

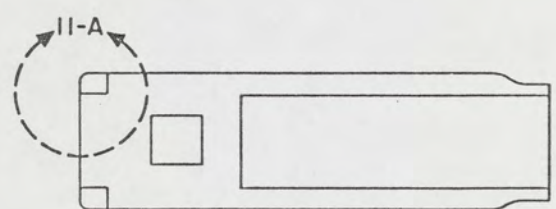
NOTES:

1. THIS DRAWING HAS BEEN DEVELOPED FROM SHIPCHECK INFORMATION FOR ACCOMPLISHING THE INSTALLATION OF WEDGE DETAIL AND MODIFICATIONS TO THE RUDDER ON LCM-8, MOD-1.
2. ALL FABRICATION WELDING AND INSPECTION TO BE IN ACCORDANCE WITH NAVSEA 0900-LP-014-5010, WELD SIZES BASED ON USE OF AWS A5.1, CLASS E7018 ELECTRODES FOR LC STEEL TO LC STEEL.
3. EQUIPMENT AND WORKMANSHIP SHALL BE IN ACCORDANCE WITH USCG AND ABS REGULATIONS.
4. REPAIR ALL PAINT DAMAGED BY THIS INSTALLATION AND PAINT ALL NEW STEEL IN ACCORDANCE WITH U.S. ARMY TECHNICAL BULLETIN TB43-0144.
5. MATERIAL ORDERED ON THIS DRAWING IS NOT INTENDED TO BE RESTRICTIVE. SUBSTITUTION OF EQUAL QUALITY MATERIAL MAY BE MADE.
6. SLIGHT DEVIATIONS FROM DIMENSIONS SHOWN ARE PERMISSIBLE TO SUIT ACTUAL CONDITIONS FOUND ABOARD THE VESSEL.
7. COMPONENTS SHOWN BY SOLID, HEAVY LINES ARE NEW AND ARE TO BE INSTALLED IN ACCORDANCE WITH THIS DRAWING. PHANTOM LINES INDICATE EXISTING COMPONENTS INSTALLED BY DRAWINGS REFERENCED AS NOTED.
8. PROVIDE CUTOUTS IN WEDGE TO MATE WITH RUDDER STRUTS IF NECESSARY.
9. TOP OF RUDDER TO BE CUT TO OBTAIN A MINIMUM OF 2" CLEARANCE.
10. PRIOR TO WELDING WEDGE TO VESSEL, THE INTERIOR OF THE WEDGE IS TO BE PRIMED WITH TWO COATS OF PRIMER CONFORMING TO FORMULA BN OF TT-P-845 AND SHALL BE APPLIED AT A MINIMUM DRY FILM THICKNESS OF ONE MIL PER COAT.
11. UPON COMPLETION OF WELDING, INSERT DRAIN PLUGS AND FILL WEDGE WITH CORROSION PREVENTIVE COMPOUND, MIL-C-16173, GRADE 1, DRAIN COMPOUND AND REINSERT ALL FILL AND DRAIN PLUGS.

REFERENCE DRAWINGS		
APPLICABLE TO HULL NUMBERS 8540 THRU 8560 AND 8580 THRU 8618		
NO.	DRAWING NO.	TITLE
1	145-4510915	LCM-8, MOD-1, BOTTOM PLATING
2	145-4510925	LCM-8, MOD-1, SKELGS AND STRUTS
3	145-4510921	LCM-8, MOD-1, DETAILS BULKHEAD AND TRANSOM

REFERENCE DRAWINGS		
APPLICABLE TO HULL NUMBERS 8520 THRU 8539		
NO.	DRAWING NO.	TITLE
1	145-2534201	LCM-8, MOD-1, BOTTOM PLATING
2	145-2534221	LCM-8, MOD-1, SKELGS AND STRUTS
3	145-2534195	LCM-8, MOD-1, BULKHEADS AND TRANSOM

