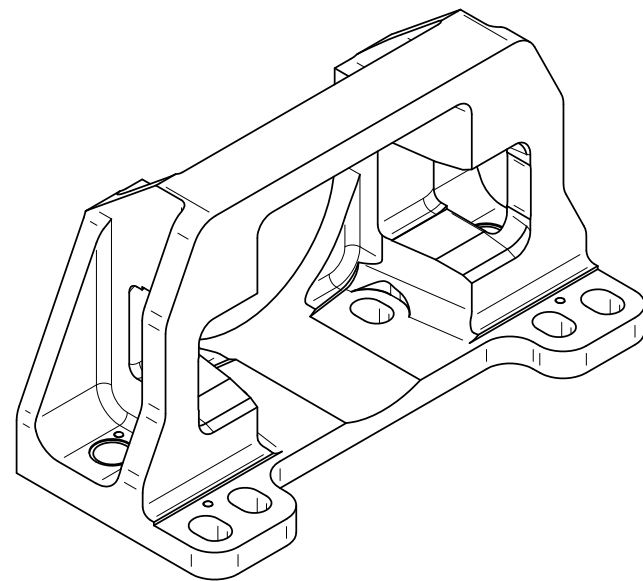
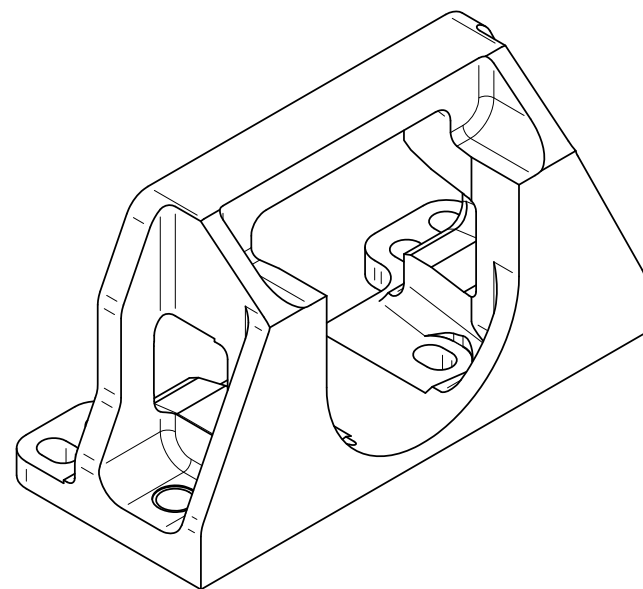


ISOMETRIC VIEW OF ROUGH MACHINING
(SEE SHT 5)



ISOMETRIC VIEW OF FINAL MACHINING



REVERSE ISOMETRIC VIEW OF FINAL MACHINING

PROCESS NOTES:-

MATERIAL SUPPLY:

1. MATERIAL TO BE IN ACCORDANCE WITH: BS EN 10083-3 GR 1.6582 OR PD970 GR 817M40 REFER TO NOTE 10 FOR FINAL MATERIAL CONDITION POST HEAT TREATMENT.
2. MATERIAL TO BE SUPPLIED IN FORGED, PLATE OR BAR FORM AND ULTRASONICALLY TESTED IN ACCORDANCE WITH BS EN 10308 OR BS EN 10228-3 (AS APPROPRIATE) TO QUALITY CLASS 4.
3. MATERIAL MAY BE SUPPLIED IN QUENCHED AND TEMPERED, OR ANNEALED CONDITION.
4. A CHEMICAL AND MECHANICAL CERTIFICATE IS TO BE SUPPLIED WITH THE MATERIAL.
5. A DESIGN AUTHORITY APPROVED INSPECTION PLAN IS REQUIRED PRIOR TO MANUFACTURE.

ROUGH MACHINING:

6. COMPONENT IS TO BE ROUGH MACHINED TO ACHIEVE A LIMITING RULING SECTION (LRS) OF 100mm PRIOR TO HEAT TREATMENT. DRAWING (AND MODEL) OF SUGGESTED ROUGH MACHINED COMPONENT ARE PROVIDED FOR INFORMATION ONLY (SEE SHEET 5).
7. SUFFICIENT MATERIAL IS TO BE LEFT ON THE ROUGH MACHINED COMPONENT TO CONTROL DISTORTION AND ALLOW FINAL MACHINING SIZES/TOLERANCES TO BE ACHIEVED.
8. ROUGH MACHINING IS TO INCLUDE A TEST BLOCK OF 60 mm SQUARE ALIGNED IN THE ORIENTATION SHOWN ON THIS DRAWING. TEST BLOCK IS TO REMAIN ATTACHED DURING THE HEAT TREATMENT PROCESS AND SEPARATED FOR TENSILE TEST. EXACT DIMENSIONS TO BE AGREED WITH HEAT TREATMENT SUB-CONTRACTOR. BLOCK SHAPE TOLERANCE TO BE IN ACCORDANCE WITH BS EN ISO 6892-1. LOCATION AND PREPARATION OF TEST BLOCK TO BE IN ACCORDANCE WITH BS EN ISO 377 BUT SAMPLE TO BE TAKEN FROM CENTRE OF TEST BLOCK.
9. ROUGH MACHINING IS TO INCLUDE 2 OFF TEST PIECES (COUPONS) FOR THE COATING PROCESS (ADHESION AND HARDNESS TESTS). TYPICAL DIMENSIONS ARE 100mm LONG x 25-40mm WIDE x 2-4mm THICK, ACTUAL DIMENSIONS ARE TO BE AGREED WITH THE COATING SUPPLIER PRIOR TO MANUFACTURE. COATING TEST PIECES TO REMAIN ATTACHED TO THE COMPONENT DURING THE HEAT TREATMENT PROCESS AND REMAIN WITH THE BATCH AFTER SEPARATION.

HEAT TREATMENT:

10. COMPONENT IS TO BE QUENCHED AND TEMPERED TO MEET MATERIAL PROPERTIES DEFINED IN BS EN 10083 OR PD970 AS APPLICABLE, AND NOTE 11, FOR 100mm REDUCED 'LRS'
11. MECHANICAL PROPERTIES TO BE: ULTIMATE STRENGTH (Rm) 850 TO 1100 MPa, 0.2% PROOF STRESS (Re) - 665 MPa MINIMUM, ELONGATION (A) - 12% MINIMUM. FAILURE TO BE DUCTILE. NO IMPACT TESTS ARE REQUIRED.
12. MARK A UNIQUE IDENTIFYING NUMBER ON COMPONENT AND HEAT TREATED TENSILE TEST BLOCK PRIOR TO SEPARATION TO ENSURE TRACEABILITY.
13. TEST BLOCK IS TO BE REMOVED AND A TENSILE TEST PERFORMED IN ACCORDANCE WITH BS EN ISO 6892-1.
14. COATING TEST PIECES ARE TO BE REMOVED AND KEPT WITH THE COMPONENT FOR LATER USE. BAG AND LABEL ALL TEST SAMPLES WITH PART NUMBER, REVISION AND BATCH NUMBER. TEST RESULTS ARE TO BE DOCUMENTED ON A SUITABLE HEAT TREATMENT RECORD.

FINAL MACHINING:

15. COMPONENT IS TO BE FINAL MACHINED TO DRAWING REQUIREMENTS. DATUM 'C' IS TO BE MACHINED, WHILST MAINTAINING A GEOMETRICAL RELATIONSHIP TO DATUMS 'A' AND 'B', AS DEFINED ON THIS DRAWING.
16. ALL DIMENSIONS ARE PRIOR TO COATING, UNLESS OTHERWISE STATED.

17. SURFACE TEXTURE TO BE 6.3 UNLESS OTHERWISE STATED.
18. ALL THREADS TO BS 3643 UNLESS OTHERWISE STATED.
19. REMOVE ALL BURRS AND SHARP EDGES.

20. HARDMARK PART NUMBER AND REVISION WHERE SHOWN THUS \blacklozenge PRIOR TO COATING. ALL CHARACTERS TO BE LEGIBLE POST COATING.
21. ALL UNSPECIFIED INTERNAL FILLET RADIUS TO BE R0.4 MAX

COATING:

22. AUTOCATALYTIC (ELECTROLESS) NICKEL COATING TO BE IN ACCORDANCE WITH BS EN ISO 4527.
23. MASK ALL THREADS PRIOR TO COATING.
24. COATING DESIGNATION IS:
AUTOCATALYTIC NICKEL COATING ISO 4527 - Fe (1.6582) (SR(200)3)/NiP(11.5)100/(ER(190)12)
FOR REFERENCE:
COATING: HIGH PHOSPHOROUS 100±10 MICRONS THICK - NiP(11.5)100
BASE MATERIAL: Fe (1.6582) HARDENED AND TEMPERED
PRE-COATING HEAT TREATMENT: 200°C TO 230°C FOR 3 HRS TO BS ISO 9587 - (SR(200)3) DE-EMBRITTLMENT.
POST-COATING HEAT TREATMENT: 190°C TO 220°C FOR 12 HRS TO BS ISO 9588 - (ER((190)12) DE-EMBRITTLMENT.
25. BATCH TEST SAMPLES ARE PROVIDED FOR:
THERMAL SHOCK TEST OF THE COATING ADHESION; TEST IS TO BE CONDUCTED IN ACCORDANCE WITH BS EN ISO 2819. HEAT SPECIMEN TO 300°C AND QUENCH IN WATER AT ROOM TEMPERATURE. NO SEPARATION OF THE COATING FROM THE BASE MATERIAL SHALL OCCUR.
HARDNESS TEST OF THE COATING; HARDNESS IS TO BE MEASURED, AFTER POST-COATING HEAT TREATMENT, IN ACCORDANCE WITH BS EN ISO 4516.
HARDNESS TO BE BETWEEN 475 HK100 AND 1000 HK100, OR BETWEEN 450 HV AND 1100 HV.
26. ADDITIONAL TEST SHIMS FOR MEASURING COATING THICKNESS AND / OR PHOSPHOROUS CONTENT ARE TO BE PROVIDED BY THE COATING SUPPLIER AS REQUIRED.
27. COATING PHOSPHOROUS CONTENT IS TO BE BETWEEN 10% AND 13%. THIS IS TO BE VERIFIED BY PERFORMING CHEMICAL ANALYSIS ON A SAMPLE OF THE COATING SOLUTION IN ACCORDANCE WITH BS EN ISO 4527 ANNEX D.
28. A CERTIFICATE OF CONFORMITY IS TO BE PROVIDED FOR EACH BATCH. THIS CERTIFICATE IS TO INCLUDE THE FOLLOWING:
DRAWING NUMBER AND REVISION, COATING BATCH NUMBER,
MINIMUM AND MAXIMUM MEASURED COATING THICKNESS,
% PHOSPHOROUS CONTENT (SEVERAL VALUES MAY BE SUBMITTED IF MEASURED AT INTERVALS DURING PROCESSING),
MEASURED HARDNESS VALUE,
ADHESION TEST RESULT (PASS OR FAIL).
29. NO OTHER HEAT TREATMENT PROCESS IS TO BE PERFORMED.
30. SMEAR ALL BARE METAL (UN-COATED) SURFACES WITH GREASE IN ACCORDANCE WITH BABCOCK LUBRICATION SPECIFICATION WSHID019553 APPLICATION 3.

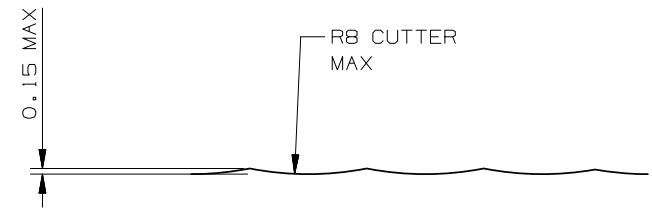
SHEET INDEX	
SHEET No	DESCRIPTION
1	ISO VIEWS & PROCESS NOTES
2,3 & 4	FINAL MACHINING DETAILS
5	ROUGH MACHINING DETAILS
6	ADDITIONAL VIEWS

GENERAL MACHINING	
FROM 0	OVER 30
UP TO 6	UP TO 30
±0.1 ±0.2 ±0.3 ±0.5 ±0.8 ±1.2 ±2.0	
RADII & CHAMFERS	
FROM 0	OVER 3
UP TO 3	UP TO 6
±0.2 ±0.5 ±1.0	
GENERAL FABRICATION	
FROM 2	OVER 400
UP TO 400	UP TO 1000
±1 ±2 ±3 ±4 ±5 ±6 ±7	

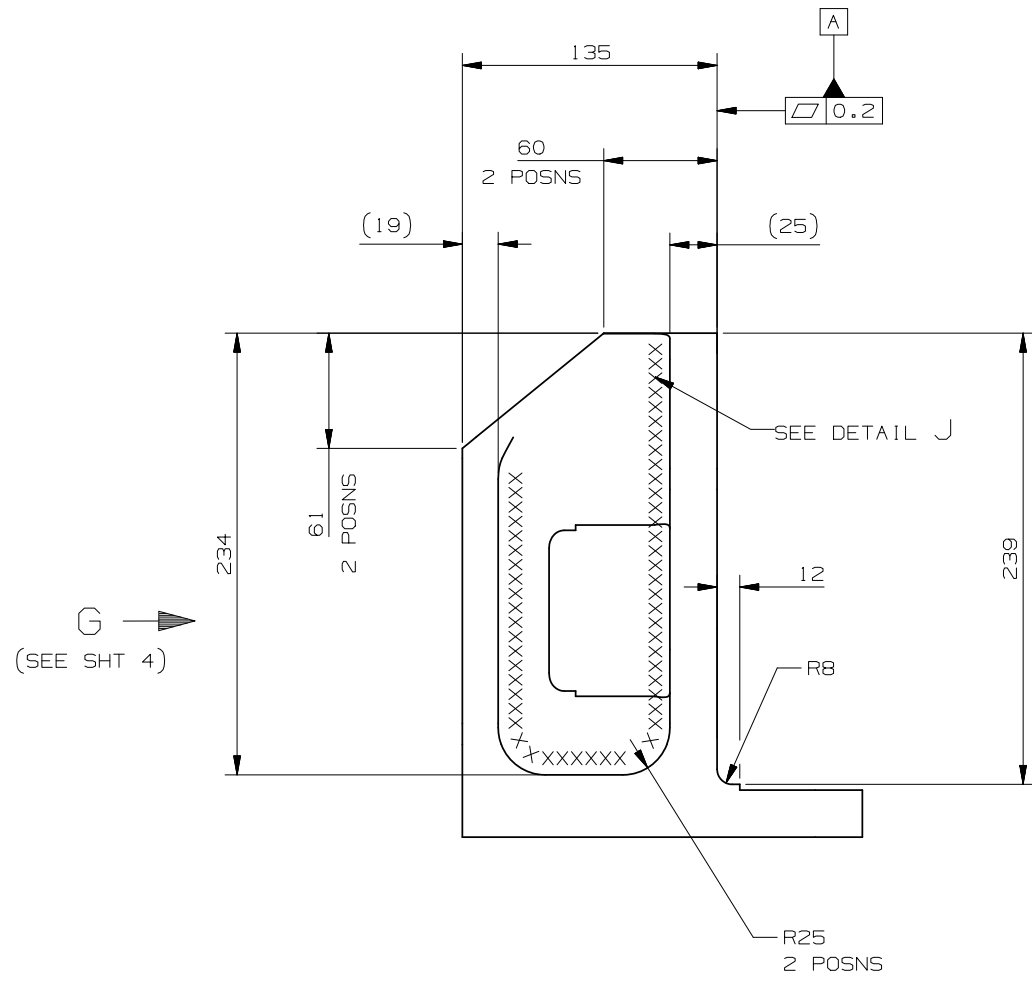
SURFACE FINISH	
3.2	UNFINISHED
Rz VALUE OR BETTER UNLESS OTHERWISE STATED VALUES ARE IN µm	
THIRD ANGLE PROJECTION	

