

Operation Chariot Build Method



Operation Chariot Build Method



Index – Whole Ship Build Method

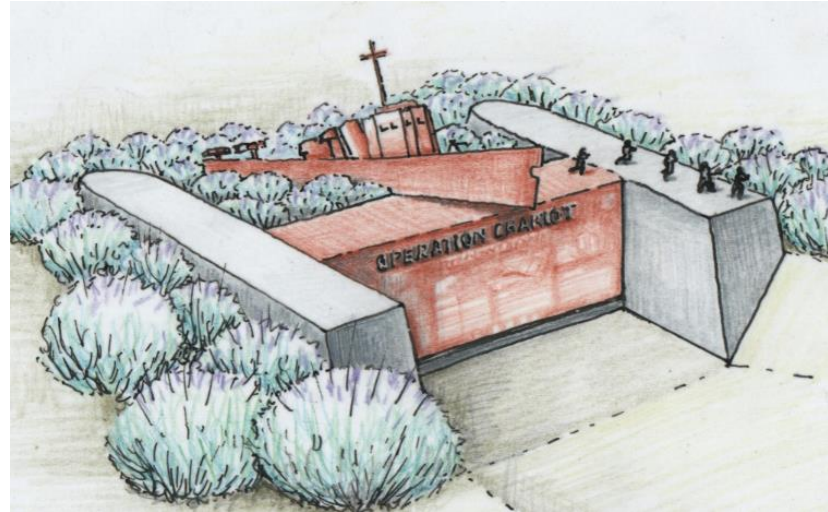
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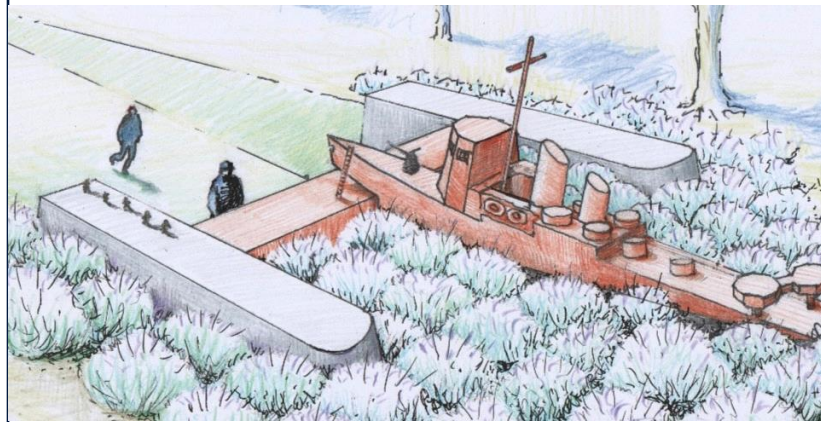
Mission Statement

Manufacture a 1:10 Scale representation of Operation Chariot , HMS Campbeltown ramming the Saint Nazaire Dock Caisson to put the dry dock out of commission , rendering it inoperable for the docking of the German Battleship Tirpitz
Material CORTEN Steel

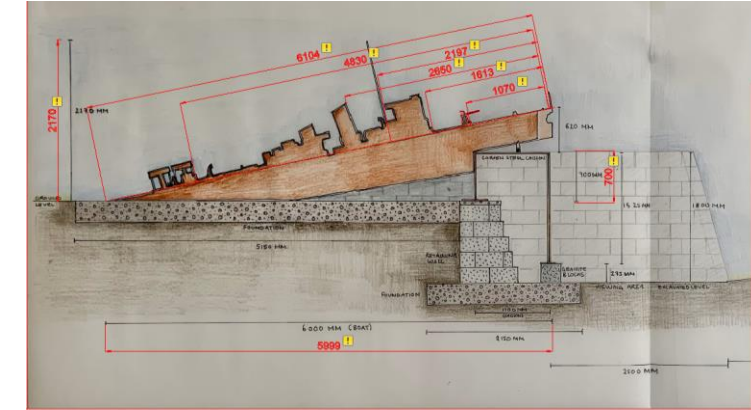
Architects Memorial Visualisation



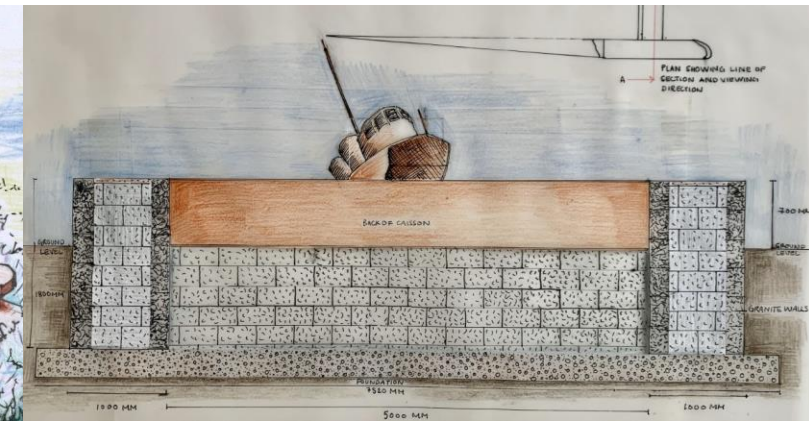
View on Starboard Side from Forward Location



View on Port Side from Aft Location



Elevation on Starboard Side



Front Elevation

stephenson hamilton risley

STUDIO

babcock™

Classification: UNCLASSIFIED

Babcock Whole Ship Build Method

Build Method Issue

- This build method has been developed specifically for HMS Campbeltown Wholeship Build Method
- Details Below:

Version	Responsibility	Date	Description
A	Production Engineering	14/05/2025	Baseline for Review / Comment
01	Production Engineering	23/07/2025	Issued for Construction

Drawing Register

SPS OPERATION CHARIOT DRAWING AND DOCUMENT LIST					
Dwg Sheet No	Drawing Title	DXF	PDF	No of Parts	Pallet No,
OP-CH-MEM	Operation Chariot Memorial Project		1		
OP-CH-BM	Operation Chariot Build Method		1		
GA-01	General Arrangement		2		
Nests	Corten Fictitious Nests		1		
AGP-01	Aft Gun Platform	1	1	25	1
BRI-01	Upper and Lower Bridge	1	1	60	2
CASS-01	Caisson	1	1	36	3
DECK-01	Deck	1	1	33	4
HULL-01	Hull		1	20	5
DKF-01	Deck Fittings Fwd	1	2	82	6
DKF-02	Deck Fittings Mid	1	2	33	7
DKF-03	Deck Fittings Aft	1	3	142	8
GUNS-01	Ship Guns	1	2	43	9
MGP-01	Mid Gun Platform	1	1	42	10
Remnants 3 and 5 Thk	Fabrication Aids etc				11
TOTALS		9	20	516	

Classification: UNCLASSIFIED

UNCLASSIFIED

Safety Moment

Our commitments



I always plan work with safety in mind



I always protect myself, others and the planet from safety, health and environment hazards



I always make sure I am fit and trained to safely carry out my work



I always assess and control risks before I set to work



I always use the correct and safest tools and equipment for the job



I always speak up if I see something unsafe



I always pause or stop work if things change, or if have a safety concern

HOME SAFE EVERY DAY

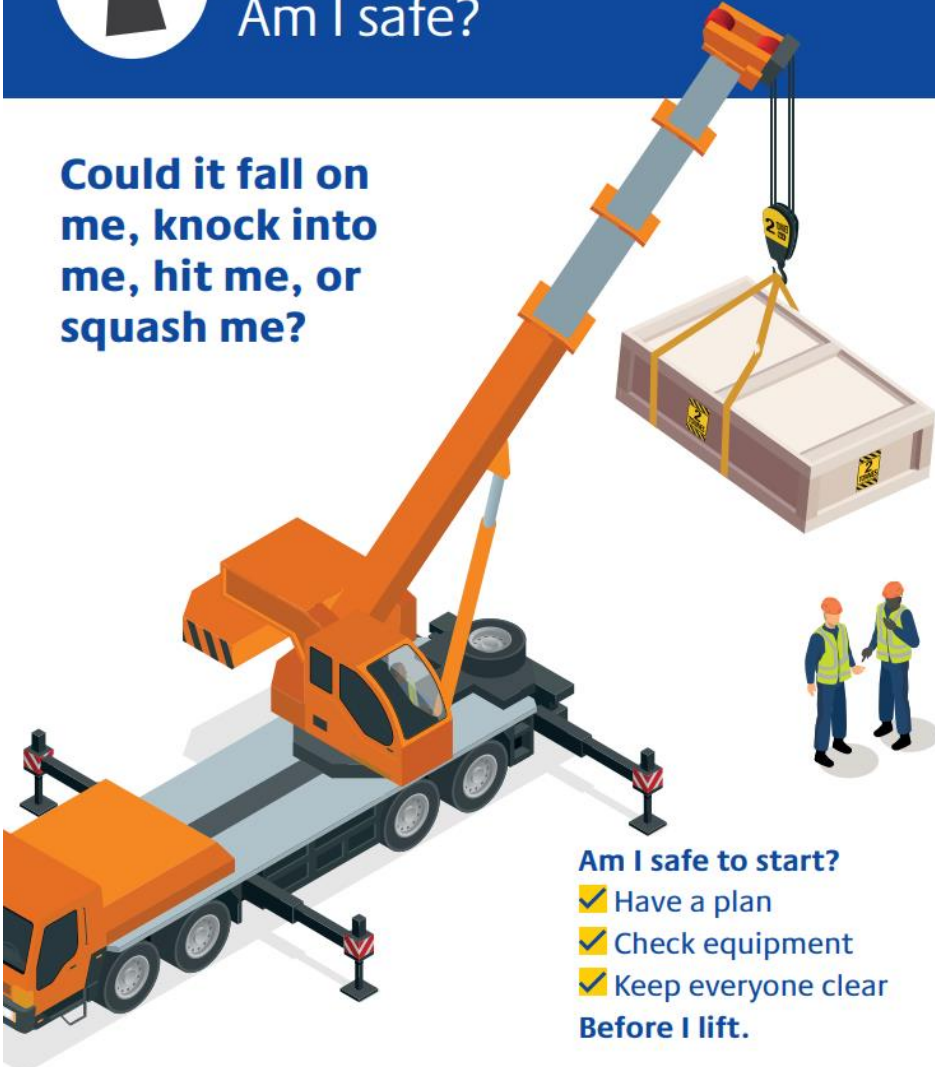
Safety starts with me



Lifting Operations

Am I safe?

Could it fall on me, knock into me, hit me, or squash me?



Am I safe to start?

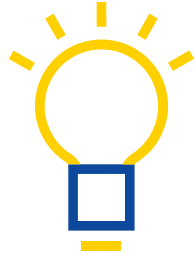
- ✓ Have a plan
- ✓ Check equipment
- ✓ Keep everyone clear

Before I lift.



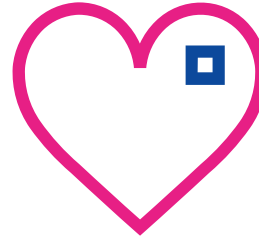
Safety Starts with Me

Our Principles



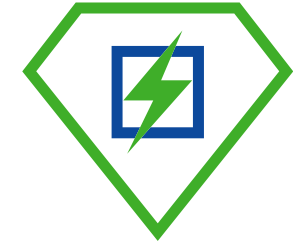
be curious

We believe in positively challenging the status quo and asking 'how might we?'.



be kind

We believe in being kind to ourselves, kind to each other and kind to the planet.



be courageous

We believe in being brave, ambitious and determined.



