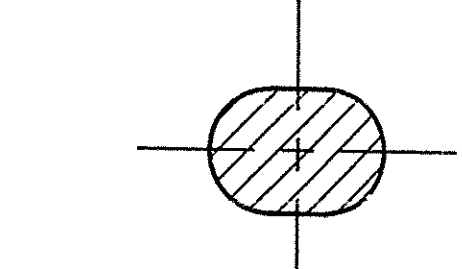
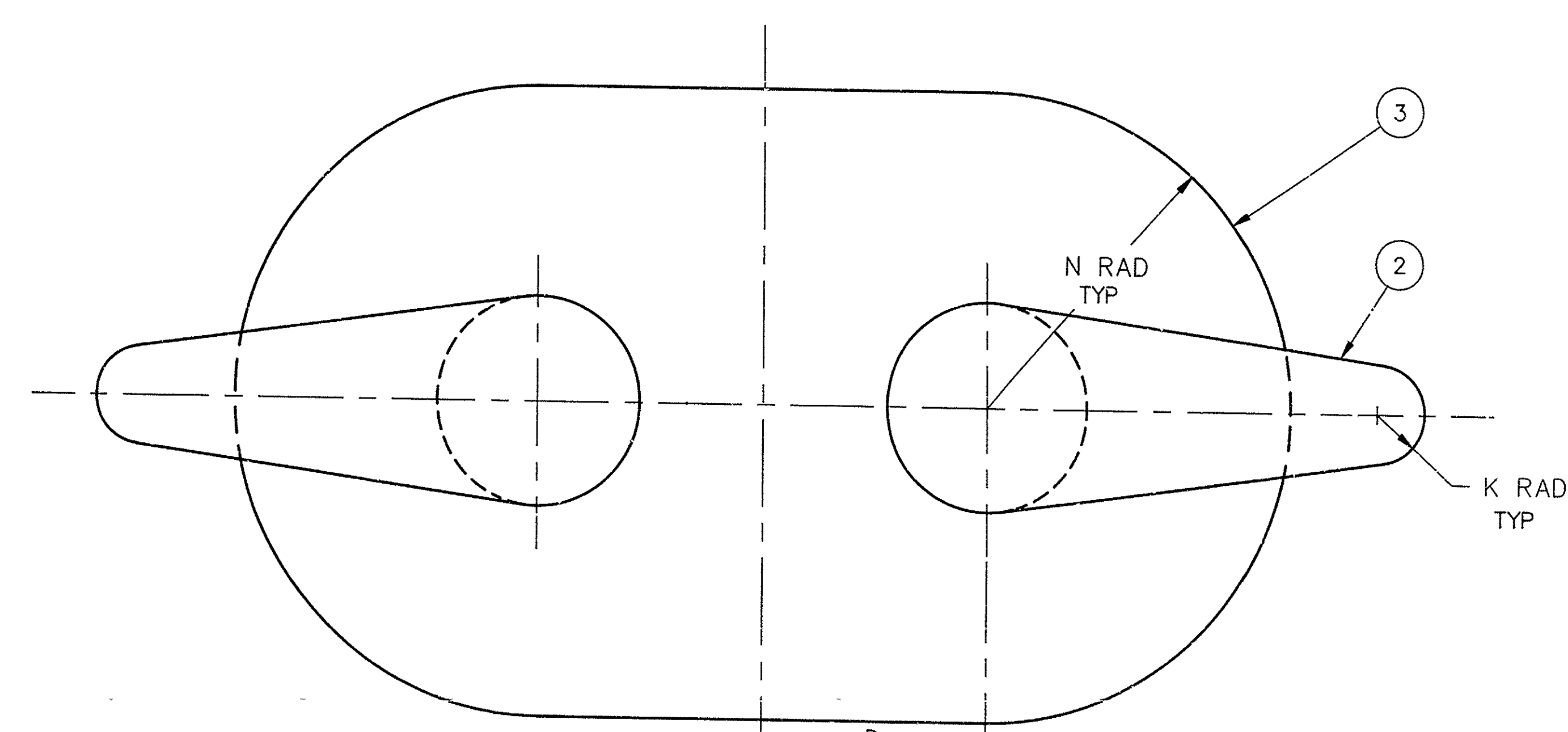