REVISION	DATE	ORIGINATED	CHECKED	APPROVED	CHANGE No.
7	30-Mar-2015	WSH	JAD	JAD	

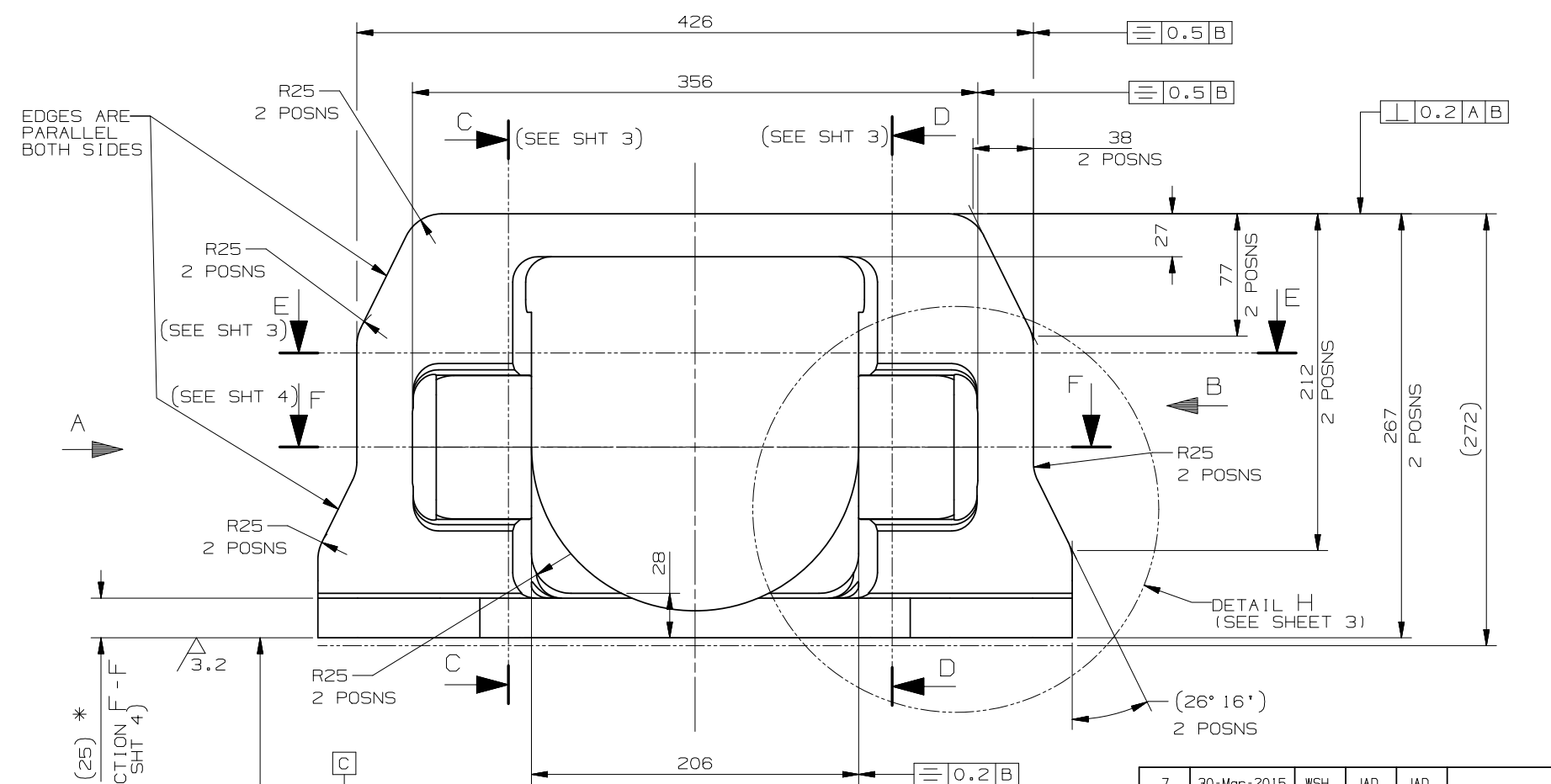
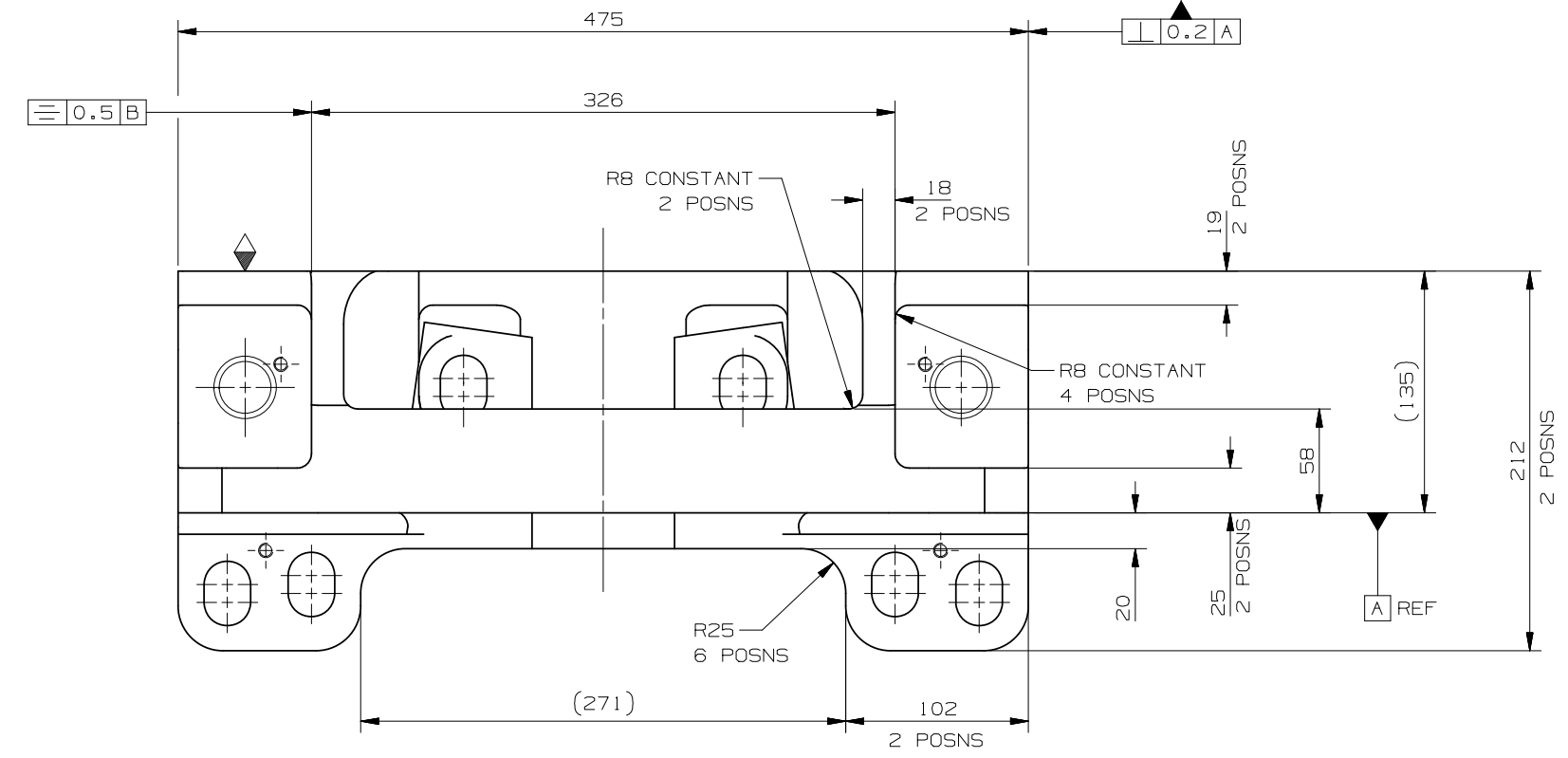
		BABCOCK INTERNATIONAL GROUP DEFENCE SYSTEMS TECHNOLOGY	
BRISTOL T+44 (0)117 9664977 F+44 (0)117 9663025 www.babcockinternational.com		LEICESTER T+44 (0)116 2750750 F+44 (0)116 2750787 www.babcockinternational.com	
TITLE: DECK BLOCK, MACHINED			
DRG / PART NO.	WSH1122219	REVISION	7
CUSTOMER DRG NO.	N/A	REVISION STATUS	Design Released
SHEET OF SHEETS		1 OF 6	
ESTIMATED MASS		44.5kg	
INSPECTION DOCUMENT		EN 10204 - 3.1	
SCALE		N.T.S.	



