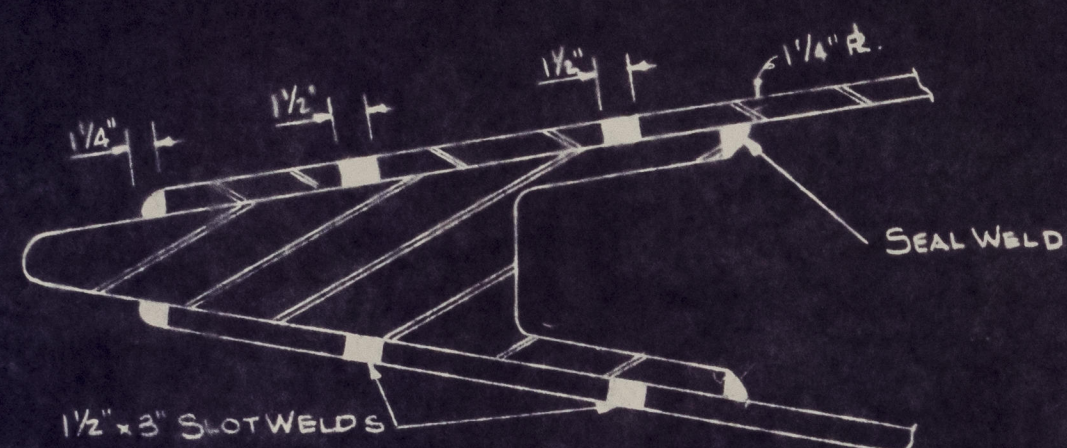
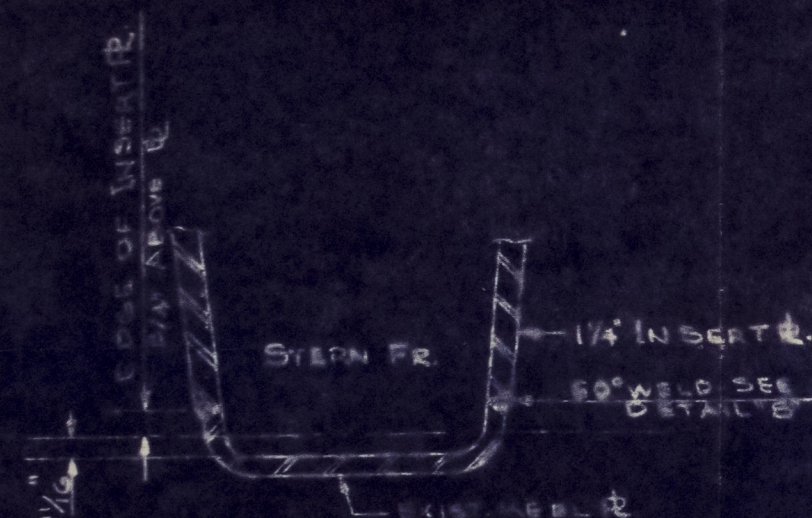


