

## Scheme of Riveting (To suit Multiple Work)

## KEEL &amp; CENTRE GIRDER.

7/8" dia.	Rivs.	spaced 4" apart	centres in seam of Keel	
1"	"	"	"	" Butts of Keel.
3/4"	"	"	"	" Butts of Centre Girder
7/8"	"	"	"	" Flat plate keel angle (both flanges) where single.
7/8"	"	"	"	" Flat plate Keel angle (both flanges) where double.
3/4"	"	"	"	" Centre Girder Top Angles (4" apart under engines).

## TANK TOP, SHELL &amp; DECK.

7/8" dia.	Rivs.	spaced 4" apart	centres in seams of Shell.	
3/4"	"	"	"	" seams of inner bottom
3/4"	"	"	"	" seams of deck plating.
7/8"	"	"	"	" Butts of Shell.
3/4"	"	"	"	" Butts of Inner Bottom Plating
3/4"	"	"	"	" Butts of Deck Plating (7/8" dia.)
7/8" R @ 4"	on	Shelter deck	amidships	" rivs. spaced 4" apart in butts of shelter deck stringer where exceeding .45
7/8"	"	"	"	" Tank angle.
7/8"	"	"	"	" Frames to Shell not exceeding 6"
7/8"	"	"	"	" Frames to Shell in After Peak on flat of floor fwd. and for .15 L at fore end to Road Line.
3/4"	"	"	"	" Reverse Frames to Tank Top (4.1/8" in way of thrust block and engine seating)
7/8"	"	"	"	" Floors to Frames & reverses throughout
3/4"	"	"	"	" Intercostal Angles to Shell both flanges (4.3/4" for .15 L at Fore End)
3/4"	"	"	"	" Intercostal angles to tank top (both flanges) 4.1/8" in engine space to tank top plating.

## HATCHES.

3/4" dia.	Rivs.	spaced 3.3/8" apart	centres in Butts of Hatch coaming plates	
3/4"	"	"	"	" Hatch Bulk angle stiffeners
3/4"	"	"	"	" Web Slide Bars
3/4"	"	"	"	" Web Mountings
3/4"	"	"	"	" Hatch Side Moulding
3/4"	"	"	"	" Hatch foundation angles
7/8"	"	"	"	" Hatch coaming to B.A. (upper deck)

## WATERTIGHT BULKHEADS

3/4" dia.	Rivs.	spaced 5.1/4" apart	centres in Bulkhead	
7/8"	"	"	"	" Boundary bars to Shell (4.3/8" above load line)
3/4"	"	"	"	" Boundary bar to Bhd.
3/4"	"	"	"	" Foundation bar to Bhd. and Tank Top.
3/4"	"	"	"	" Deck bar to Bhd. & Deck.
3/4"	"	"	"	" Seams, vertical or horizontal
3/4"	"	"	"	" Butts of bulkhead plating.

\* Butts of Shetrone, Shelter deck stringer plate ~ Shelter deck plating .56 over to have 3 Rows @ 3 1/2" or @ 4" or QR @ 4".



# TUNNEL

3/4"	dia.	Rivs.	spaced	5.1/4"	apart	centres	in	Tunnel Stiffs.	✓
3/4"	"	"	"	3.1/2"	"	"	"	Tunnel Foundation	✓
3/4"	"	"	"	3.1/2"	"	"	"	Tunnel seams	✓
3/4"	"	"	"	3.3/8"	"	"	"	Tunnel Butts	✓

# CASINGS

5/8"	dia	Rivs.	spaced	5"	apart	centres	in	casing	stiffs.	✓
5/8"	"	"	"	3.3/4"	"	"	"	"	seams and butts	✓ (not required)
3/4"	"	"	"	3.3/8"	"	"	"	"	casing coaming butts	✓
3/4"	"	"	"	3.3/4"	"	"	"	"	casing foundations	✓

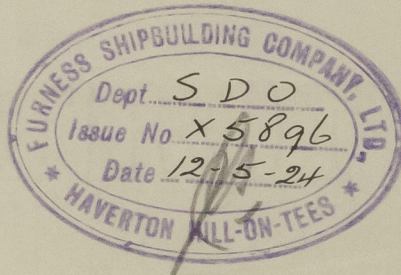
# DECKS

3/4"	dia.	Rivs.	spaced	5.1/4"	apart	centres	in	Deck beams	to deck.	✓
7/8"	"	"	"	4.1/2"	"	"	"	Shelter/gunwale angle (zig-zag in 5 x 5" bar)		
7/8"	"	"	"	4"	"	"	"	Shelter Deck gunwale angle in 3.1/2" x 3.1/2" bar		✓

All rivet spacings above are given in inches, not diameters.

Where 7/8" dia. rivs. are used instead of 3/4" as given above, the

spacing to be proportionately wider. (Subject to the necessity for providing support to the caulking edge of thinned plating)



© 2020

Lloyd's Register  
Foundation

0145 2 1/2