DETAIL J
SHOWING PERMITTED MACHINED SURFACE
PROFILE ON FACES MARKED THUS XXXX
SCALE 10:1



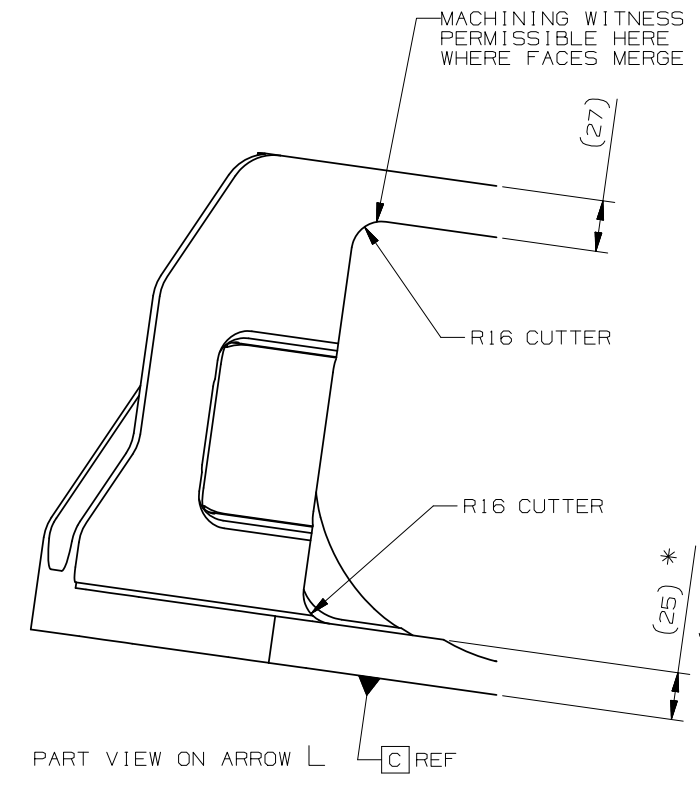
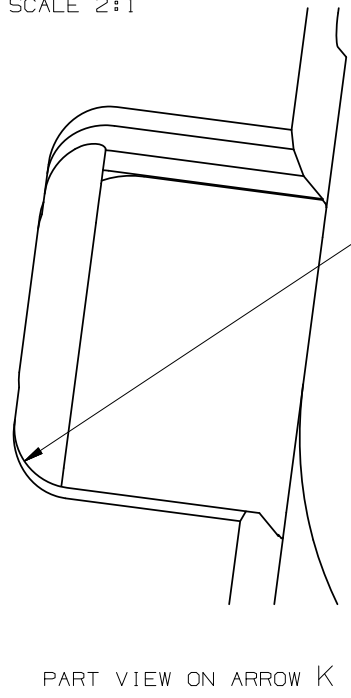
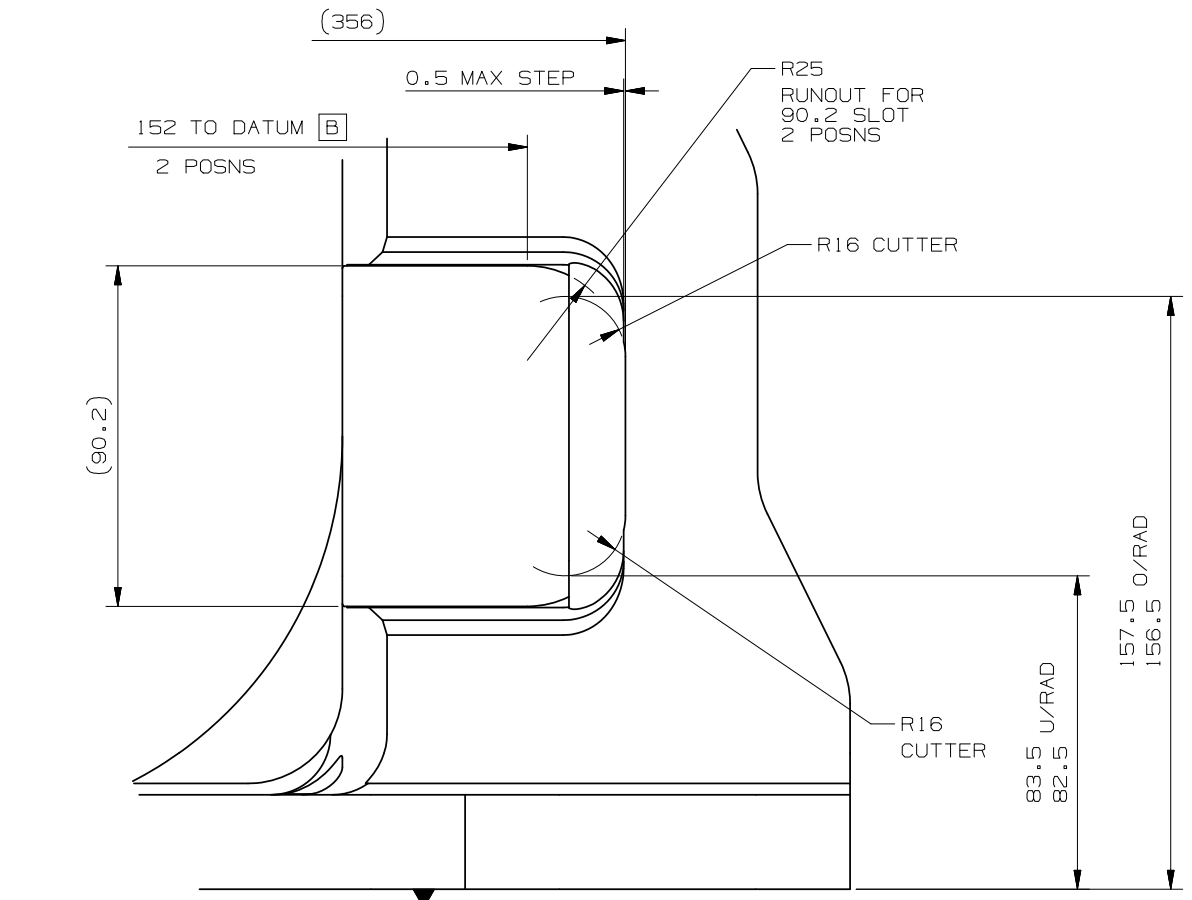
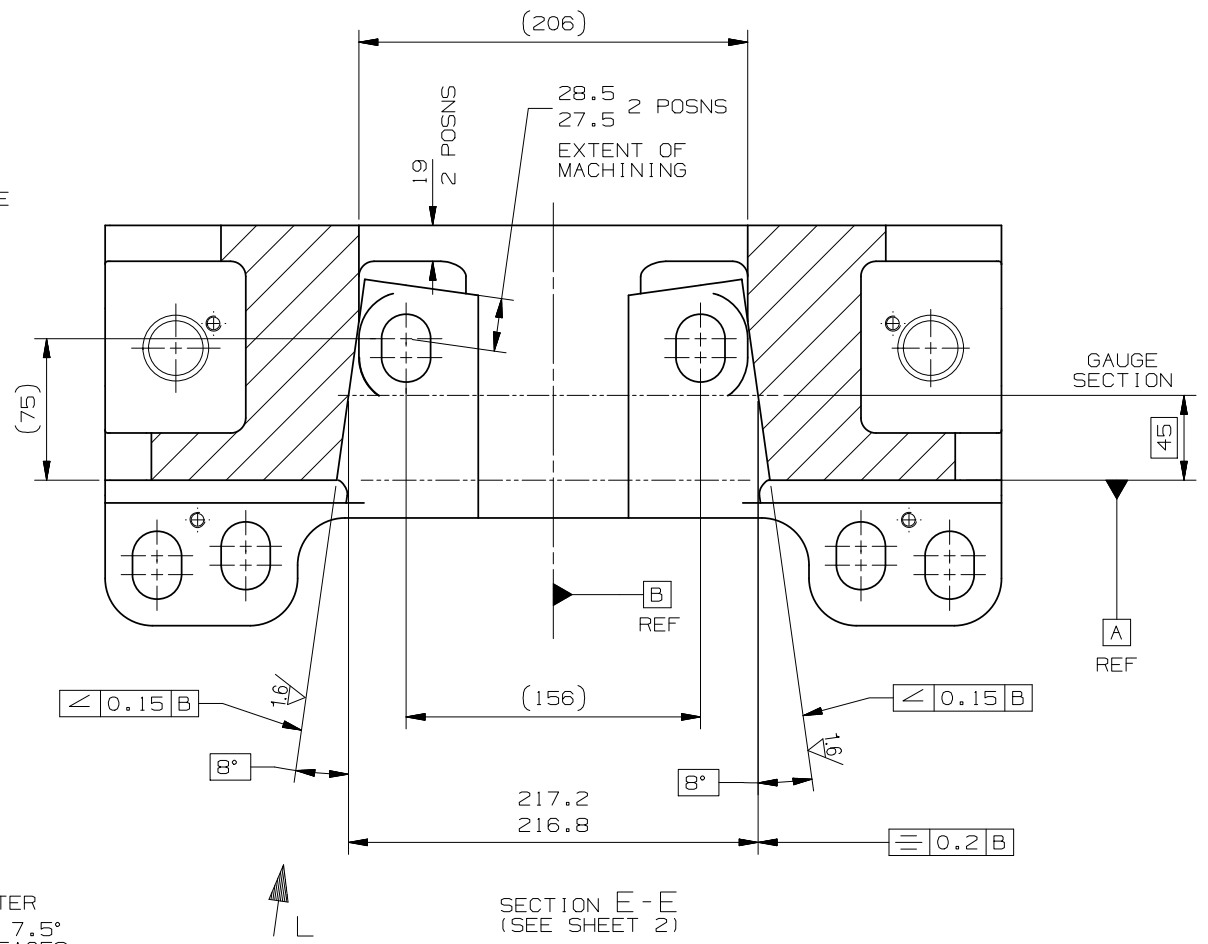
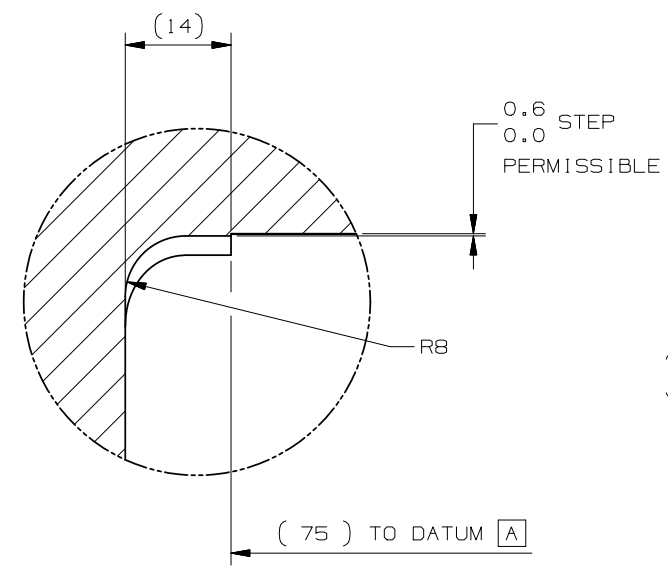
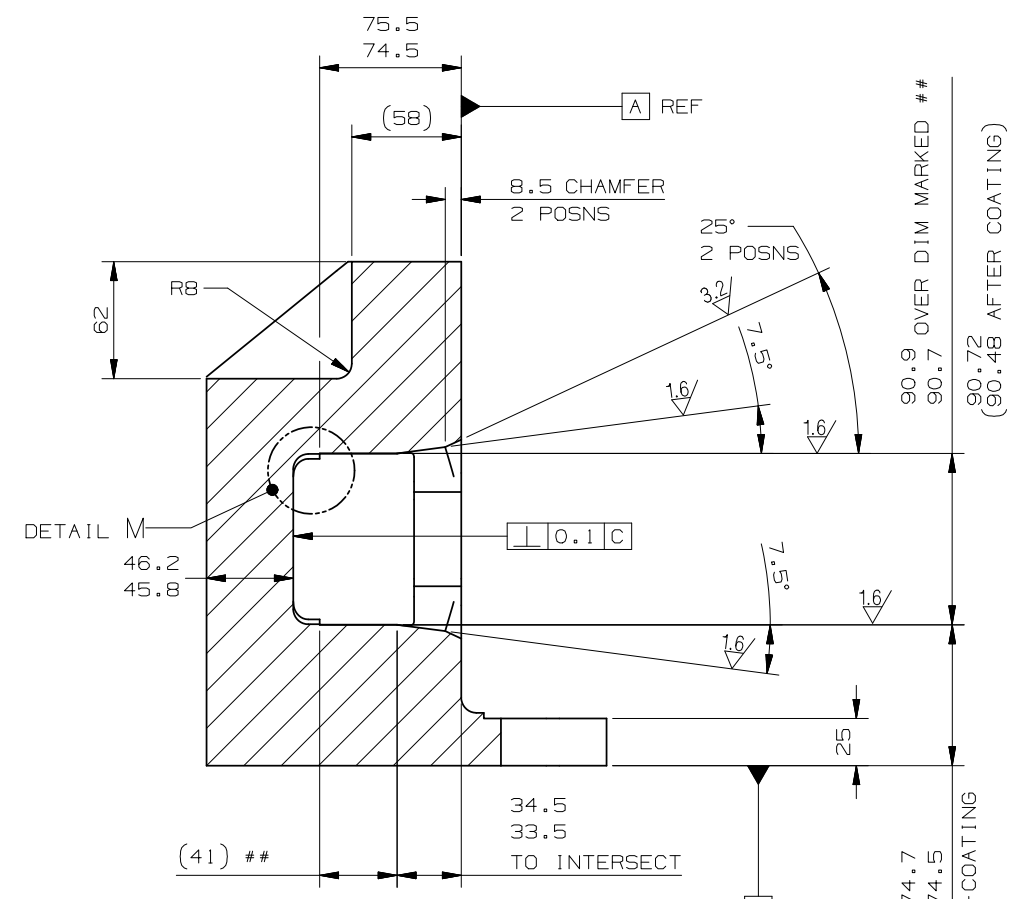
VIEW ON ARROW A
VIEW ON ARROW B SIMILAR



