R. VENTS - FD-82-B1-65

UNIT	EXISTING LIBERTY TYPE DRY CARGO SHIPS, TANKERS, TANK-CARRIERS & TROOPSHIPS CARRYING 1000 TROOPS OR LESS
TITLE	STRUCTURAL ALTERATIONS
	UNITED STATES COAST GUARD MERCHANT MARINE TECHNICAL DIV. WASHINGTON, D.C.
	CAPTAIN, U.S.C.G. CHIEF, DIV. MAR. TECH. DIV.
	CAPTAIN, U.S.C.G. CHIEF, DIV. MAR. TECH. DIV.
	LT. COMMANDER, U.S.C.G.R.

DRAWN BY	A.C. HILDRETH, JUNIOR NAVAL ARCHITECT
SCALE	AS SHOWN
DATE	23 JUNE 1945
SHEET	OF
DRAWING NO.	E.M.W.(P-B)-17

APPROVED BY AMERICAN BUREAU OF SHIPPING AUG 20, 1945

APPROVED BY U.S. MARITIME COMMISSION AUG. 25, 1945

Capt. USNR

VESSELS COVERED BY THIS PLAN.
SUGGESTED THAT THE TANKS OF THE
SITION FROM THE STANDPOINT OF

HAVE TOO GREAT A LENGTH OF CUT AT THE
RED STRAPS.
ERS USED IN THE COAST GUARD BOOKLET
) - DATED APRIL 1945.

APPROVED
JUL 1 1947
LLOYD'S REGISTER OF SHIPPING
NEW YORK

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ex
Ref. "John Jacob Astor"
Gal rept No. 4880.

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ON

0.4# PL DBLRS SHOWN AT U.DK VENTS - FR# 82-83 P&S
W.S.A.

T EXISTING LIBERTY TYPE DRY CARGO SHIPS, TANKERS, TANK-CARRIERS & TROOPSHIPS CARRYING 1000 TROOPS OR LESS	DRAWN BY W T McAULEY ASSOC NAVAL ARCHITECT
LE STRUCTURAL ALTERATIONS	
UNITED STATES COAST GUARD MERCHANT MARINE TECHNICAL DIV. EADQUARTERS WASHINGTON D.C.	SCALE AS SHOWN DATE 23, JUNE 1945
Edward McMacatchen, Jr. NAVAL ARCHITECT CAPTAIN, U.S.C.G.R. CHIEF, MER. MAR. TECH. DIV. T. COMMANDER, U.S.C.G.R.	SHEET 1 OF 1 DRAWING NO. E.M.M. 17-S11-17-1

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