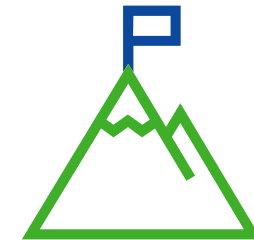
think : outcomes

We believe in measuring success by the results we deliver and the positive impact we make.



collaborate

We believe Babcock is greater than the sum of its parts.



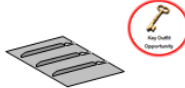
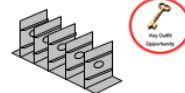
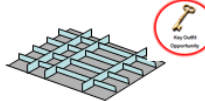
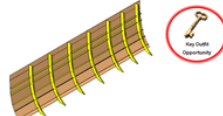
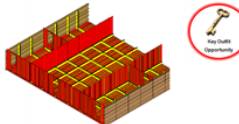
own and deliver

We believe our collective success depends on individual actions.

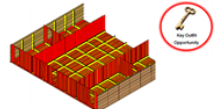
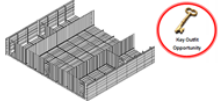
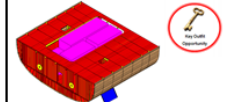
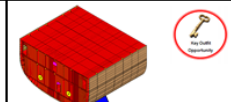
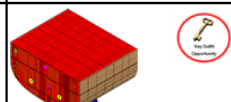
Build Strategy



Explanation Of Build Strategy Process Assembly Definition (Stages 1-5)

Sequence	Build Stage	Description	Example	Outfit Opportunity
1	Minor Assembly	An assembly of two or more single parts which together have length and breadth but no significant depth.		Preservation 
2	Sub Assembly	Minor assemblies and/or single parts joined together to give an assembly some length, breadth and depth.		Paint Preservation 
3	Flat Panel Assembly	A Flat Plate assembly with stiffeners		Cable Tray Pipe Banks Machinery Modules 
4	Curved Panel Assembly (Typical Shell Panel)	A Curved Plate assembly with stiffeners		Penetrations Paint Preservation 
5	Major Assembly	Two or more Assemblies and single parts joined together to give an assembly with a significant dimension or weight to form an almost complete unit at it's penultimate stage of fabrication.		Staged System Paint Preservation 

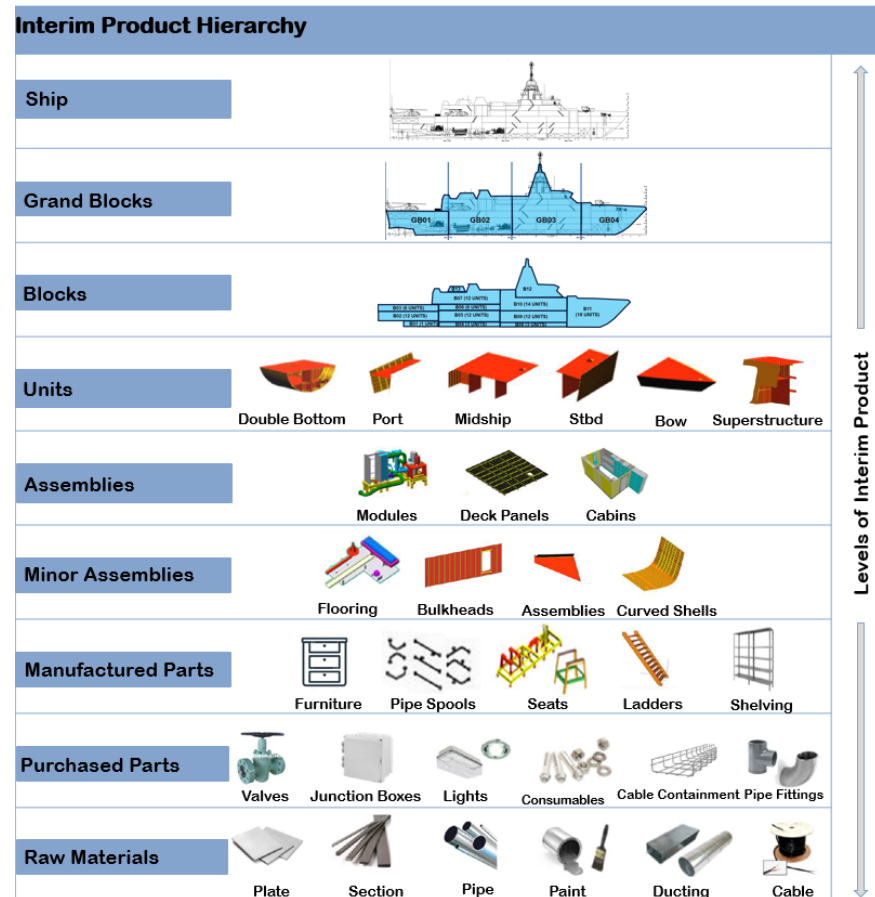
Explanation Of Build Strategy Process Assembly Definition (Stages 6-11)

Sequence	Build Stage		Description	Example	Outfit Opportunity
6	Unit Assembly	Pre Paint	The final fabrication stage of a steelwork unit in which the last assemblies and single parts are fitted. Pre-paint stage is when all the hotwork activities are finalised.		Staged Outfit Paint Preservation 
7		Post Paint	The final fabrication stage of a steelwork unit in which the last assemblies and single parts are fitted. Post-paint stage is after the unit has been painted up to but not including final coat.		
8	Sub Block Assembly		The combination of two or more Unit Assemblies prior to a final erection into the Block Assembly.		Lock Out Modular Units 
9	Block Assembly		The combination of Sub Blocks and/or Units to form a block		Lock Out Modular Units 
10	Ship Integration		Hull systems		Ship Assembly and Integration 
11	Ship comissioning		Final Ship Trials HATS (Harbour Acceptance Trials)		Final Systems STW and HATS 

Build Strategy Process

The Build Strategy process is based on these key stages

- Mature Design
- Fabrication Drawings complete
- Lifting/Turning Complete
- Procurement of raw materials
- Mark, Cut, Prep Process (cut parts)
- Panel build (from receiving cut parts)
- Earliest possible outfit opportunities
- Outfit P01
- Outfit P02
- Unit build (from panel build)
- Block erection (from unit build)
- Lock Out
- Hotwork completed (during block erection)
- Surface protect (pre hotwork complete)
- Outfit / System installation (pre surface protect)
- Block Integration (once block erection completed)
- FAT / HAT / SAT
- Noise and Vibration Trials
- Interim Acceptance
- DSAT



DEVONPORT ROYAL DOCKYARD

babcockTM



HMS Campbeltown being converted

Campbeltown began the Devonport repairs in January. During this time, she was selected for a special operation and was withdrawn from regular service for modifications. She was to be used in Operation Chariot, a planned assault operation on the docks at [Saint-Nazaire](#). In 1942 the German battleship *Tirpitz*—anchored at [Trondheim](#) in Norway—was considered to present a grave threat to [Atlantic convoys](#).^[12] Should *Tirpitz* enter the Atlantic, the [Louis Joubert drydock](#) at Saint-Nazaire—which had originally been built for the liner [SS Normandie](#)—was a vital target; it was the only German-held drydock on the European coast of the Atlantic that was large enough to service the battleship.^{[13][14]} If this drydock could be put out of action, any offensive sortie by *Tirpitz* into the Atlantic would be much more dangerous for the *Kriegsmarine* to carry out, making it less likely that they would risk deploying her.^[15]

Campbeltown was the size of a German Möwe-Class torpedo boat and changes to its superstructure, like eliminating two of her four stack and angling the remaining two gave her a German silhouette. They equipped her with Oerlikon guns but removed her main gun and replaced it with a lighter 12 pounder. The shipwrights added additional armor plating around the deck and the bridge, while stripping all other extraneous equipment to reduce her draft.

General characteristics

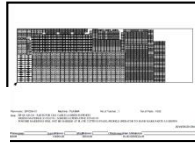
Class and type	<i>Wickes-class destroyer</i>
	<i>Town-class destroyer</i>
Displacement	1,260 long tons (1,280 t)
Length	314 ft 4 in (95.81 m)
Beam	30 ft 6 in (9.30 m)
Draught	9 ft (2.7 m) (light)
	12 ft (3.7 m) (full load)

Prepare Plate and section Nests IAW Schedule and issue to Production



Raw material delivery to Rosyth C/W
Material Certificates log into system
clear Quality checks and prepare to issue

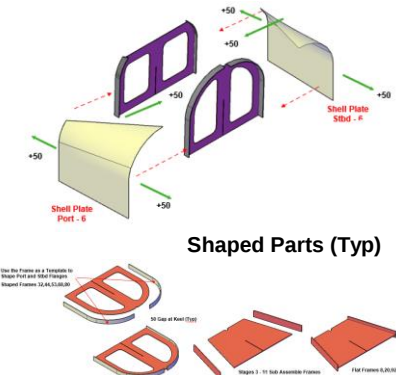
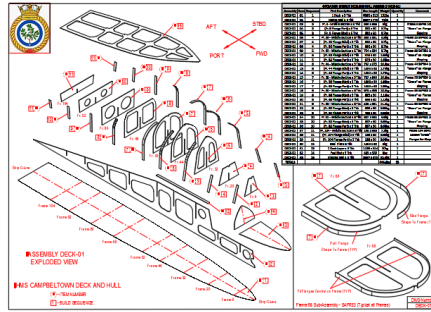
Raw material delivery to Rosyth C/W
Material Certificates log into system
clear Quality checks and prepare to issue



