4plate Lifting Hatch emergency escape on gas struts

6pl Recess Horizontal
6pl Recess Vertical
60x6 Flat Capping
60x60x6 Angle Stiff's

6pl Al Al Coachroof 2½"x2½"x¼" Angle (or 2¾"x2¾"x10g Box) Beams @ 300 crs Rolled to 13000 Radius

Hinge Arrangement (see detail)

102x51 Channels either side of hatch opening

5pl Steel Coachroof 80x80x6 Angle Beams

6pl Cabin Sides

60x60x6 Angle Stiff's @ 400 crs

6pl E.R. Bulkhead

60x60x6 Angle Frames

102x51 Channel Supports

6mm plate tank tops (Removable)

Skylight

20 Dia Pipe capping
6pl Raised Bulwark
6pl Fore Deck
60x60x6 Angle Beams

6pl Bulkhead stiffened by 40x40x4 Angles @ 400 crs

6pl Tank Boundaries

Ballast Water Tank

6pl Tank Plating

6pl Bow Cone

Bow Fore Water Tank

Window Apertures

6pl Side Shell 80x80x6

Shell Angle

DH Frames

Side Entrance P&S

Window Aperture

6pl Cabin Sides

Window Aperture

200x150 Vent P&S with Flap Closure

10pl Counter

70x70x8 Angle Bearer

on 10pl Eng. Girders

10pl Weed Hatch Coamings (6pl Closure Plate

250x200 Vent with Flap Closure

Seamless 250 ID Heavy Wall Bow Thruster Tube

Pump Recess at base of stakes

200x10pl Floors Capped by 80x8 Reverse Bar

12pl Bottom Shell 700x6pl Chine Strake

200x10 ℄ Girder 80x8 Flat

6pl Oil Tight Floor

8pl/10pl Skeg Sides

200x12pl Skeg Base

200x150 Vent P&S with Flap Closure

6pl Side Shell

80x80x6 Angle Side & Counterstiffs

10 plate Counter Plate

6pl Tank Boundaries

6pl Radius Stern

10pl Weed Hatch

100x100 Wall Rubber Trunk

6pl Side Shell

6pl Bow Cone

6pl Bhd stiff'd by 40x40x6 Angle Stiffs

6pl Tank Plating Stiff'd by 40x40x6

80x80x6 Angle 700x6pl Chine

Intermediate Strake

Frames

12pl Plate Bottom 200x10 + 80x8 Frames

Shell on Reverse Bar

60x60x6 Angle Frames in way of lift

200x10 ℄ Girder 80x8 Top Flat

Water Ballast Tank

100x12pl Skeg Base

10pl Skeg Sides

80x80x8 Angle Bearer

10pl Eng. Girders

6pl Oil Tight Floor

6pl Hatch Cover - Hinged at aft end supported on gas struts

6pl Fore Deck

6pl Hatch Coamings

6pl Recesses

40x40x4 Angle Stiff's

50x6 Flat Top Stiffener

6pl Fore Deck on 60x60x6 Angles @ 600 crs

8pl Bkts + 80x80x6 Stiff's @ 400 crs

Hydraulic Ram Cylinder

100mm I.D. Deck Tube

6pl Cabin Sides

6pl Horizontal Recess

6pl Vertical Recess

6pl Bracket

40x40x4 Angle Stiff's

50x6 Flat Top Stiffener

60x60x8 RHS Pillars

8pl Hinge plate See Detail Sheet 4

5pl Coachroof Beams on 60x60x6 Angle @ 600 Centres

6pl Hatch Coaming

30 Dia Tube Handrail P&S

Pumpout & Rinse out Fittings

102x51 Channel Supports/Drainage

6pl Curtain Plate

6pl Raised Side Deck

6pl Side Shell

Channels drain thru' stern

6pl Tank Boundaries

6mm Removeable Top Plate P&S

60x60x6 Angle Beams @ 600 centres

6pl Cabin Sides

6pl Sidedeck

102x51 Channel F&A of Hatch Opening

6pl Sidedeck

⊗ = Vents = Tannoy/Pancake Type or Votos Upstr

Radials at 30° 45° & 60° from Sky Light Centre

50x8 pl Longl's & Radials

or 2½" 2" x10g Box

6pl Al Alloy Roof on 2½"x2½"x¼" Angle Beams @ 300 crs Rolled to 13000 Radius

