





B-52

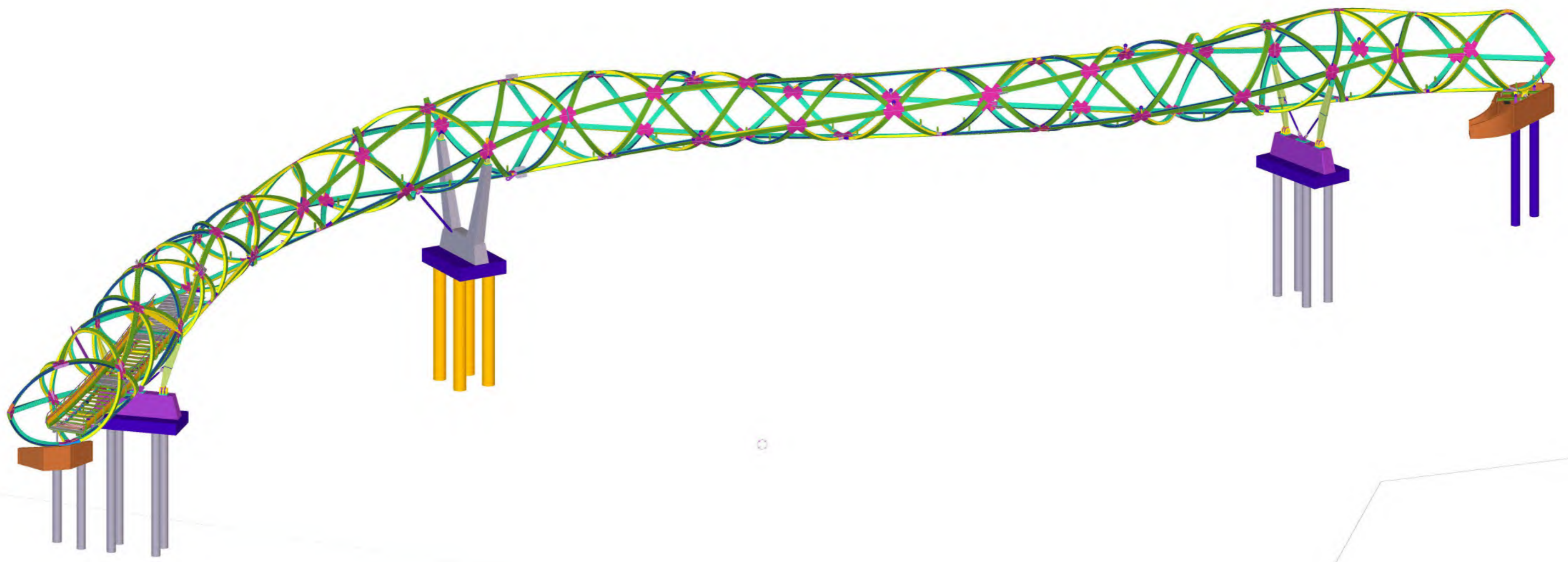
M-40 S/NS23

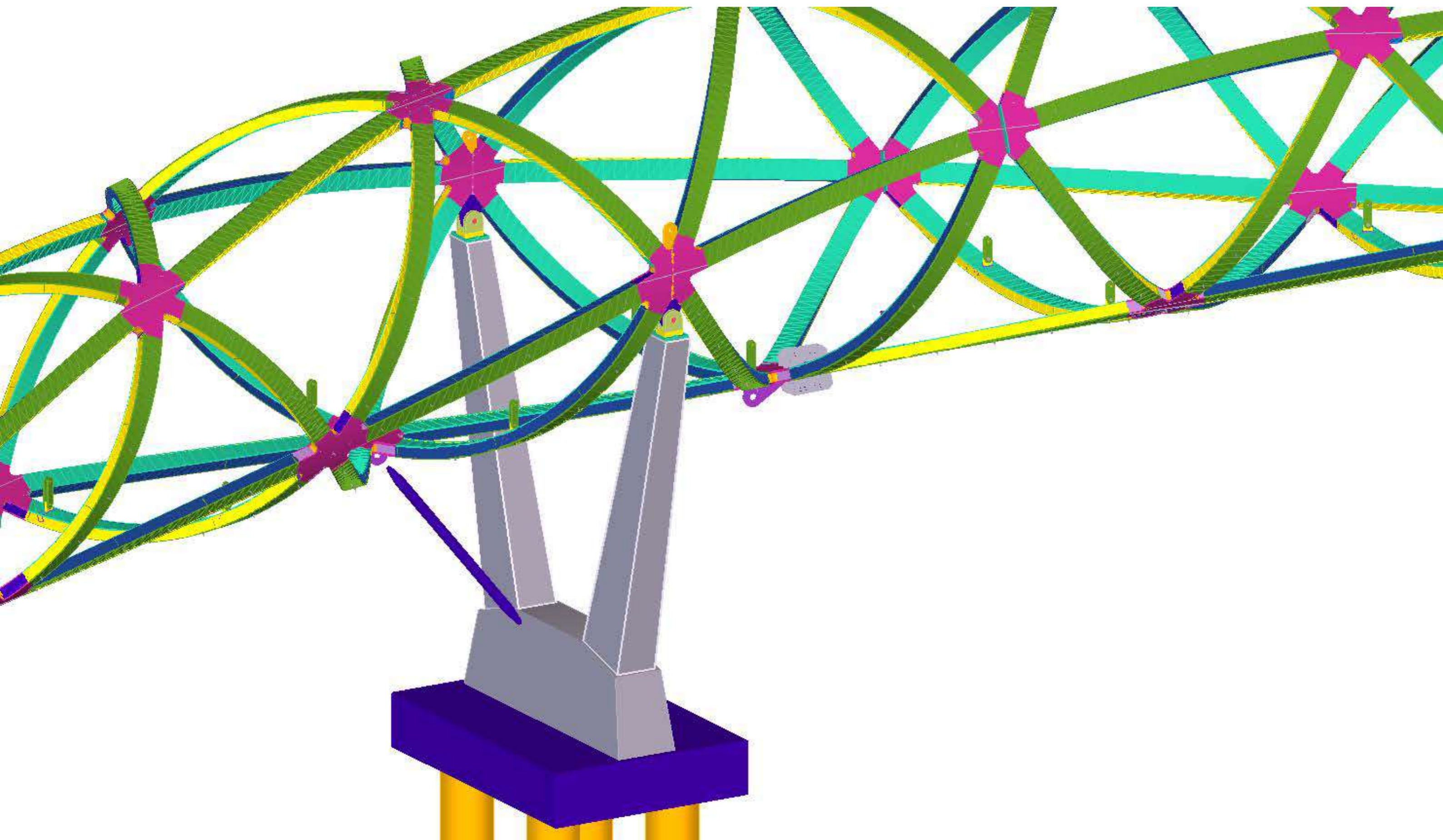


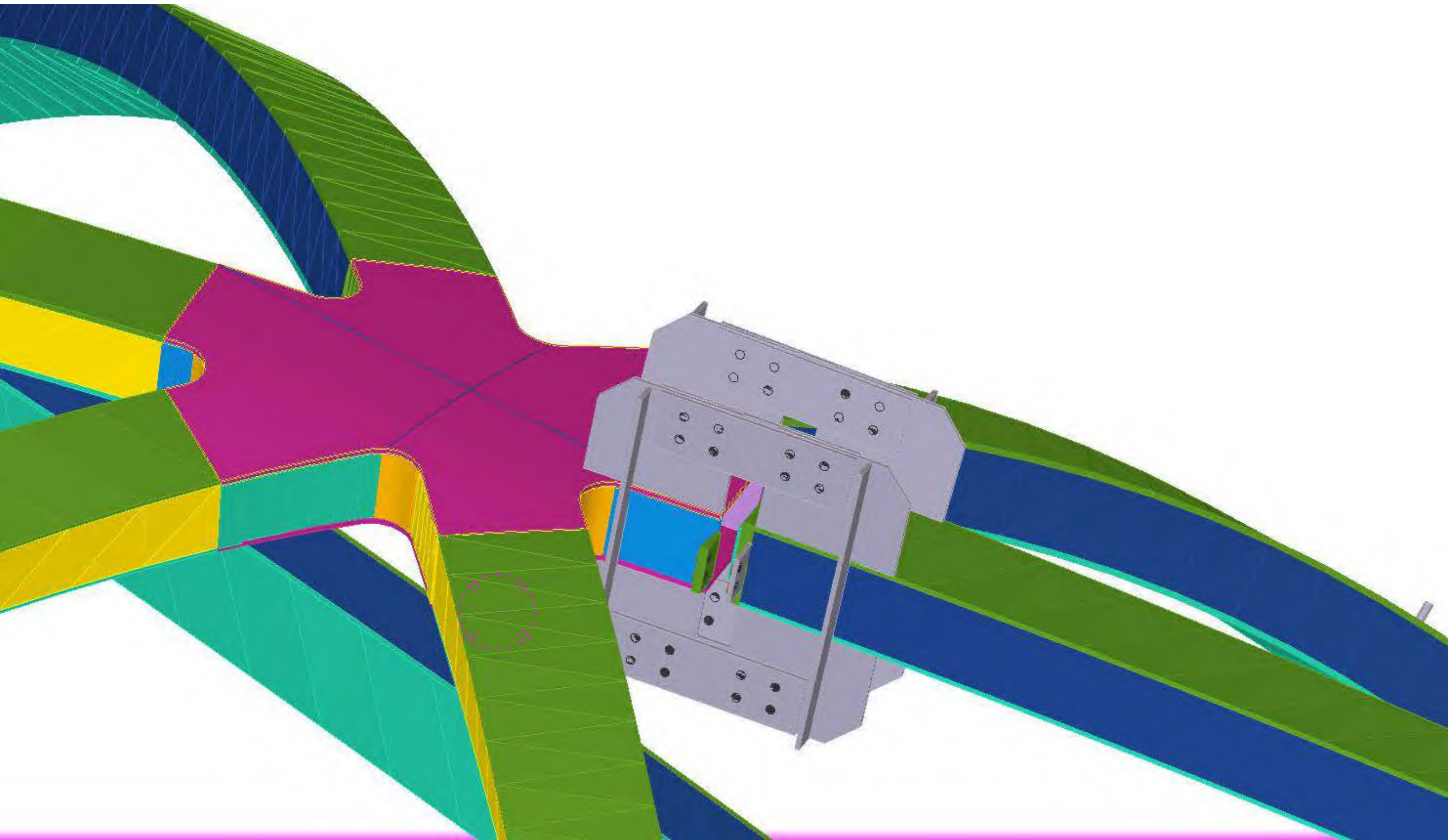


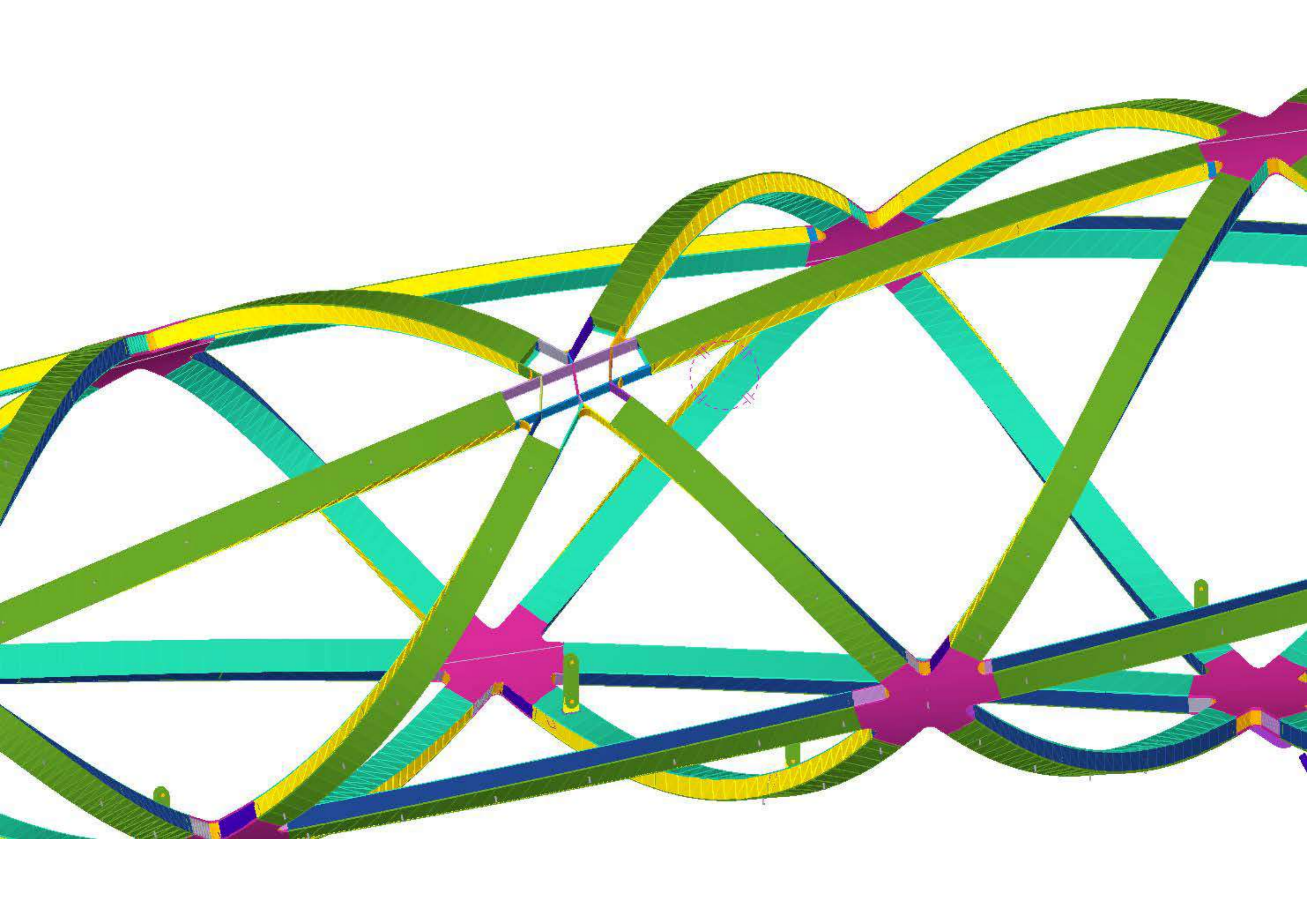