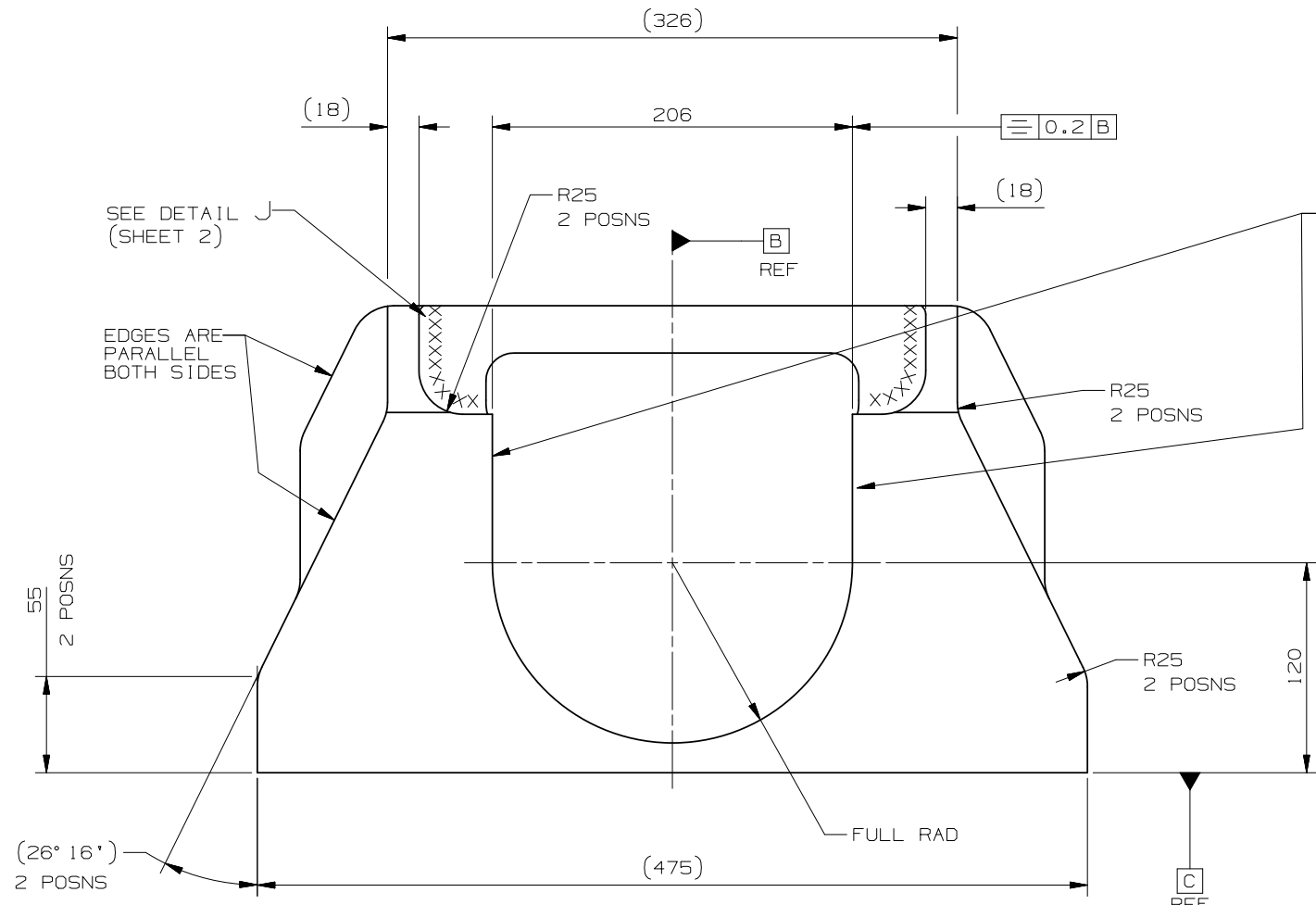
FRONT VIEW

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GENERAL MACHINING		SURFACE TEXTURE TO BS EN ISO 25178-1	
FROM 0 OVER 8 30 120 400 1000 2000	±0.1 ±0.2 ±0.3 ±0.5 ±0.8 ±1.2 ±2.0	3.2 UN/CE	Ra VALUE OR BETTER UNLESS OTHERWISE STATED VALUES ARE IN µm
UP TO 6 UP TO 30 120 400 1000 2000		UN/CE	
RADIUS & CHAMFERS		CUSTOMER AUTHORITY	
FROM 0 OVER 3 6	ANGULAR ±0° 30'	N/A	
UP TO 3 UP TO 6		MATERIAL	
±0.2 ±0.5 ±1.0		SEE NOTES	
GENERAL FABRICATION		SPECIFICATION & GRADE	
FROM 2 OVER 400 1000 2000 4000 8000 20000	THIRD ANGLE PROJECTION	SEE NOTES	
UP TO 400 UP TO 1000 2000 4000 8000 20000		INSPECTION DOCUMENT	
±1 ±2 ±3 ±4 ±5 ±6 ±7		EN 10204 - 3.1	
		SCALE	
		1:2 UOS	
		ESTIMATED MASS	
		44.5kg	

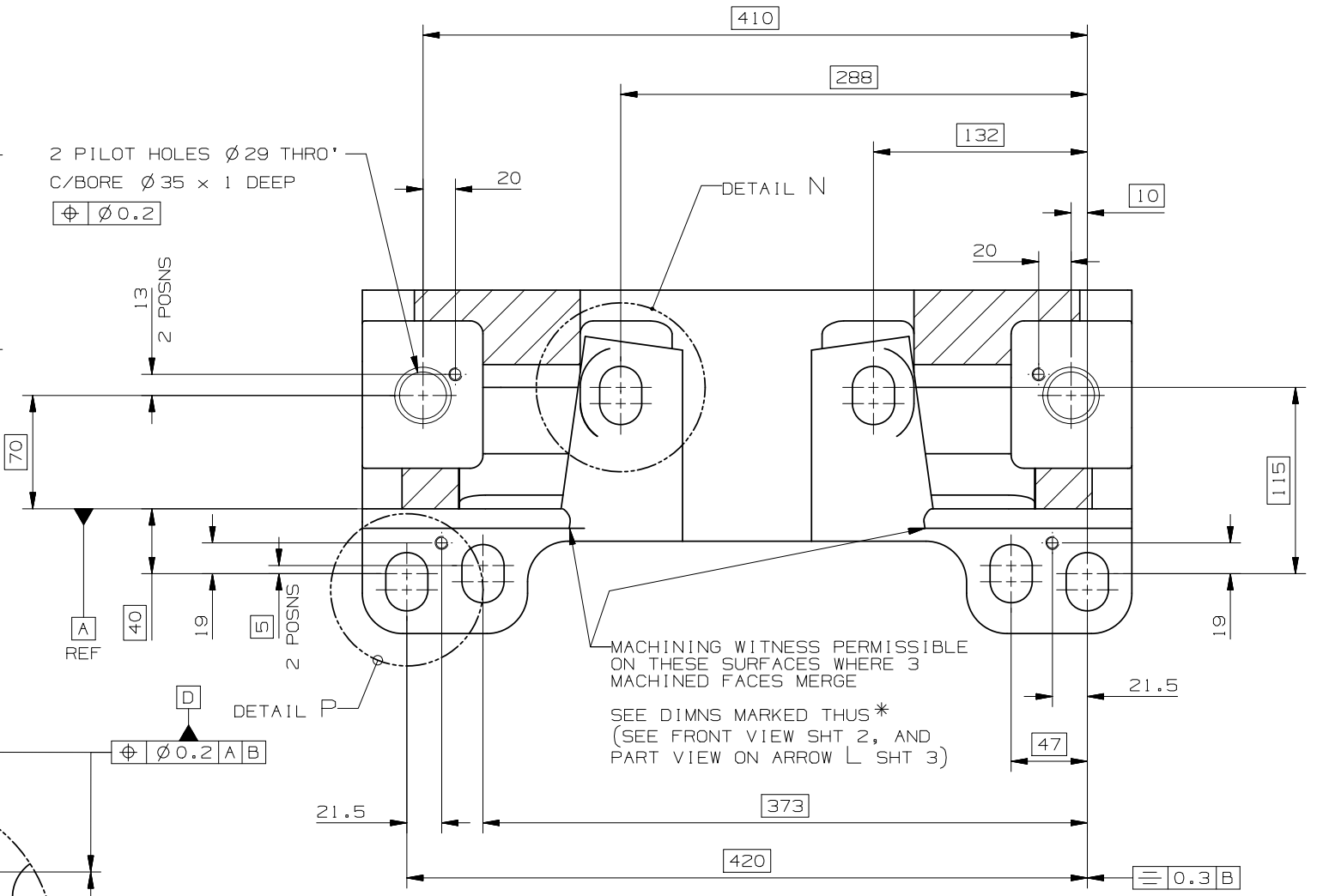
7	30-Mar-2015	WSH	JAD	JAD	
REVISION	DATE	ORIGINATED	CHECKED	APPROVED	CHANGE No.
BABCOCK INTERNATIONAL GROUP DEFENCE SYSTEMS TECHNOLOGY BRISTOL: T144 10117 966497 F144 10118 275079 www.babcockinternational.com LEICESTER: T144 10118 275079 F144 10117 966497 www.babcockinternational.com					
TITLE					
DECK BLOCK, MACHINED					
DRG / PART NO.					
WSH1122219					
REVISION					
7					
SHEET OF SHEETS					
2 OF 6					
REVISION STATUS					
Design Released A1					
CUSTOMER DRG NO.					
N/A					
SECURITY CLASSIFICATION					
COMMERCIAL IN CONFIDENCE					



