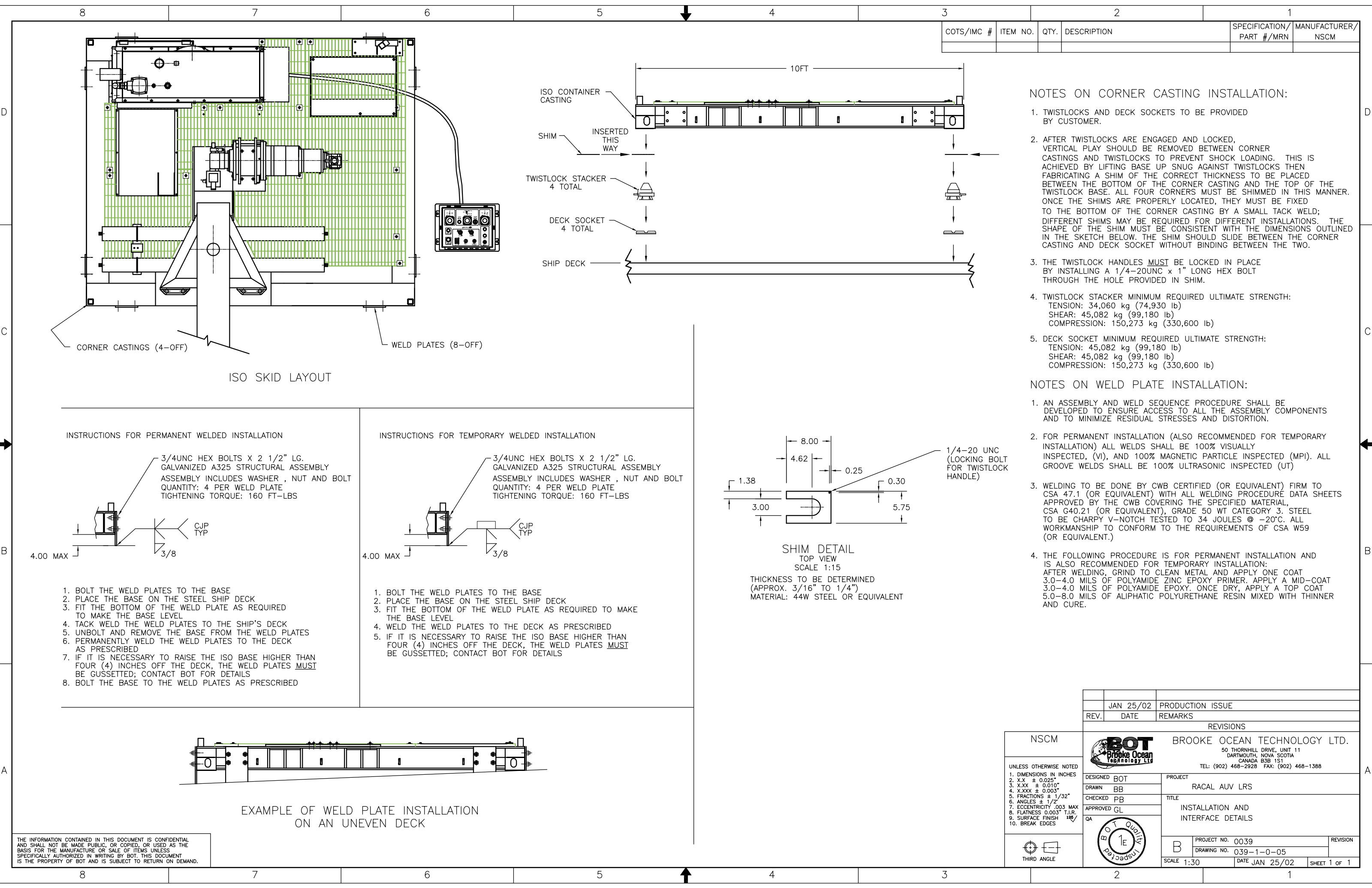




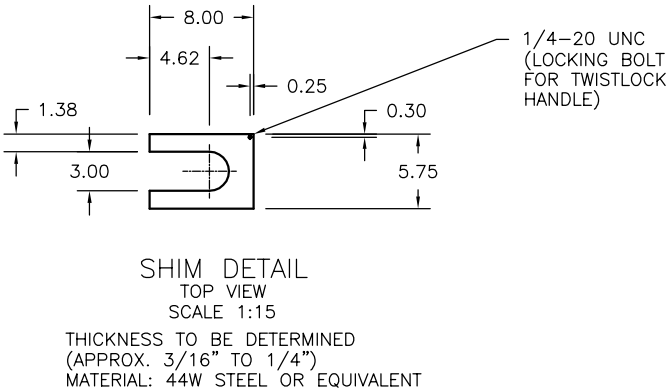
COTS/IMC #	ITEM NO.	QTY.	DESCRIPTION	SPECIFICATION/ PART #/MRN	MANUFACTURER/ NSCM

NOTES ON CORNER CASTING INSTALLATION:

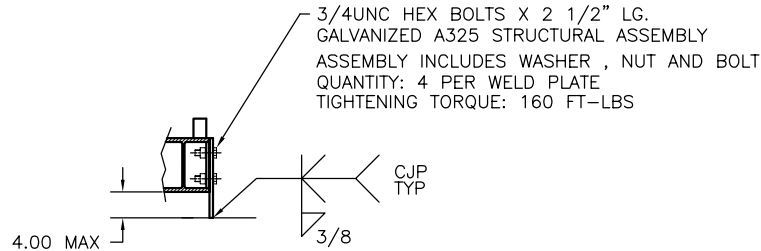
1. TWISTLOCKS AND DECK SOCKETS TO BE PROVIDED BY CUSTOMER.
2. AFTER TWISTLOCKS ARE ENGAGED AND LOCKED, VERTICAL PLAY SHOULD BE REMOVED BETWEEN CORNER CASTINGS AND TWISTLOCKS TO PREVENT SHOCK LOADING. THIS IS ACHIEVED BY LIFTING BASE UP SNUG AGAINST TWISTLOCKS THEN FABRICATING A SHIM OF THE CORRECT THICKNESS TO BE PLACED BETWEEN THE BOTTOM OF THE CORNER CASTING AND THE TOP OF THE TWISTLOCK BASE. ALL FOUR CORNERS MUST BE SHIMMED IN THIS MANNER. ONCE THE SHIMS ARE PROPERLY LOCATED, THEY MUST BE FIXED TO THE BOTTOM