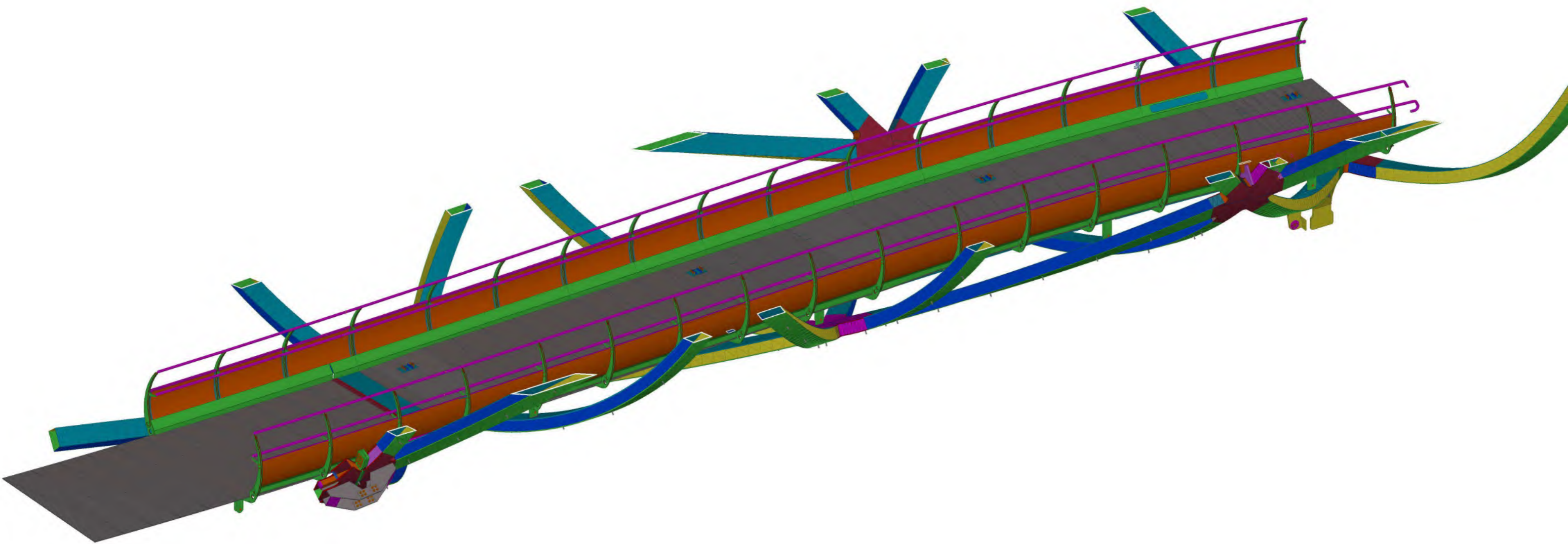


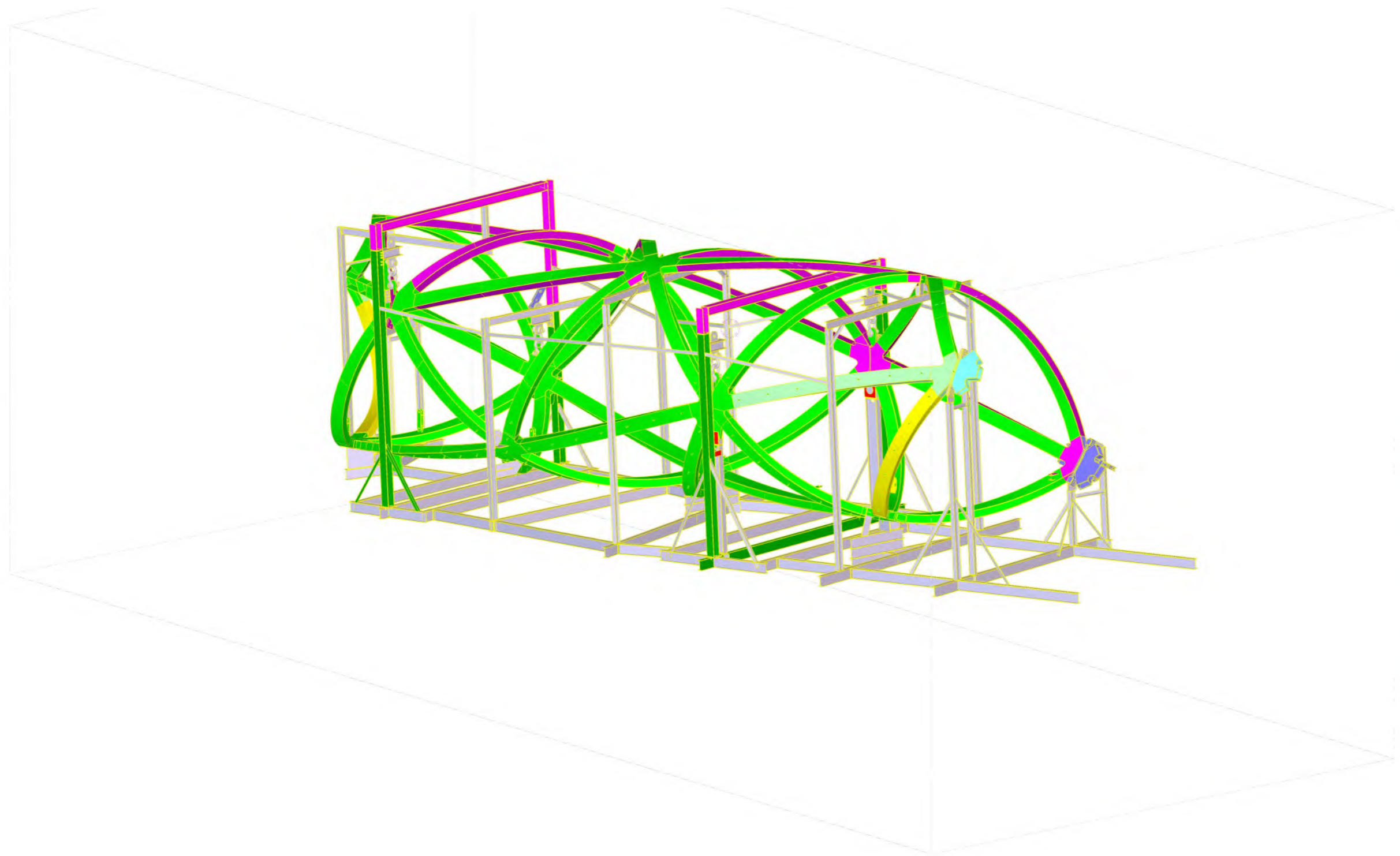


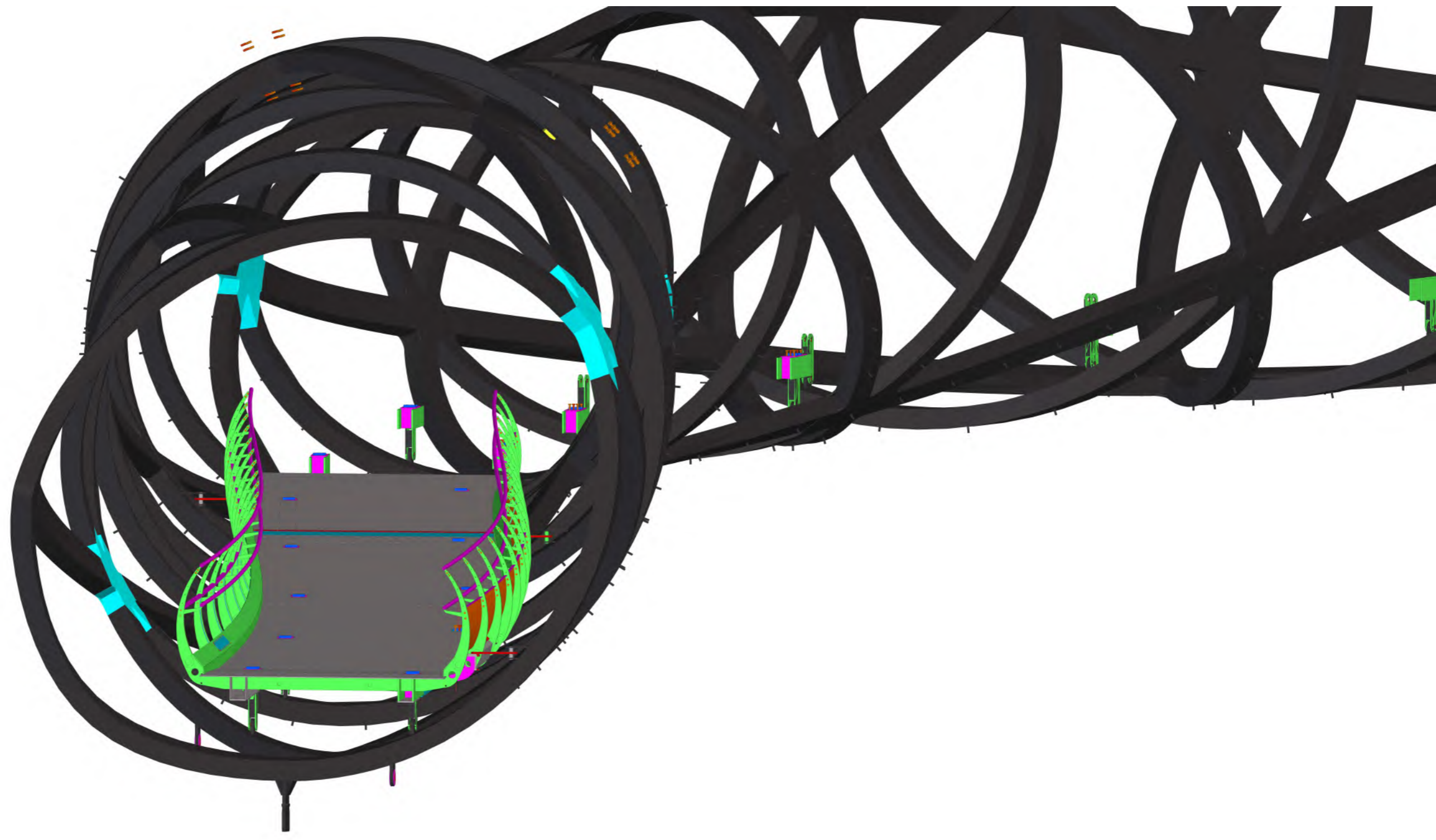


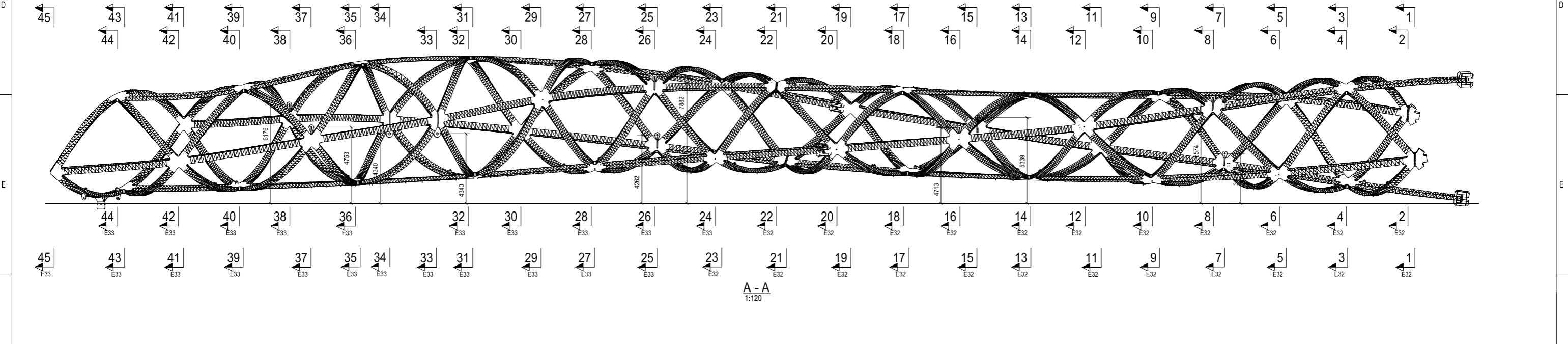
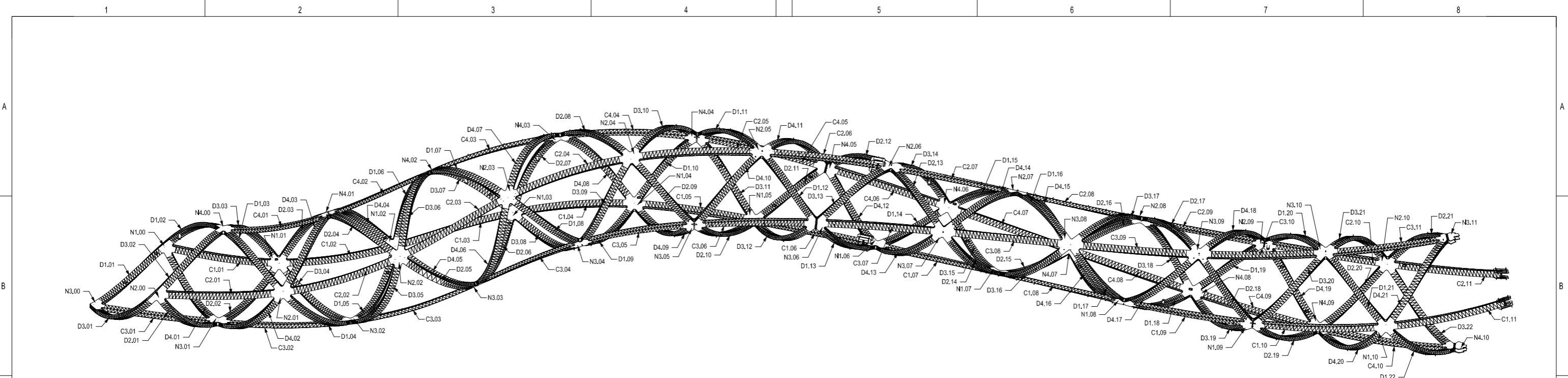






