REVISION

REV	DESCRIPTION	BY	DATE	APPROVED

Distribution Statement:
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No deviations shall be made without authorization unless noted otherwise.

CONCURRENCE			APPROVAL		
CODE	SIGNATURE	DATE		SIGNATURE	DATE
106	/s/S. Murray	02/19/15	BRANCH SUPV.	/s/ R. Zmijewski, C/100PI	02/20/15
350	/s/R. Lukkasson	02/19/15	CHECKED	/s/ L. Blocher, C/980R	02/19/15
			DRAWN	/s/ B. Peterson, C/380R	02/12/15
			DESIGNED	/s/ B. Peterson, C/380R	02/12/15

GENERAL TOLERANCES	
Under 12 inches	+/- 1/16"
12 to 72 inches	+/- 1/8"
Over 72 inches	+/- 1/4"

DEPARTMENT OF THE NAVY PUGET SOUND NAVAL SHIPYARD
PRODUCTION ENGINEERING DIVISION, CODE 380
BREMERTON, WASHINGTON

FOUNDATION FOR 688 OFF-LOAD ACCESS HATCH

SIZE	CAGE CODE	DWG NO.	REV.
A	82522	380R - 67	-

SCALE: NONE

SHEET: 1 OF 7

MATERIAL LIST

Pc #	QTY	DESCRIPTION & SIZE	MAT DESIG.	MATERIAL SPEC.	REMARKS
1	2	PL 3/16 x size to suit	Steel	ASTM A36	Countoured base walls
2	2	PL 3/16 x size to suit	Steel	ASTM A36	Walls
3	4	HSS 3x3x3/16 x 12' - 0"	Steel	ASTM A500 GR B	Perimeter member
4	2	Bar 3 x 3/16 x 12' - 1-1/4"	Steel	ASTM A36	Curved flange
5	12	Bar 2 x 3/16 x various lengths	Steel	ASTM A36	Wall stiffeners
6	4	L 2x2x3/16 x 12' - 0"	Steel	ASTM A36	Mounting flange
7	4	L 2x2x3/16 x 1' - 10-1/2"	Steel	ASTM A36	Corner reinforcement
8	8	Nut, Heavy Hex 5/8"	Steel	ASTM A563	Hoist Ring attachment
9	AR	1/4" Rubber Gasket	Rubber		Glue to underside of perimeter

REFERENCES

A) PSNS Welding Procedure #WP-NN/FAC
B) AWS D1.1 Structural Welding Code - Steel

GENERAL NOTES

1. This drawing provides details to fabricate a 688 class Off-Hull Access Hatch assembly foundation. The foundation is contoured to adapt to the submarine hull, and the top mounting flange allows attachment of a vendor equipment hatch. The foundation mounting flange is square to allow attachment of equipment hatch with hinged door oriented either parallel or perpendicular to the submarine axis.

2. Design Info: Foundation will support a 2,000 lb equipment hatch with snow load, is suitable for wind loading, and is capable of rigging with equipment hatch attached.

