

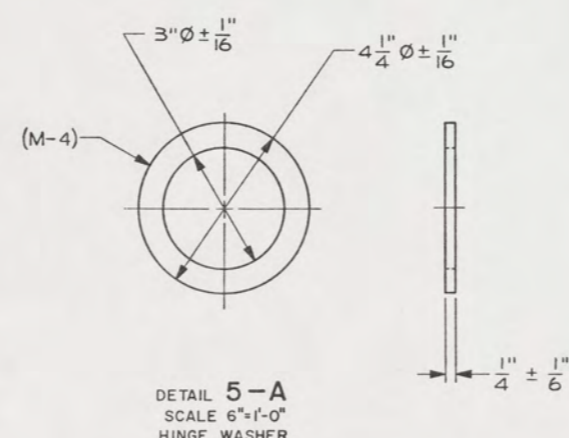
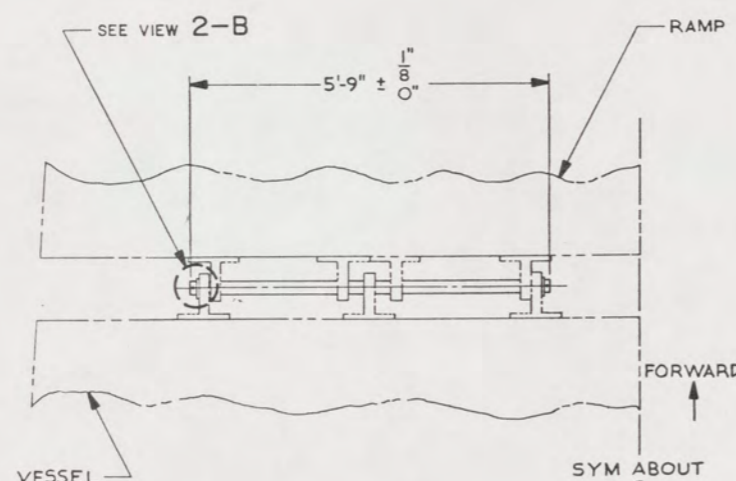
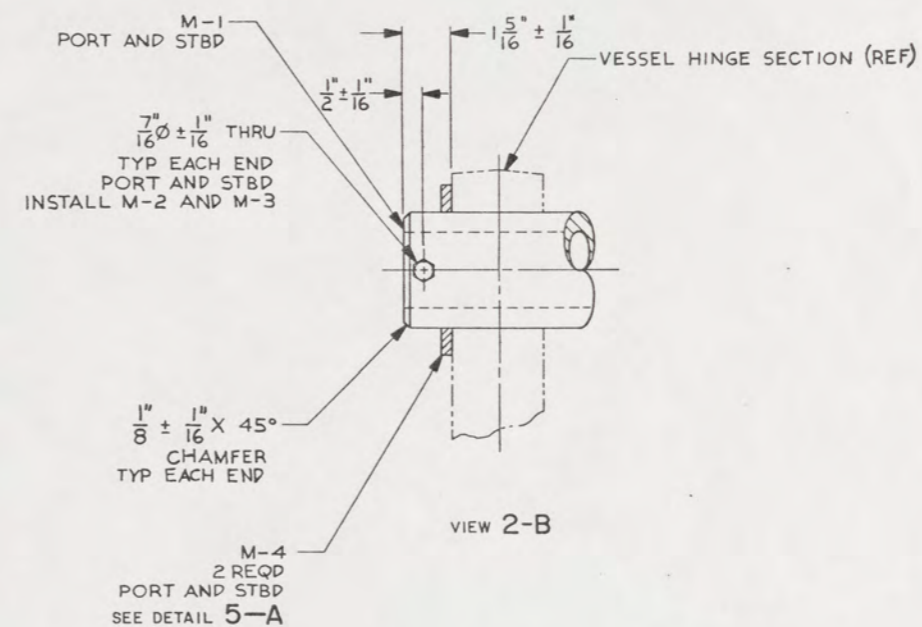
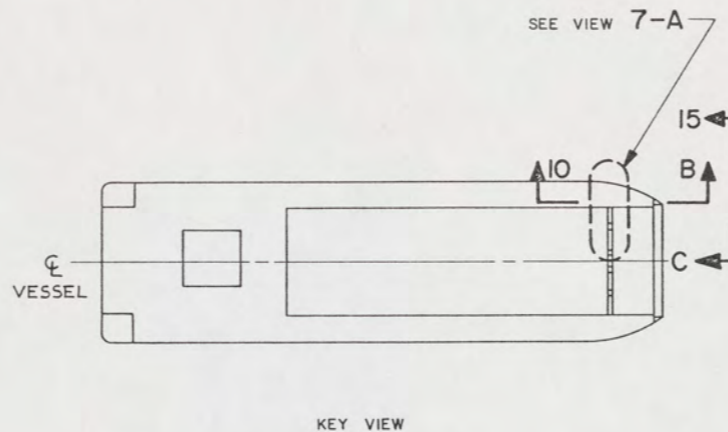
NOTES:

- THIS DRAWING HAS BEEN DEVELOPED FROM SHIPCHECK INFORMATION FOR ACCOMPLISHING THE INSTALLATION OF RAMP HINGE MODIFICATIONS TO LCM-8, MOD 1.
- EQUIPMENT AND WORKMANSHIP SHALL BE IN ACCORDANCE WITH USCG AND ABS REGULATIONS.
- REPAIR ALL PAINT DAMAGED BY THIS INSTALLATION AND PAINT ALL NEW STEEL IN ACCORDANCE WITH U.S. ARMY TECHNICAL BULLETIN TB-3-0144.
- MATERIAL ORDERED ON THIS DRAWING IS NOT INTENDED TO BE RESTRICTIVE. SUBSTITUTION OF EQUAL QUALITY MATERIAL MAY BE MADE EXCEPT FOR ITEMS MARKED GFE.
- SLIGHT DEVIATIONS FROM DIMENSIONS SHOWN ARE PERMISSIBLE TO SUIT ACTUAL CONDITIONS FOUND ABOARD THE VESSEL.
- 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.
- ALL FABRICATION WELDING AND INSPECTION TO BE IN ACCORDANCE WITH NAVSEA C900-LP-014-5010. WELD SIZES BASED ON USE OF AWS A5.1, CLASS E7018 ELECTRODES FOR LC STL TO CRES.
- REMOVAL OF EXISTING HINGE PINS, IF SEIZED IN PLACE, SHALL BE ACCOMPLISHED BY CUTTING THE PINS CLOSE TO EACH SIDE OF HINGES, THEN BURNING THRU THE WALL OF THE REMAINING TUBULAR SECTION, TO THE HINGE BORE. THE RAMP MUST BE SUPPORTED ADEQUATELY TO PREVENT MOVEMENT DURING HINGE REMOVAL AND REPLACEMENT.
- SHIM AS NECESSARY BETWEEN HINGE FACES TO PREVENT LATERAL MOVEMENT OF RAMP, USING HINGE WASHERS, M-4 AS SHIMS.

REFERENCE DRAWINGS APPLICABLE TO HULL NUMBERS 8540 THRU 8560 AND 8580 THRU 8618		
NO.	DRAWING NO.	TITLE
1	145-4510924	LCM-8, MOD 1, STRUCTURAL RAMP DETAILS
2	145-4510921	LCM-8, MOD 1, DETAILS, BULKHEAD AND TRANSOM

REFERENCE DRAWINGS APPLICABLE TO HULL NUMBERS 8520 THRU 8539		
NO.	DRAWING NO.	TITLE
1	145-2534227	LCM-8, MOD-1, STRUCTURAL RAMP DETAILS
2	145-2534195	LCM-8, MOD-1, BULKHEAD AND TRANSOM

STATUS OF REVISIONS					
SH	ZONE	LTR	DESCRIPTION	DATE	APPROVED
2	A		SEE ECP NO. 90HE3309 AND 90HE3310	18 Jun 87	KAS



YARD	FIND NO.	FSCM	DWG SIZE	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL	
M-9				MS15720-3	2	FITTING, LUBRICATION, 1/4-28 TAPER THD, 90°		CRES	
M-8	82654			75000664	2	BUMPER, DOCK, 1 3/8" X 2 3/8" X 25 FT L (STANPRO)	COML	RBR	
M-7				MS15721-5	2	FITTING, LUBRICATION, 1/8 PTF, 90°		CRES	
M-6				UNS S30400	84 FT	STRIP, 1/8" X 1"	ASTM A167	CRES	
M-5				UNS S30400	84 FT	BAR, FLAT, 1/4" X 1/2"	ASTM A276	CRES	
M-4				UNS C46200	AR	ROD OR BAR, NAVAL BRASS	SEE NOTE 9	ASTM B21	BRASS
M-3				MS51922-17	4	NUT, HEX, SELF-LOCKING, PREVAILING TORQUE, 3/8-16 UNC-2B		STL	
M-2				MS35307-372	4	SCREW, HEX HD, 3/8-16 UNC X 3 1/2" LG		CRES	
M-1				UNS G41350	2	TUBING, 2 7/8 OD X 1/2 WALL X 5'-9" LG		ASTM A519	STL

UNLESS OTHERWISE SPECIFIED DIM/TOLERANCES ARE: IN.