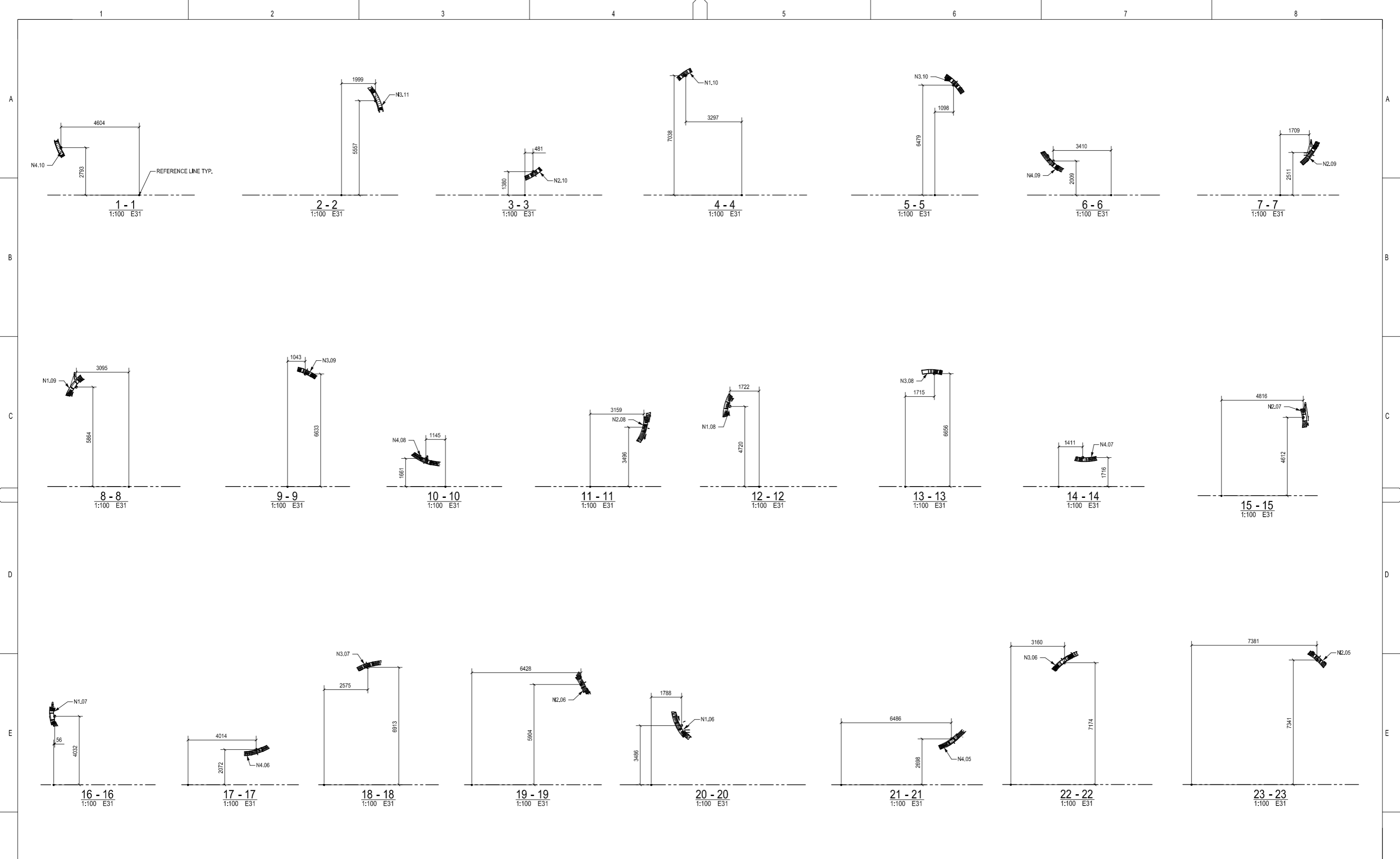




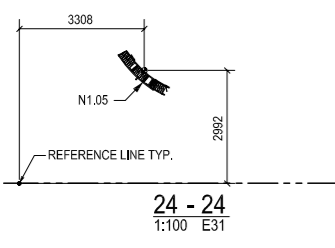


A - A
1:120

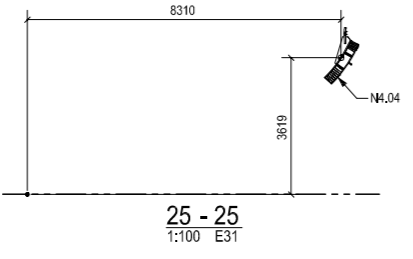
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		DO NOT SCALE				PROJECT:	
		ALL DIMENSION IN MILLIMETERS				DESC.: E31	
		GENERAL TOLERANCES U.N.O.		FINISH:		TITLE ASSEMBLY JIG LIFT- 3 & 4	
		NOMINAL SIZE: X		TOLERANCE: ±1		DRAWING No.: S+L- E31	
		X		±0.5		REV: A	
A 06.04.2019 ISSUED FOR APPROVAL		NS		WEIGHT (Kg):		SCALE: 1:120	
REV	DATE	DESCRIPTION	BY	X.XX	±0.1	SHEET No. 0	SHEET SIZE: A1



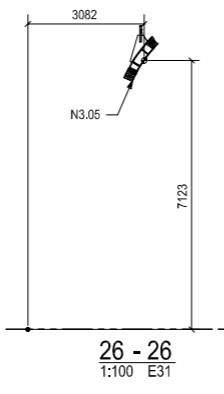
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				ALL DIMENSION IN MILLIMETERS				PROJECT:	
				GENERAL TOLERANCES U.N.O.		FINISH:		DESC.: E32	
				NOMINAL SIZE: X		TOLERANCE: ±1		TITLE ASSEMBLY JIG LIFT- 3 & 4	
				X.X		±0.5		DRAWING No.: S+L- E32	
				X.XX		±0.1		REV: A	
A	06.04.2019	ISSUED FOR APPROVAL	NS			WEIGHT (Kg):		SCALE: 1:100	
REV	DATE	DESCRIPTION	BY					SHEET No. 0	SHEET SIZE: A1



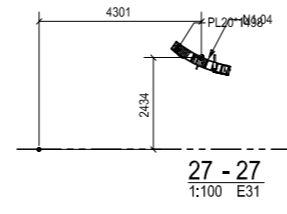
24 - 24
1:100 E31



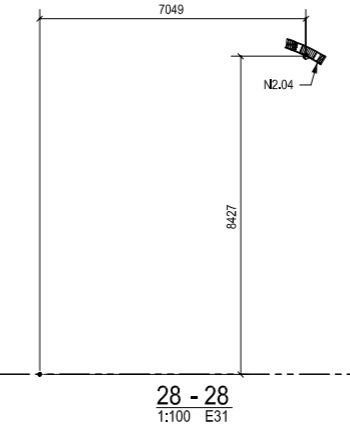
25 - 25
1:100 E31



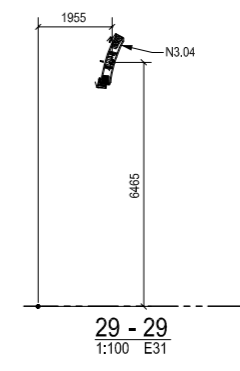
26 - 26
1:100 E31



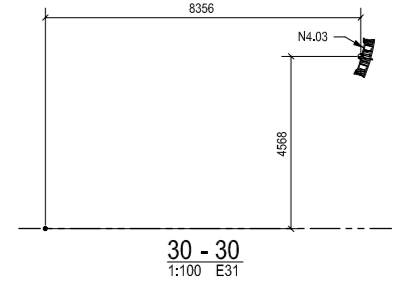
27 - 27
1:100 E31



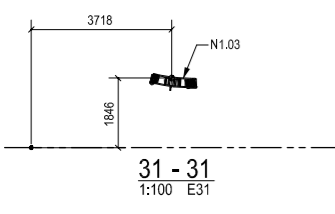
28 - 28
1:100 E31



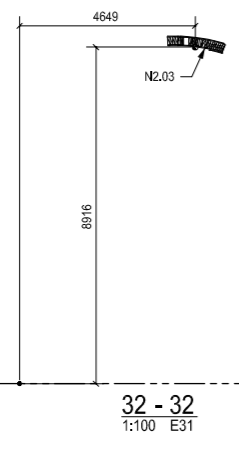
29 - 29
1:100 E31



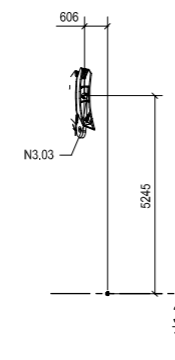
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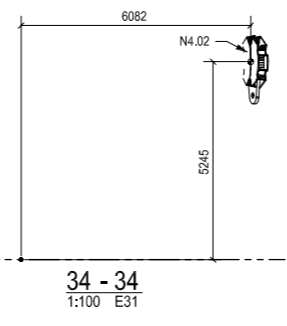
31 - 31
1:100 E31



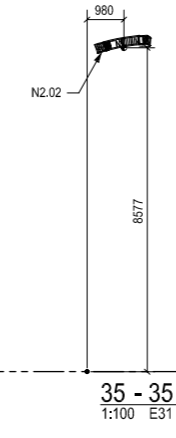
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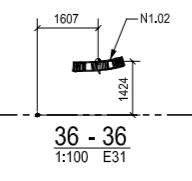
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1:100 E31



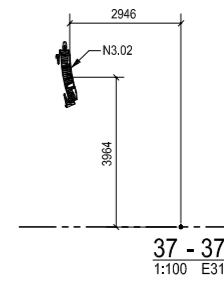
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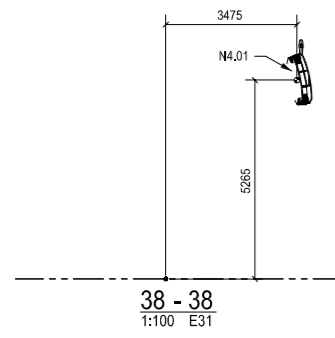
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1:100 E31



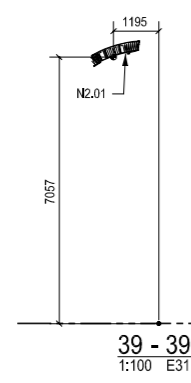
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1:100 E31



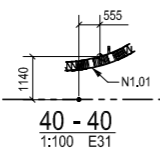
37 - 37
1:100 E31



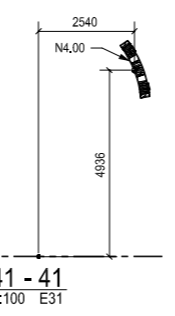
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1:100 E31



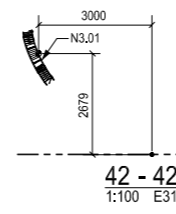
39 - 39
1:100 E31



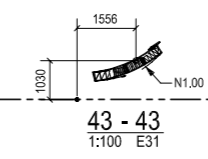
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1:100 E31



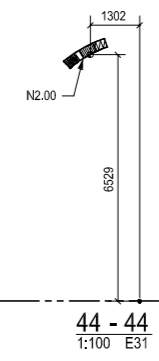
41 - 41
1:100 E31



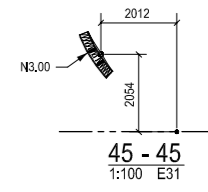
42 - 42
1:100 E31



43 - 43
1:100 E31



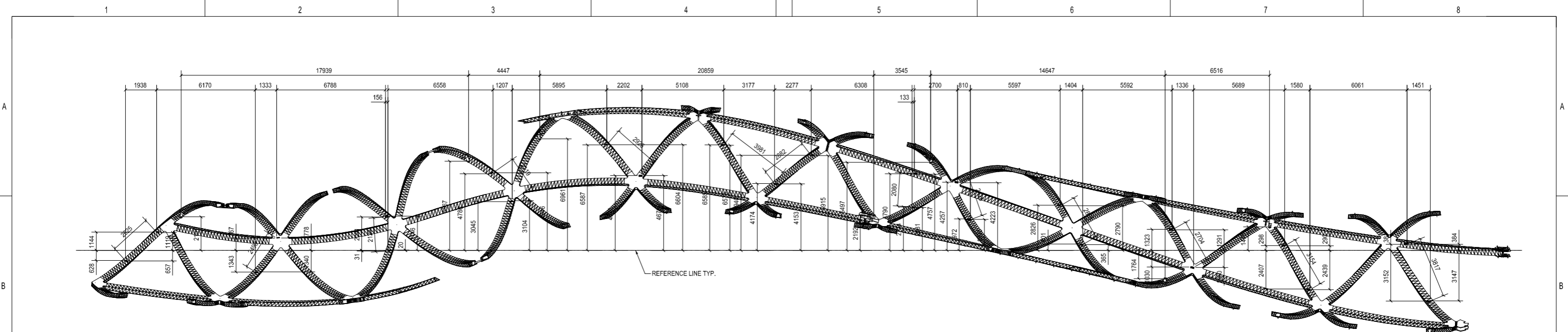
44 - 44
1:100 E31



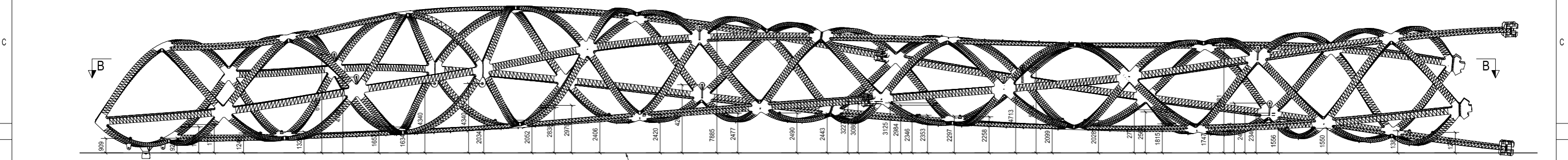
45 - 45
1:100 E31

		AS 1100 - 3RD ANGLE PROJECTION		QTY:		
		DO NOT SCALE				
		ALL DIMENSION IN MILLIMETERS				
		GENERAL TOLERANCES U.N.O.		FINISH:		
		NOMINAL SIZE:	TOLERANCE:	WEIGHT (Kg):		
		X	±1			
A		06.04.2019	ISSUED FOR APPROVAL	NS	X.X	±0.5
REV	DATE	DESCRIPTION		BY	X.XX	±0.1