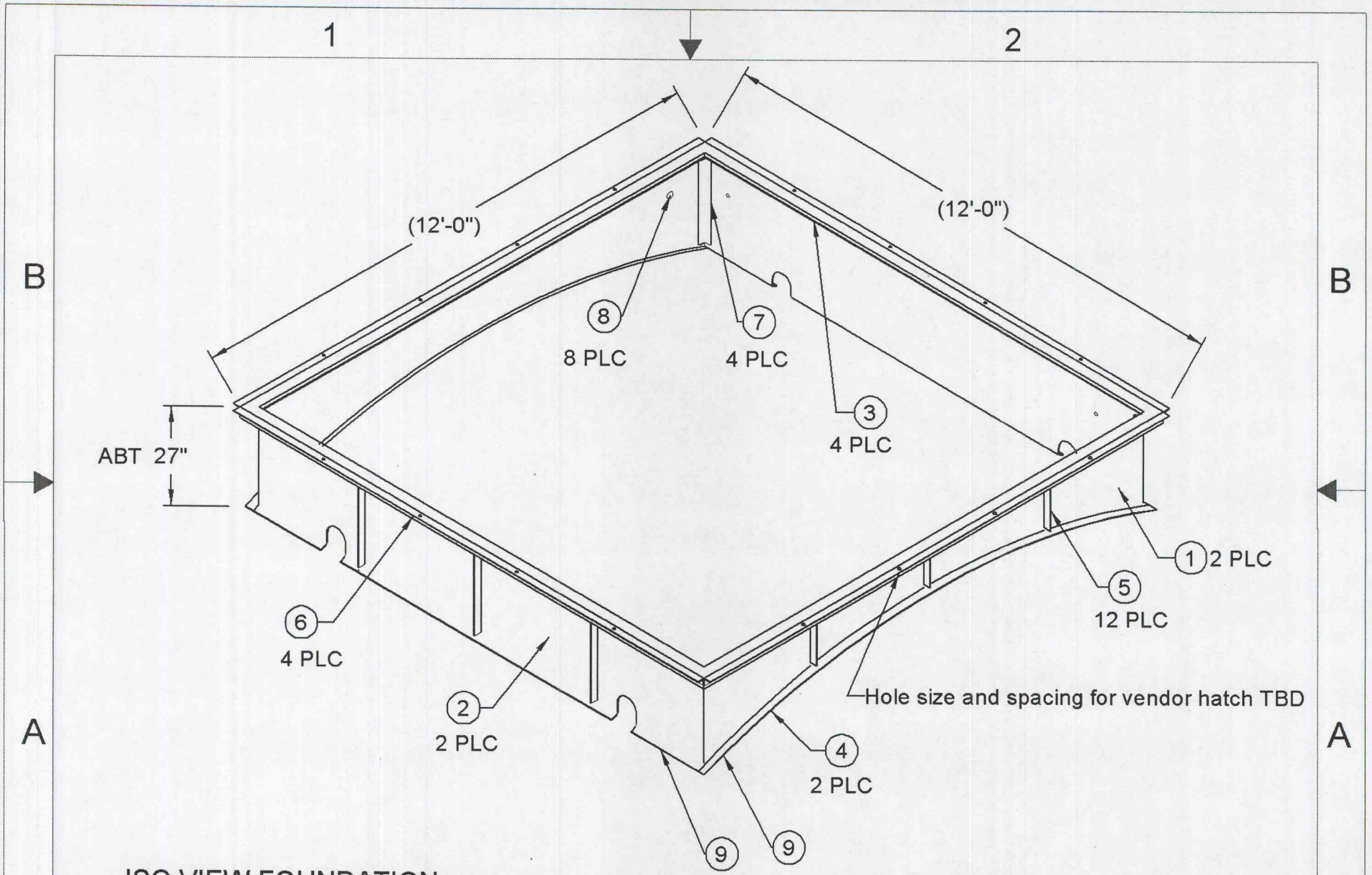
3. Smooth and debur all rough edges. Welding shall be performed per ref (a) or (b) with visual inspection and acceptance criteria of all welds at least the size specified with no visible cracks or porosity. Upon completiong of fabrication, clean and prepare surfaces according to paint instructions and paint entire assembly with marine grade paint.

4. Use swivel hoist rings in Pc. 8 for rigging foundation with or without vendor hatch. Secure foundation to hull by means of welded "dog and wedge" in four places.