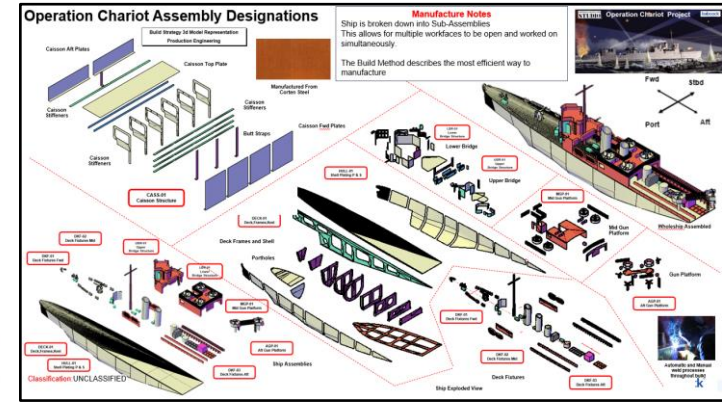
Profile Plate Nesting



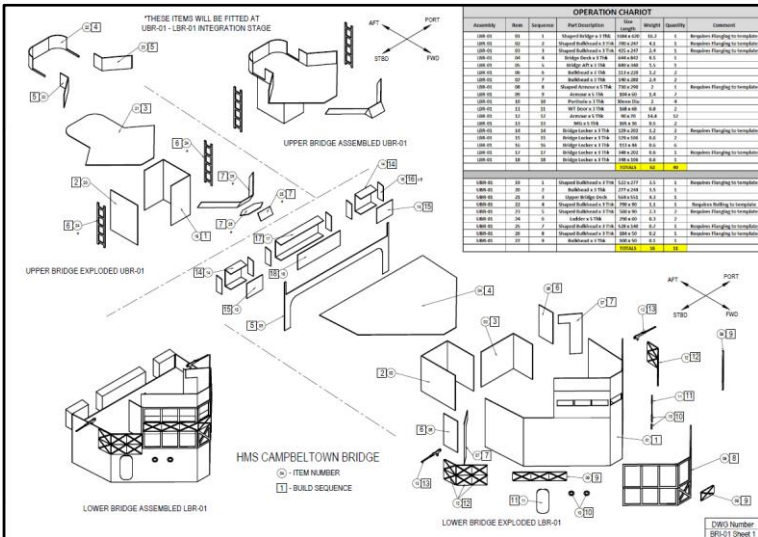
Profile Plate Cutting



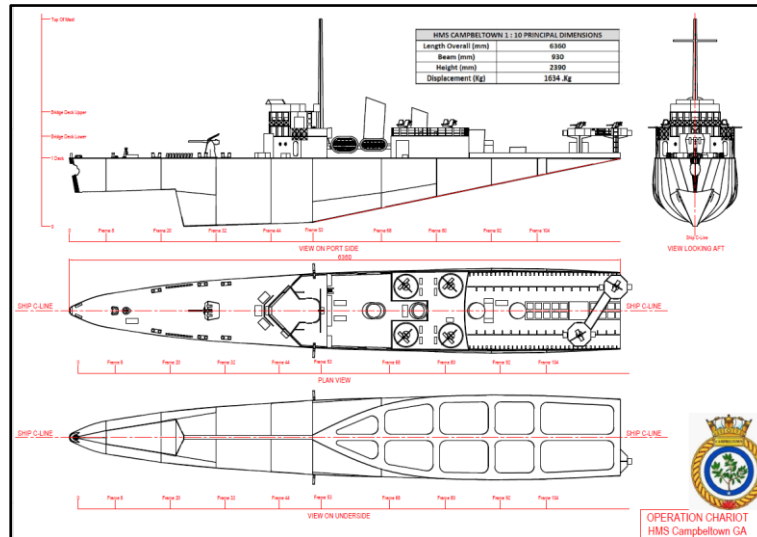
Shaped Parts (Typ)



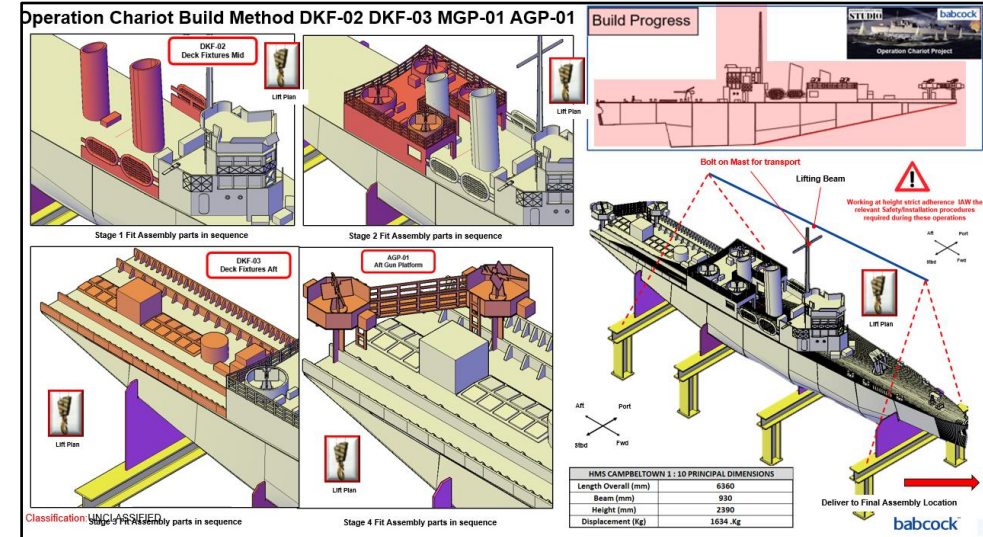
- ## 2.Receipt Material Mark Cut And Prep (MCP)



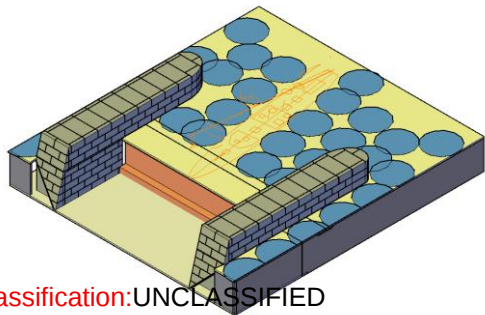
6. Manufacture Sub-Assemblies



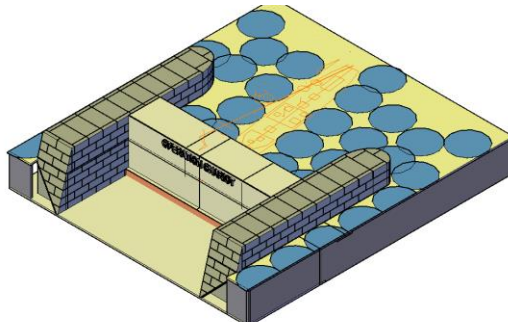
7. Assemble IAW the Build Method



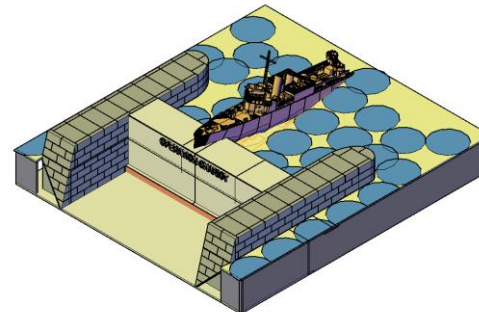
8. Prepare Assemblies for delivery



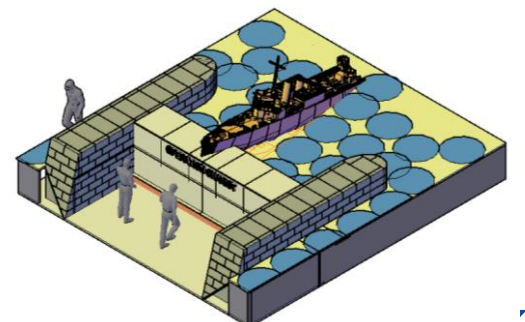
Lift Plan



Lift Plan



Lift Plan



12. Project Complete

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9. On site determine transport and logistics Prep Area

10. Install Caisson

11. Install HMS Campbeltown

12. Project Complete

Facilities, Space Loading, Logistics

Manufacture Facilities Check Sheet

Space Loading , Manufacture envelope , Ship Envelope Approx 7000 x 3000 x 2000 , Caisson 6000 x 2000 x 2000 Location ? Bay 3, Bay 6 , Bay 10 , Bay 11 , Training Centre
Deck Assemblies will fit on a standard workbench

Craneage capacities ensure Assemblies will be under the Overhead Crane lifting envelopes, movement via Fork Lifts Etc Plan Ahead

Welding Plant available , welding CORTEN steel 3mm , 5mm Thick Weld Processes Minimal Fillets, Stitch Welds , Corner to corner welds , Full welding IWO Lift Padeyes Etc.

Fabrication Plant available , Flanger capacities Rolling capacities Guillotines etc

MCP (Marking , cutting and prepping) of CORTEN Steel

Plasma , laser , waterjet cutting , Hand Plasma , Burning Torch , Grinders

Hand tools available

Material available to manufacture templates , eg thin Aluminium , Template card for shell plates



Facilities, Space Loading

FABRICATION FACILITIES : - FABRICATION BAY No.3 MANUFACTURING SPACE LOADING FOOTPRINT

Crane Capacities 2 x 15 Te Crane

Floor Space 55 x 14 1m2 Represented below

Exit Door 11m Wide x 7.9m High

Exit Facility South Door



Square on plan represents 1 m2 floor spa

Approximate location of pillar

Work Bench

NORTH

EAST

SOUTH

POTENTIAL SITE HMS CAMPBELL

Operations A-N 1-8
Sub-Assembly delivery

WEST

Sub Assembly Principal Dimensions			
Assembly Designation	L x B x H (m)	Weight Kg	Comments
DECK - 01	6360 x 967 x 790	500	Manufacture on Trestles (Fab Area)
CASS - 01	4990 x 1100 x 1575	675.5	Manufacture on Trestles (Fab Area)
AGP-01	819 x 795 x 341	19.1	Manufacture on Bench
BRI-01	846 x 763 x 260	78	Manufacture on Bench
DKF-01	Various Assys		Manufacture on Bench
DKF-02	Various Assys		Manufacture on Bench
DKF-03	Various Assys		Manufacture on Bench
GUNS-01 (MK 14)	352 x 216 x 279	4.8	Manufacture on Bench
GUNS-01 (20mm Oerliken)	285 Dia x 161	5kg	Manufacture on Bench x 4
MGP-01	906 x 899 x 440	146.5	Manufacture on Bench



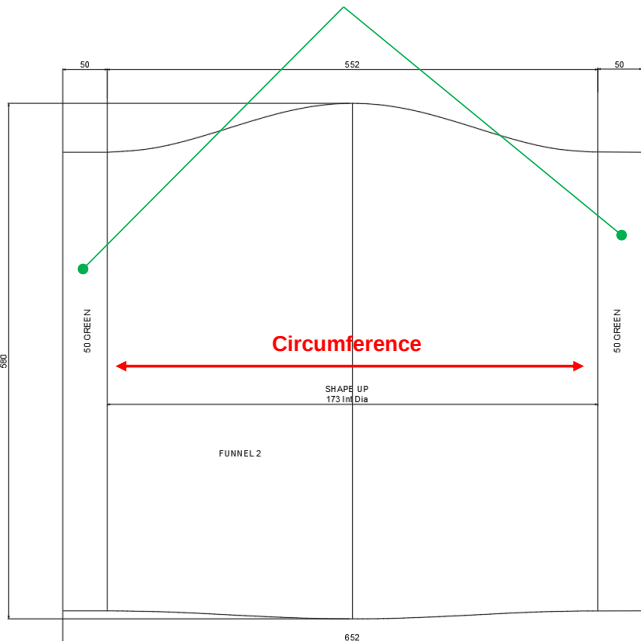
SPACE LOADING PLAN SHOWN ABOVE DENOTES A CLEAR FLOORSACE WORKING AREA. PRIOR TO COMMITTING A SPACE LOAD FOOTPRINT THE AREA MUST BE ASSESSED FOR ANY OBSTRUCTIONS NEW PLANT ETC THAT WILL IMPACT ON AVAILABLE SPACE

WEST

EAST

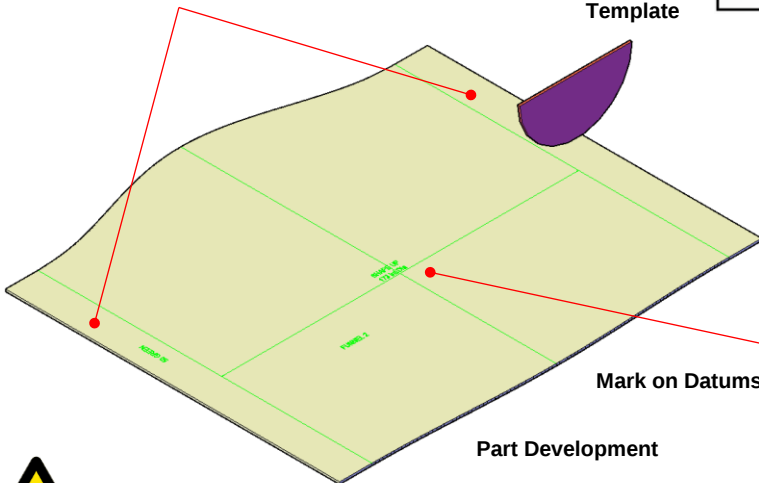
Secondary Operations (Rolling Parts)