6pl Downturn

2"x2"x10g Box Section Beams Rolled to 13000 Radius

2½"x1"x10g RHS Lower Edge

2½"x1"x10g RHS Bottom Edge

2"x2"x10g Stiffeners Box Section

25 Dia Bar-Plate End Cap

See Sheet 4 for Hinge Detail

6pl Roof

6pl Return

90x6 Door Frame

6pl Cabin Side

400x6pl Sidedeck Step Recess

6pl Step Bracket

60x60x6 Angle Intermediate Frame

6pl Side Shell

6pl x700 Chine Strake

60x60x6 Angle Frame

6pl Bottom Shell

102x51 Channel

6pl Hatch Coaming

5pl Roof

60x60x6 Angle Beams

See Detail Sheet 4

60x60x8 RHS Pillars

60x60x6 Angle Stiff'

6pl Inner Recess

6pl Base

6pl Bracket

60x60x6 Angle Stiff'

6pl Cabin Side

6pl Sidedeck

60x60x6 Angle Frames

300x8pl Floor Cap

200x10pl Plate Floor

100x100 Lightening Hole

Welding Mousehole/Drainage

102x51 Channel

6pl Curtain Plate

6pl Sidedeck

6pl Side Shell

50x19x3 Half Round

6pl Edge Rubbing Bars

10pl Counter Plate

75x75x6 Angle for Beds

Beta 60 Engine ℄ Rod ℄ Box

10pl Skeg Sides

200x12pl Skeg Base

2off 635 Dia Keg Cooling Tubes for Main Engine 8mm 2900 Long

5pl Bkts

60x60x6 Angle Beams @ 600 crs

5pl Coachroof

6pl Cabin Sides

60x60x6 Angle Stiffs

60x60x6 Angle Frames

6pl Side Shell

700 x 6pl Chine Strake

200x10pl Floors

80x8 Top Flat

Hinge Arrangment

Section Shown on Centreline
Hinge Pin to be Maximum 2 Sections
Steel Roof Hinge Barrels to be Stainless Steel welded to Steel Roof upstand
Alloy Roof Hinge Barrels to be Stainless Steel welded to a Stainless Steel Carrier Angle which slots through the Alloy Roof structure
Dissimilar Metal Coatings to be Applied to Alloy and Stainless Steel

2½"x2½"x½"x¼" Angle Beams Alloy

6pl Roof Alloy

10pl Hinge Beam

2½"x2½"x¼" Angle Beam

5pl Steel Roof

Ypl Hinge Beam 6066 Flat Bar

Scale 1:2

6pl SS SE 316 Hinge Carrier

12 Dia SS SE 316 Hinge Pin

70x10pl Alloy

20 Dia Alloy Bar End Cover

8 Dia Monel or SS SS Bolts @ Height at ℄

6pl Al Al Roof

10pl Al Al Hinge Beam

2½"x2½"x¼" Angle Beam

⅜ Dia Monel Bolts

6pl SS SE Hinge Carrier

70x8pl Hinge Carrier

12 Dia SS SE 316 Hinge Pin

SS SS Hinge Pin Carrier

Preferred Hinge Arrangment

Scale 1:2

Welding Schedule

Hull Seams	Double Continuous
Hull Butts	" "
Tank Boundaries	" "
Cabin/Coachroof Seams	Single Continuous
Cabin/Coachroof Butts	" "
Rubbing Strakes	Continuous either side
Frame/Shell Connection	Staggered Intermittent
Side Shell Long'ls	" "
Engine Girders	Double Continuous
Cabin to Deck	Single Continuous
Deck to Hull	S " "
Cabin Frames	Staggered Intermittent
Coachroof Beams	" "

Hull: Staggered Intermittent = 75mm Stitch Length, 10mm Throat Depth @ 150 Centres either side of member - Doubled at ends

Cabin: Staggered Intermittent = 50mm Stitch Length, 6mm Throat Depth @ 200 Centres either side of member - Doubled at ends

Steel to BS 4360 43A EN10025 S275
Al Alloy to 5083 & 6063

FLOATING CHURGH
Sheet 3 Scale 1 : 20

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15, WRENSFIELD
HEMEL HEMPSTEAD
HP1 1RN

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