ONE PLACE (X) ±
TWO PLACE (XX) ±
THREE PLACE (XXX) ±
ANGLES ±

THIRD ANGLE PROJECTION

DO NOT SCALE THIS DRAWING

FOR INTERPRETATION OF DRAWING 000-STD-100 APPLIES

REMOVE BURRS AND SHARP EDGES TO
BREAK SHARP EDGES FILLET RADIUS TO

MATERIAL

DRAWN BY RKK/JF DATE 5 JAN 87
CHECKED BY DATE
CONTRACT NO.
DESIGN APPROVAL
DATE
APPROVED FOR PROCUREMENT
DATE

U.S. ARMY
BELVOIR RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER
FORT BELVOIR, VIRGINIA 22060-5606

LCM-8, MOD-I, RAMP HINGE
AND SEAL MODIFICATIONS

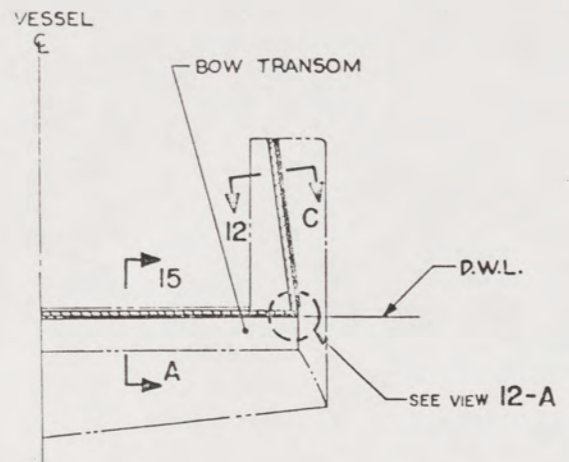
SIZE A1
FSCM 97403
DWG NO. 13226E9457
SCALE NONE SHEET 1 OF 2