“Green” (Additional material required for rolling to shape)



Part Development

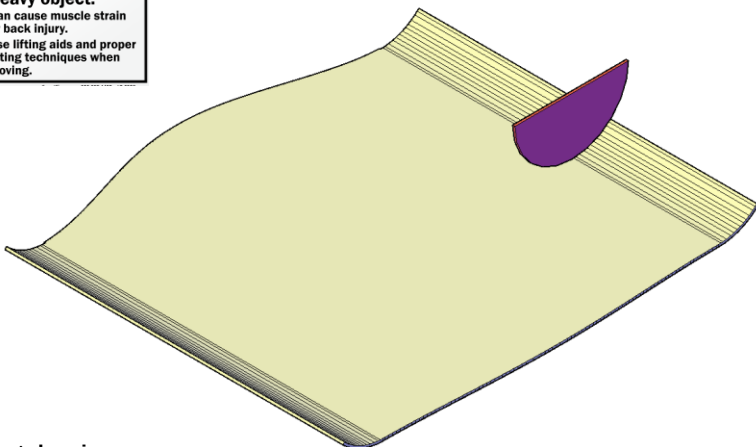
Shape up the ends to the Template



Part Development

Template

Mark on Datums IAW relevant drawings



Stage 2 .Start shaping the Part Development to the Template



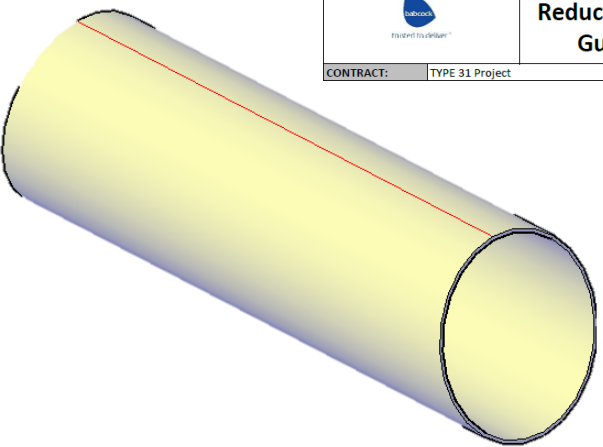
Beware of welding flash

Stage 1.Manufacture template to Internal Diameter

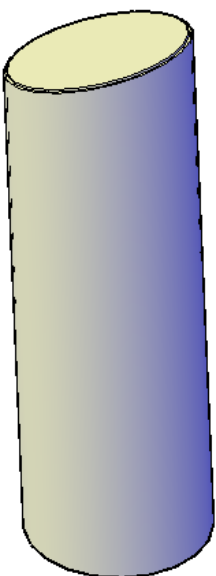


Minimise Weld Distortion through good practice

Classification:UNCLASSIFIED	Weld Distortion Reduction Welder Guidelines		DOC No:	TSC-DC-01
			REVISION:	0
CONTRACT:	TYPE 31 Project	FABRICATION CODE:	Lloyds 2017	



Stage 4 .Complete the rolling process

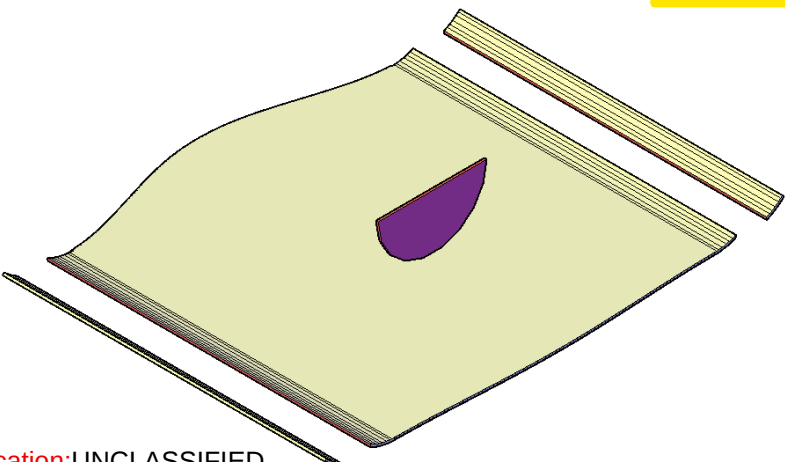


Stage 5 .Assembly complete

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UNCLASSIFIED

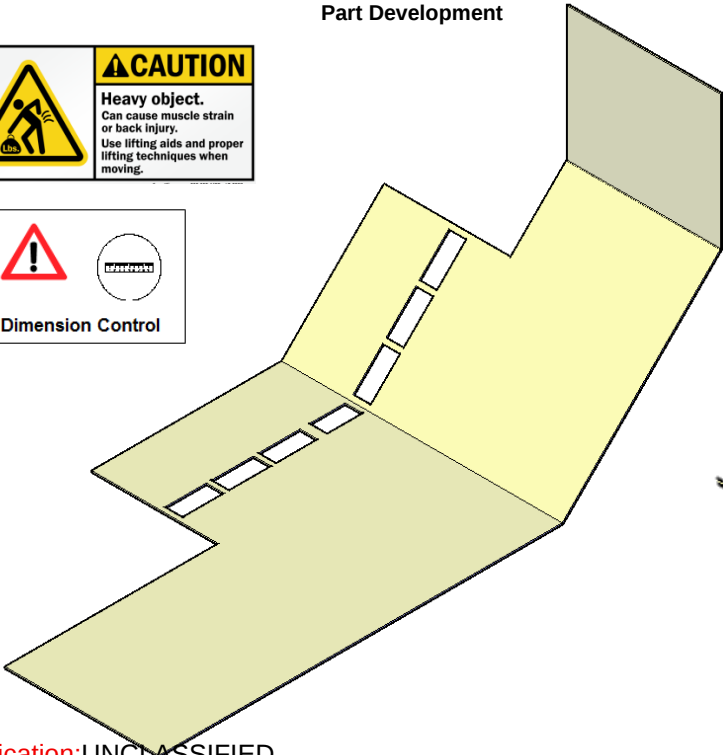
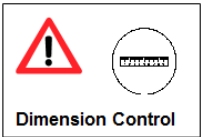
Stage 3 .Remove the “Green”



Secondary Operations (Flanging)