GENERAL NOTES

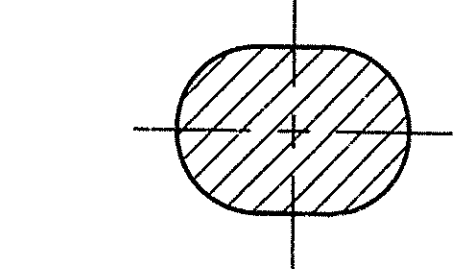
- CLEAT (PC 1) SHALL BE HEAT TREATED TO OBTAIN A MINIMUM TENSILE STRENGTH OF 90,000 PSI (BRINELL HARDNESS 175-200).
- ALL CHAFING SURFACES AND WELDS IN WAY OF ROPE CONTACT SHALL HAVE A 125 MICRO-INCH FINISH IAW ANSI B46.1.
- PRIOR TO ZINC COATING (NOTE 8), CLEAT (PC 1) SHALL BE 100% MAGNETIC PARTICLE (MT) INSPECTED IAW MIL-STD-271 WITH ACCEPTANCE STANDARDS IAW NAVSEA 0900-LP-003-8000, CLASS 3.
- WELDING & STRESS RELIEF
 - WELDING AND STRESS RELIEF OF CLEAT WELDMENT (PC 1) SHALL BE IAW MIL-STD-278, CLASS M-2, CATEGORY A.
 - WELDING OF CLEAT (PC 1) TO SHIP STRUCTURE SHALL BE IAW MIL-STD-1689.
- ALL WELDS SHALL BE 100% MAGNETIC PARTICLE (MT) INSPECTED IAW MIL-STD-271 WITH ACCEPTANCE STANDARDS IAW NAVSEA 0900-LP-003-8000, CLASS 3. WELDS OF PCS 2 & 3 SHALL BE MAGNETIC PARTICLE (MT) INSPECTED PRIOR TO ZINC COATING (NOTE 8).
- APPLICABLE WIRE ROPE SHALL BE TYPE 1, CLASS 3, 6 X 37, IMPROVED PLOW STEEL, FIBER CORE WIRE ROPE IAW RR-W-410.
- WHEN FITTING CLEATS TO DECK OR STRUCTURE, CARE SHALL BE TAKEN THAT STIFFNESS OF PLATING IS SUFFICIENT TO DEVELOP FULL STRENGTH OF CLEAT WITHOUT BUCKLING, OTHERWISE SUITABLE INSERT PLATES OR DOUBLERS AND STIFFENING OF STRUCTURE SHALL BE PROVIDED.
- CLEAT (PC 1) SHALL BE ZINC-COATED AFTER STRESS RELIEF AND NDT (NOTES 3, 4a AND 5). THE COATING MAY BE APPLIED BY EITHER THE HOT-DIP PROCESS IAW ASTM A153, THE MECHANICAL DEPOSITED PROCESS IAW ASTM B695, CLASS 25, TYPE II, OR THE ELECTRODEPOSITED PROCESS IAW ASTM B633, CLASS FE/ZN25, TYPE II AT THE MANUFACTURER'S OPTION.
- APPLICABLE FIBER ROPE MAY BE NYLON, POLYESTER OR MANILA ROPE WITH BREAKING STRENGTH NOT GREATER THAN CORRESPONDING CLEAT TEST LOAD SHOWN IN THE TABLE ON THIS DRAWING.

