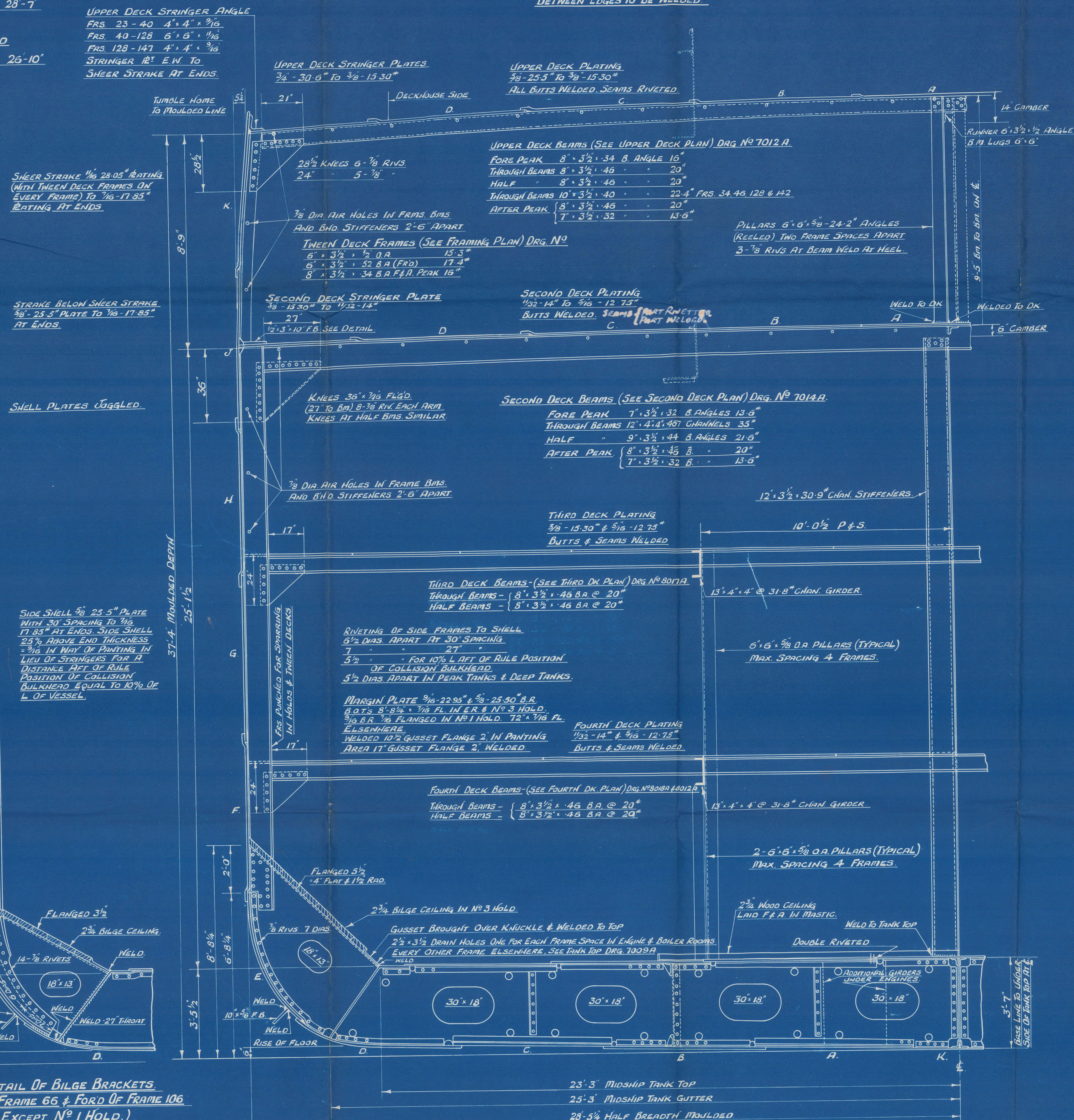


<u>LENGTH B.P.</u>	416'-0"
<u>BREADTH EXTR.</u>	37'-1"
<u>BREADTH MLD.</u>	36'-10 1/2"
<u>DEPTH MLD. UPPER DK.</u>	37'-4"
<u>DEPTH MLD. SECOND DK.</u>	28'-7"
<u>DEPTHS TO LENGTH UPPER DECK.</u>	
<u>CLASS + 10001 WITH FREEBOARD</u>	
<u>DRAFT MLD.</u>	26'-10"

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 BEVELLED TO WITHIN 1/8"
FROM BOTTOM PLATE. GAP OF 1/8" TO BE KEPT
BETWEEN EDGES TO BE WELDED.