Part Development

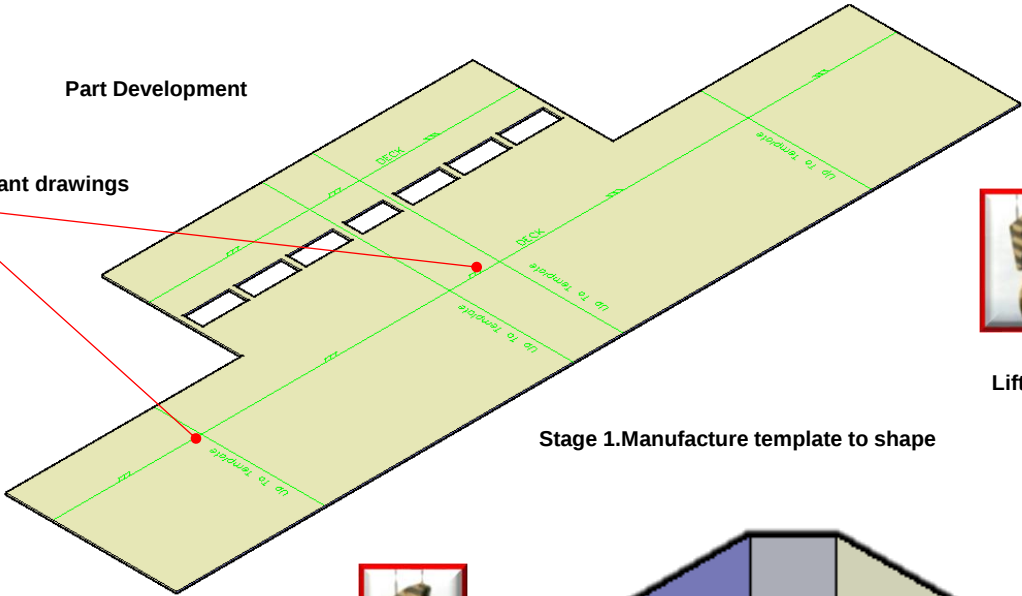


Lift Plan

Stage 2 .Start shaping the Part Development to the Templates

Part Development

Mark on Datums IAW relevant drawings

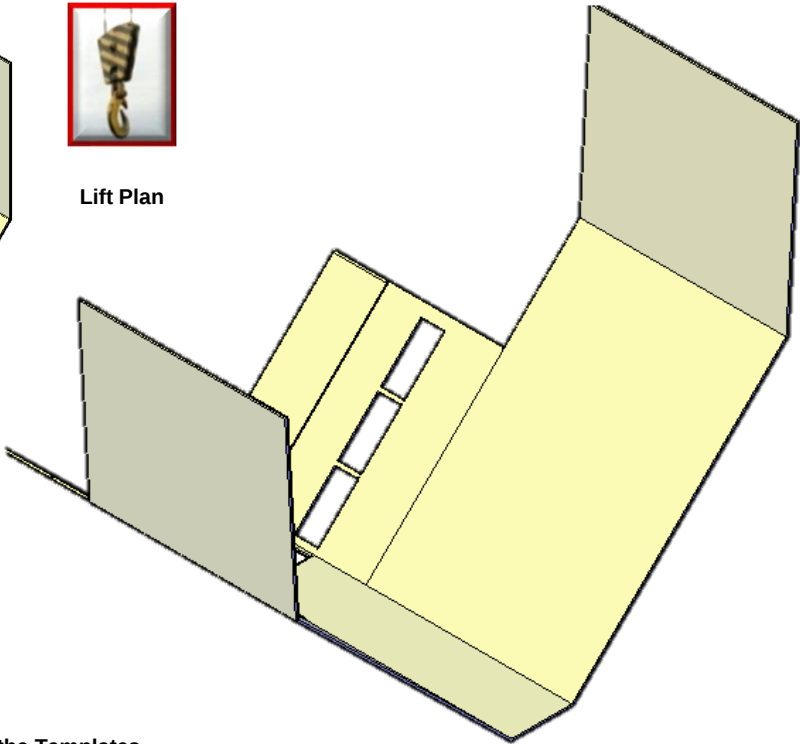


Lift Plan

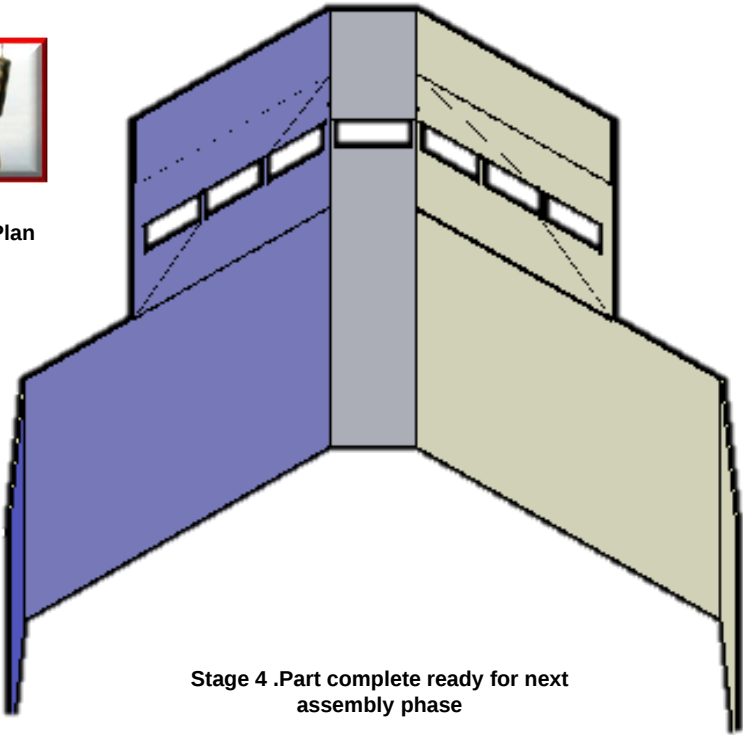
Stage 1.Manufacture template to shape



Lift Plan

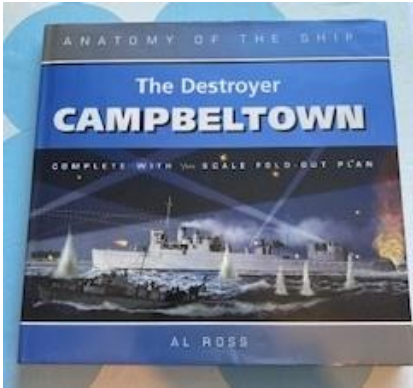


Stage 3 .Complete the shaping process

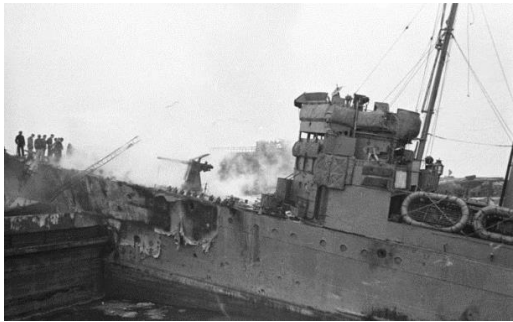
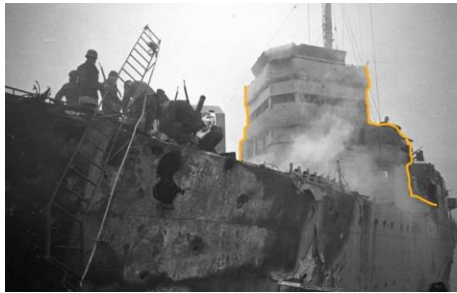
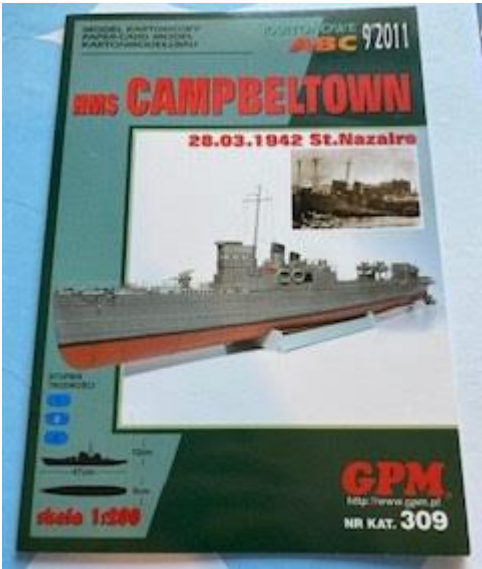


Stage 4 .Part complete ready for next assembly phase

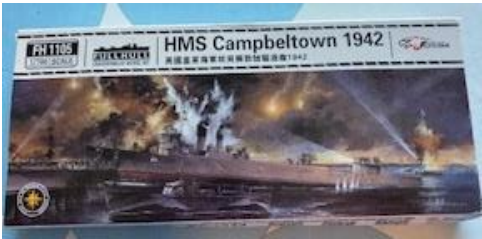
Operation Chariot Research and Resource



Anatomy Of The Ship



Historic Photos

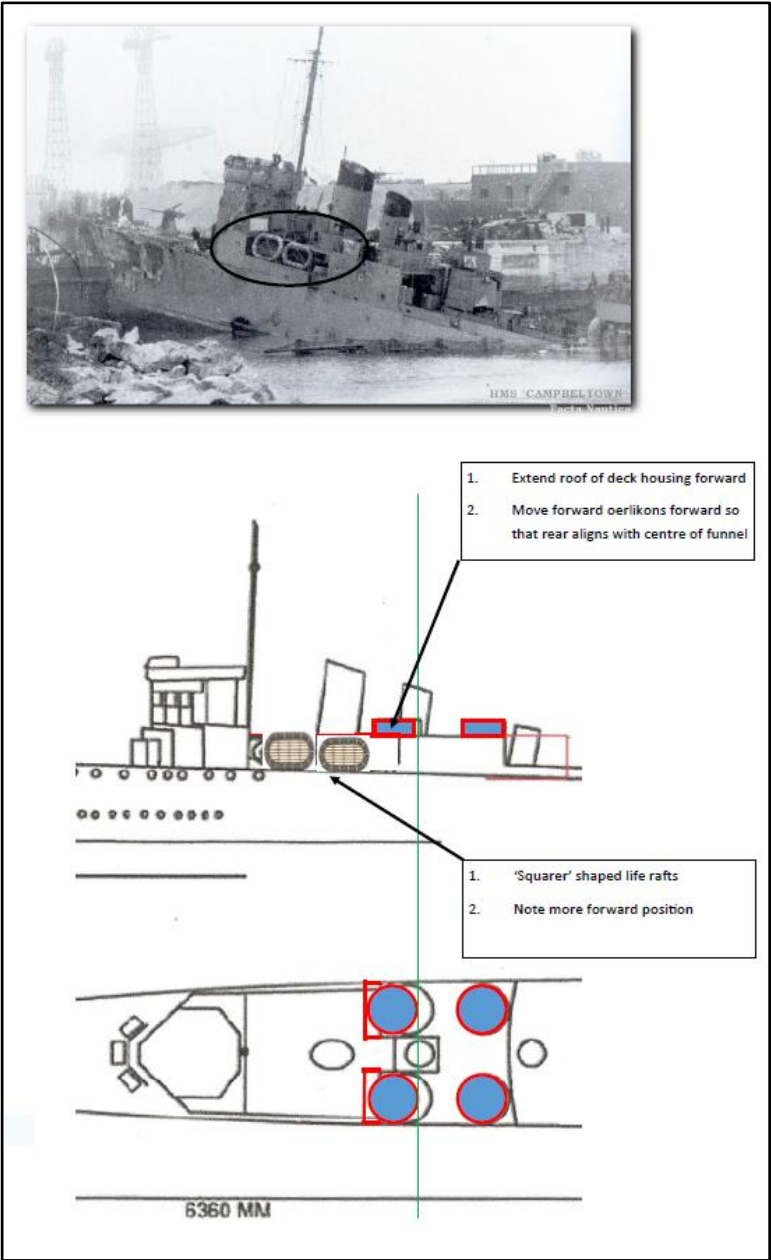


HMS Campbeltown Models



Meeting with Designers Manchester 23.01.2025

MK 1 Model



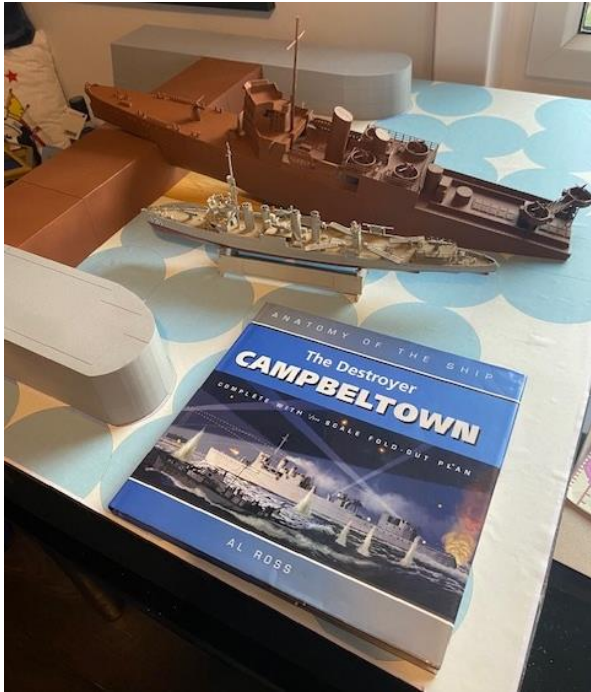
Expert Analysis and Feedback

Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Mark 1 Model

Operation Chariot Research and Resource MK2 Model and Site



Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Material Take Off (MTO) SPS Material

OPERATION CHARIOT PLATE NESTS							
Nest No.	Assemblies	Block	Thk	Material Type	Plate Dimensions	Quantity	Comments
SPS-001	DECK-01 ,	SHIP	5	CORTEN	7500 x 1500	1	Length required to manufacture Deck,C-Line Girder in 1 piece
SPS-002	DECK-01 ,	SHIP	5	CORTEN	7500 x 1500	1	Length required to manufacture Deck,C-Line Girder in 1 piece
SPS-003	CASS-01	CAISSON	5	CORTEN	3000 x 1250	1	CASS-01 Internal Stiffeners
SPS-004	CASS-01	CAISSON	5	CORTEN	3000 x 1250	1	CASS-01 Internal Stiffeners
SPS-005	UBR-0 ,LBR-01,MGP-01 , DKF-01,DKF-02,DKF-03	SHIP	3	CORTEN	7500 x 1500	1	Various smaller Assemblies
SPS-006	CASS-01 HULL-01	CAISSON	3	CORTEN	7500 X 1500	1	Caisson parts and Shell Plates
SPS-007	CASS-01 HULL-01	CAISSON	3	CORTEN	7500 X 1500	1	
SPS-008	CASS-01 HULL-01	CAISSON	3	CORTEN	7500 X 1500	1	
Corten Front Panel							Supplied by others
RETAIN ALL REMNANTS AND DELIVER TO THE MANUFACTURING LOCATION						8	



PLATE NEST No.SPS-001 7500 x 1500 x 5 CORTEN STEEL

PLATE NEST No.SPS-002 7500 x 1500 x 5 CORTEN STEEL

PLATE NEST No.SPS-003 3000 x 1250 x 5 CORTEN STEEL

PLATE NEST No.SPS-004 3000 x 1250 x 5 CORTEN STEEL

PLATE NEST No.SPS-005 7500 x 1500 x 3 CORTEN STEEL

PLATE NEST No.SPS-006 7500 x 1500 x 3 CORTEN STEEL

PLATE NEST No.SPS-007 7500 x 1500 x 3 CORTEN STEEL

PLATE NEST No.SPS-008 7500 x 1500 x 3 CORTEN STEEL

OPERATION CHARIOT
SPS NESTS

Classification: UNCLASSIFIED

Manufacture Notes

- Fictitious nesting FOR INFO ONLY dependant on supplier available plate dimensions

Drawing Register

SPS OPERATION CHARIOT DRAWING AND DOCUMENT LIST					
Dwg Sheet No	Drawing Title	DXF	PDF	No of Parts	Pallet No.
OP-CH-MEM	Operation Chariot Memorial Project		1		
OP-CH-BM	Operation Chariot Build Method		1		
GA-01	General Arrangement		2		
Nests	Corten Fictitious Nests		1		
AGP-01	Aft Gun Platform	1	1	25	1
BRI-01	Upper and Lower Bridge	1	1	60	2
CASS-01	Caisson	1	1	36	3
DECK-01	Deck	1	1	33	4
HULL-01	Hull	1	1	20	5
DKF-01	Deck Fittings Fwd	1	2	82	6
DKF-02	Deck Fittings Mid	1	2	33	7
DKF-03	Deck Fittings Aft	1	3	142	8
GUNS-01	Ship Guns	1	2	43	9
MGP-01	Mid Gun Platform	1	1	42	10
Remnants 3 and 5 Thk	Fabrication Aids etc				11
TOTALS		10	20	516	

CORTEN A Material

2No 7500x1500x5mm = £1387.00 each supply only (£1522.00 each profiled high def plasma)
2No 3000x1250x5mm = £578.00 each supply only (£638.00 each profiled high def plasma)
4No 7500x1500x3mm = £781.00 each supply only (£911.00 each profiled high def plasma)

If you can re-nest into the above then that would be great and sufficient, however if you require more plate just pro rata the rate and sizes.