5. For questions on this drawing contact PSNS-IMF Code 380R Brian Peterson, 360-476-5957.

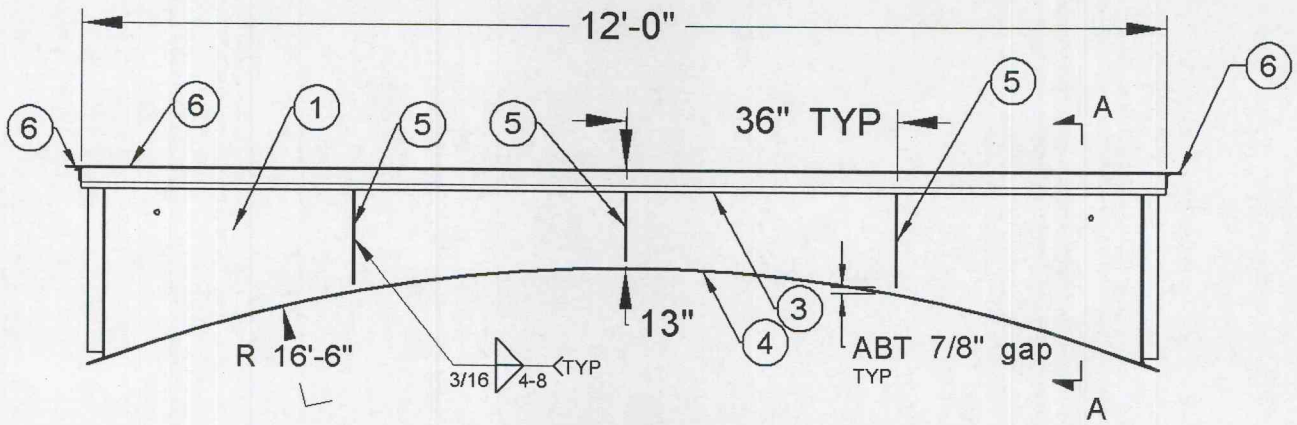
SIZE	CAGE CODE	DWG NO.	REV.
A	82522	980R- 67	-
SCALE: AS NOTED		SHEET: 2 OF 7	