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

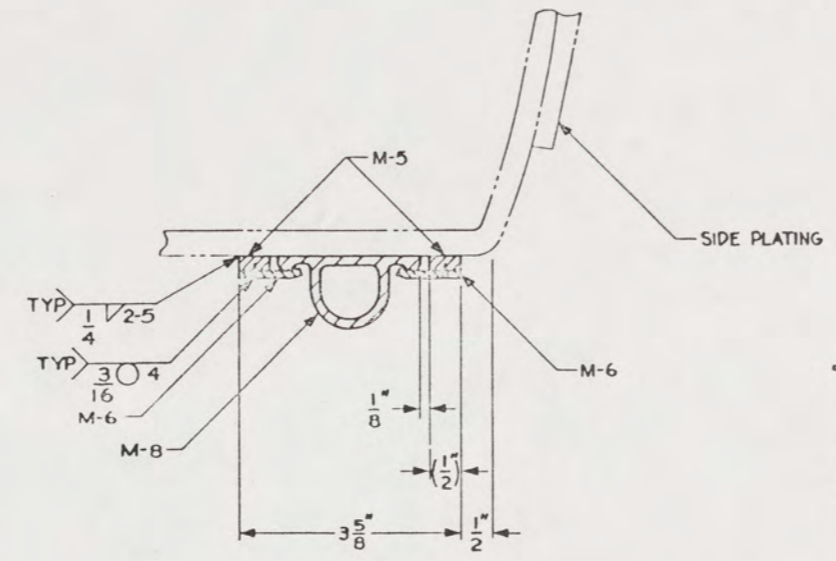
30

16 15 14 13 12 11 10 9

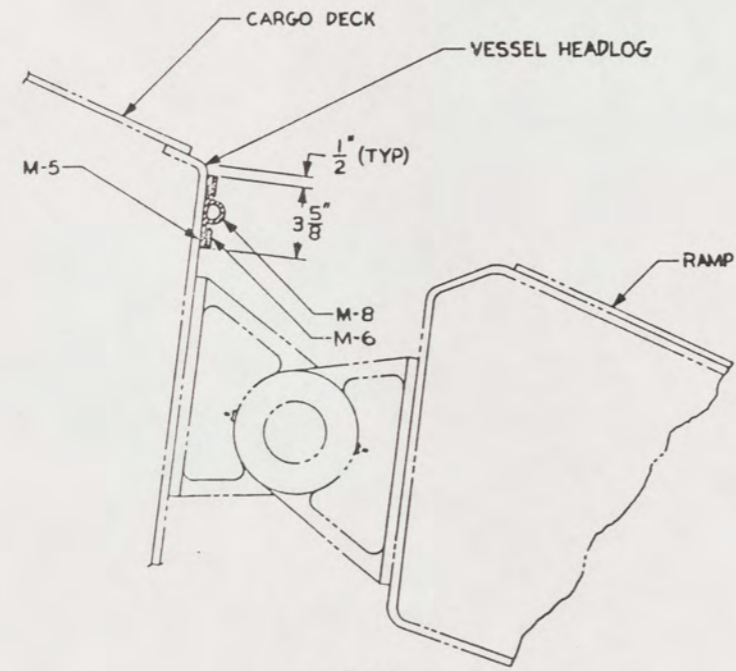
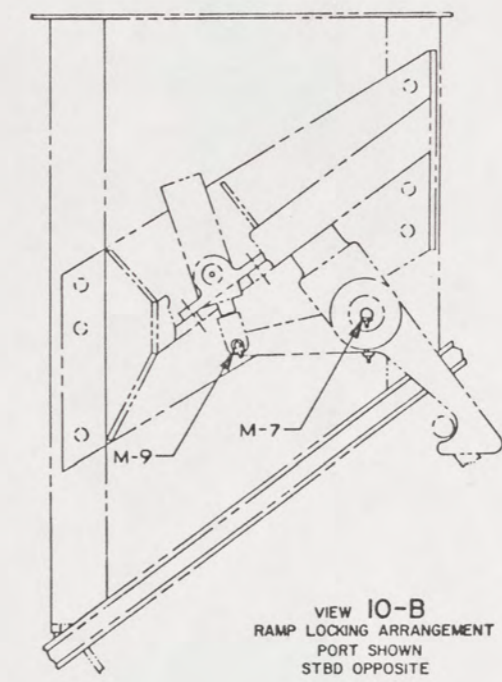
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED



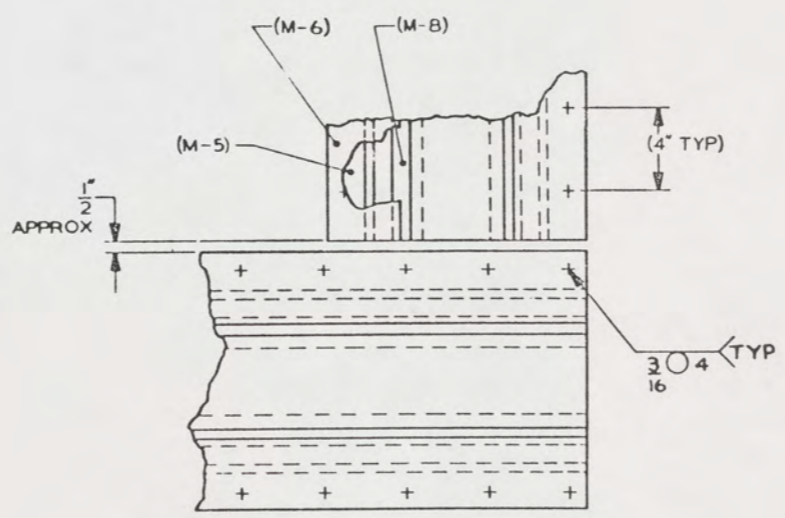
VIEW 15-C
ROTATED 90° CW
PORT SIDE LOOKING AFT
STARBOARD SIDE SIMILAR
(RAMP OMITTED FOR CLARITY)



SECTION 12-C
PORT SIDE SHOWN
STARBOARD SIDE OPPOSITE



SECTION 15-A
BOTTOM SEAL



VIEW 12-A
TYPICAL PORT AND STARBOARD

31

FIND NO.	PSCM	DWG SIZE	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL	
PARTS LIST								
UNLESS OTHERWISE SPECIFIED DIM/TOLERANCES ARE: \pm 1/16 IN.					DRAWN BY JFF/JF			DATE 12 JAN 87
ONE PLACE (.X) \pm					CHECKED BY GY PLMO			DATE 15 NOV 86
TWO PLACE (.XX) \pm					CONTRACT NO.			
THREE PLACE (.XXX) \pm					DESIGN APPROVAL			
ANGLES \pm					DATE 15 MAR 87			
DO NOT SCALE THIS DRAWING								
FOR INTERPRETATION OF DRAWING DIM/STB-100 APPLIES								
REMOVE BURRS AND BREAK SHARP EDGES			SHARP EDGES TO		APPROVED FOR PROCUREMENT			
BREAK SHARP EDGES			FILLET RADIUS TO		DATE 15 MAR 87			
MATERIAL					SIZE A1	FSC 97403	DWG NO. 13226E9457	
					SCALE		SHEET 2	

16 15 14 13 12 11 10 9