NOTE:- BULGE FRAME & BOTTOM FRAME TO BE ORDERED
AND TURNED ETC. IN ONE LENGTH.
RINGS IN BOTTOM FRAMES TO SHELL & FLOORS
SPACED 7 DIAS THREE STRAKES OF SHELL
NEXT TO KEEL TO BE 10% ABOVE $\frac{1}{8}$ THICKNESS
= $\frac{3}{8}$ ($\frac{1}{16}$ IN WAY OF 2" SPACING) FROM $\frac{1}{2}$ L
FORWARD TO COLLISION BWD.

DETAIL OF BILGE BRACKETS.
OF FRAME 66 & FORD OF FRAME
(EXCEPT NO 1 HOLD.)

BOTTOM PLATING 5/8" - 25.5" WITH 30" SPACING TO 1/2" 20.4" AT ENDS.
THREE STRAKES OF SHELL NEXT TO KEEL TO BE 10%
ABOVE ϕ THICKNESS FROM 1/2 L. FWD. TO COLLISION B'D.

KEEL 52 x 3/4 - 30-60° FOR 3/8" SL. TO 1/8" 28-05°
AT ENDS. 3/8" RIVS. IN SEAMS AND FRAMES
BUTTS ELECTRIC WELDED.

FRAMES (SEE FRAMING PLAN) DRG. N° 7003A

<u>MAIN FRAMES</u>	12' 4" x 467'-35"	CUMMINS TO 2 ND DW. IN E.R. & N ^O 3 HOLD 30 APART EXCEPT FTS 78 TO 93 INC. WHICH ARE 12' 4" x 590 CHG ^D
	12' 4" x 4590-40"	E.R. N ^O 2 & E.S. HOLDS 30 APART.
	10' 3 3/4" x 425'-25.5"	N ^O 1 HOLD 27 APART FROM 2 ND OIL TO MARGIN.
<u>PENK</u>	8' 3 1/2" x 34'-16"	B. ANGLES SPACED 24" APART.

[illegible]

EQUIPMENT

- | | | |
|---|---------------------------|---------------------------------------|
| 2 | STOCKLESS ANCHORS | 8400 LBS EACH |
| 1 | STUD CABLE CHAIN | 270 FATHOMS 2 1/2" H.T. STEEL |
| 1 | STREAM ANCHOR (STOCKLESS) | 23 3/4 CWTs |
| 1 | STREAM WIRE | 90 FATHOMS 5' - 6" x 12 F.S.W. |
| 1 | TOWLINE | 120 " 4 1/2" - 6" x 24 SPECIAL F.S.W. |
| 2 | HAWSERS | 90 " 2 1/2" - 6" x 12 F.S.W. |
| 2 | WARPS | 90 " 2 1/2" - 6" x 12 " " |