We don't do the stainless or the etching - we do however mark the plates with chalk pens)

3-4 days delivery

Operation Chariot Procurement PO 73-315990

Purchase Order

Our Order Date
16/07/2025
Purchase Order
73 - 315990
Revision
0

Supplier	Delivery Address
SPS A DIVISION OF BARCLAY AND MATHIESON 180 HARDGATE ROAD SHIELDHALL GLASGOW LANARKSHIRE G51 4TB	Bay 24, Kings James IV Road Rosyth Business Park, Rosyth Rosyth, Dunfermline Fife KY11 2YD UNITED KINGDOM
	Terms Of Delivery Delivered at Place

Snr Buyer : Lindsay McPhail
Telephone : 01383 424988
Email : lindsay.mcphail@babcockinternational.com
Project Chariot
IAW SC(MT)-TEM-003 - Terms and Conditions (attached to PO)
Babcock shall not receive any material which is from Russian Origin
Any sizeable remnant material to be delivered with piece parts
Supplemental PDF's

CASS-01 SHEET 1
DKF-03 SHEET 3
DKF-03 SHEET 2
DKF-03 SHEET 1
DKF-02 SHEET 2
DKF-02 SHEET 1
DKF-01 SHEET 2
DKF-01 SHEET 1
MGP-01
BRI-01 SHEET 001
DECK-01 SHEET 1
HULL-01 SHEET 1
GUNS-01 MK14 GUN
GUNS-01 20MM GUN TUB
AGP-01 SHEET 1

Deliver material to BAY 3
This Order is subject to Babcock Marine & Technology terms and conditions of Contract.
This contract may also be subject to flow down conditions. If flow down conditions apply these will be detailed in the terms and conditions documents provided.



SPS OPERATION CHARIOT DRAWING AND DOCUMENT LIST					
Dwg Sheet No	Drawing Title	DXF	PDF	No of Parts	Pallet No,
OP-CH-MEM	Operation Chariot Memorial Project		1		
OP-CH-BM	Operation Chariot Build Method		1		
GA-01	General Arrangement		2		
Nests	Corten Fictitious Nests		1		
AGP-01	Aft Gun Platform	1	1	25	1
BRI-01	Upper and Lower Bridge	1	1	60	2
CASS-01	Caisson	1	1	36	3
DECK-01	Deck	1	1	33	4
HULL-01	Hull	1	1	20	5
DKF-01	Deck Fittings Fwd	1	2	82	6
DKF-02	Deck Fittings Mid	1	2	33	7
DKF-03	Deck Fittings Aft	1	3	142	8
GUNS-01	Ship Guns	1	2	43	9
MGP-01	Mid Gun Platform	1	1	42	10
Remnants 3 and 5 Thk	Fabrication Aids etc				11
TOTALS		10	20	516	

Purchase Order

Our Order Date
16/07/2025
Purchase Order
73 - 315990
Revision
0

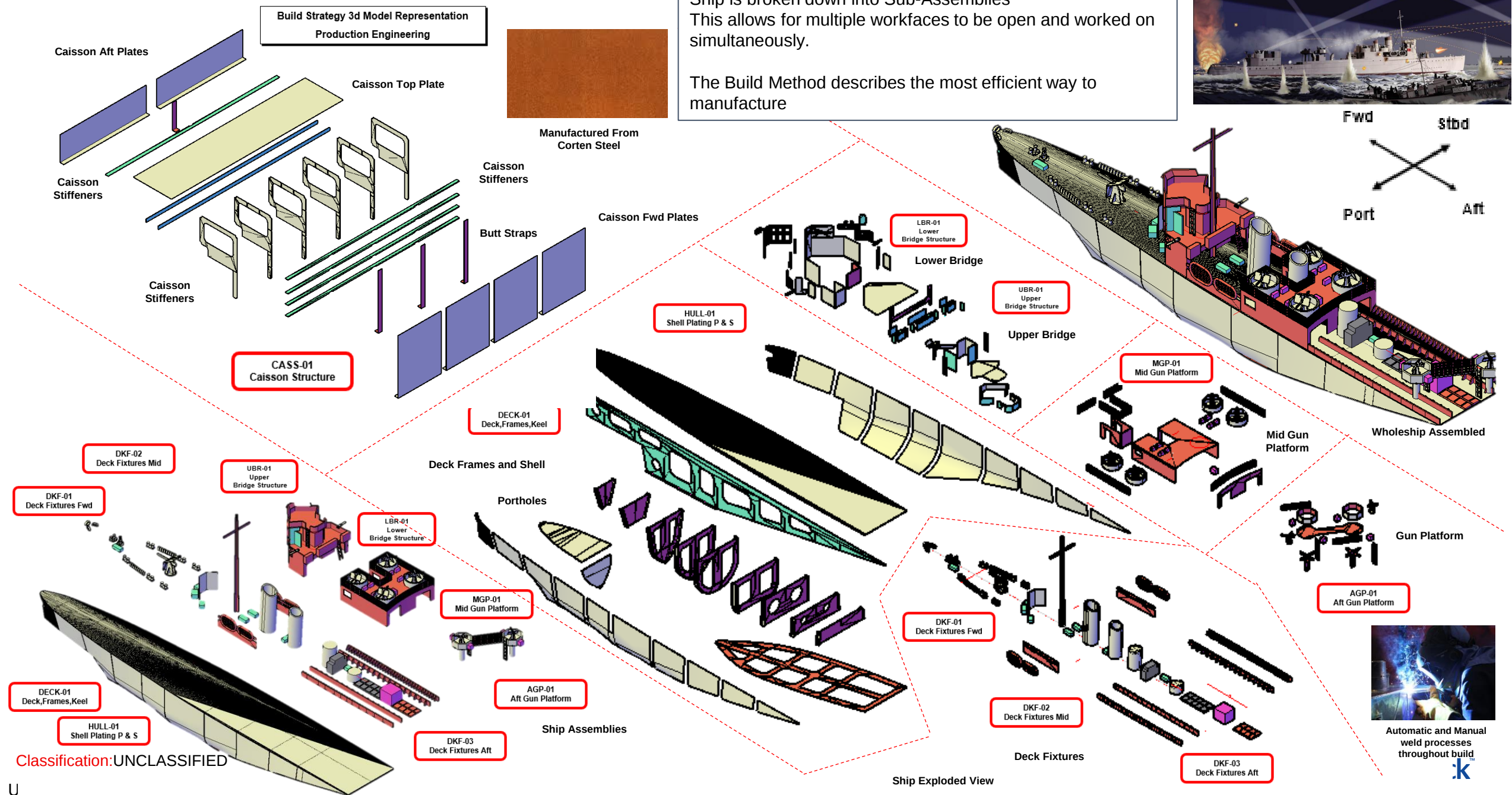
LineYour Part No	Quantity	UoM	Price	Del. Date
Rel Our Part No	Description			
1		1.00 EA	4,000.00	31/07/2025
1	SC-CHARGES			
	Supply Material and Profile parts IAW DXF files listed below submitted alongside PO			
	AGP-01			
	BRI-01			
	CASS-01			
	DECK-01 HULL -01			
	DKF-01			
	DKF-02			
	DKF-03			
	GUNS-01			
	MGP-01			

Operation Chariot Assembly Designations

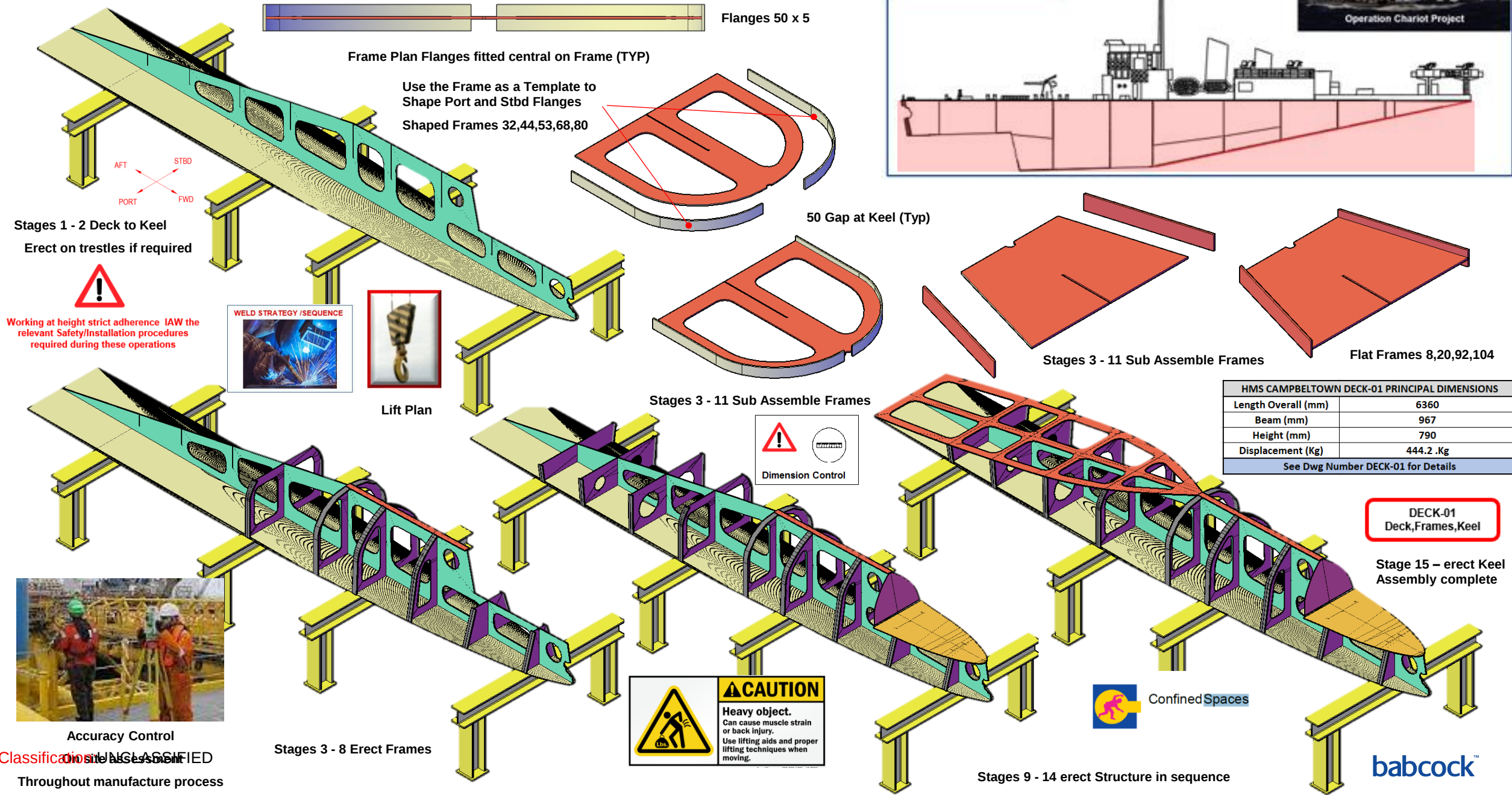
Manufacture Notes

Ship is broken down into Sub-Assemblies
This allows for multiple workfaces to be open and worked on simultaneously.