ATTACHMENT 2 -- SPMYM2-15-Q-0401

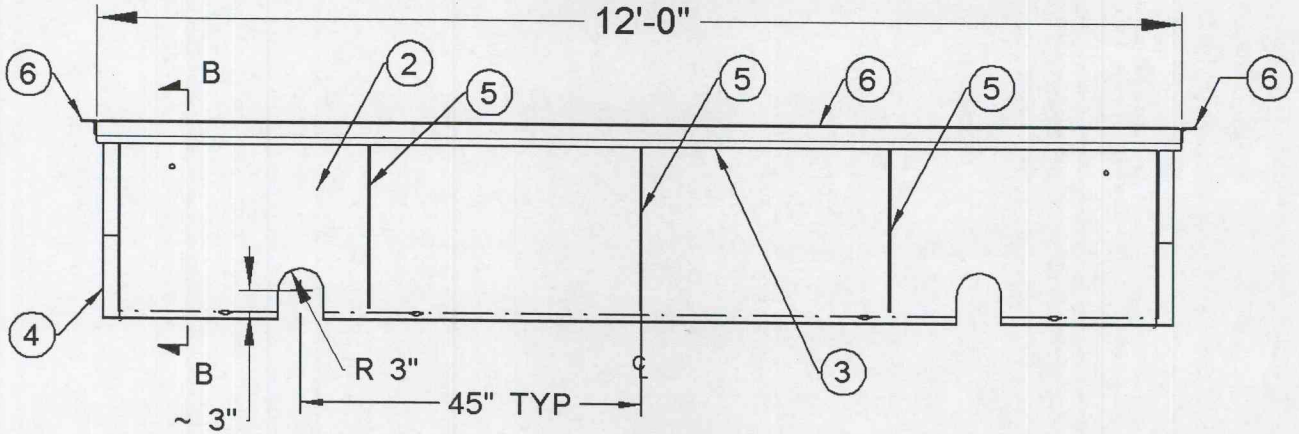


ISO VIEW FOUNDATION

SIZE	CAGE CODE	DWG NO.	REV.
A	82522	380R - 67	-
SCALE: NONE			SHEET: 3 OF 7



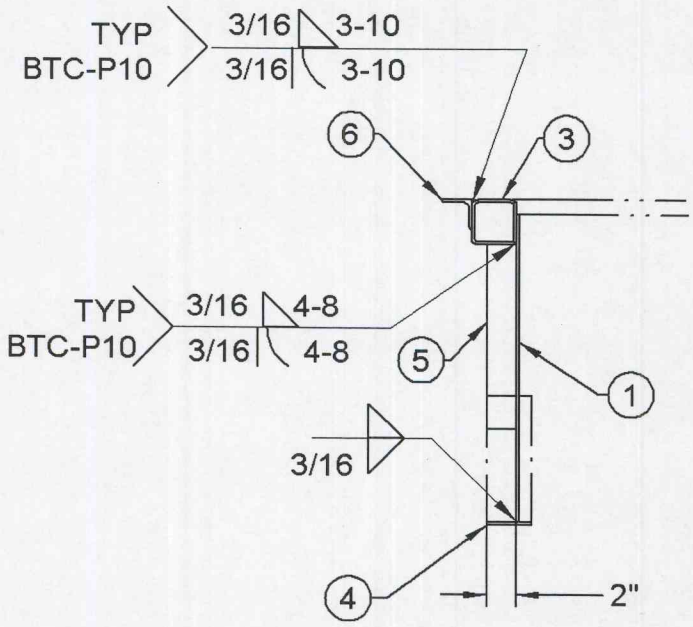
END ELEV VIEW



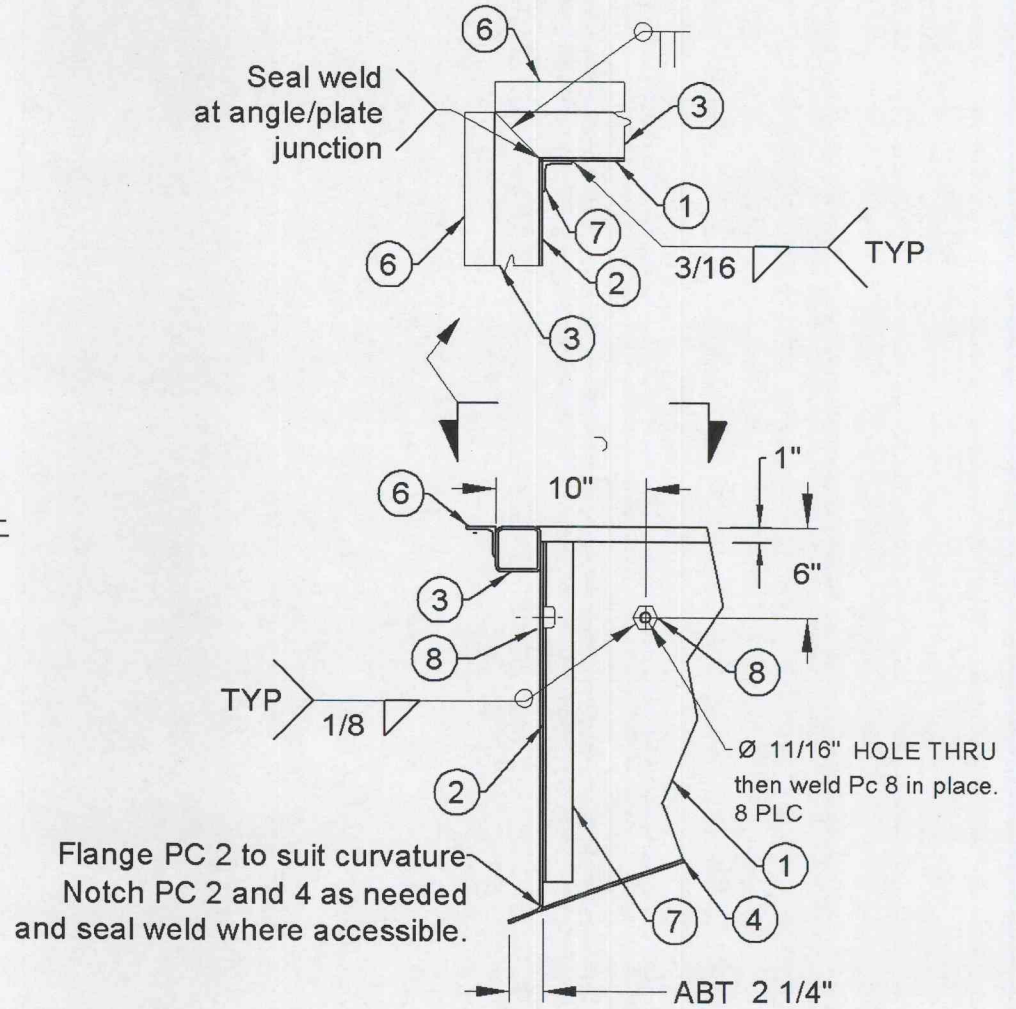
SIDE ELEV VIEW

Pc. 9 not shown

SIZE	CAGE CODE	DWG NO.	REV.
A	82522	380R - 67	-
SCALE: NONE			SHEET: 4 OF 7