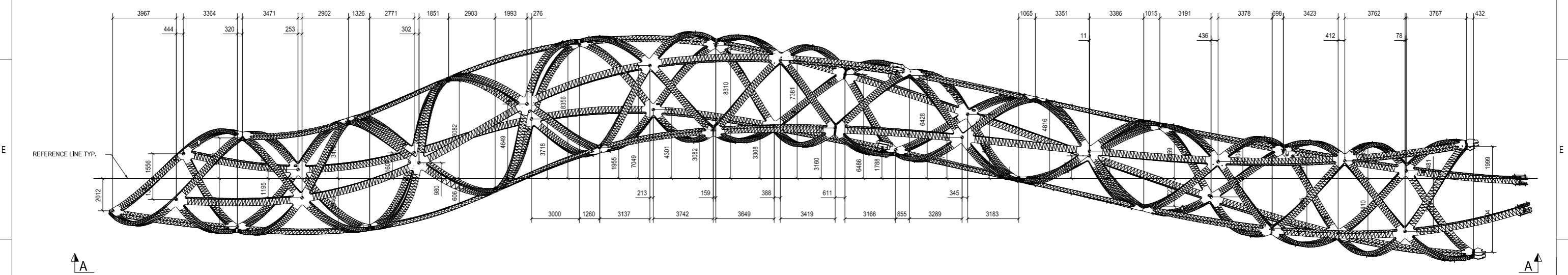
CLIENT:			
PROJECT:			
DESC: E33			
TITLE ASSEMBLY JIG LIFT- 3 & 4			
DRAWING No.: S+L- E33		REV: A	
SCALE: 1:100	SHEET No. 0	SHEET SIZE: A1	



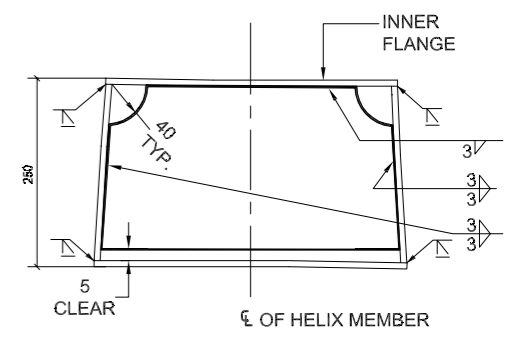
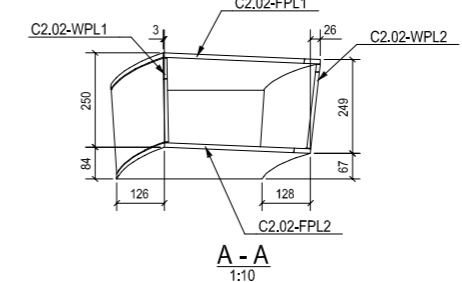
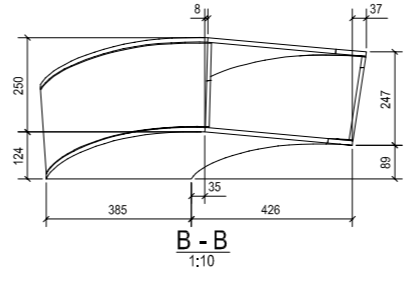
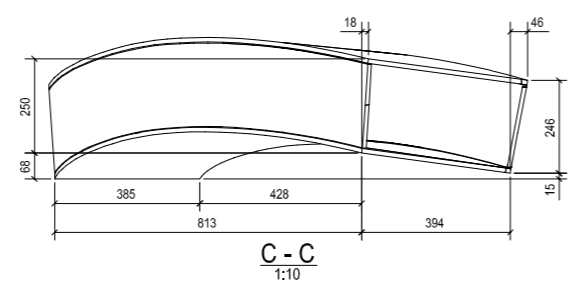
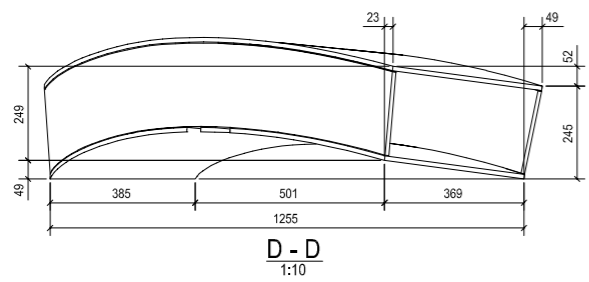
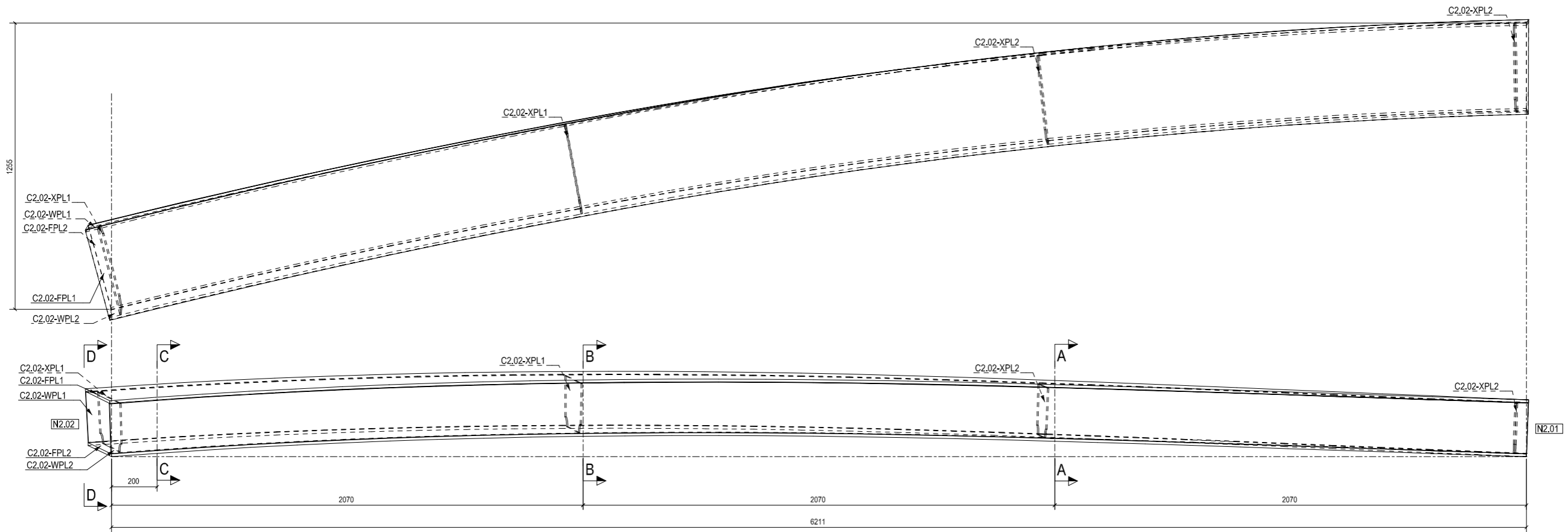
B - B
1:120



A - A
1:120



				AS 1100 - 3RD ANGLE PROJECTION		QTY:		CLIENT:	
				DO NOT SCALE				PROJECT:	
				ALL DIMENSION IN MILLIMETERS				DESC.: E34	
				GENERAL TOLERANCES U.N.O.		FINISH:		TITLE ASSEMBLY JIG LIFT- 3 & 4	
				NOMINAL SIZE: X		WEIGHT (Kg):		DRAWING No.: S+L- E34	
				TOLERANCE: ±1				REV: A	
A 06.04.2019 ISSUED FOR APPROVAL				NS X.X				SCALE: 1:120	
REV DATE DESCRIPTION				BY X.XX				SHEET No. 0	
				±0.1				SHEET SIZE: A1	



TYPICAL CHORD/DIAGONAL FABRICATION PLATE & WELDING DETAIL
N.T.S.

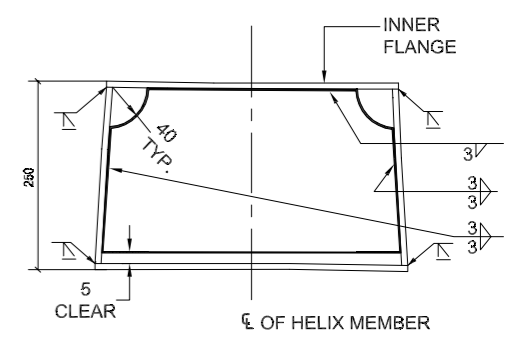
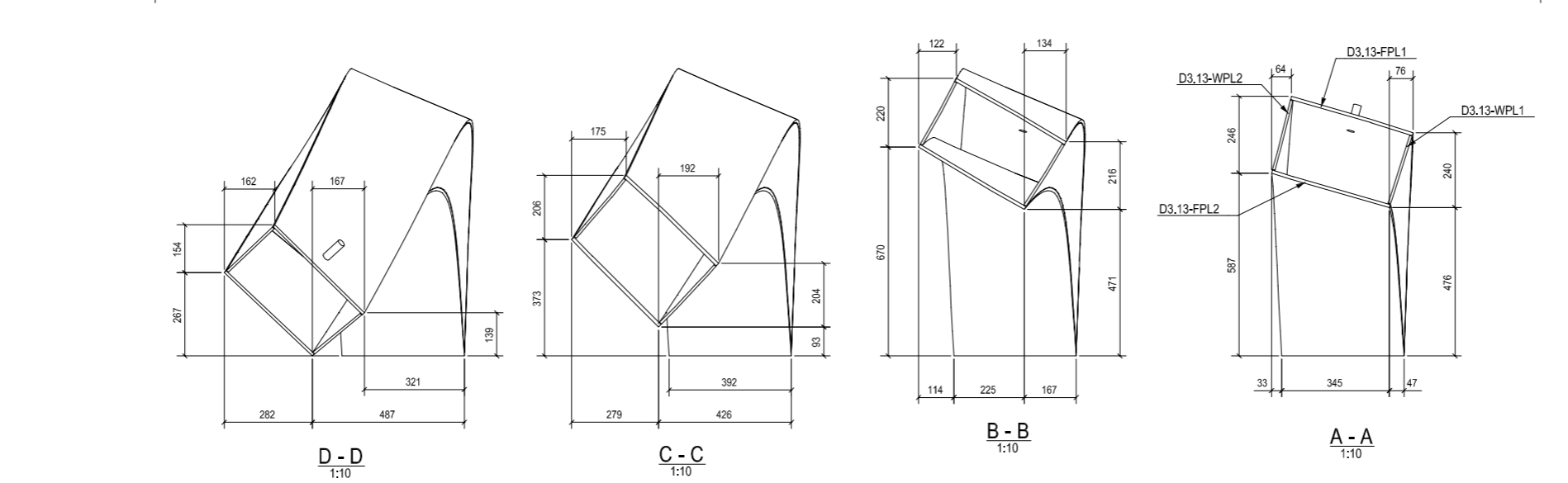
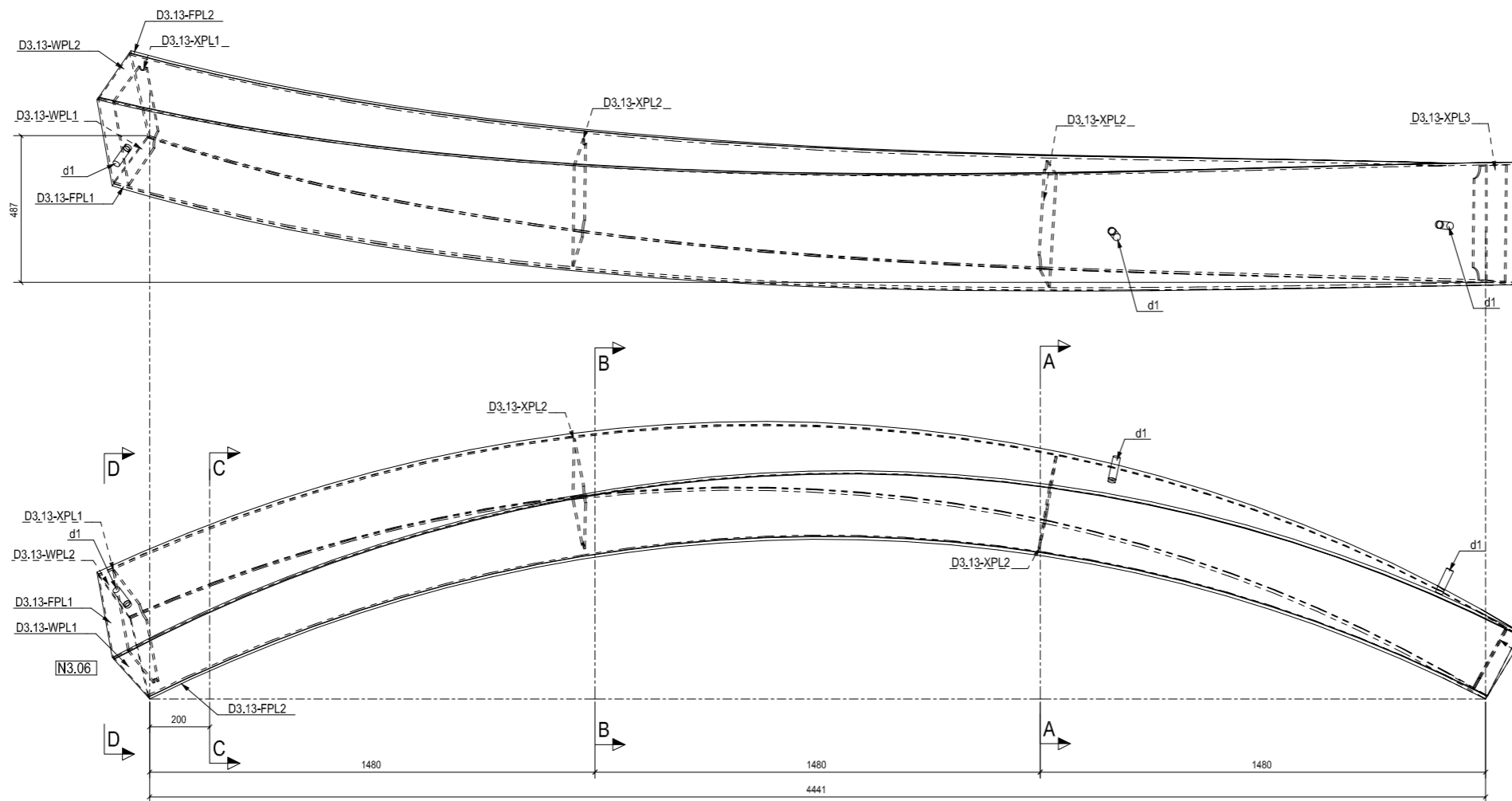
REFERENCE SHOP DRAWING:- S4W001(1)
REFERENCE DESIGN DRAWING:- DS2016/001399 SHEET 113(5), 114(6), 115(6), 116(10), 123(4), 124(6)

D=DUPLEX

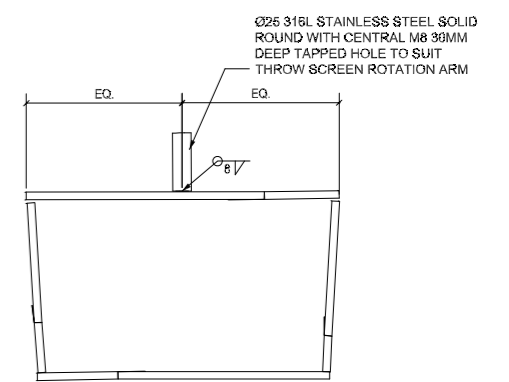
PART LIST						
QTY	MARK	PROFILE	GRADE	LENGTH	WEIGHT(Kg)	AREA(m ²)
1	C2.02-FPL1	PLT12*3992	350	5424	248,2	5,4
1	C2.02-FPL2	PLT12*4067	350	5314	230,2	5,0
1	C2.02-WPL1	PLT10*4453	350	4899	111,3	3,0
1	C2.02-WPL2	PLT10*4406	350	4805	110,1	2,9
2	C2.02-XPL1	PL6*221	350-L0	393	7,6	0,3
2	C2.02-XPL2	PL6*221	350-L0	394	7,6	0,3
TOTAL:					715	16,9

AS 1100 - 3RD ANGLE PROJECTION				QTY: 1 REQUIRED	
DO NOT SCALE				FINISH:	
ALL DIMENSION IN MILLIMETERS				WEIGHT (Kg): 715	
GENERAL TOLERANCES U.N.O.					
NOMINAL SIZE:		TOLERANCE:			
X		±1			
X.X		±0.5			
X.XX		±0.1			
REV	DATE	DESCRIPTION	BY		
0	13.02.2019	ISSUED FOR FABRICATION	NS		

CLIENT:					
PROJECT:					
DESC.:	C2.02				
ASSEMBLY MARK.:	C2.02				
DRAWING No.:	S+L- C2.02				REV: 0
SCALE: 1:10	SHEET No.	0	SHEET SIZE:	A1	



TYPICAL CHORD/DIAGONAL FABRICATION PLATE & WELDING DETAIL
N.T.S.