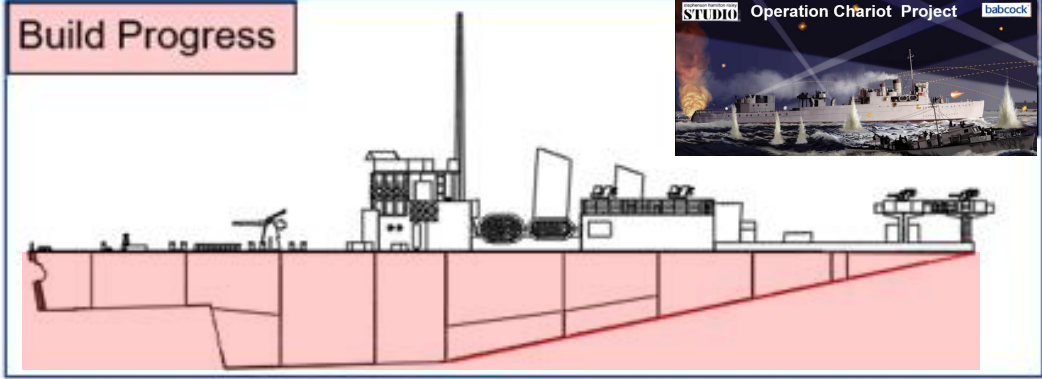
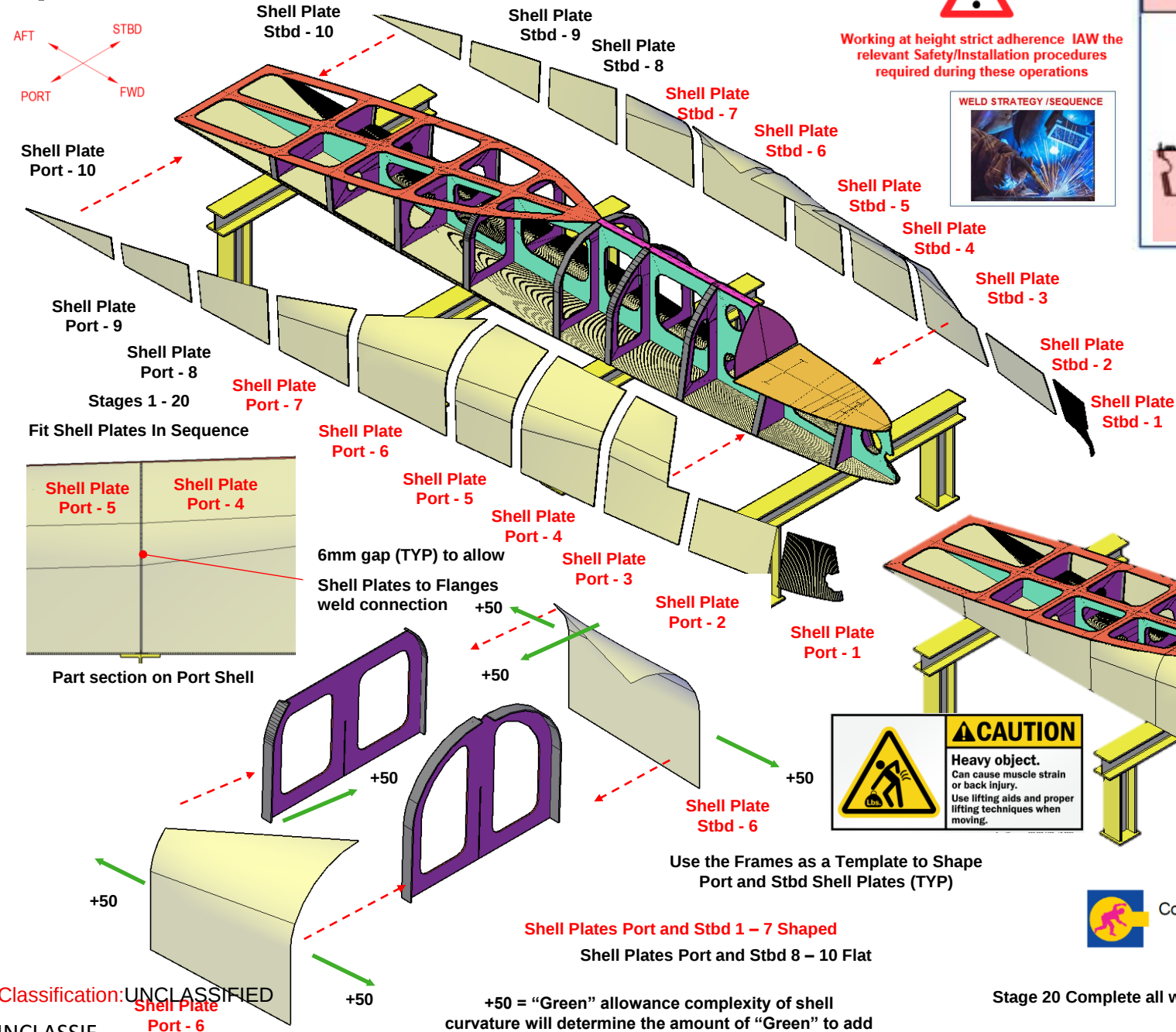
The Build Method describes the most efficient way to manufacture



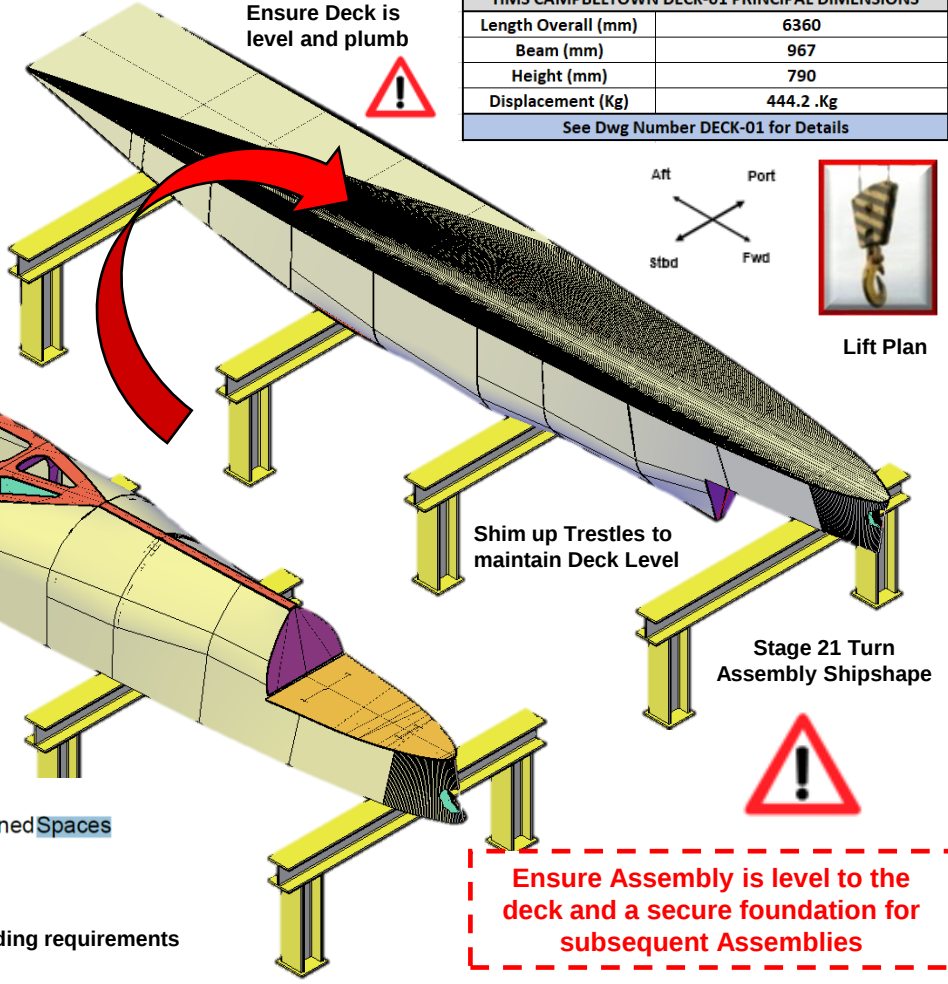
Operation Chariot Build Method DECK-01



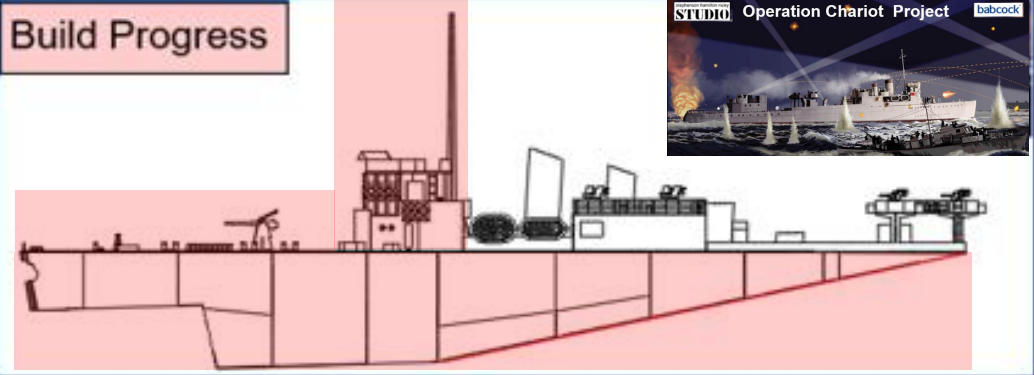
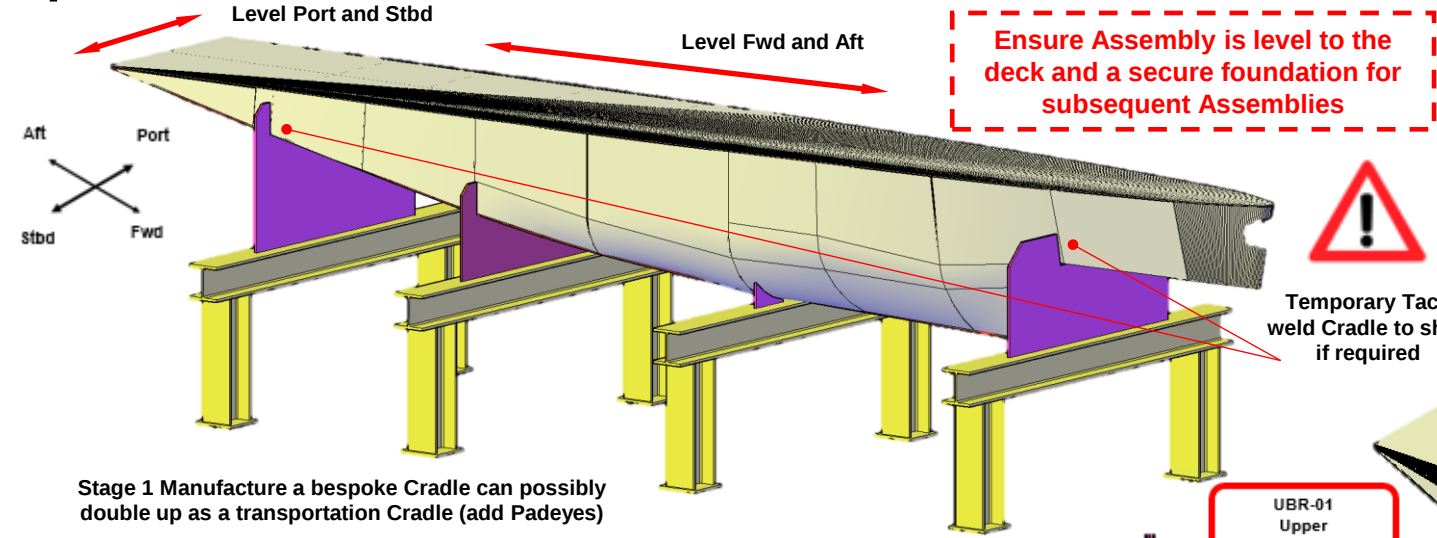
Operation Chariot Build Method HULL - 01