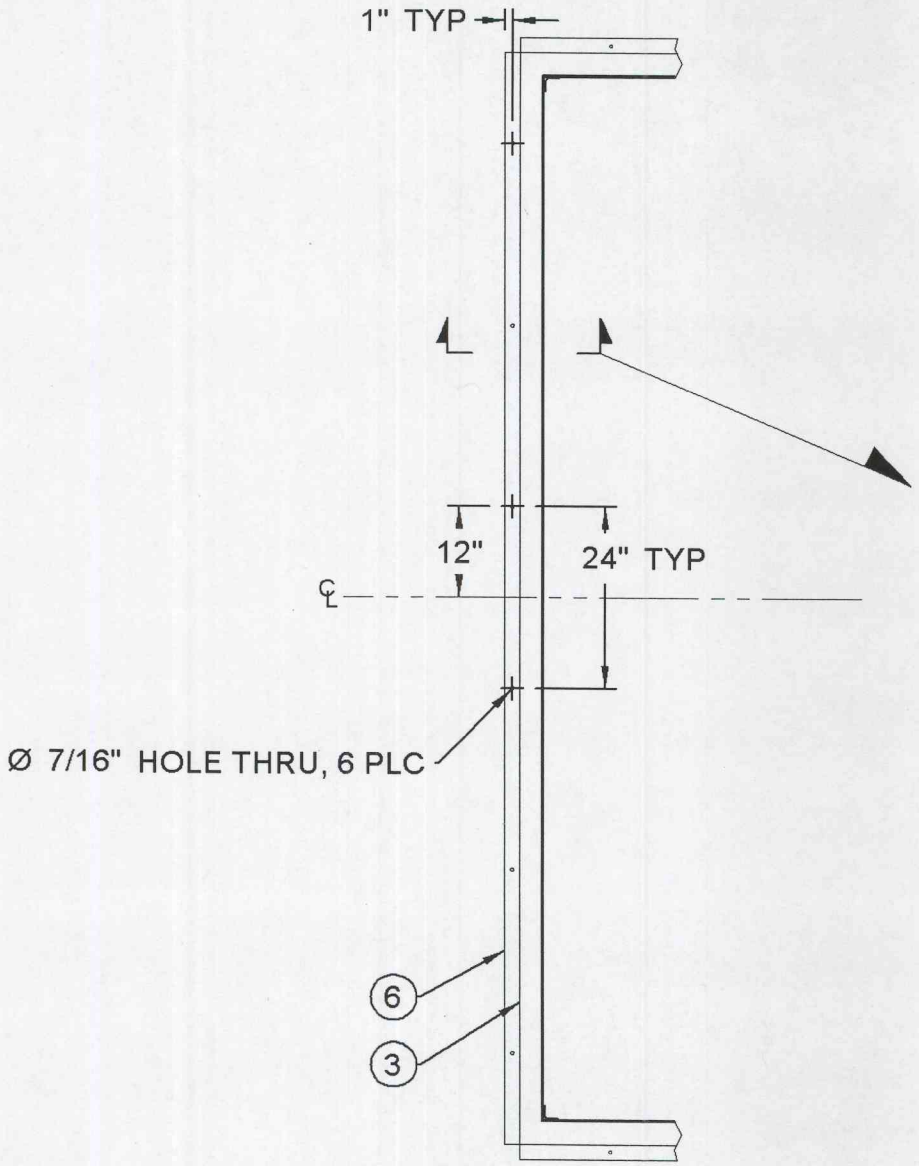
SEC A-A



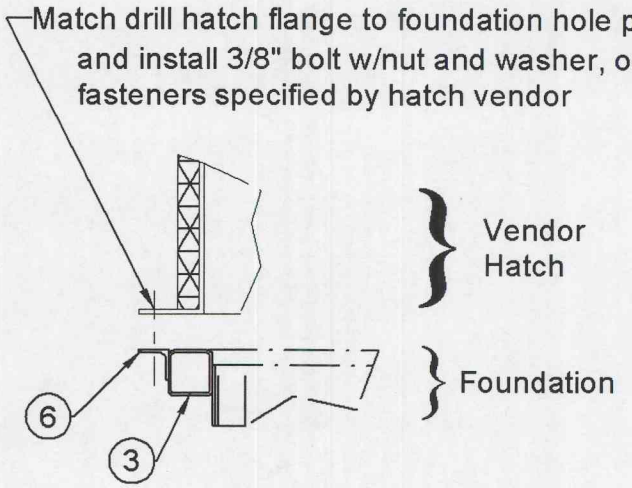
SEC B-B

Pc. 9 not shown

SIZE	CAGE CODE	DWG NO.	REV.
A	82522	380R - 67	-
SCALE: NONE			SHEET: 5 OF 7



Plan View Hatch Mounting Flange
Hatch not shown



Section View Hatch-Foundation Interface

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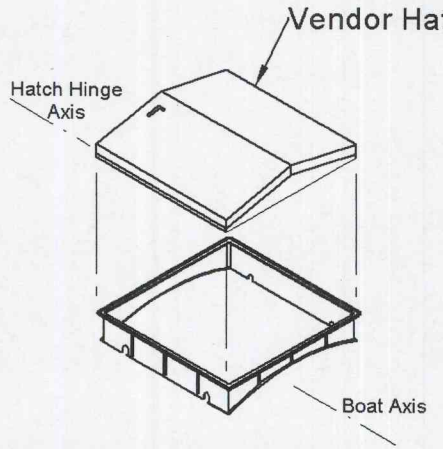
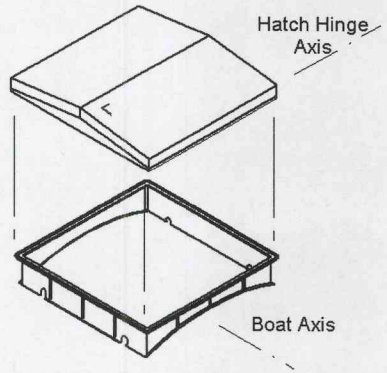