CLEAT SIZE	THE LARGEST APPLICABLE FIBER ROPE CROMF SEE NOTE 9	THE LARGEST APPLICABLE WIRE ROPE DIA SEE NOTE 6	CLEAT DIMENSIONS																WT (LBS)	CLEAT TEST LOAD (LBS)
			A	B	C	D	E	F	G	H	J	K	L	M	N	P	R			
5	1	—	5	1 1/4	15/16	13/16	7/8	3/32	5/16	9/16	15/16	3/8	1/8	3/8	5/16	1/16	3/16	1.50	2,700	
6 1/2	1 5/16	—	6 1/2	1 5/8	1 1/4	2 3/8	1 1/8	1 1/8	13/32	11/16	7/4	3/16	7/16	11/16	1/8	3/16	3.00	5,200		
8	1 1/2	1/4	8	2 1/2	2 1/4	1 1/4	5/32	1/2	7/8	1 1/2	5/16	3/16	1/2	1 7/8	1/8	3/16	4.50	6,900		
10	1 3/4	5/16	10	2 1/2	1 7/8	3 3/8	1 1/2	3/16	5/8	1 1/16	7/8	3/8	1/4	9/16	2 1/4	1/8	1/4	7.50	9,000	
12	2	3/8	12	3 2 1/4	4	1 3/4	7/32	3/4	5/16	2 1/4	7/16	1/4	5/8	2 5/8	3/16	1/4	11.25	12,200		
14	2 1/2	7/16	14	3 1/2	2 5/8	4 3/4	2 1/8	1/4	7/8	1 1/2	2 5/8	1/2	5/16	3 3/4	3/16	1/4	20.0	18,400		
16	3	9/16	16	4 3/4	3 5/2	2 1/2	5/16	1	1 3/4	3	5/8	3/8	7/8	3 3/4	3/16	3/8	32.0	27,000		
18	3 1/2	5/8	18	4 1/2	3 3/8	6 1/8	2 3/4	11/32	1 1/8	2	3 3/8	11/16	1/4	1	4 1/8	1/4	3/8	44.0	36,000	
20	4	3/4	20	5 3/4	4 7/8	3 1/8	3/8	1 1/4	2 1/8	3 3/4	13/16	1/4	1 1/8	4 11/16	1/4	1/2	63.0	48,000		
22	4 1/2	3/4	22	5 1/2	4 1/8	7 5/8	3 1/2	7/16	1 3/8	2 3/8	4 1/8	7/8	1 1/4	5 1/4	1/4	1/2	88.0	60,000		
24	5	7/8	24	6 4 1/2	8 3/8	3 7/8	1 1/2	1 1/2	2 5/8	4 1/2	1	5/16	1 3/8	5 13/16	1/4	5/8	118.0	73,000		
26	5 1/2	1	26	6 1/2	4 7/8	9 1/8	4 1/4	17/32	1 5/8	2 7/8	4 7/8	1 1/16	5/16	1 1/2	6 3/8	3/8	5/8	155.0	90,000	
30	6	1 1/8	30	7 1/2	5 5/8	10 3/8	4 3/4	9/16	1 7/8	3 1/4	5 5/8	1 1/8	3/8	1 5/8	7 1/8	3/8	3/4	215.0	106,000	
34	6 1/2	1 1/8	34	8 1/2	6 3/8	11 1/2	5 1/4	5/8	2	3 3/4	6 3/8	1 1/4	3/8	1 3/4	7 11/16	3/8	3/4	275.0	123,000	

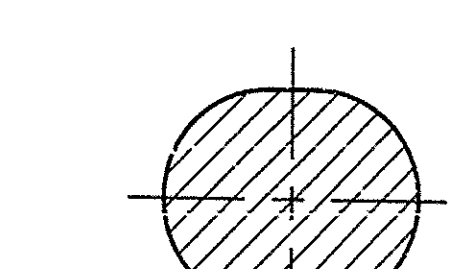
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
A		COMPLETELY REDRAWN		