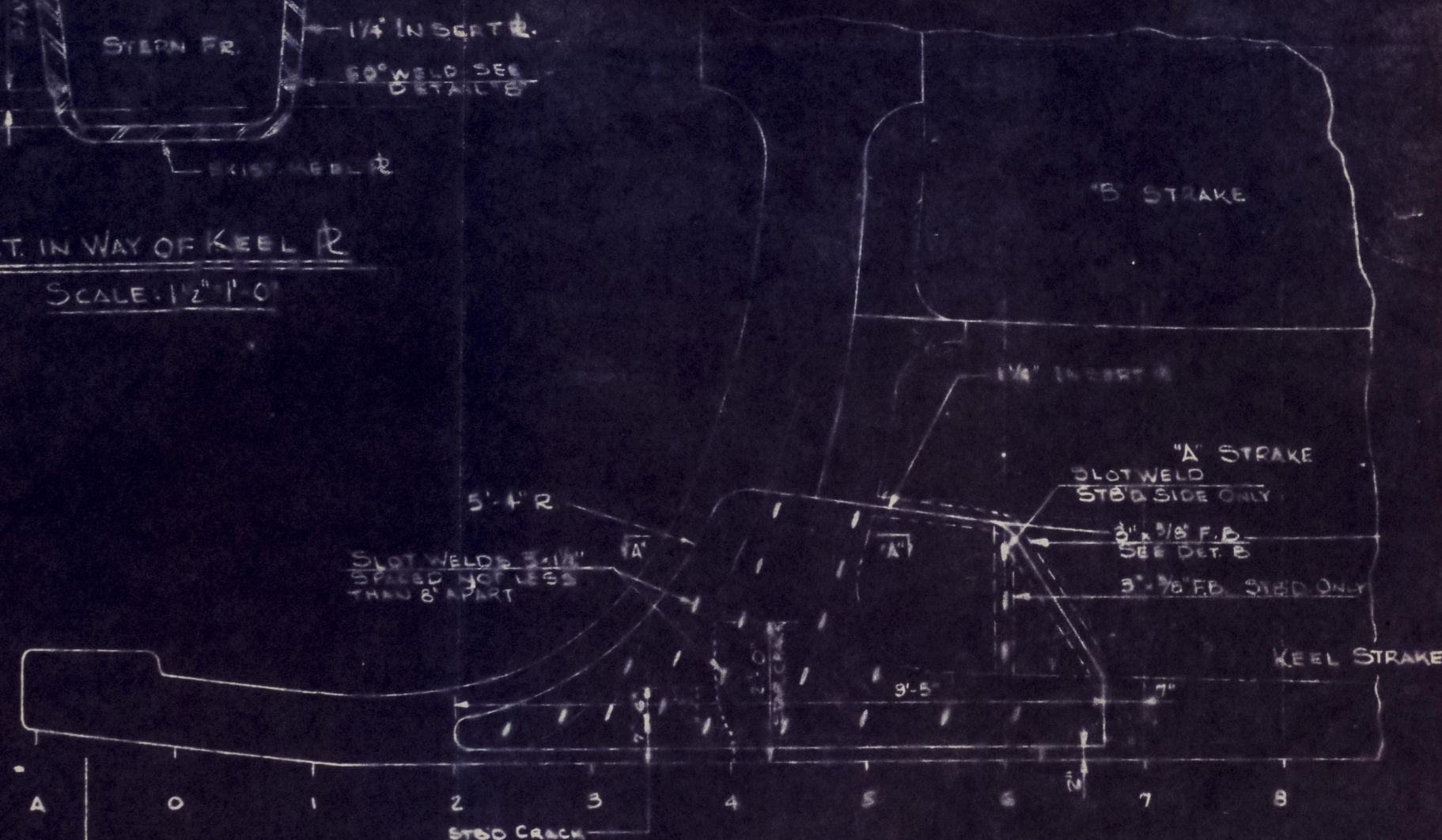
SECT. AFT END OF KEEL R.
SCALE: 1/2" = 1'-0"



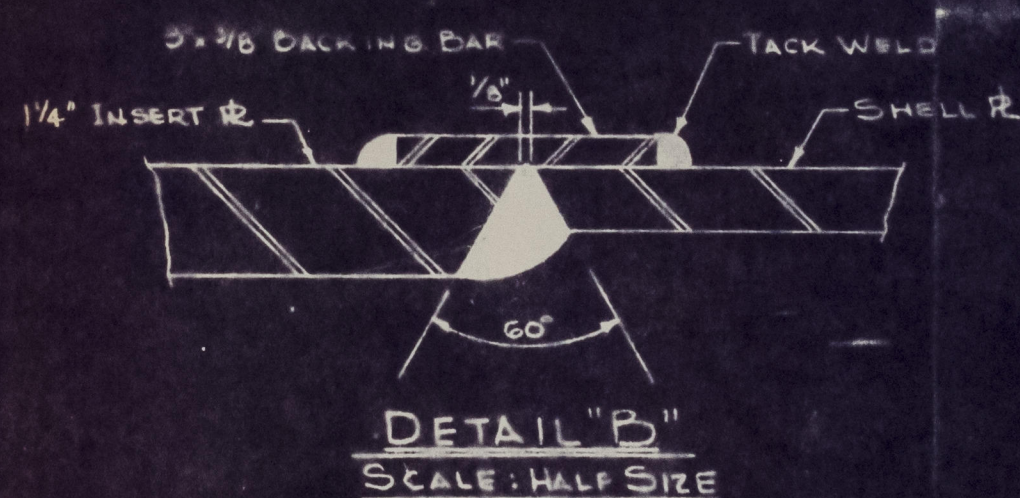
SECTION 'A-A'
SCALE: 1/2" = 1'-0"



