

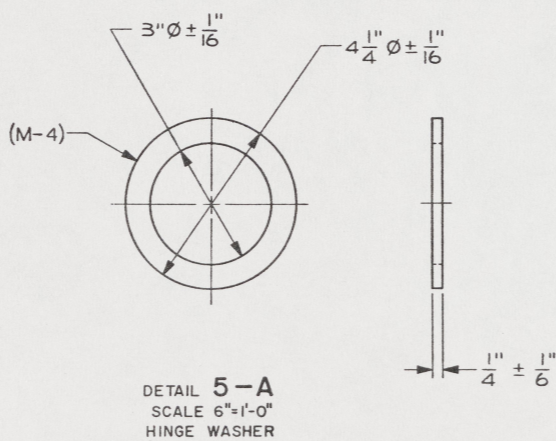
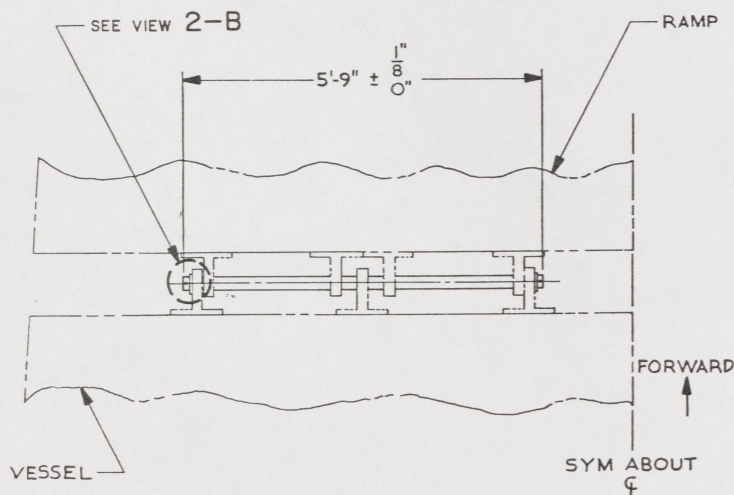
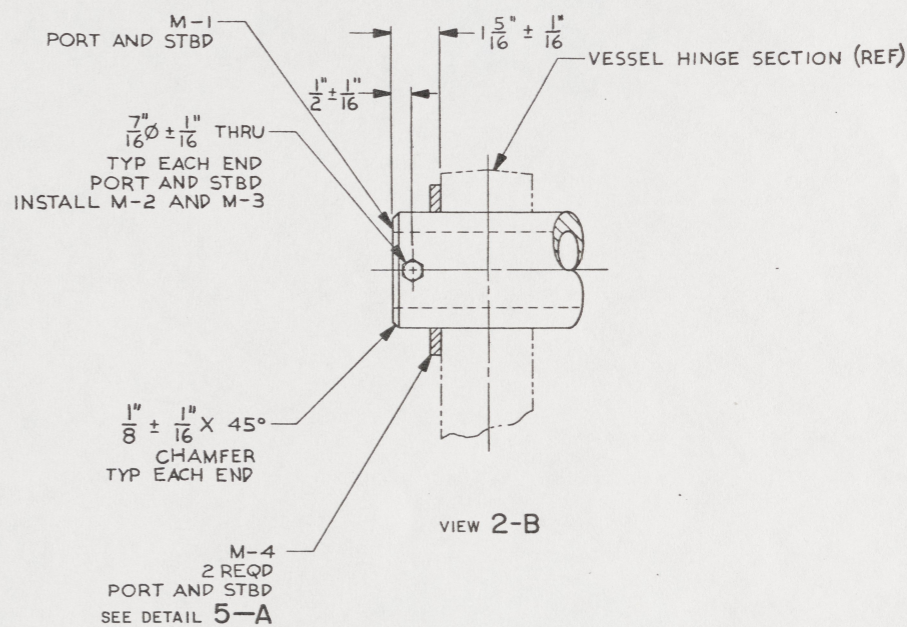
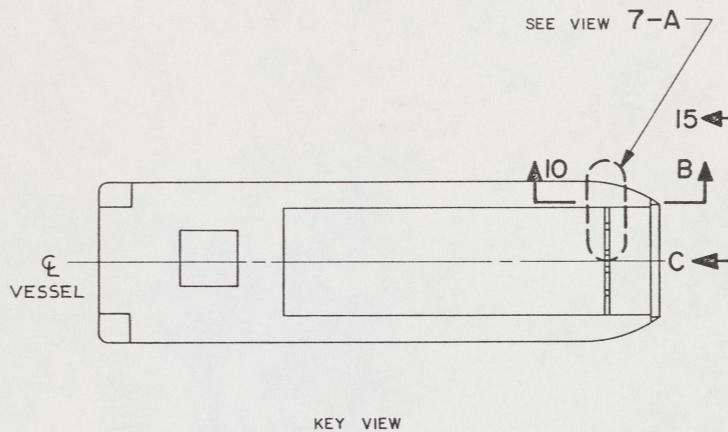
NOTES:

- 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 TB43-0144.
- 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
—	—	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
GFE	M-8	82654		75000664	2	BUMPER, DOCK, 1 3/8" X 2 3/8" X 25 FT L (STANPRO)	COML	RBR
YARD	M-7			MS15721-5	2	FITTING, LUBRICATION, 1/8 PTF, 90°		CRES
YARD	M-6			UNS S30400	84 FT	STRIP, 1/8" X 1"	ASTM A167	CRES
YARD	M-5			UNS S30400	84 FT	BAR, FLAT, 1/4" X 1/2"	ASTM A276	CRES
GFE	M-4			UNS C46200	AR	ROD OR BAR, NAVAL BRASS SEE NOTE 9	ASTM B21	BRASS
GFE	M-3			MS51922-17	4	NUT, HEX, SELF-LOCKING, PREVAILING TORQUE, 3/8-16 UNC-2B		STL
GFE	M-2			MS35307-372	4	SCREW, HEX HD, 3/8-16 UNC X 3 1/2" LG		CRES
GFE	M-1			UNS G41350	2	TUBING, 2 7/8 OD X 1/2 WALL X 5'-9" LG	ASTM A519	STL

PARTS LIST			
UNLESS OTHERWISE SPECIFIED DIM/TOLERANCES ARE: IN.	DRAWN BY	DATE	U.S. ARMY
ONE PLACE (X) ±	RKK/JF	5 JAN 87	BELVOIR RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER
TWO PLACE (XX) ±	CHECKED BY		FORT BELVOIR, VIRGINIA 22060-5606
THREE PLACE (XXX) ±	DATE		
ANGLES ±	CONTRACT NO.		
DO NOT SCALE THIS DRAWING	DESIGN APPROVAL		
FOR INTERPRETATION OF DRAWING 000-STD-100 APPLIES	DATE		
REMOVE BURRS AND SHARP EDGES TO	APPROVED FOR PROCUREMENT		
BREAK SHARP EDGES FILLET RADIUS TO	DATE		
MATERIAL			
	SIZE	FSCM	DWG NO.
	A1	97403	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

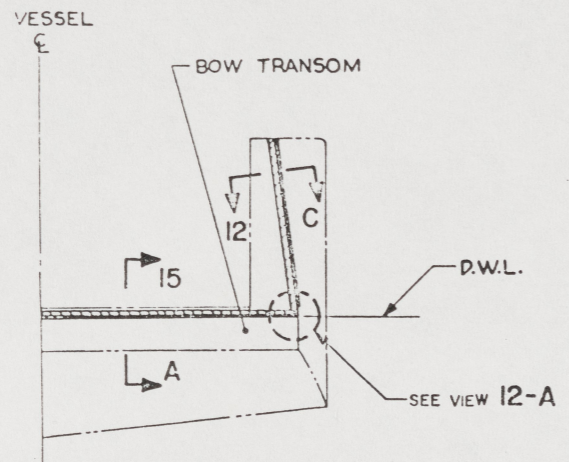
12

11

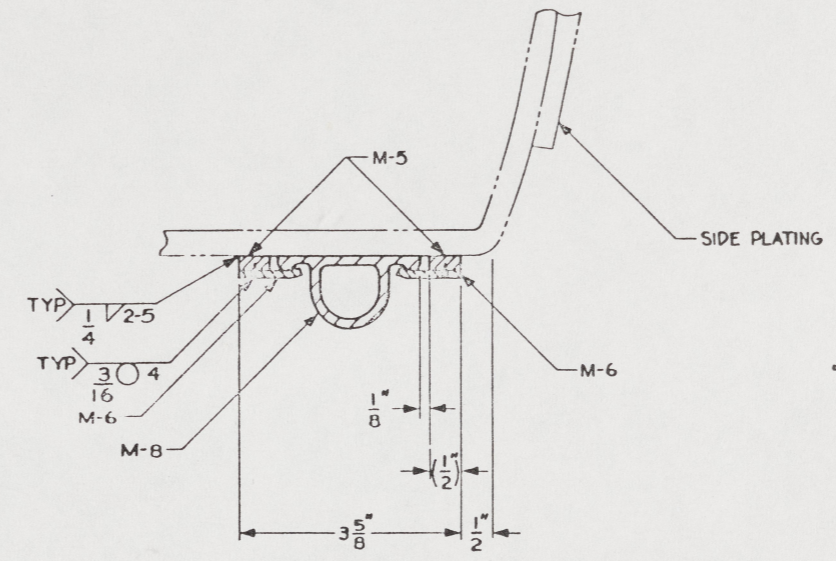
10

9

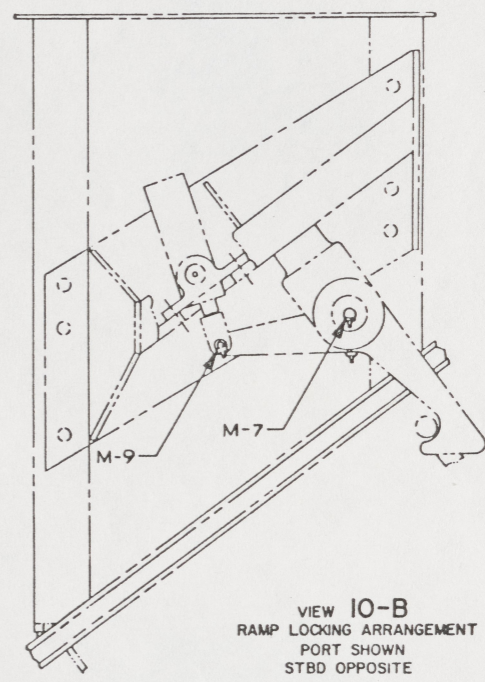
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED



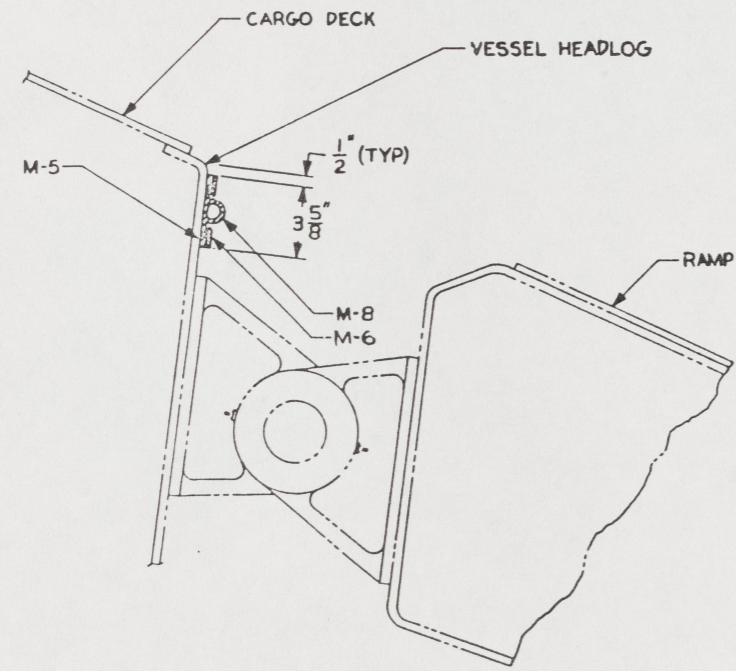
VIEW 15-C
ROTATED 90° CW
PORT SIDE LOOKING AFT
STARBOARD SIDE SIMILAR
(RAMP OMITTED FOR CLARITY)



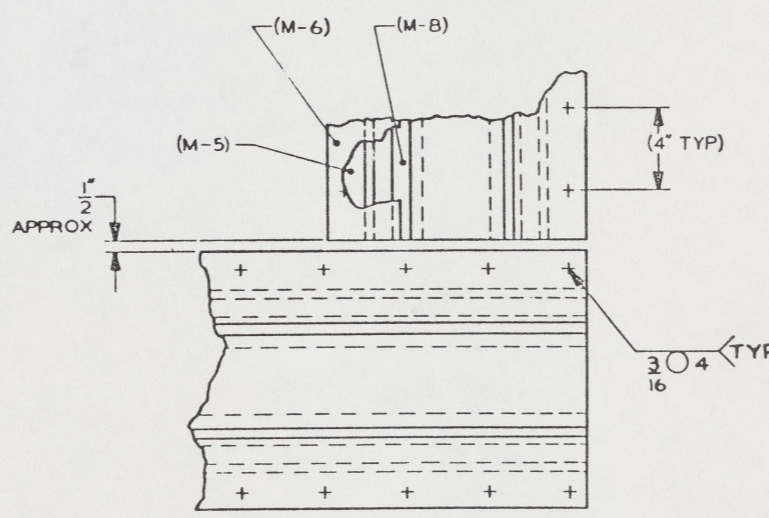
SECTION 12-C
PORT SIDE SHOWN
STARBOARD SIDE OPPOSITE



VIEW 10-B
RAMP LOCKING ARRANGEMENT
PORT SHOWN
STBD OPPOSITE



SECTION 15-A
BOTTOM SEAL



VIEW 12-A
TYPICAL PORT AND STARBOARD

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 GT/PLD			DATE 13 NOV 86
TWO PLACE (.XX) \pm					THIRD ANGLE PROJECTION			
THREE PLACE (.XXX) \pm					CONTRACT NO.			
ANGLES \pm					DESIGN APPROVAL			
DO NOT SCALE THIS DRAWING					DATE 15 MAR 83			
FOR INTERPRETATION OF DRAWING BOB-STD-100 APPLIES					APPROVED FOR PROCUREMENT			
REMOVE BURRS AND BREAK SHARP EDGES					DATE 15 MAR 83			
SHARP EDGES TO					SIZE A1			FSC 97403
FILLET RADII TO					DWG NO. 13226E9457			
MATERIAL					SCALE			SHEET 2

16

15

14

13

12

11

10

9

31