TYPICAL INTERMEDIATE DOWEL CONNECTION
N.T.S.

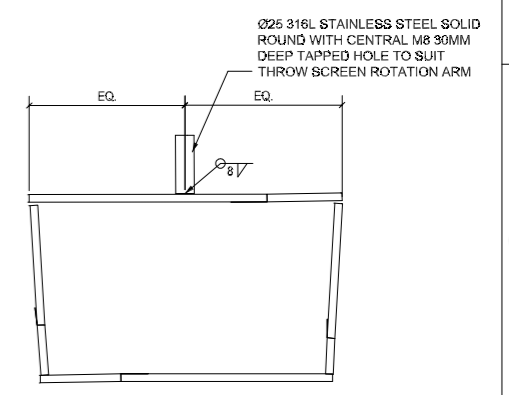
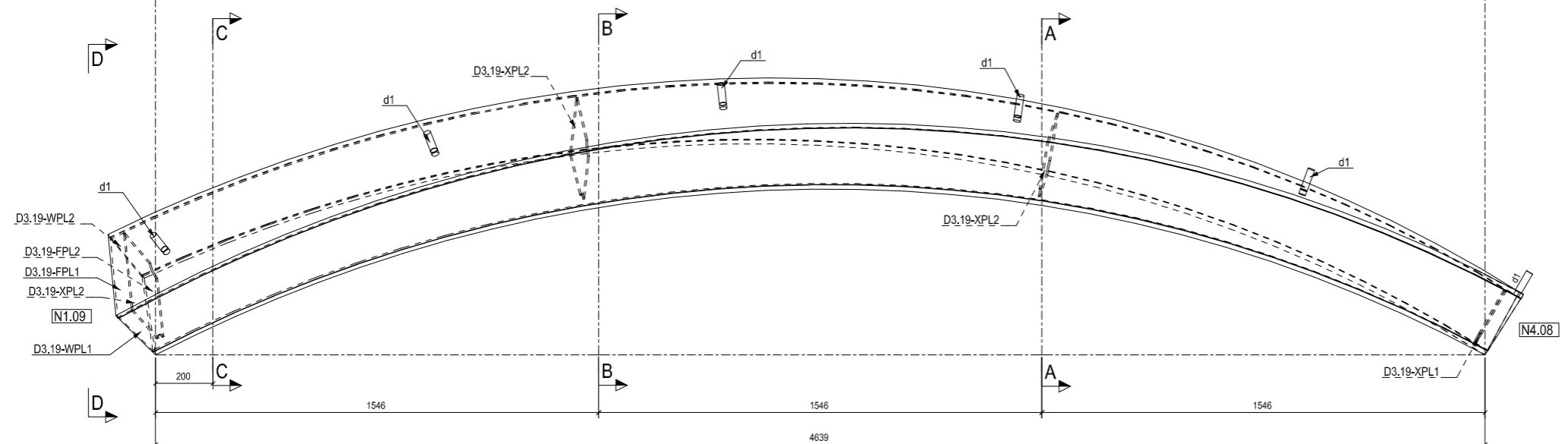
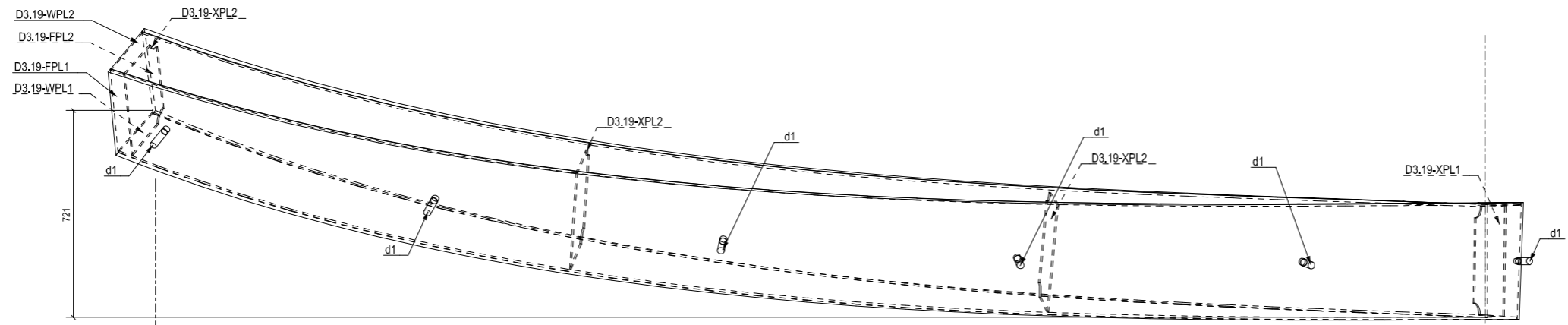
* = NOMINAL LENGTH, TO BE CONFIRMED BY SCREEN DESIGNER PRIOR TO FABRICATION OF THIS PART.
D=DUPLEX

PART LIST						
QTY	MARK	PROFILE	GRADE	LENGTH	WEIGHT(kg)	AREA(m ²)
1	D3.13-FPL1	PLT10*1707	350	4870	157.2	4.1
1	D3.13-FPL2	PLT10*2271	350	4442	144.3	3.8
1	D3.13-WPL1	PLT8*1151	350	4640	67.8	2.2
1	D3.13-WPL2	PLT8*1175	350	4701	68.6	2.3
1	D3.13-XPL1	PL6*224	350-L0	389	3.9	0.2
2	D3.13-XPL2	PL6*224	350-L0	390	7.9	0.3
1	D3.13-XPL3	PL6*224	350-L0	391	3.9	0.2
3	d1	D25	316L SS	77	0.9	0.0
TOTAL:				454.5	13.1	

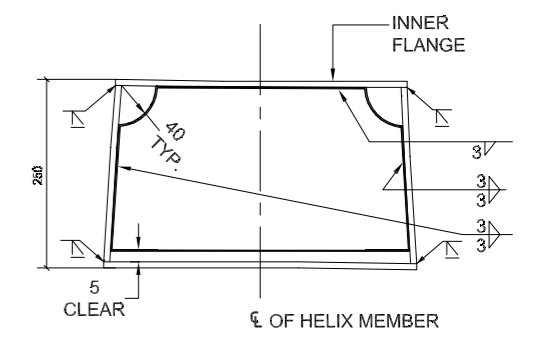
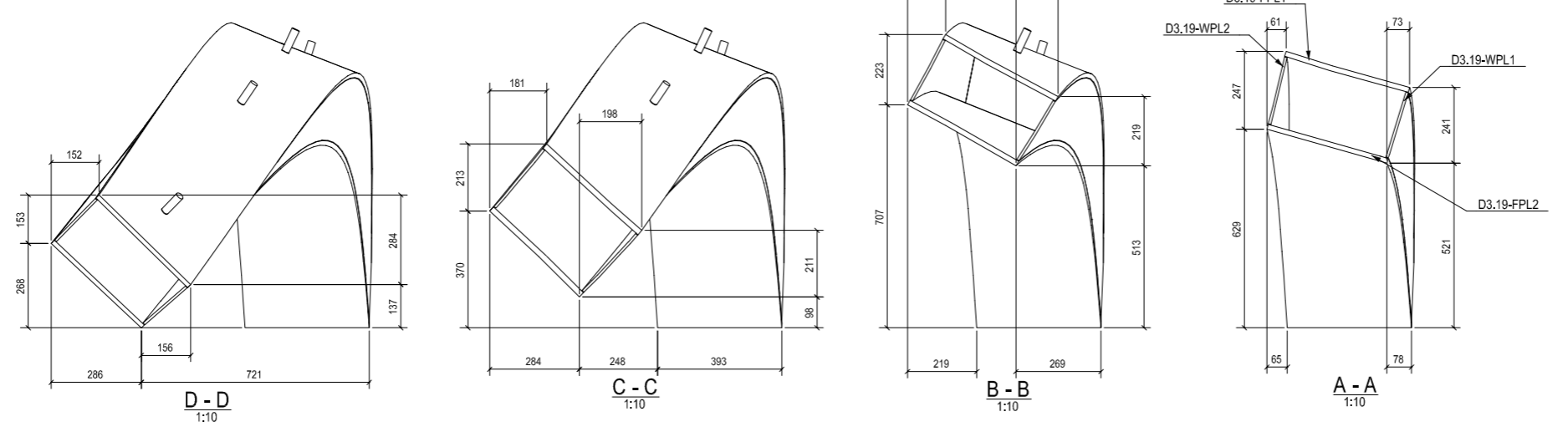
AS 1100 - 3RD ANGLE PROJECTION				QTY: 1 REQUIRED	
DO NOT SCALE				FINISH:	
ALL DIMENSION IN MILLIMETERS				WEIGHT (Kg): 455	
GENERAL TOLERANCES U.N.O.				DRAWING No.: S+L- D3.13	
NOMINAL SIZE:		TOLERANCE:		REV: 0	
X		±1		SCALE: 1:10	
X.X		±0.5		SHEET No. 0	
X.XX		±0.1		SHEET SIZE: A1	
REV	DATE	DESCRIPTION	BY		
0	13.02.2019	ISSUED FOR FABRICATION	NS		

REFERENCE SHOP DRAWING:- S3W001(1)
REFERENCE DESIGN DRAWING:- DS2016/001399 SHEET 113(5), 114(6), 115(6), 116(10), 123(4), 124(6)

CLIENT:			
PROJECT:			
DESC.:	D3.13		
ASSEMBLY MARK.:	D3.13		
DRAWING No.:	S+L- D3.13		REV: 0
SCALE: 1:10	SHEET No. 0	SHEET SIZE: A1	



TYPICAL INTERMEDIATE DOWEL CONNECTION
N.T.S.



TYPICAL CHORD/DIAGONAL FABRICATION
PLATE & WELDING DETAIL
N.T.S.

* = NOMINAL LENGTH. TO BE CONFIRMED BY SCREEN DESIGNER PRIOR TO FABRICATION OF THIS PART.

D=DUPLEX

PART LIST						
QTY	MARK	PROFILE	GRADE	LENGTH	WEIGHT(Kg)	AREA(m ²)
1	D3.19-FPL1	PLT16*2757	350 Z35	4779	264.7	4.4
1	D3.19-FPL2	PLT16*2270	350 Z35	4676	243.0	4.0
1	D3.19-WPL1	PLT8*2063	350	4538	67.8	2.2
1	D3.19-WPL2	PL8*2038	350	4588	68.1	2.3
1	D3.19-XPL1	PL6*211	350-L0	391	3.7	0.2
3	D3.19-XPL2	PL6*212	350-L0	390	11.1	0.5
6	d1	D25	316L SS	77 *	1.7	0.0
TOTAL:					660.1	13.6

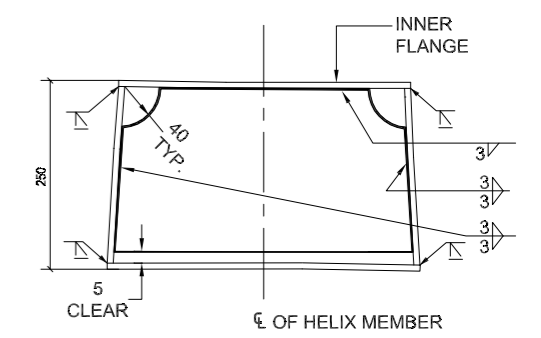
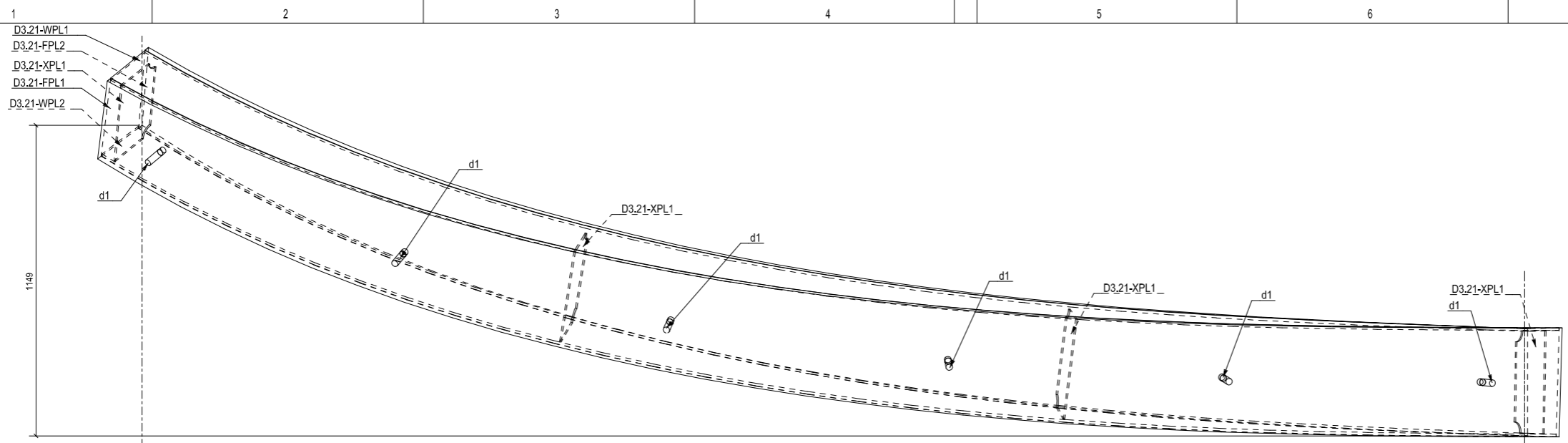
AS 1100 - 3RD ANGLE PROJECTION			
DO NOT SCALE			
ALL DIMENSION IN MILLIMETERS			
GENERAL TOLERANCES U.N.O.			
NOMINAL SIZE:		TOLERANCE:	
X		±1	
X.X		±0.5	
X.XX		±0.1	
REV	DATE	DESCRIPTION	BY
0	13.02.2019	ISSUED FOR FABRICATION	NS