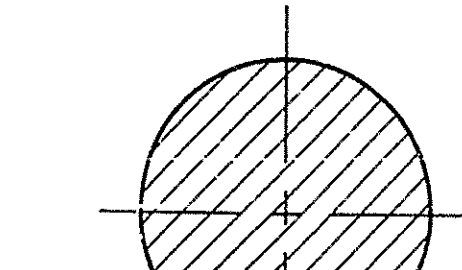
SECTION D-D



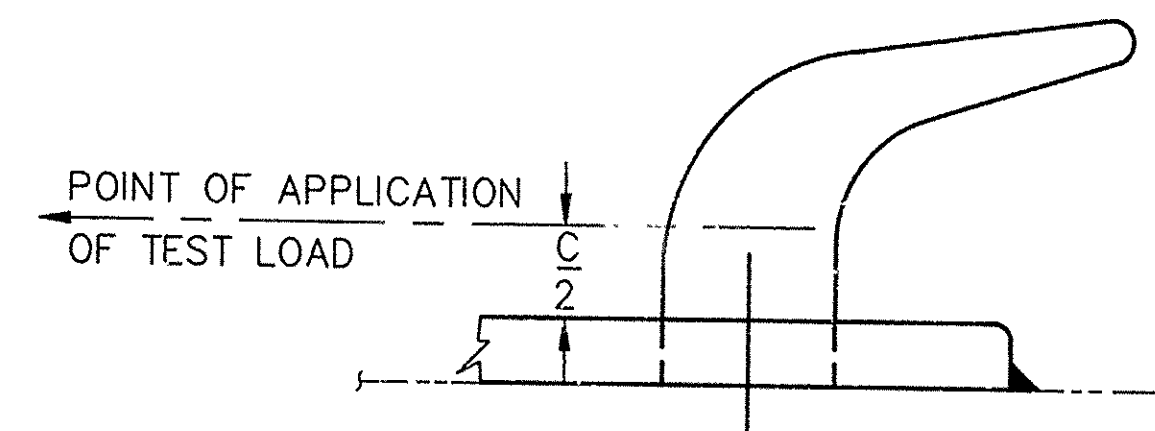
SECTION C-C



SECTION B-B



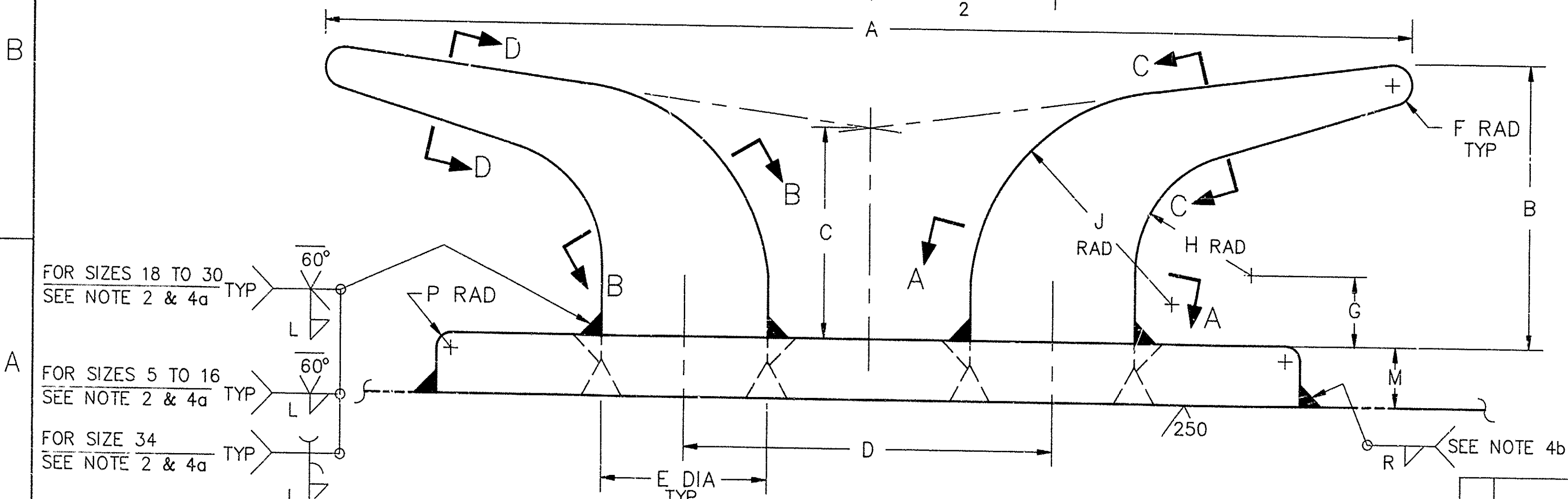
SECTION A-A



TEST DIAGRAM

NO REQ	PC NO	DESCRIPTION	MATERIAL	MATL SPEC	REMARKS	REF DWG
1	3	BASE PLATE	STL ALLOY	ASTM A829 GR4130 COND M AR		
2	2	HORN	FORGED STL ALLOY	ASTM A322 GR 4130		
1	1	CLEAT, WELDMENT	STEEL		CONSISTS OF PCS 2 & 3 SEE NOTE 1	

PARTS LIST



DETAIL 6-A CLEAT, WELDMENT

SUPERSEDES DWG NO. S1201-921572

TYPE DRAWING

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UNLESS OTHERWISE NOTED, DIMENSIONS ARE IN INCHES

TOLERANCES ARE IN ACCORDANCE WITH COMMERCIAL PRACTICE UNLESS OTHERWISE INDICATED ON DRAWING.

CONTRACT NO. N00024-85-D-4408
PREP ACTIVITY W. ROSENBLATT & SON 03675

CHASN SYD PREPARED 6/28/63
WEB 6/28/63
CHECKED ML 6/28/63
HD ENGR

NAVY APPROVAL
PROJ ENGR
DR. HD LW HALSALL 6/28/63
DIV. DIR WH OADIVER 6/28/63
SUBGRP DIR R.E. LAPIN 6/28/63
APPD FOR COMNAVSEA R.E. LAPIN 6/28/63

DEPARTMENT OF THE NAVY WASHINGTON, D.C. 20362-5101
NAVAL SHIP SYSTEMS COMMAND

CLEATS WELDED HORN TYPE

SCALE: NONE | MASS (WEIGHT)

NO 80064 804 DRAWING NO. 2276338 REV A

SHEET 1 OF 1

NO	DRAWING TITLE	DWG NO
	REFERENCE DRAWING(S)	