SECT. IN WAY OF KEEL R.
SCALE: 1/2" = 1'-0"



ELEVATION - STERN FRAME
STBD SIDE SHOWN - PORT SIMILAR
SCALE: 1/2" = 1'-0"



ACCOMPANY: NCC REPORT NO. 9078
DATED: 1952

ALTERATIONS				
Authorisation	ALT. No.	DATE	DESCRIPTION	APP'D.

GENERAL NOTE:

1- THIS DWG. SHOWS THE REINFORCING AS CONSTRUCTED ON SHIP.

WELDING SEQUENCE:

- 1- WELD FLAT BAR TO FLOOR AND TO SHELL PLATE.
- 2- ERECT P&S INSERT RS. FROM TEMPLATE AND TACK WELD TO STERN FRAME AND TO FLAT BAR.
- 3- SEAL WELD FWD. & TOP EDGES OF R. TO BACKING FLAT BAR.
- 4- SEAL WELD R. TO STERN FRAME FLANGE, STARTING AT FWD. LOWER END AND WORKING AFT AND UP.
- 5- SLOT WELD SIDE R. TO CASTING & FLOOR ON STBD. SIDE AS SHOWN.
- 6- WELD FWD. END OF SIDE PLATING P&S. SIMULTANEOUSLY, WORKING FROM BOTTOM TO TOP.
- 7- WELD LOWER BUTT OF SIDE R. WITH KEEL R., P&S. SIMULTANEOUSLY, WORKING FROM FWD. END AFT TO GAP WHERE KEEL R. MEETS SHOULDER CASTING.
- 8- WELD UP GAP BETWEEN CASTING SHOULDER AND END OF KEEL PLATE, PEEN EXCEPT LAST LAYER.
- 9- WELD TOP EDGE OF SIDE PLATE TO SHELL AND CASTING, WORKING FROM FWD. TO AFT.
- 10- WELD AFTER EDGE OF SIDE PLATE TO CASTING WORKING FROM TOP DOWN.

REFERENCE DWGS:

BETH. DWG. A-3122 - CRACKS IN STERN FRAME - STBD. SIDE
SUN. SHIPBLDG. DWG. 241-103-A - STERN FRAME

S.S. IMPERIAL TORONTO

APPROVED _____

APPROVED _____

APPROVED _____

Approved: *[Signature]*

CONTRACT JQ-3512B

BETHLEHEM STEEL COMPANY
SHIPBUILDING DIVISION
BALTIMORE YARD BALTIMORE, MD.

STERN FRAME REINFORCING

Drawn By: *[Signature]* Chief Draftsman
Traced By: *[Signature]* Chief Engineer
Checked By: *[Signature]* Inspector
Scale: AS SHOWN Date: 4-30-55

DRAWING No. B-3701 ^{Alt. 6}

DEPT.	DATE ISSUED	
	2,30-55	5,22-55
YARD SUPT.		
ESTIMATING		
PIPE		
ELECTRIC		
SHEET METAL		
OUTSIDE MACH.		
WELD. LOFT		
MILL		
ORDER		
OFFICE		
SHIP SUPT.		
RIGGER		
FORGE		
WELDING		
CARPENTER		
JOINER		
PATTERN		
MACHINE		
PAINT		
U.S. C.G.		
CLASS. <i>6020A</i>		
OWNER		

[Handwritten notes]