OF THE CORNER CASTING BY A SMALL TACK WELD; DIFFERENT SHIMS MAY BE REQUIRED FOR DIFFERENT INSTALLATIONS. THE SHAPE OF THE SHIM MUST BE CONSISTENT WITH THE DIMENSIONS OUTLINED IN THE SKETCH BELOW. THE SHIM SHOULD SLIDE BETWEEN THE CORNER CASTING AND DECK SOCKET WITHOUT BINDING BETWEEN THE TWO.
3. THE TWISTLOCK HANDLES MUST BE LOCKED IN PLACE BY INSTALLING A 1/4-20UNC x 1" LONG HEX BOLT THROUGH THE HOLE PROVIDED IN SHIM.
4. TWISTLOCK STACKER MINIMUM REQUIRED ULTIMATE STRENGTH:
TENSION: 34,060 kg (74,930 lb)
SHEAR: 45,082 kg (99,180 lb)
COMPRESSION: 150,273 kg (330,600 lb)
5. DECK SOCKET MINIMUM REQUIRED ULTIMATE STRENGTH:
TENSION: 45,082 kg (99,180 lb)
SHEAR: 45,082 kg (99,180 lb)
COMPRESSION: 150,273 kg (330,600 lb)

NOTES ON WELD PLATE INSTALLATION:

1. AN ASSEMBLY AND WELD SEQUENCE PROCEDURE SHALL BE DEVELOPED TO ENSURE ACCESS TO ALL THE ASSEMBLY COMPONENTS AND TO MINIMIZE RESIDUAL STRESSES AND DISTORTION.
2. FOR PERMANENT INSTALLATION (ALSO RECOMMENDED FOR TEMPORARY INSTALLATION) ALL WELDS SHALL BE 100% VISUALLY INSPECTED, (VI), AND 100% MAGNETIC PARTICLE INSPECTED (MPI). ALL GROOVE WELDS SHALL BE 100% ULTRASONIC INSPECTED (UT)
3. WELDING TO BE DONE BY CWB CERTIFIED (OR EQUIVALENT) FIRM TO CSA 47.1 (OR EQUIVALENT) WITH ALL WELDING PROCEDURE DATA SHEETS APPROVED BY THE CWB COVERING THE SPECIFIED MATERIAL, CSA G40.21 (OR EQUIVALENT), GRADE 50 WT CATEGORY 3. STEEL TO BE CHARPY V-NOTCH TESTED TO 34 JOULES @ -20°C. ALL WORKMANSHIP TO CONFORM TO THE REQUIREMENTS OF CSA W59 (OR EQUIVALENT.)
4. THE FOLLOWING PROCEDURE IS FOR PERMANENT INSTALLATION AND IS ALSO RECOMMENDED FOR TEMPORARY INSTALLATION:
AFTER WELDING, GRIND TO CLEAN METAL AND APPLY ONE COAT 3.0-4.0 MILS OF POLYAMIDE ZINC EPOXY PRIMER. APPLY A MID-COAT 3.0-4.0 MILS OF POLYAMIDE EPOXY. ONCE DRY, APPLY A TOP COAT 5.0-8.0 MILS OF ALIPHATIC POLYURETHANE RESIN MIXED WITH THINNER AND CURE.

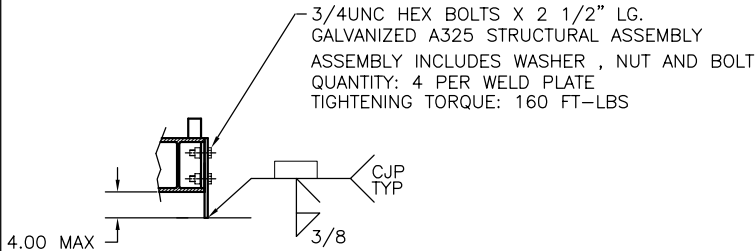


INSTRUCTIONS FOR PERMANENT WELDED INSTALLATION

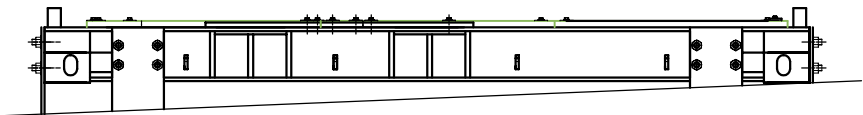


1. BOLT THE WELD PLATES TO THE BASE
2. PLACE THE BASE ON THE STEEL SHIP DECK
3. FIT THE BOTTOM OF THE WELD PLATE AS REQUIRED TO MAKE THE BASE LEVEL
4. TACK WELD THE WELD PLATES TO THE SHIP'S DECK
5. UNBOLT AND REMOVE THE BASE FROM THE WELD PLATES
6. PERMANENTLY WELD THE WELD PLATES TO THE DECK AS PRESCRIBED
7. IF IT IS NECESSARY TO RAISE THE ISO BASE HIGHER THAN FOUR (4) INCHES OFF THE DECK, THE WELD PLATES MUST BE GUSSETED; CONTACT BOT FOR DETAILS
8. BOLT THE BASE TO THE WELD PLATES AS PRESCRIBED

INSTRUCTIONS FOR TEMPORARY WELDED INSTALLATION



1. BOLT THE WELD PLATES TO THE BASE
2. PLACE THE BASE ON THE STEEL SHIP DECK
3. FIT THE BOTTOM OF THE WELD PLATE AS REQUIRED TO MAKE THE BASE LEVEL
4. WELD THE WELD PLATES TO THE DECK AS PRESCRIBED
5. IF IT IS NECESSARY TO RAISE THE ISO BASE HIGHER THAN FOUR (4) INCHES OFF THE DECK, THE WELD PLATES MUST BE GUSSETED; CONTACT BOT FOR DETAILS



EXAMPLE OF WELD PLATE INSTALLATION ON AN UNEVEN DECK

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APPROVED	GL	INSTALLATION AND INTERFACE DETAILS
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DRAWING NO. 039-1-0-05		
SCALE 1:30	DATE JAN 25/02	SHEET 1 OF 1