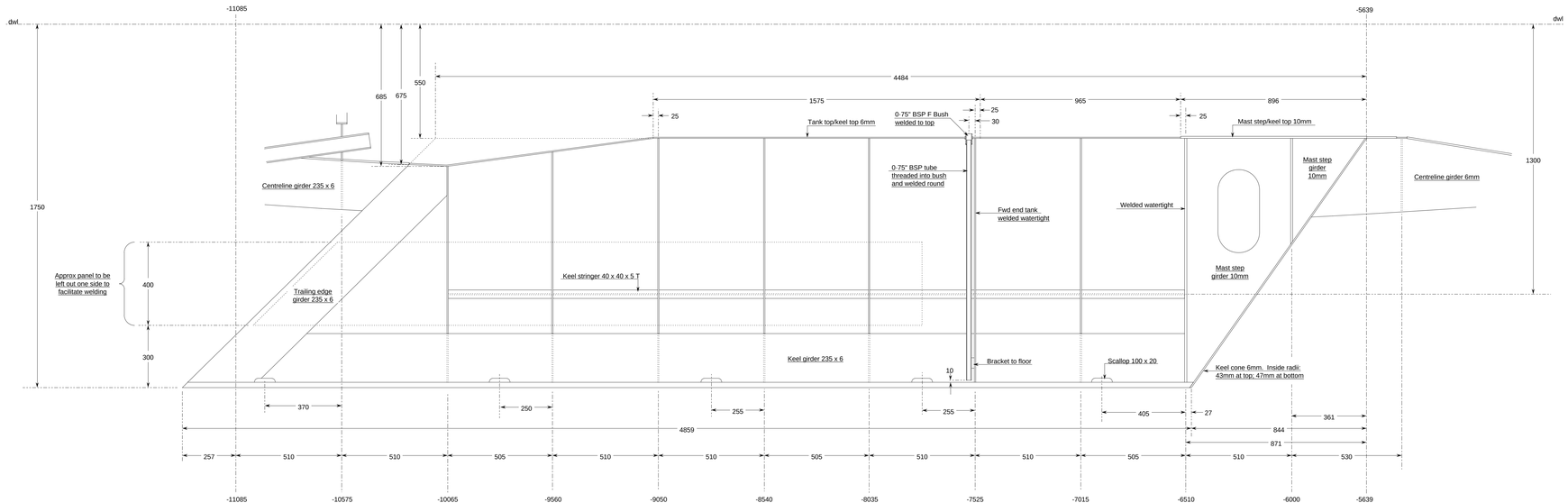
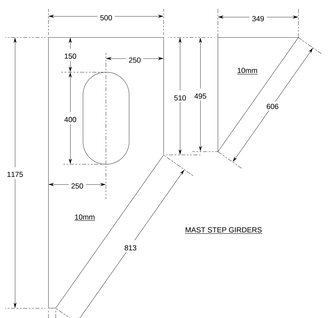
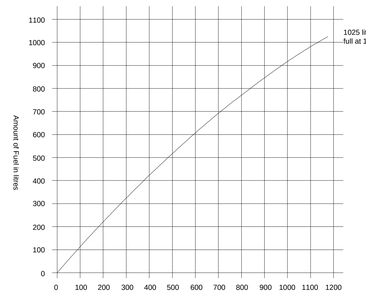




MAST STEP GIRDERS

APPROXIMATE CAPACITY GRAPH OF FUEL TANK SECTION OF KEEL



Notes:

1. All measurements and dimensions are in millimetres unless noted otherwise.
2. The Zero Point is the intersection of the Datum Waterline (marked "dwl") and the forefoot.
3. The centreline is marked " C/line ".
4. Offsets are measured about centreline.
5. Heights are measured above or below (marked "-") the dwl.
6. Positions are measured forward and aft (marked "-") of the Zero Point.
7. Frame and Floor positions are given to centre of webs.
8. Bulkhead positions are given to centre of bulkhead plating.
9. Tube diameters refer to outside diameter (followed by wall thickness) unless otherwise noted.
10. Refer to weld schedules for details of weld factors etc.
11. Before making keel tops, check actual dimensions of inside edge of top of keel envelope - these may vary (because of distortion) from the offsets given. In practice, it is best for the keel tops to lap on to the top edges of the keel envelope by about 1mm to facilitate welding.
12. Test tank section of keel at 460 mbar (= 3500 mm static head above top of tank) for 24 hours.
13. Test mast step section of keel to 300 mbar (= 1800 mm static head above top of tank) for 24 hours.
14. Testing of keel sections to be carried out after all welding to section and adjacent structures is completed. Fittings etc to be blanked off with screw bungs.
15. Keel sides and leading edge cone are steel grade 50A; other structures can be either 50A or 43A.
16. Scallops in bottom edge of keel girder are to allow fuel (or water in bilge sump section) to flow from side to side of keel; note also that fwd. and aft scallops are in way of centreline keel bolts and thus allow threaded ends of bolts to pronude into keel envelope.
16. Ensure that fuel tank dip pipes are adequately bracketed to keel structure to prevent vibration and thus fracture.

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Boat 044

Keel Envelope Profile

Scale	1/10
Date	30/05/2010
Plan No.	044/005/001
Issue No.	01 web
Drawing:	1118 x 305 – 44" x 12"