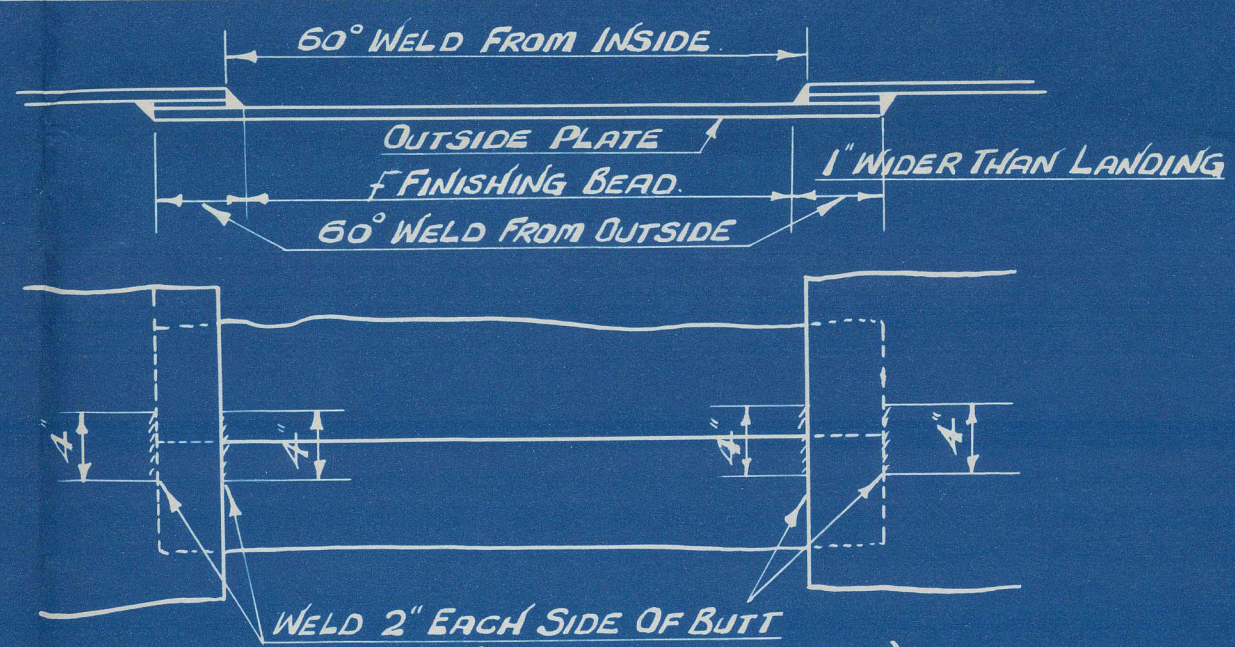
WELDING NOTES

FLAT KEEL. WELD BUTTS FROM INSIDE (WELD IN WAY OF CVK BARS AND SEAMS ONLY) DO NOT COMPLETE WELD UNTIL CVK & GARBBOARD STRAKES ARE BOLTED UP.

CV KEEL. WILL COME RIVETED COMPLETE EXCEPT IN WAY OF BUTTS OF PLATING. SHORT BARS APPROX 15" & 30" LONG TO BE INTRODUCED HERE AND FITTED AFTER CVK IS IN PLACE. BUTTS OF ANGLES TO BE WELDED.

C.V. KEEL. WILL COME RIVETED COMPLETE EXCEPT IN WAY OF BUTTS

BOTTOM SHELL PLATING.



ON SEAMS (BOTH INSIDE & OUTSIDE)
ALL BUTTS OF BOTTOM SHELL TO BE VEED OUT AND WELDED FROM
THE INSIDE. THIS IS DONE TO OBTAIN DOWN HAND WELDING TO FULLEST EXTEN
BUTTS OF INSIDE STRAKES WILL BE VEED OUT FULL WIDTH. THE BUTTS
OF OUTSIDE STRAKES TO BE VEED INKDE AND WELDED BETWEEN THE
LANDING EDGES OF INSIDE STRAKES ONLY. THIS WELD WILL BE
COMPLETED BY VEEDING OUTSIDE ON THE SHIP AND WELDING BOTH
SEAMS. THESE TO VEED OUT 1" WIDER THAN LANDING.

SIDE SHELL INSIDE STRAKES TO BE VEED OUT AND WELDED FROM THE INS.
AND ENDS OUTSIDE STRAKES TO BE VEED OUT AND WELDED FROM
CLEAR OF THE OUTSIDE.

7. A STRAKE. THIS IS A CLINKER STRAKE. THE BUTTS TO BE VEED AND WELDED FROM OUTSIDE AND LOWER EDGE WHICH IS INSIDE IS TO BE FINISHED IN THE SAME MANNER AS OUTSIDE PLATES THAT ARE VEED 1" WIDER THAN LANDING AND WELDED FROM INSIDE.
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. SHAFT TUNNEL PLATING TO BE FILLET WELDED TO TANK TOP SIMILAR TO BHD².
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 EDGE TO BE BUTTED ON SHELL PLATE AND FILLET WELDED AS THE ORDINARY FLOORS AS WELL AS AT INTERIOR FLOORS WILL BE WELDED TO THIS PLATE INSIDE AND BULGE BRACKETS WELDED OUTSIDE. NO ANGLE CONNECTIONS WILL BE FITTED ON EITHER SIDE. TANK MARGIN PLATE. ALL BUTTS OF TANK MARGIN PLATES TO FLOW OUTSIDE WITH FINISHING BEAD INSIDE.

W.T. BHD² TO BE ALL RIVETED EXCEPT IN MAY OF TANK TOP AND TANK
NO FOUNDATION ANGLE TO BE FITTED TO TANK TOP OR MARGIN
AND PLATING AND STIFFENER BRACKETS BUTTED HARD ON
TOP AND TANK MARGIN AND FILLET WELDED. BULKHEAD STIFF-
ENERS TO BE CARRIED DOWN BILGE AND STOPPED 1/2 SIDE
OF MARGIN PLATE.

BILGE BRKTS KNUTED TO FRAME AND BILGE ANGLE AND WELDED TO TANK
AND GUSSET MARGIN. GUSSET PLATE WELDED TO FLANGE OF BILGE BRK
PLATE. AND WELDED TO TANK TOP.

O.T. BHD'S TO BE OF ALL WELDED CONSTRUCTION.

WT & O.T. TO BE WELDED DIRECT TO SHELL & TANK TOP
FLOORS IN WITHOUT ANGLES. SEE SKETCH.
DOUBLE BOTTOM. THROAT WELD
VARIABLE WITH

THICKNESS OF PLATE.

THROAT WELD
VARIABLES WITH
THICKNESS OF PLATE.

VICTUALLING SHIPS.

MIDSHIP SECTION.

DRAWN W.T. TRACED J.B.S. CHECKED
SCALE $\frac{1}{2} = 1$ FL
DATE APRIL 14, 1944 DWG. No. 8226A

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