STATUS OF REVISIONS			
NO.	DATE	DESCRIPTION	APPROVED



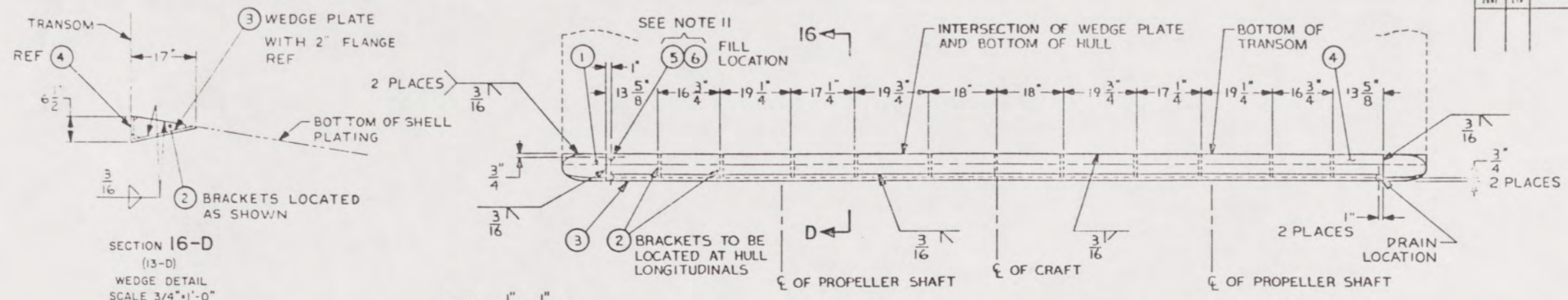
KEY VIEW 5-B
SCALE NONE

THIS DRAWING APPLIES
TO HULL NUMBERS
8520 THROUGH 8560 AND
8580 THROUGH 8618 ONLY

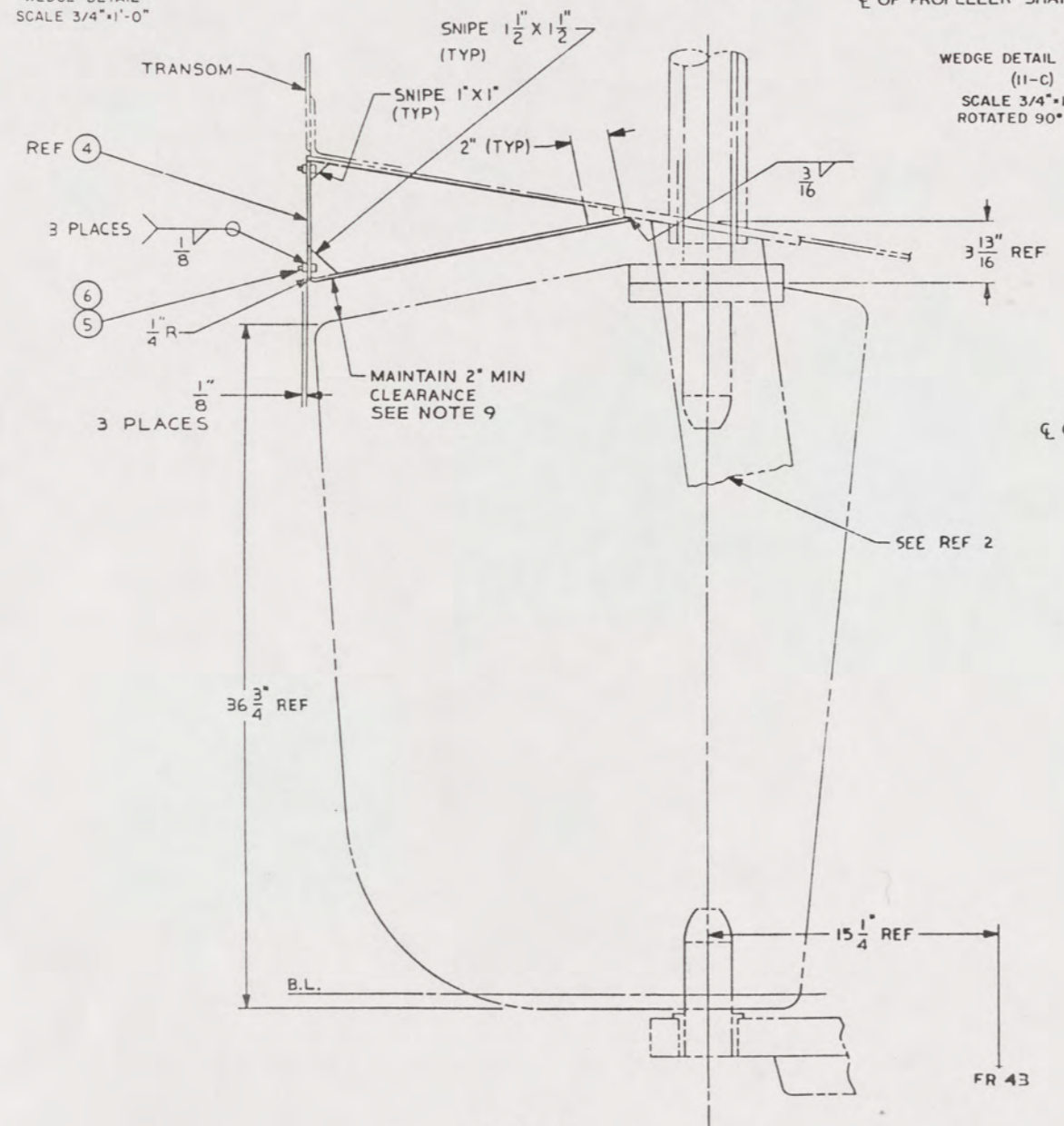
YARD	QTY	SAE	DESCRIPTION	SPECIFICATION	MATERIAL
YARD 6	3	SAE 130109E	PLUG, 3/8"-18 NPTF	SAE J531	STEEL
YARD 5	3	SAE 13013B	COUPLING, 3/8"-18 NPTF	SAE J530	STEEL
YARD 4	1		PLATE, 3/16" THK	ASTM A36	STEEL
YARD 3	1		PLATE, 3/16" THK	ASTM A36	STEEL
YARD 2	11		PLATE, 3/16" THK	ASTM A36	STEEL
YARD 1	2		PLATE, 3/16" THK	ASTM A36	STEEL