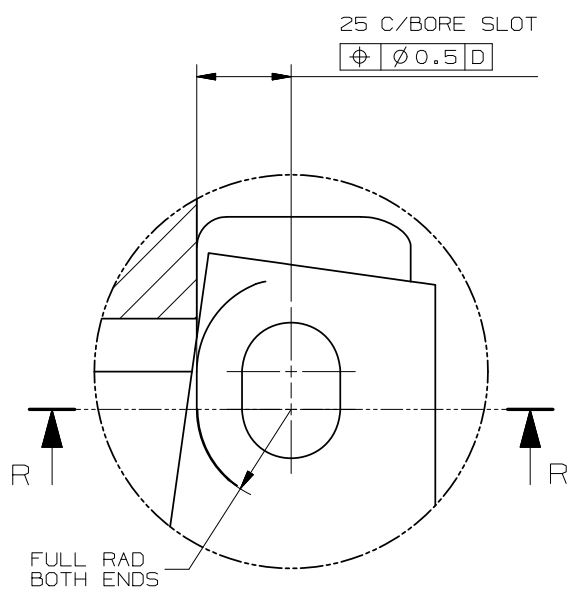
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GENERAL MACHINING		SURFACE TEXTURE TO BS EN ISO 25178-1		CUSTOMER AUTHORITY		TITLE		BABCOCK INTERNATIONAL GROUP DEFENCE SYSTEMS TECHNOLOGY							
FROM 0	OVER 8	30	120	400	1000	2000	3.2	UNFINISHED	N/A		DECK BLOCK, MACHINED				
UP TO 6	UP TO 30	120	400	1000	2000		Ra VALUE OR BETTER UNLESS OTHERWISE STATED VALUES ARE IN µm	SEE NOTES							
±0.1		±0.2		±0.3		±0.5		±0.8		±1.2		±2.0			
RADI1 & CHAMFERS		ANGULAR		±0° 30'		GENERAL FABRICATION		THIRD ANGLE PROJECTION		SPECIFICATION & GRADE		SEE NOTES			
FROM 0	OVER 3	6			FROM 2		OVER 400	1000	2000	4000	8000	20000	INSPECTION DOCUMENT	SCALE	ESTIMATED MASS
UP TO 3	UP TO 6				UP TO 400	UP TO 1000	2000	4000	8000	20000			EN 10204 - 3.1	1:2 UOS	44.5kg
±0.2		±0.5		±1.0		±1		±2		±3		±4		±5	
±1		±2		±3		±4		±5		±6		±7		±8	
DR7 / PART NO.		WSHI122219		REVISION		7		SHEET OF SHEETS		3 OF 6		CUSTOMER DRG NO.		N/A	
REVISION STATUS		Design Released		SIZE		A1		SECURITY CLASSIFICATION		COMMERCIAL IN CONFIDENCE					



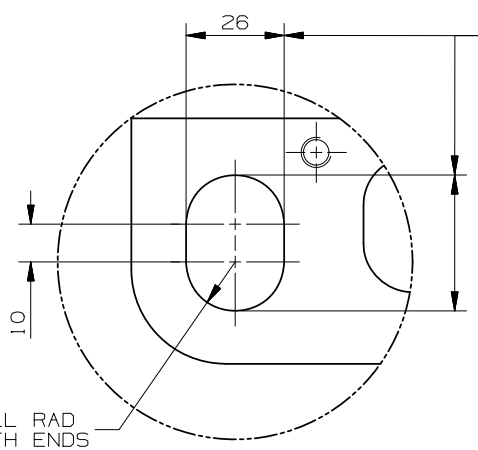
VIEW ON ARROW G
SHOWING REAR FLANGE DETAILS
(SEE SHEET 2)



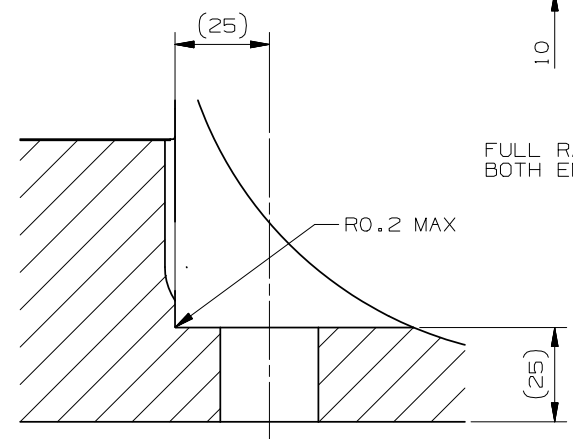
SECTION F-F
(SEE SHEET 2)



DETAIL N
2 OFF C/BORE SLOTS
SCALE 1:1



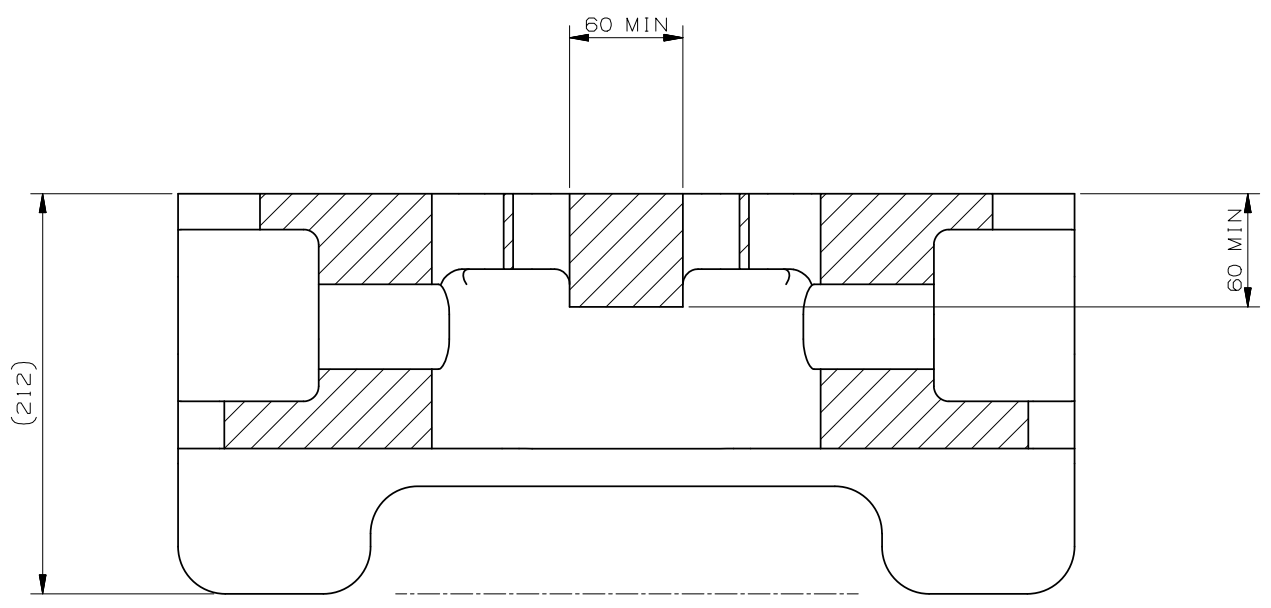
DETAIL P
SHOWING TYPICAL SLOT DETAIL
SCALE 1:1



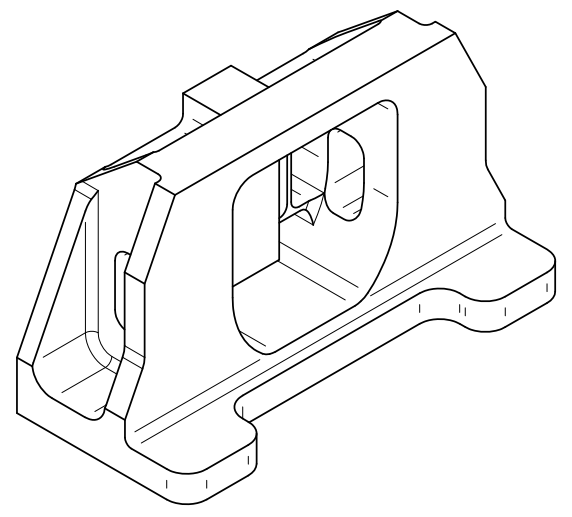
PART SECTION R-R

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GENERAL MACHINING		SURFACE TEXTURE TO BS EN ISO 25178-1		CUSTOMER AUTHORITY		TITLE			
FROM 0	OVER 6	30	120	400	1000	2000	N/A		BABCOCK INTERNATIONAL GROUP DEFENCE SYSTEMS TECHNOLOGY
UP TO 6	UP TO 30	120	400	1000	2000	MATERIAL		BRISTOL T144 10117 966497 F144 10118 275079 www.babcockinternational.com	
RADI1 & CHAMFERS		ANGULAR ±0°30'		SPECIFICATION & GRADE		DRG / PART NO.			REVISION
FROM 0	OVER 3	6	SEE NOTES		SEE NOTES		WSH1122219	7	4 OF 6
UP TO 3	UP TO 6	Rz VALUE OR BETTER UNLESS OTHERWISE STATED VALUES ARE IN µm		INSPECTION DOCUMENT		CUSTOMER DRG NO.		REVISION STATUS	SIZE
±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	N/A	Design Released	A1
GENERAL FABRICATION		THIRD ANGLE PROJECTION		SCALE		ESTIMATED MASS		SECURITY CLASSIFICATION	
FROM 2	OVER 400	1000	2000	4000	8000	20000	1:2 UOS	44.5kg	COMMERCIAL IN CONFIDENCE
UP TO 400	UP TO 1000	2000	4000	8000	20000	±1			