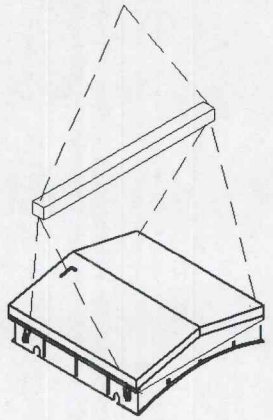


Hatch Oriented Hinge Parallel to Boat Axis

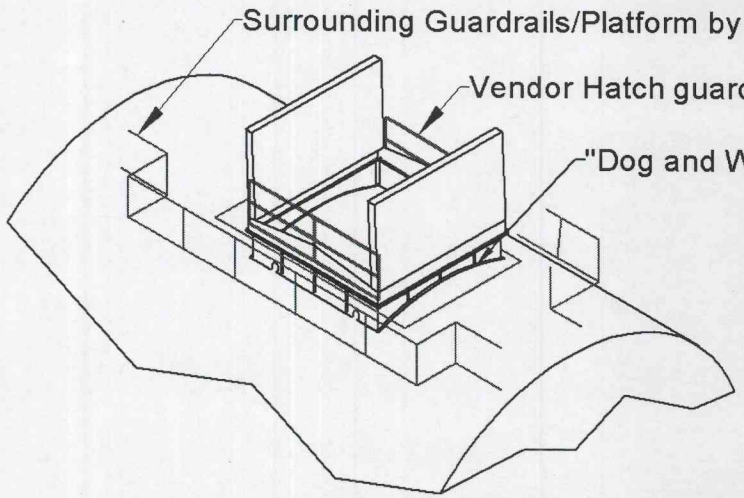


Hatch Oriented Hinge Perpendicular to Boat Axis



ISO View Rigging Assembly

Use spreader/strongback to prevent damage to hatch



ISO View of Assembly in use On Hull

RIGGING, ASSEMBLY, & INSTALLATION

SIZE	CAGE CODE	DWG NO.	REV.
A	82522	380R - 67	-
SCALE: NONE			SHEET: 7 OF 7