QTY:
1 REQUIRED

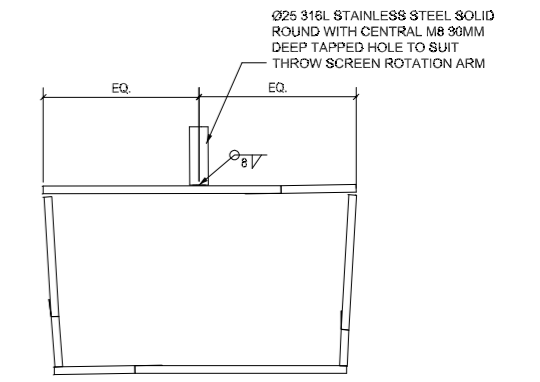
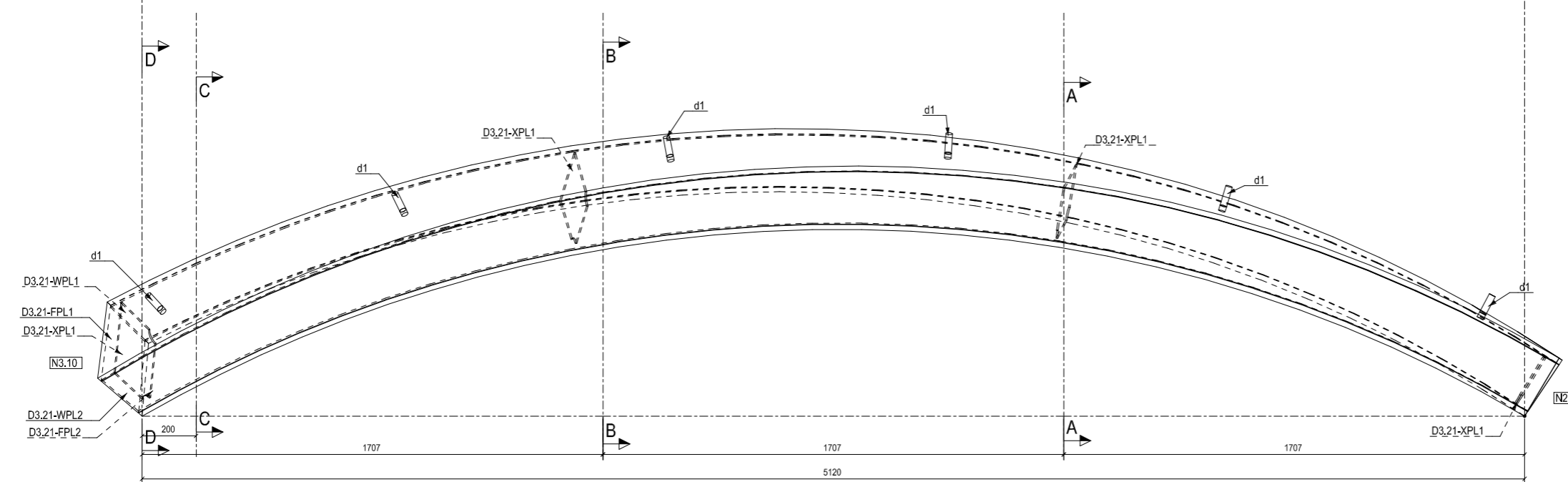
FINISH:

WEIGHT (Kg):
660

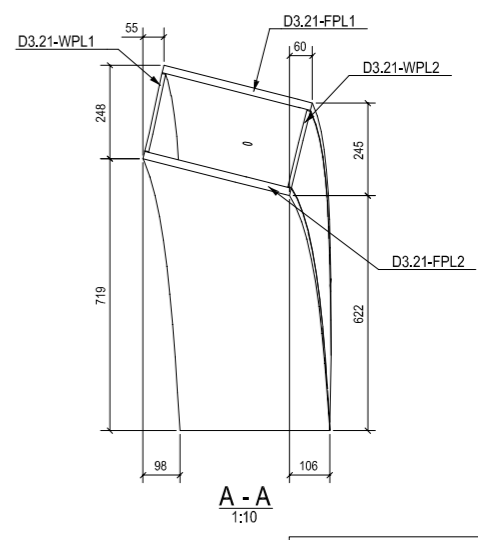
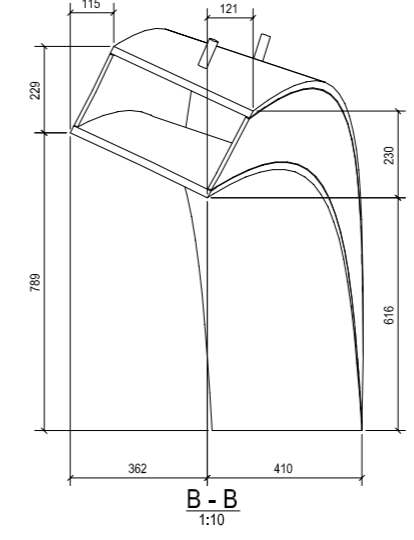
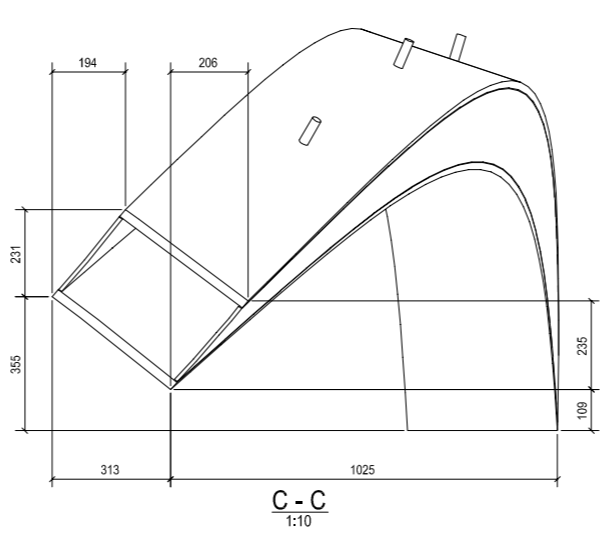
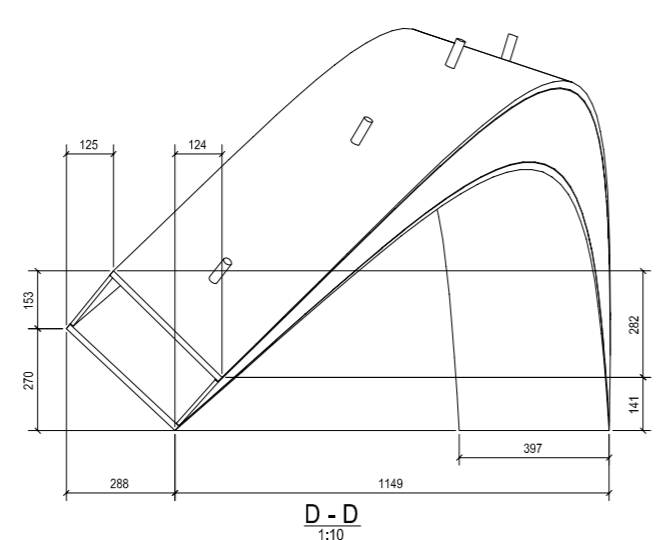
REFERENCE SHOP DRAWING:- S3W001(1)			
REFERENCE DESIGN DRAWING:- DS2016/001399 SHEET 113(5), 114(6), 115(6), 116(10), 123(4), 124(6)			
CLIENT: PROJECT:			
DESC.: D3.19			
ASSEMBLY MARK.: D3.19			
DRAWING No.: S+L- D3.19			REV: 0
SCALE: 1:10	SHEET No. 0	SHEET SIZE: A1	



TYPICAL CHORD/DIAGONAL FABRICATION PLATE & WELDING DETAIL
N.T.S.



TYPICAL INTERMEDIATE DOWEL CONNECTION
N.T.S.



* = NOMINAL LENGTH. TO BE CONFIRMED BY SCREEN DESIGNER PRIOR TO FABRICATION OF THIS PART.
D=DUPLIX

PART LIST						
QTY	MARK	PROFILE	GRADE	LENGTH	WEIGHT(kg)	AREA(m ²)
1	D3.21-FPL1	PL20*2370	350 Z35	5620	368,0	4,9
1	D3.21-FPL2	PLT20*2499	350 Z35	5242	343,6	4,6
1	D3.21-WPL1	PLT10*1774	350	5269	91,4	2,4
1	D3.21-WPL2	PLT10*1765	350	5318	92,0	2,5
4	D3.21-XPL1	PL6*204	350-L0	384	14,1	0,6
6	d1	D25	316L SS	77	1,7	0,0
				TOTAL:	910,8	15

REV	DATE	DESCRIPTION	BY	X	±1
0	13.02.2019	ISSUED FOR FABRICATION	NS	X.X	±0.5
				X.XX	±0.1

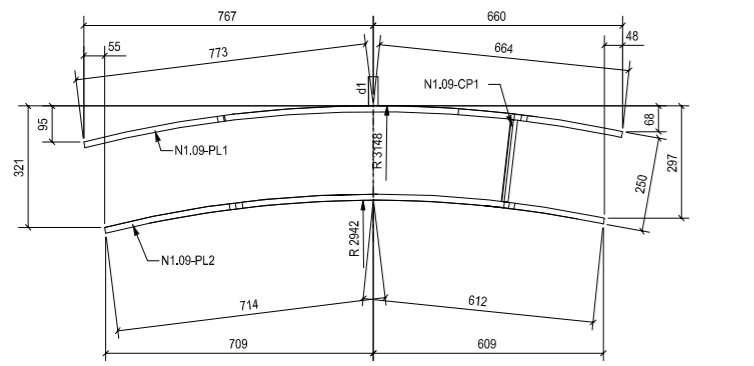
AS 1100 - 3RD ANGLE PROJECTION
DO NOT SCALE
ALL DIMENSION IN MILLIMETERS
GENERAL TOLERANCES U.N.O.

QTY:
1 REQUIRED

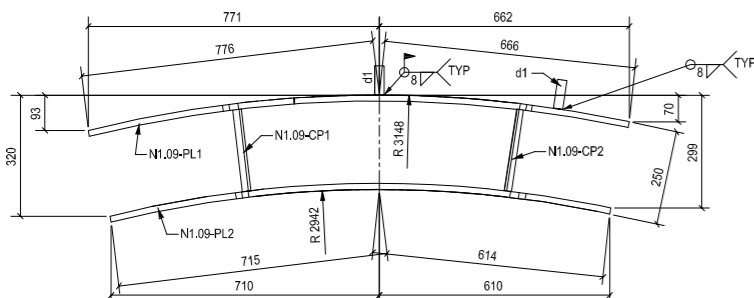
FINISH:
WEIGHT (Kg):
911

REFERENCE SHOP DRAWING:-
S3W001[1]
REFERENCE DESIGN DRAWING:-
DS2016/001399 SHEET 113[5], 114[6], 115[6], 116[10], 123[4], 124[6]

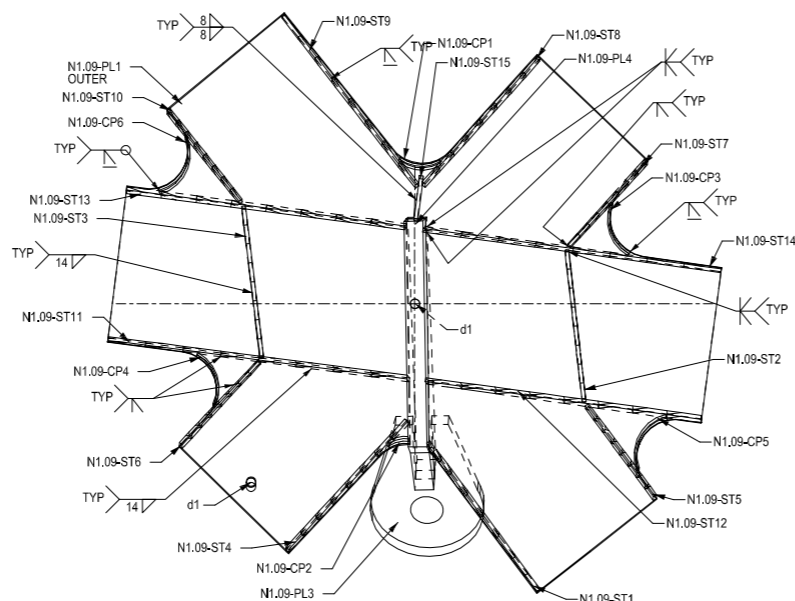
CLIENT:
PROJECT:
DESC.: **D3.21**
ASSEMBLY MARK.: **D3.21**
DRAWING No.: **S+L- D3.21** REV: **0**
SCALE: **1:10** SHEET No. **0** SHEET SIZE: **A1**