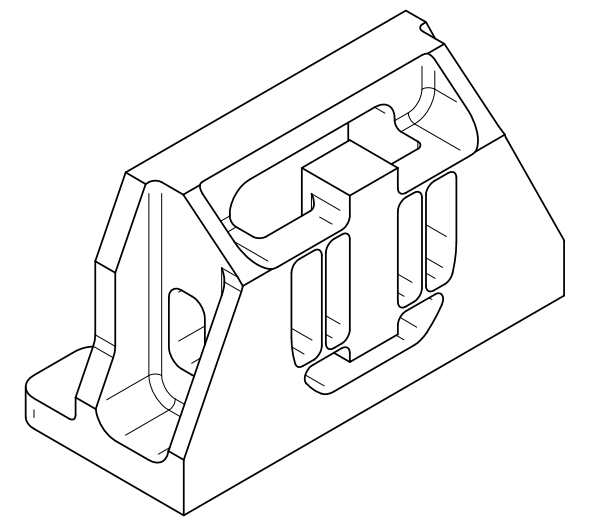
SECURITY CLASSIFICATION
COMMERCIAL IN CONFIDENCE



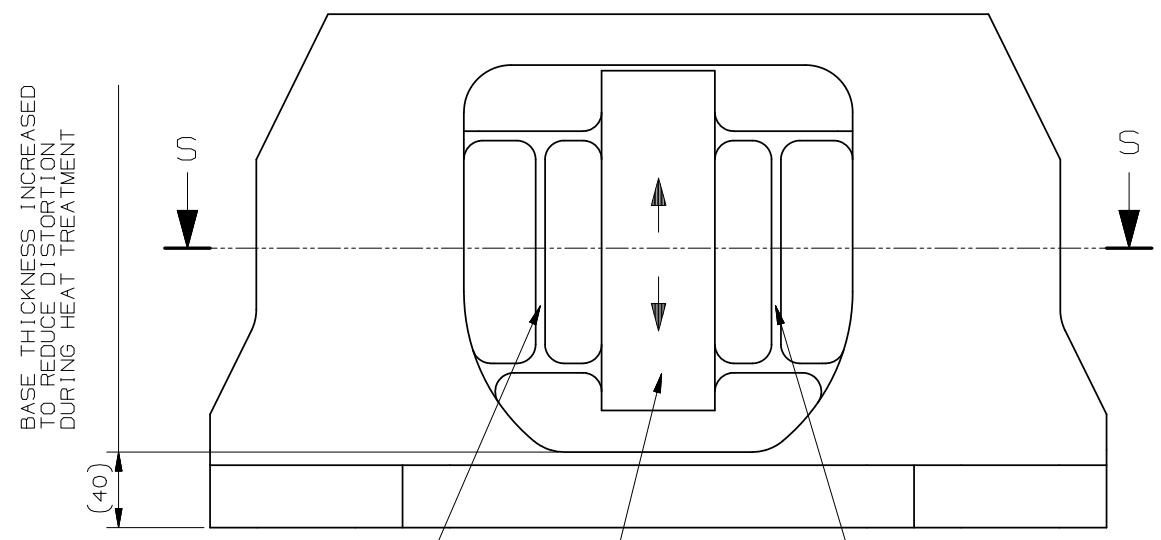
SECTION S-S



REPEAT ISOMETRIC VIEW OF ROUGH MACHINING N.T.S.



REVERSE ISOMETRIC VIEW OF ROUGH MACHINING N.T.S.

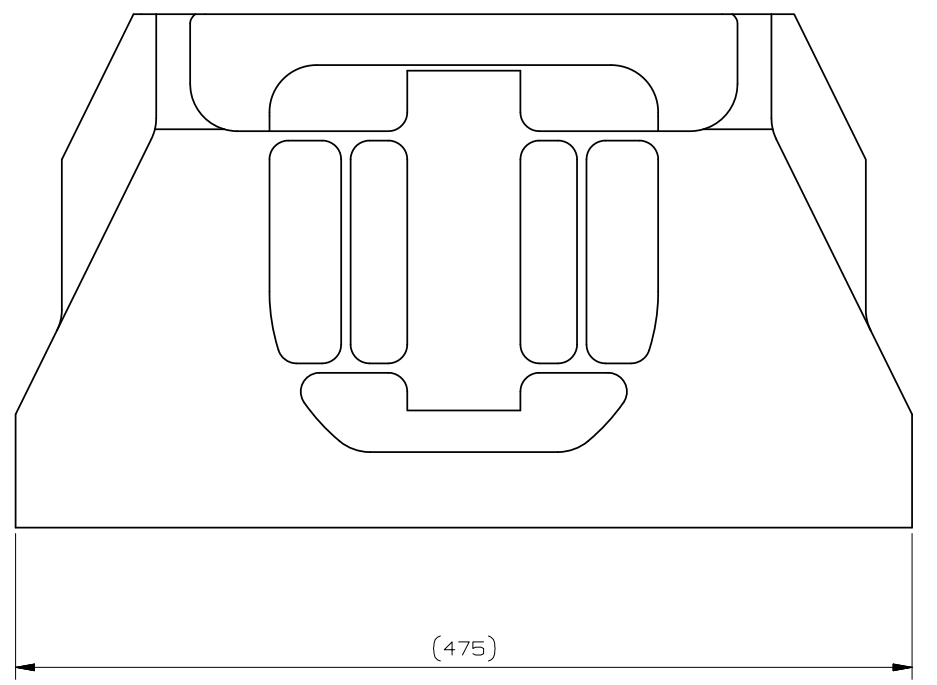
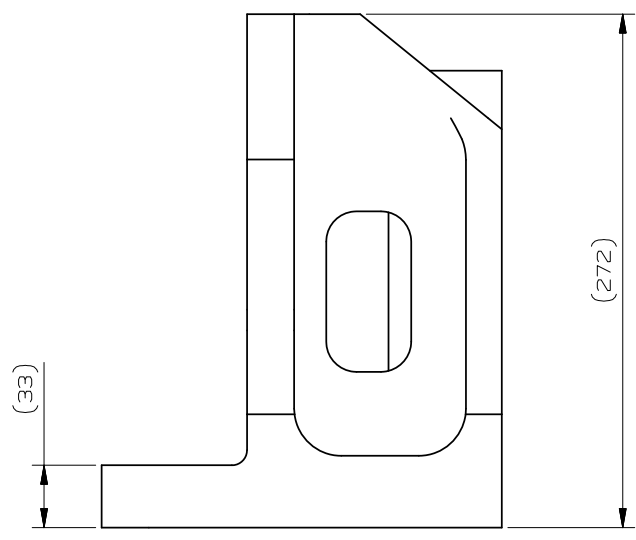