PARTS LIST		APPROVALS	
<p>DO NOT SCALE THIS DRAWING</p> <p>FOR INTERPRETATION OF DRAWING GO TO STD-100 APPLIES</p> <p>REMOVE BURRS AND BREAK SHARP EDGES</p> <p>SHARP EDGES — 18 —</p> <p>FILED EDGES — 18 —</p> <p>MATERIAL —</p>	<p>DESIGN APPROVAL</p> <p>DATE: 15 NOV 88</p> <p>APPROVED FOR PROCUREMENT</p> <p>DATE: 15 NOV 88</p>	<p>DESIGNED BY: TER</p> <p>CHECKED BY: CRY PLO</p> <p>DATE: 10 NOV 88</p> <p>CONTRACT NO:</p>	<p>U.S. ARMY QUALITY EQUIPMENT RESEARCH AND DEVELOPMENT COMMAND FORT BELVOIR, COLORADO 80205</p> <p>LCM-8, MOD-1, ADDITION OF WEDGE DETAIL AND MODIFICATIONS TO RUDDER</p> <p>SIZE: A1 YECN: 97403 DWD NO: 13226E9453</p> <p>SCALE AS NOTED SHEET 1 OF 2</p>

REVISIONS			
NO.	DATE	DESCRIPTION	BY

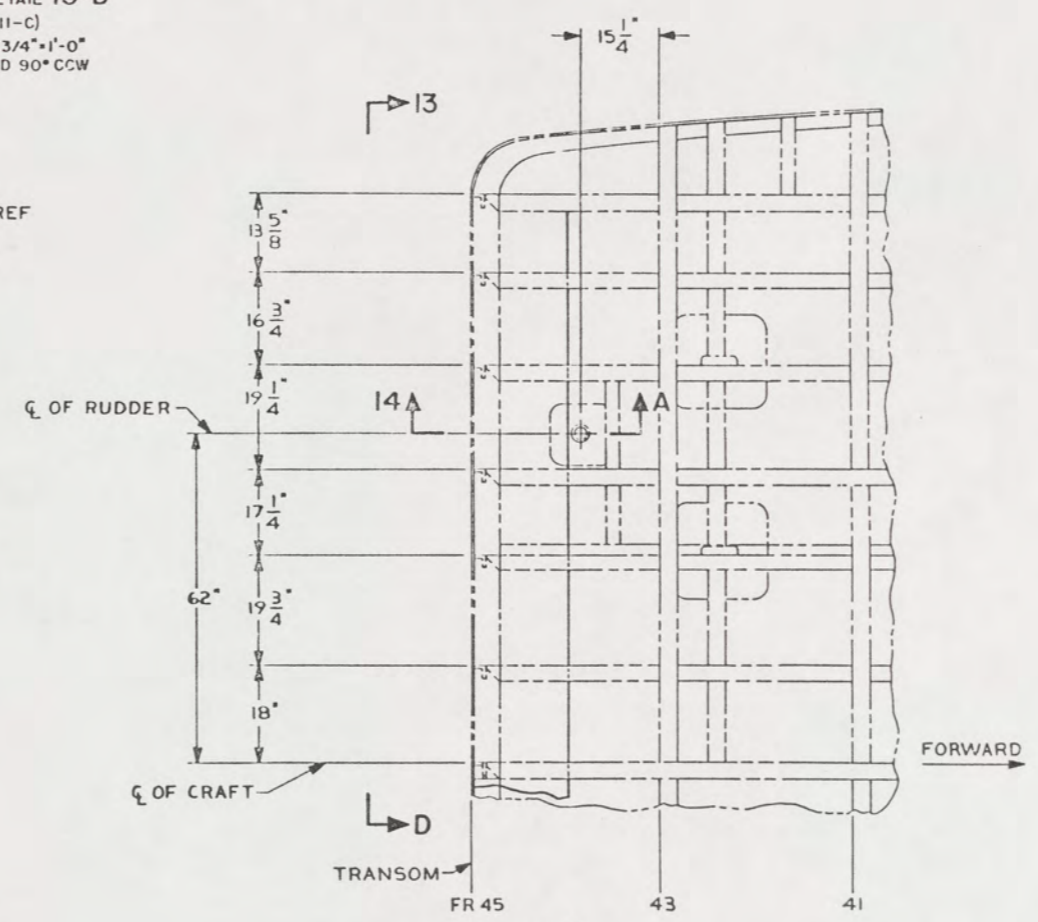


SECTION 16-D
(13-D)
WEDGE DETAIL
SCALE 3/4"=1'-0"



DETAIL 14-A
(11-C)
RUDDER ASSEMBLY
SCALE 3"=1'-0"

WEDGE DETAIL 13-D
(11-C)
SCALE 3/4"=1'-0"
ROTATED 90° CCW



VIEW 11-A
(6-B)
SCALE NONE

UNLESS OTHERWISE SPECIFIED DIM/TOLERANCES ARE IN INCHES		DRAWN BY: TER		DATE: 22 AUG 64	
ONE PLACE (0.1)	3	CHECKED BY: C.T. Prad	10 NOV 64		
TWO PLACE (0.01)	3	CONTRACT NO:			
THREE PLACE (0.001)	3	DESIGN APPROVAL:			
FOUR PLACE (0.0001)	3	DATE: 12 NOV 64			
FILLET RADIUS	TO	APPROVED FOR PROCUREMENT:			
MATERIAL		DATE: 13 SEP 65			
DO NOT SCALE THIS DRAWING		FOR INTERPRETATION OF DIMENSIONS SEE 100 APPLIES		U.S. ARMY MOBILITY EQUIPMENT RESEARCH AND DEVELOPMENT COMMAND FORT BELVOIR, VIRGINIA 22060	
REMOVE SHARP AND BREAK SHARP EDGES		SHARP EDGES TO		LCM-8, MOD-1, ADDITION OF WEDGE DETAIL AND MODIFICATIONS TO RUDDER	
SCALE		SCALE		SHEET 2	
SIZE: A1		TSCN: 97403		DWA NO: 13226E9453	

18