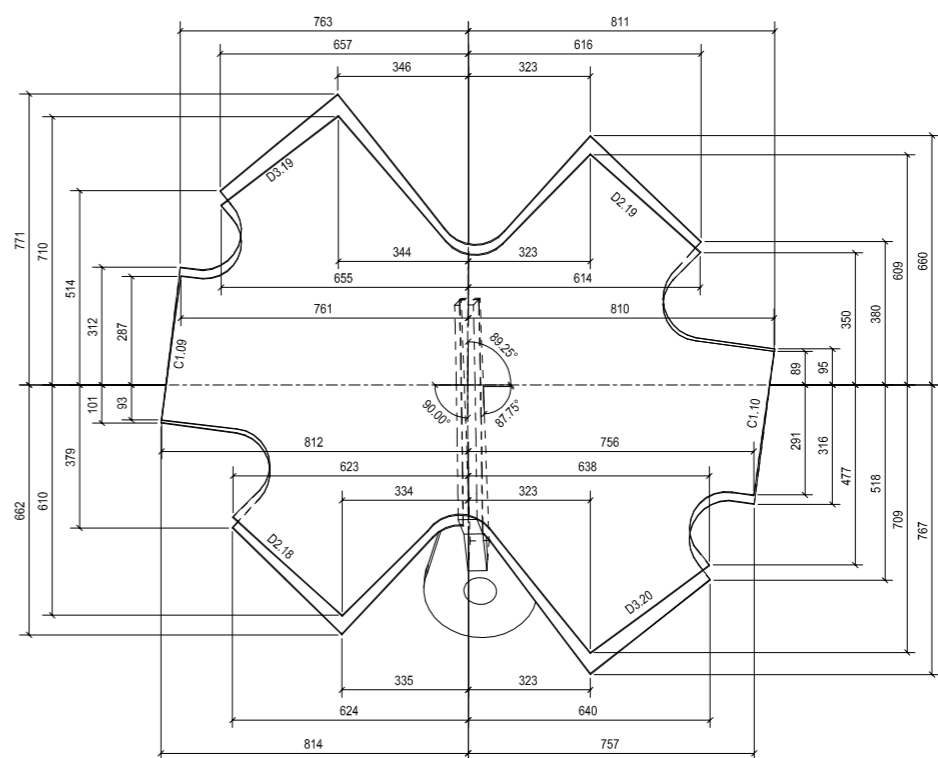
E - E
1:10



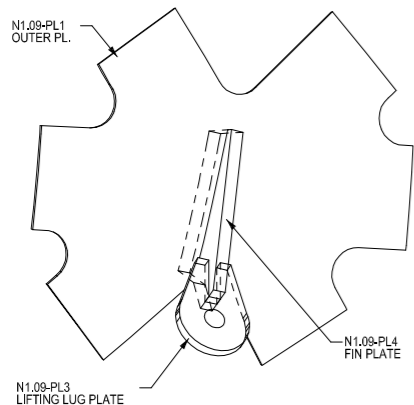
D - D
1:10



B - B
1:10

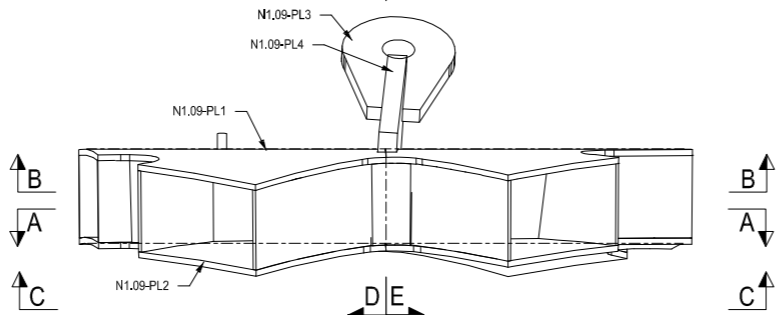


C - C
1:10

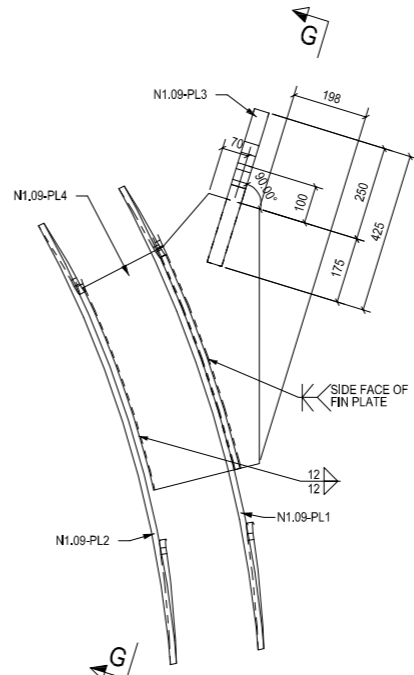


3D VIEW
SCALE 1:15

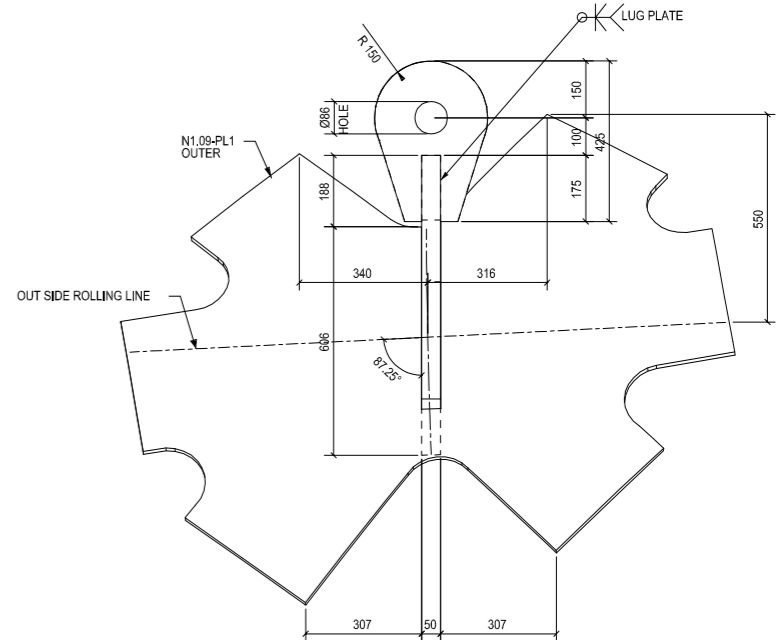
(INNER NODE & DIAGONAL OR CHORD STIFFENER PLATE OMITTED FOR CLARITY.)



D - E



DETAIL OF LIFTING LUG



G - G
1:10

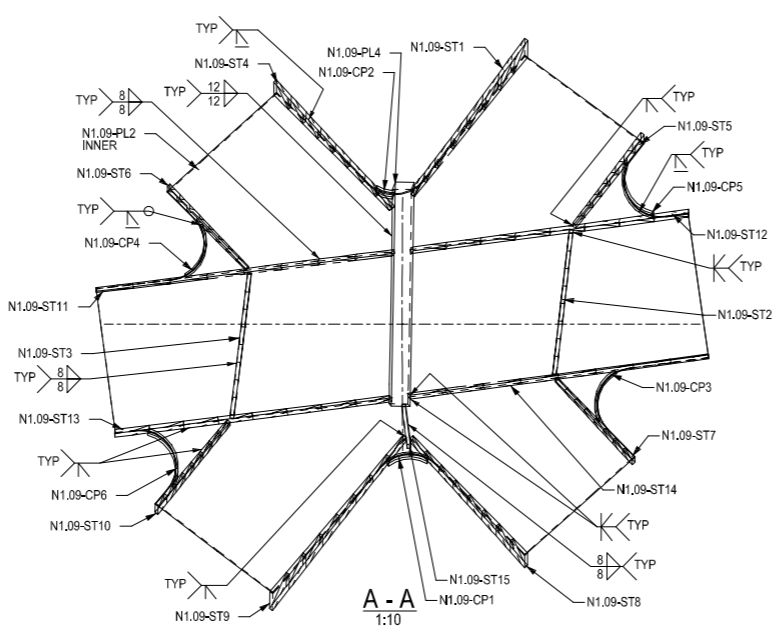
1* = N1.09-PL3 To use Heat No: 5564478, Unit ID: AF149A1

2* = N1.09-PL4 To use Heat No: 7569049, Unit ID: DP464A1

* = NOMINAL LENGTH, TO BE CONFIRMED BY SCREEN DESIGNER PRIOR TO FABRICATION OF THIS PART.

D=DUPLX

PART LIST						
QTY	MARK	PROFILE	GRADE	LENGTH	WEIGHT(kg)	AREA(m ²)
1	N1.09-CP1	PL6*108	350-L0	218	1.1	0.1
1	N1.09-CP2	PL6*58	350-L0	218	0.5	0.0
1	N1.09-CP3	PL6*145	350-L0	218	1.5	0.1
1	N1.09-CP4	PL6*150	350-L0	218	1.6	0.1
1	N1.09-CP5	PL6*170	350-L0	218	1.8	0.1
1	N1.09-CP6	PL6*171	350-L0	218	1.8	0.1
1	N1.09-PL1	PL16*1551	350 Z35	1630	181.8	3.0
1	N1.09-PL2	PL16*1437	350 Z35	1630	171.8	2.8
1	N1.09-PL3	PL40*394	350 ¹¹	394	27.8	0.2
1	N1.09-PL4	PL50*466	350 Z35 ²¹	786	97.2	0.6
1	N1.09-ST1	PLT10*357	350	513	8.2	0.2
1	N1.09-ST2	PLT10*239	350	403	6.7	0.2
1	N1.09-ST3	PLT10*316	350	434	6.7	0.2
1	N1.09-ST4	PLT10*334	350	506	7.8	0.2
1	N1.09-ST5	PLT10*271	350	334	5.1	0.1
1	N1.09-ST6	PLT10*271	350	337	5.1	0.1
1	N1.09-ST7	PLT10*271	350	335	5.1	0.1
1	N1.09-ST8	PLT10*334	350	489	7.6	0.2
1	N1.09-ST9	PLT10*405	350	602	9.6	0.3
1	N1.09-ST10	PLT10*274	350	338	5.2	0.1
1	N1.09-ST11	PLT10*530	350	821	13.7	0.4
1	N1.09-ST12	PLT10*454	350	774	12.6	0.3
1	N1.09-ST13	PLT10*491	350	772	12.7	0.3
1	N1.09-ST14	PLT10*496	350	828	13.6	0.4
1	N1.09-ST15	PL10*115	350	221	1.9	0.1
2	d1	D25	316L SS	77*	0.6	0.0
				TOTAL:	609.0	10.4



A - A
1:10

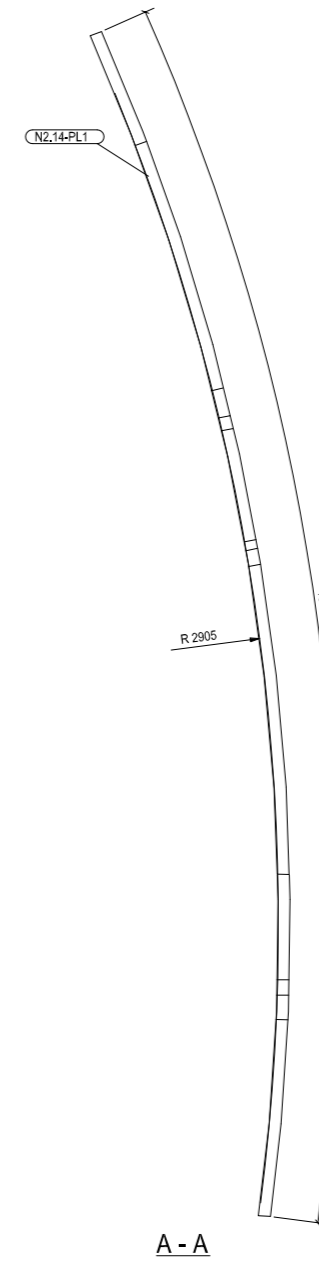
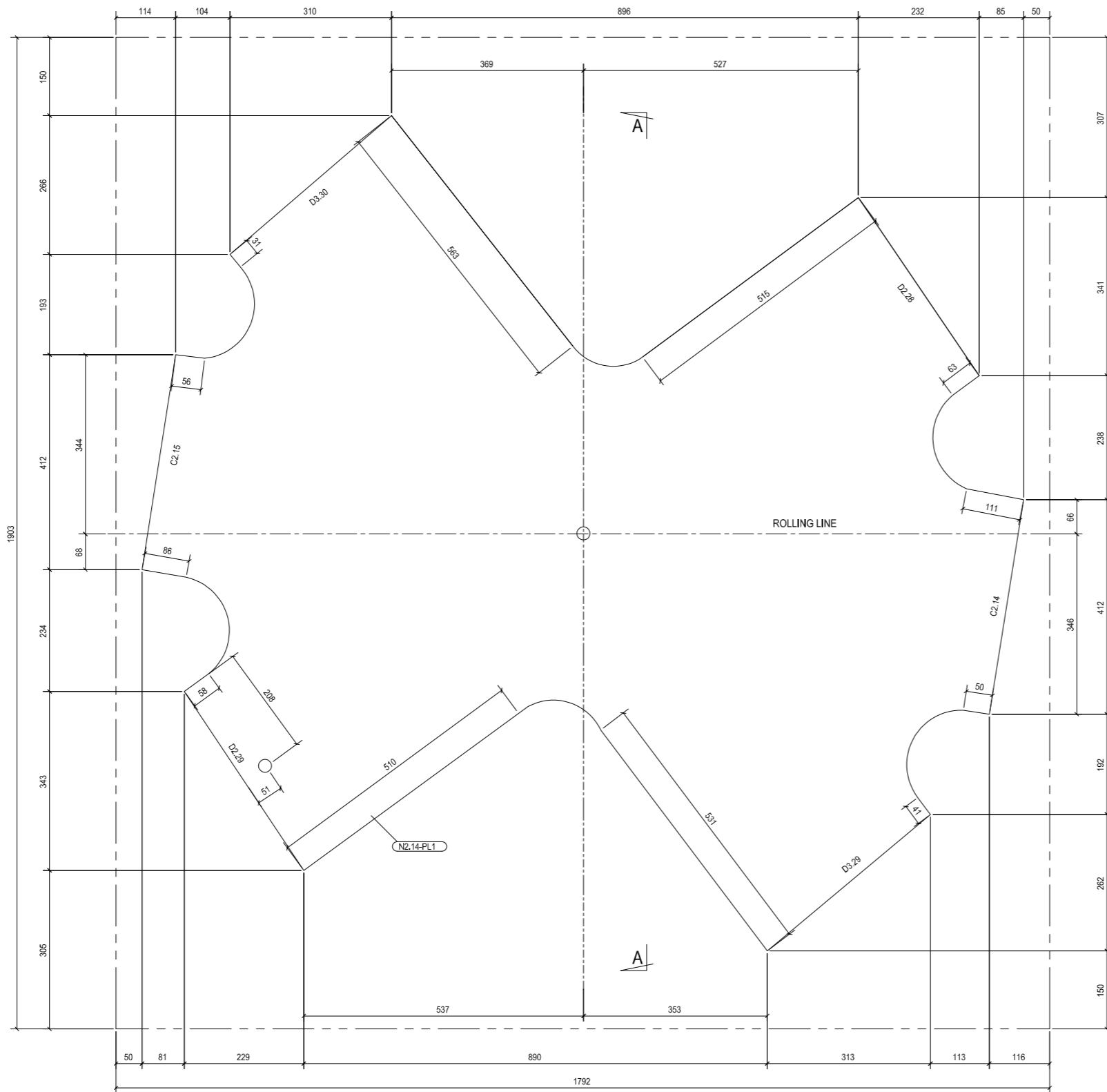
AS 1100 - 3RD ANGLE PROJECTION		QTY:	
DO NOT SCALE		1 REQUIRED	
ALL DIMENSION IN MILLIMETERS		FINISH:	
GENERAL TOLERANCES U.N.O.		WEIGHT (Kg):	
NOMINAL SIZE:	TOLERANCE:	609	
X	±1		
0	±0.5		
REV	DATE	ISSUED FOR FABRICATION	BY
	24.04.2019		
		DESCRIPTION	