BASE THICKNESS INCREASED TO REDUCE DISTORTION DURING HEAT TREATMENT

TEST SAMPLE FOR COATING

TEST SAMPLE FOR COATING

60 MIN SQ. VERTICAL BLOCK FOR TENSILE TESTING AFTER HEAT TREATMENT. ARROWS INDICATE DIRECTION OF TENSILE TEST.



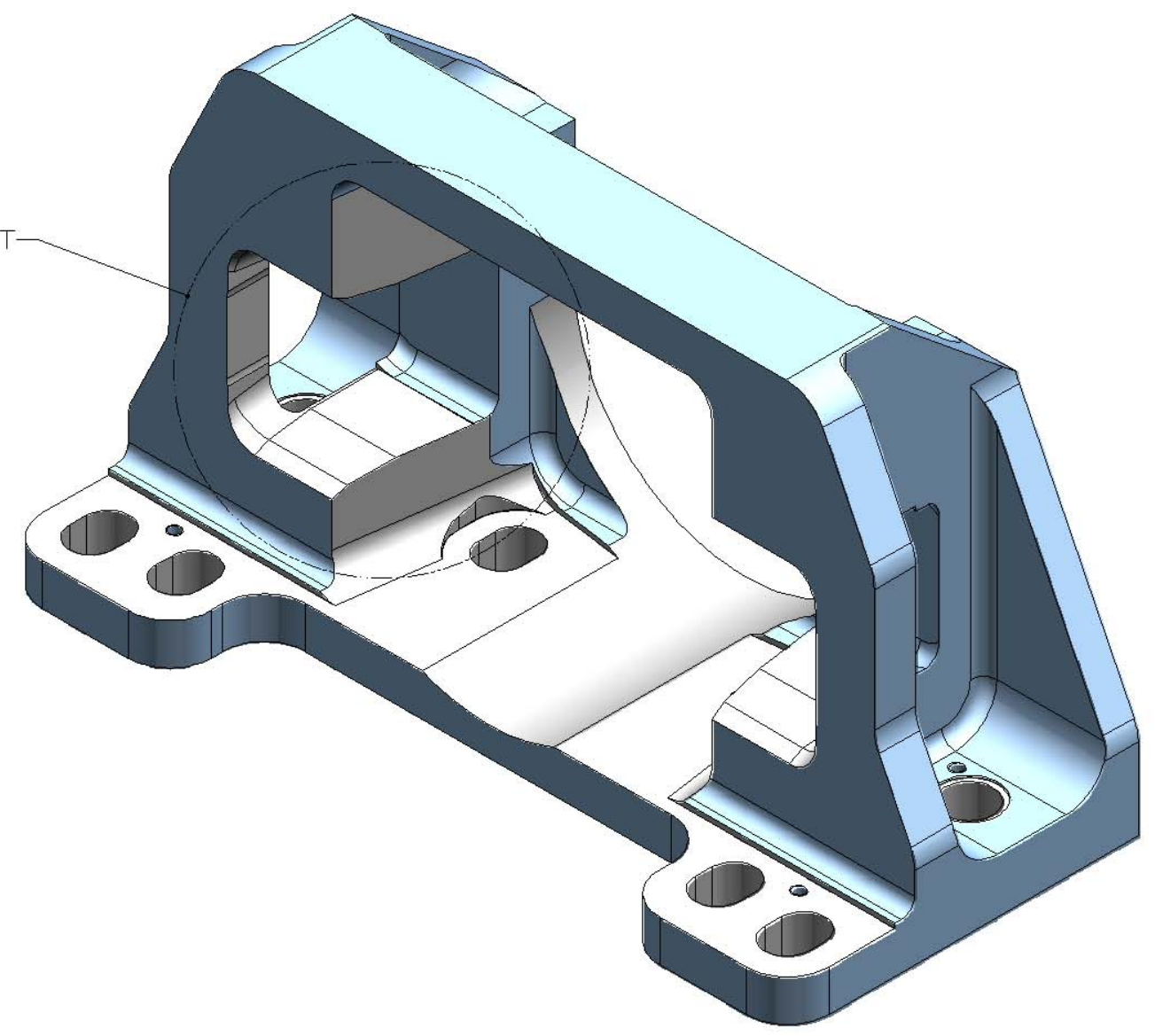
NOTE: DIMENSIONS ON THIS SHEET ARE A GUIDE ONLY FOR ROUGH MACHINING OF THE COMPONENT.

ALL DIMENSIONS ARE IN MILLIMETRES		GENERAL TOLERANCES TO BS EN 22768 UNLESS OTHERWISE STATED	
GENERAL MACHINING			
FROM 0	OVER 8	30	120
UP TO 6	UP TO 30	120	400
±0.1	±0.2	±0.3	±0.5
RADI & CHAMFERS		ANGULAR ±0° 30'	
FROM 0	OVER 3	6	
UP TO 3	UP TO 6		
±0.2	±0.5	±1.0	
GENERAL FABRICATION		THIRD ANGLE PROJECTION	
FROM 2	OVER 400	1000	2000
UP TO 400	UP TO 1000	2000	4000
±1	±2	±3	±4

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SURFACE TEXTURE TO BS EN ISO 25178-1		CUSTOMER AUTHORITY	
FROM 0	OVER 3	N/A	
UP TO 3	UP TO 6		
±0.2	±0.5		
MATERIAL		SEE NOTES	
SPECIFICATION & GRADE		SEE NOTES	
INSPECTION DOCUMENT		SCALE	
EN 10204 - 3.1		1:2 U05	
ESTIMATED MASS		44.5kg	

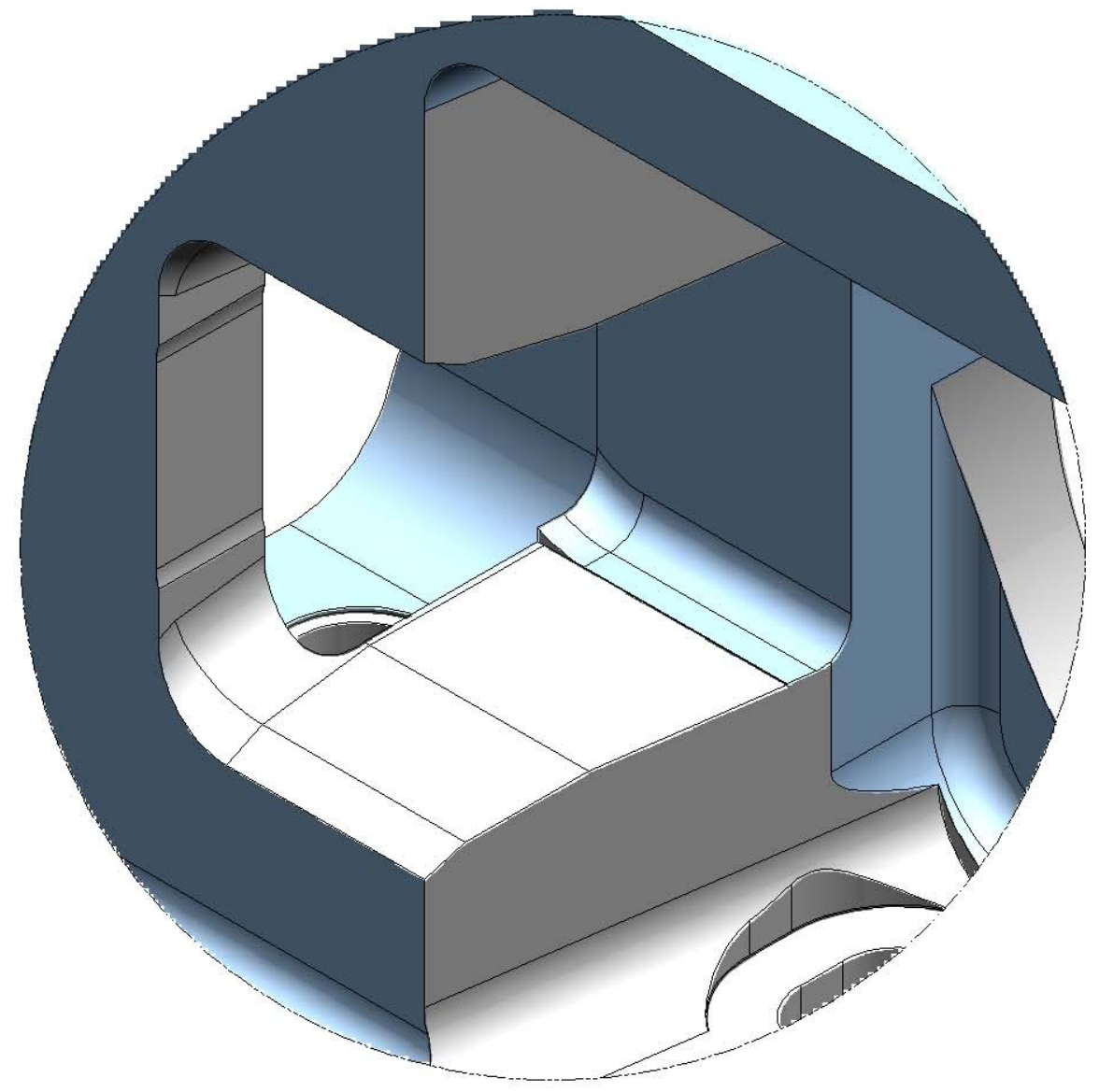
7	30-Mar-2015	WSH	JAD	JAD	
REVISION	DATE	ORIGINATED	CHECKED	APPROVED	CHANGE No.
BABCOCK INTERNATIONAL GROUP DEFENCE SYSTEMS TECHNOLOGY BRISTOL T+44 (0)117 9664977 F+44 (0)117 9663025 www.babcockinternational.com LEICESTER T+44 (0)116 2750750 F+44 (0)116 2750757 www.babcockinternational.com					
TITLE					
DECK BLOCK, MACHINED					
DRG / PART NO.					
WSH1122219					
REVISION					
7					
SHEET OF SHEETS					
5 of 6					
CUSTOMER DRG NO.					
N/A					
REVISION STATUS					
Design Released					
SIZE					
A1					

DETAIL T



ISOMETRIC VIEW OF FINAL MACHINING
FOR INFORMATION ONLY

DETAIL T



7	30-Mar-2015	WSH	JAD	JAD	
REVISION	DATE	ORIGINATED	CHECKED	APPROVED	CHANGE No.

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RADIII & CHAMFERS		UNLESS OTHERWISE STATED	
FROM 0	OVER 3 8	SURFACE FINISH	
UP TO 3	UP TO 8	10 BS EN ISO 25179-1	
GENERAL FABRICATION		CUSTOMER ABILITY	
FROM 2	OVER 400 1000 2000 4000 8000 12000	N/A	
UP TO 450	UP TO 1000 2000 4000 8000 12000	MATERIAL	
		SEE NOTES	
		SPECIFICATION & GRADE	
		SEE NOTES	
		INSPECTION DRAWING	
		EN 10204 - 3.1	
		SCALE	
		N.T.S.	
		ESTIMATED MASS	
		44.5kg	

BABCOCK INTERNATIONAL GROUP DEFENCE SYSTEMS TECHNOLOGY		TITLE	
BRIEFING 11-24 10117 0054877 www.babcock-international.com		DECK BLOCK, MACHINED	
LEICESTER 11-24 05116 380268 www.babcock-international.com		DWG / PART NO.	
		WSH1122219	
		REVISION	
		7	
		SHEET OF SHEETS	
		6 of 6	
		DESIGNER Dwg No.	
		N/A	
		REVISION STATUS	
		Design Released	
		SIZE	
		A1	