

# PRINCIPAL DIMENSIONS.

LENGTH B.P.	416'-0"
BREADTH EXTR.	57'-1"
BREADTH MLD.	56'-10 1/2"
DEPTH MLD. UPPER DK.	37'-4"
DEPTH MLD. SECOND DK.	28'-7"
DEPTHS TO LENGTH UPPER DECK	
CLASS 10001 WITH FREEBOARD	
DRAFT MLD.	26'-10"

UPPER DECK STRINGER ANGLE  
FRS. 23-40 4" x 4" x 3/8"  
FRS. 40-128 6" x 6" x 1/2"  
FRS. 128-147 4" x 4" x 3/8"  
STRINGER 1/2" E.W. TO  
SHEER STRAKE AT ENDS.

BUTT WELDS IN ALL CLASSES TO HAVE  
A FINISHING BEAD.  
FIRST TWO BEADS IN BUTT WELDS  
TO BE WELL PEENED.

PLATES TO BE VEE'D OUT TO A 60° INCLUDED ANGLE  
FOR ALL BUTT WELDS AND REVELLED TO WITHIN 1/8"  
FROM BOTTOM PLATE. GAP OF 1/8" TO BE KEPT  
BETWEEN EDGES TO BE WELDED.

## EQUIPMENT.

- 2 STOCKLESS ANCHORS 8400 LBS EACH.
- 1 STUD CHAIN 270 FATHOMS 2 1/2" H.T. STEEL
- 1 STREAM ANCHOR (STOCKLESS) 25 1/2 CWT.
- 1 STREAM WIRE 30 FATHOMS 5" x 12 F.S.W.
- 1 TOWLINE 120 " 4 1/2" x 24 SPECIAL F.S.W.
- 2 HAWSEERS 30 " 2 1/2" x 12 F.S.W.
- 2 WARPS 30 " 2 1/2" x 12 " "

## WELDING NOTES.

**FLAT KEEL** WELD BUTTS FROM INSIDE (WELD IN WAY OF G.V.K. BARS AND SEAMS ONLY) DO NOT COMPLETE WELD UNTIL G.V.K. & GABBOARD STRAKES ARE BOLTED UP.

**G.V. KEEL** WILL COME RIVETED COMPLETE EXCEPT IN WAY OF BUTTS OF PLATING. SHORT BARS APPROX. 15' x 30" LONG TO BE INTRODUCED HERE AND FITTED AFTER G.V.K. IS IN PLACE. BUTTS OF ANGLES TO BE WELDED.

**BOTTOM SHELL PLATING** 60" WELD FROM INSIDE. OUTSIDE PLATE 1" WIDER THAN LANDING. 60" WELD FROM OUTSIDE.

**SIDE SHELL AND ENDS** INSIDE STRAKES TO BE VEE'D OUT AND WELDED FROM THE INSIDE. OUTSIDE STRAKES TO BE VEE'D OUT AND WELDED FROM THE OUTSIDE.

**CLEAR OF BOTT. SHELL** THIS IS A CLINKER STRAKE. THE BUTTS TO BE VEE'D AND WELDED FROM OUTSIDE AND LOWER EDGE WHICH IS INSIDE IS TO BE FINISHED IN THE SAME MANNER AS OUTSIDE PLATES. THAT IS VEE'D 1" WIDER THAN LANDING AND WELDED FROM INSIDE.

**J.A. STRAKE** NOTE: ALL SHELL LANDINGS TOP & BOTTOM FOR 3" EACH SIDE OF SHELL BUTTS TO BE WELDED.

**TANK TOP** ALL TANK TOP PLATING/SEAMS AND FLOOR ANGLES TO BE RIVETED. ALL BUTTS TO BE WELDED FROM TOP SIDE. TANK TOP SEAMS TO BE WELDED FOR 3" EACH SIDE OF BUTT. SHEET TUNNEL PLATING TO BE FILLET WELDED TO TANK TOP SIMILAR TO BHO'S. NO FOUNDATION BARS TO BE FITTED. PLATING TO HAVE SAME PROCEDURE AS TANK TOP.

**TANK MARGIN PLATE** FLANGED ON TOP AND LAP RIVETED TO TANK TOP PLATING. BOTTOM EDGES TO BE BUTTED ON SHELL PLATE AND FILLET WELDED AS SKETCHED. THE ORDINARY FLOORS AS WELL AS O.T. & W.T. FLOORS WILL BE WELDED TO THIS PLATE INSIDE AND BULGE BRACKETS WELDED ON OUTSIDE. NO ANGLE CONNECTIONS WILL BE FITTED ON EITHER SIDE OF TANK MARGIN PLATE. ALL BUTTS OF TANK MARGIN PLATES WELDED FROM OUTSIDE, WITH FINISHING BEAD INSIDE.

**W.T. BHO'S** TO BE ALL RIVETED EXCEPT IN WAY OF TANK TOP AND TANK MARGIN. NO FOUNDATION ANGLE TO BE FITTED TO TANK TOP OR MARGIN. BHO PLATING AND STIFFENERS BRACKETS BUTTED HARD ON TANK TOP AND TANK MARGIN AND FILLET WELDED. BULKHEAD SHELL BARS TO BE CARRIED DOWN BULGE AND STOPPED 1/2" SHORT OF MARGIN PLATE.

**BULGE BRKTS AND GUSSET PLATE** RIVETED TO FRAME AND BULGE ANGLE AND WELDED TO TANK MARGIN. GUSSET PLATE WELDED TO FLANGE OF BULGE BRACKET AND WELDED TO TANK TOP.

**O.T. BHO'S** TO BE OF ALL WELDED CONSTRUCTION.

**W.T. & O.T.** TO BE WELDED DIRECT TO SHELL & TANK TOP WITHOUT ANGLES. SEE SKETCH.

**FLOORS IN DOUBLE BOTTOM** THROUGH WELD VARIES WITH THICKNESS OF PLATE.

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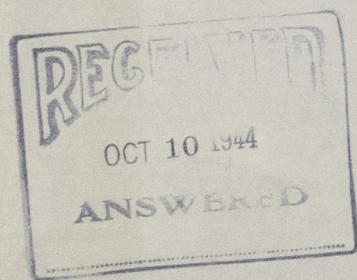
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