REFERENCE SHOP DRAWING:-
S3W001[1]

REFERENCE DESIGN DRAWINGS:-
ARUP Lifting Lug design 31.08.18
DS2016/001399, 113[5], 114[6], 117[7], 118[7], 119[4], 120[4], 121[3], 122[4], 123[4], 124[6]

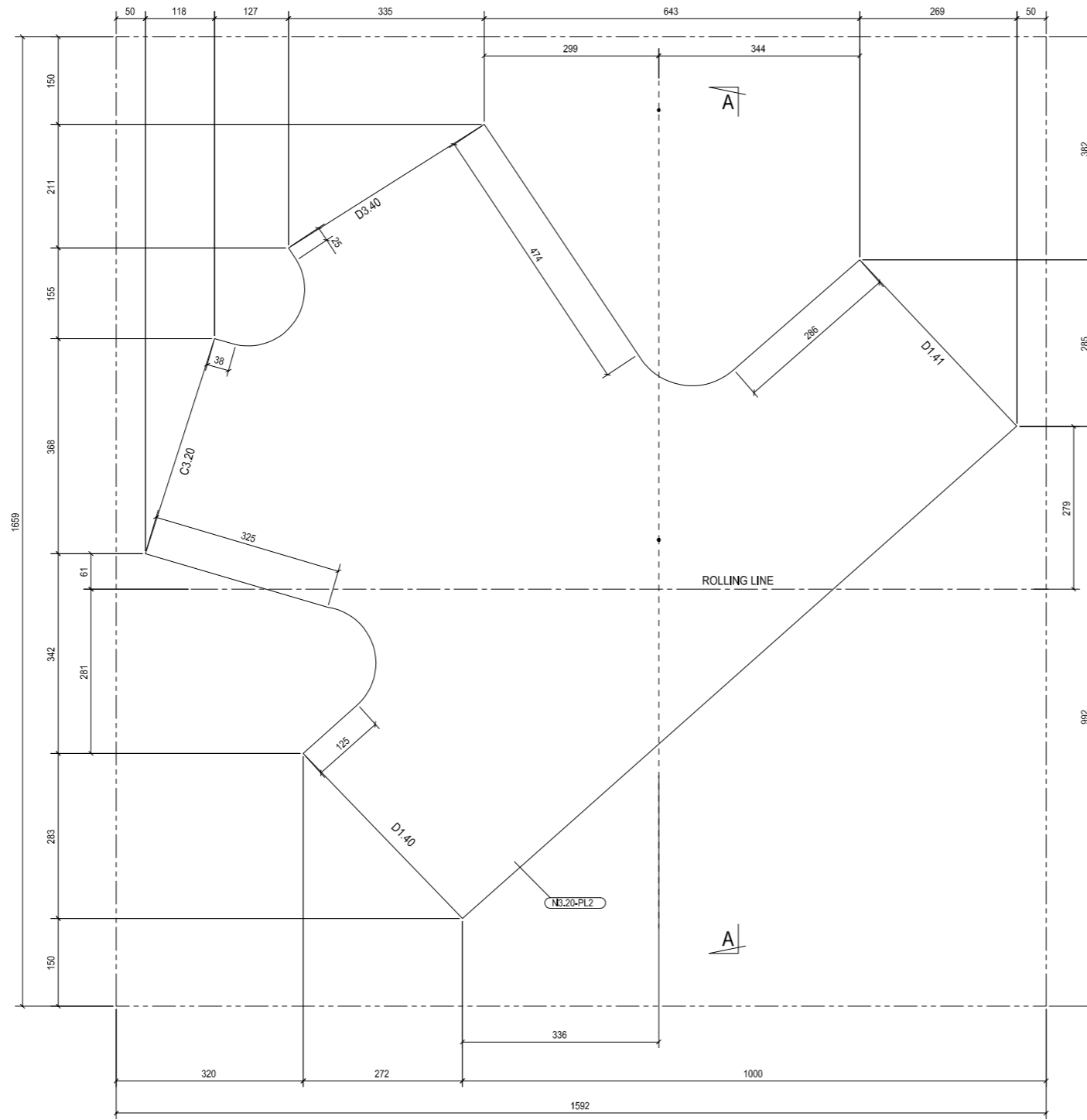
FABRICATION NOTES:-
1) WELDING SEQUENCE IS CRITICAL TO REDUCING THE RISK OF LAMELLAR TEARING. COMPLETE ALL WELDS BETWEEN CENTRAL STIFFENERS, SIDE STIFFENERS AND WEBS FIRST. COMPLETE NON DESTRUCTIVE EXAMINATION BEFORE WELDING STIFFENER/WEB ASSEMBLY TO THE NODE PLATES.
2) INNER AND OUTER CURVED NODE PLATES TO BE LOCALLY PRESSED FLAT TO ENSURE ALIGNMENT WITH ADJACENT DIAGONAL / CHORD FLANGE PLATE. APPLIES AT ALL INTERFACES PER NODE.

CLIENT:			
PROJECT:			
DESC.:	N1.09		
ASSEMBLY MARK.:	N1.09		
DRAWING No.:	S+L- N1.09	REV:	0
SCALE:	1:10	SHEET No.	0
		SHEET SIZE:	A1



UNFOLD VIEW PLAN

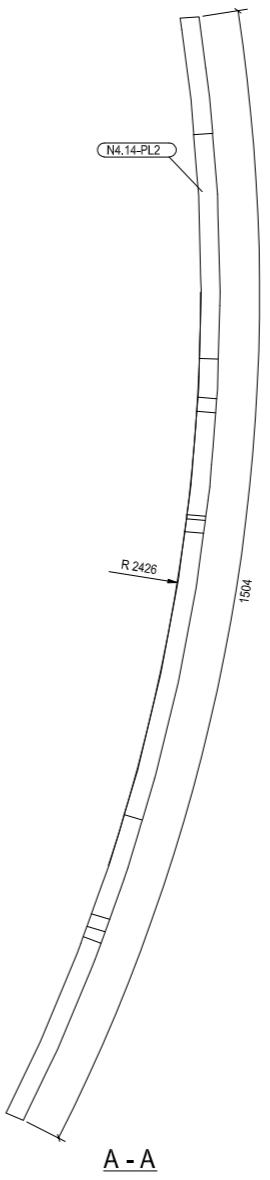
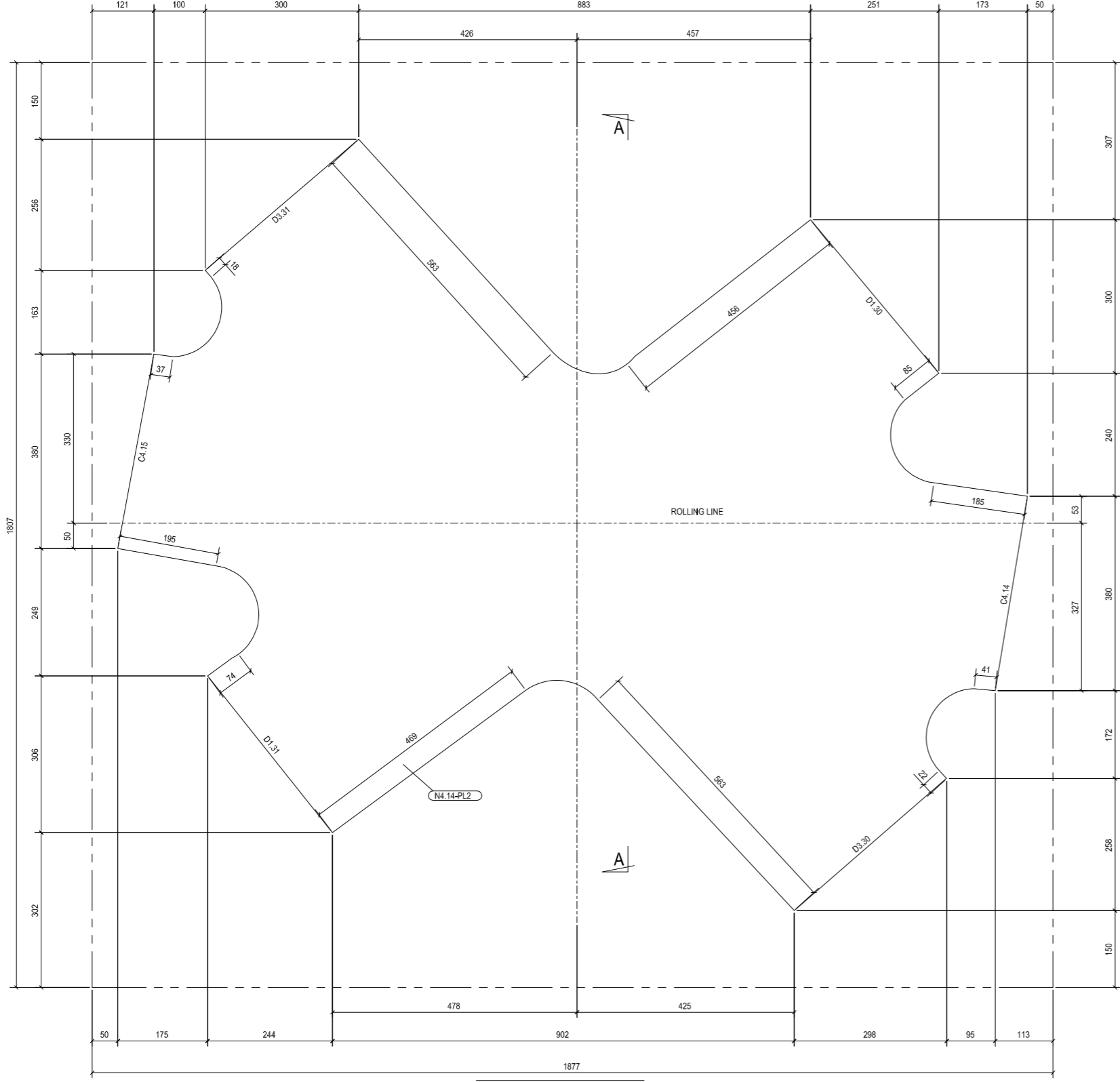
				AS 1100 - 3RD ANGLE PROJECTION		QTY: 1 REQUIRED		CLIENT:	
				DO NOT SCALE		PROFILE: PL16*1603		PROJECT:	
				ALL DIMENSION IN MILLIMETERS		GRADE: 350 Z35		DESC.:	
				GENERAL TOLERANCES U.N.O.		WEIGHT (Kg): 200		PT/MK No. N2.14-PL1	
NOMINAL SIZE:		TOLERANCE:						DRG No. N2.14-PL1	
B 15.02.2019		ISSUED FOR APPROVAL		HA X ±1				REV: B	
A 15.02.2019		ISSUED FOR APPROVAL		KS X.X ±0.5				SCALE: 1:5	
REV	DATE	DESCRIPTION		BY	X.XX	0.1	DESIGNED:	DRAWN: HA	CHECKED: KS
								SHEET No. 1	
								SHEET SIZE: A1	



UNFOLD VIEW PLAN



				AS 1100 - 3RD ANGLE PROJECTION		QTY: 1 REQUIRED		CLIENT:	
				DO NOT SCALE		PROFILE: PL10*1359		PROJECT:	
				ALL DIMENSION IN MILLIMETERS		GRADE: 350		DESC:	
				GENERAL TOLERANCES U.N.O.		WEIGHT (Kg): 76		PT/MK No. N3.20-PL2	
		NOMINAL SIZE:		TOLERANCE:		DESIGNED:		DRG No. N3.20-PL2	
B		14.02.2019		ROLLING LINE MOVED		DRAWN: HA		REV: B	
A		26.12.2018		ISSUED FOR APPROVAL		CHECKED: KS		SCALE: 1:5	
REV	DATE	DESCRIPTION	BY	X.XX	0,1	SHEET No. 1		SHEET SIZE: A1	



UNFOLD VIEW PLAN

			AS 1100 - 3RD ANGLE PROJECTION			QTY: 1 REQUIRED			CLIENT: PROJECT:		
			DO NOT SCALE			PROFILE: PL25*1507			DESC:		
			ALL DIMENSION IN MILLIMETERS			GRADE: 400 Z35			PT/MK No. N4.14-PL2		
			GENERAL TOLERANCES U.N.O.			WEIGHT (Kg): 294			DRG No. N4.14-PL2 REV: B		
			NOMINAL SIZE:	TOLERANCE:		DESIGNED:			DRAWN: KK CHECKED: KS		
B	15.02.2019	ISSUED FOR APPROVAL	HA	X	±1	SCALE: 1:5			SHEET No. 1		
A	15.02.2019	ISSUED FOR APPROVAL	KS	X.X	±0.5	SHEET SIZE: A1					
REV	DATE	DESCRIPTION	BY	X.XX	0.1						