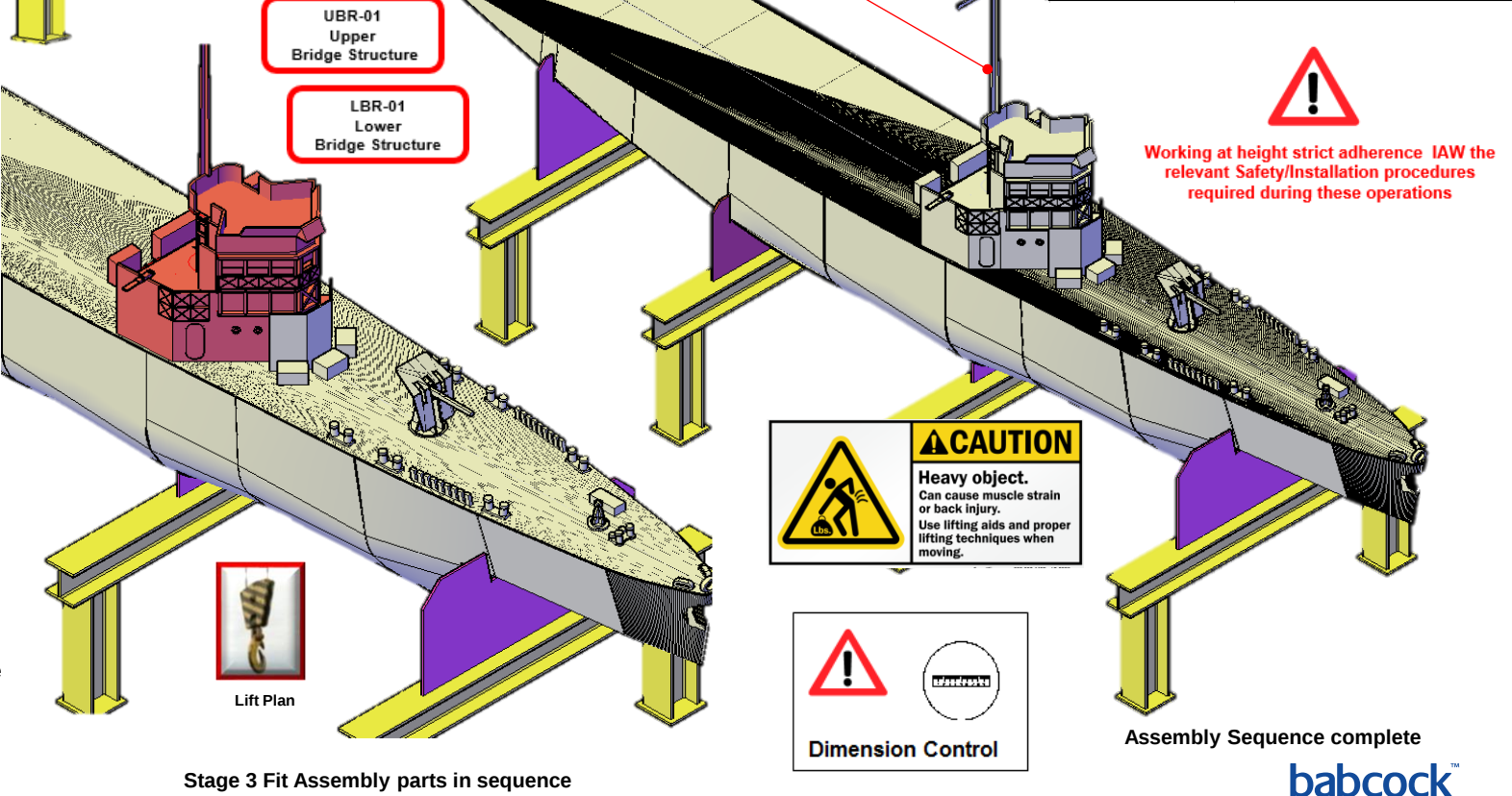
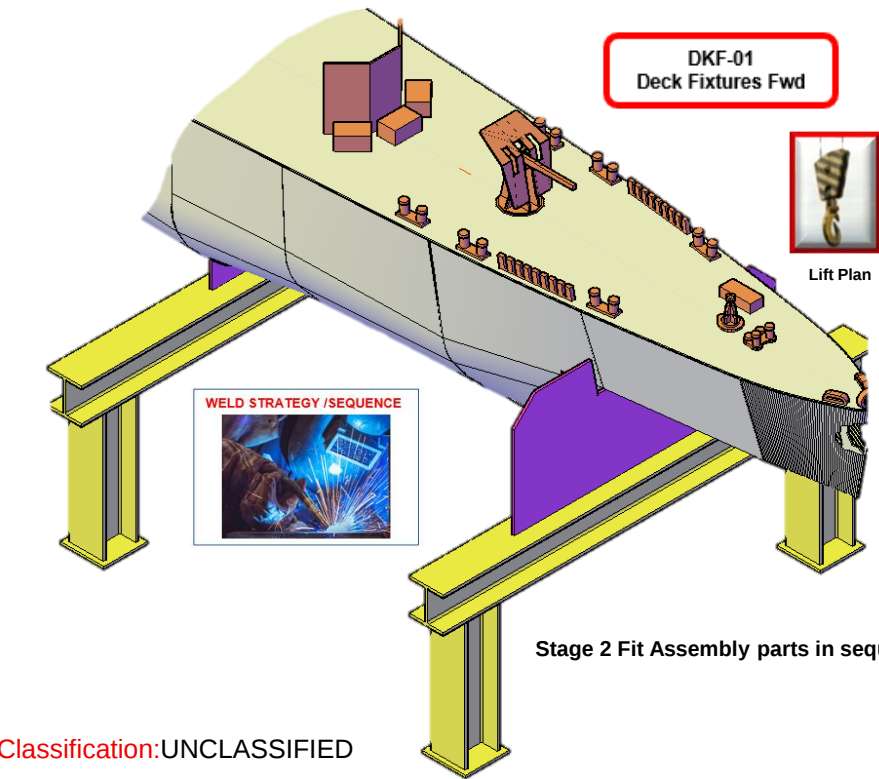
HMS CAMPBELTOWN DECK-01 PRINCIPAL DIMENSIONS	
Length Overall (mm)	6360
Beam (mm)	967
Height (mm)	790
Displacement (Kg)	444.2 .Kg
See Dwg Number DECK-01 for Details	



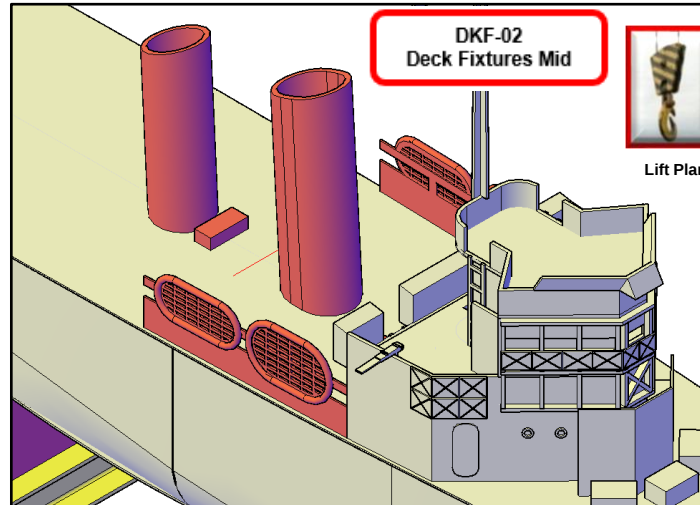
Operation Chariot Build Method DKF-01 – BRI-01



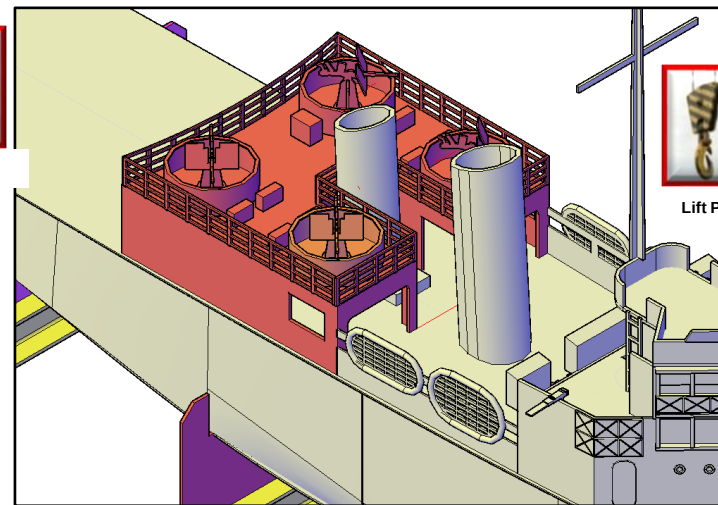
HMS CAMPBELTOWN DECK-01 PRINCIPAL DIMENSIONS	
Length Overall (mm)	6360
Beam (mm)	967
Height (mm)	790
Displacement (Kg)	444.2 .Kg
See Dwg Number DECK-01 for Details	



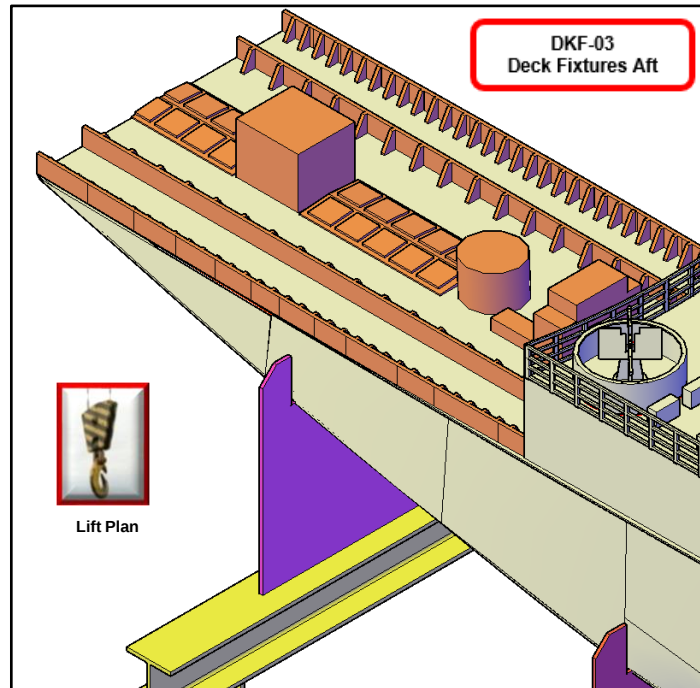
Operation Chariot Build Method DKF-02 DKF-03 MGP-01 AGP-01



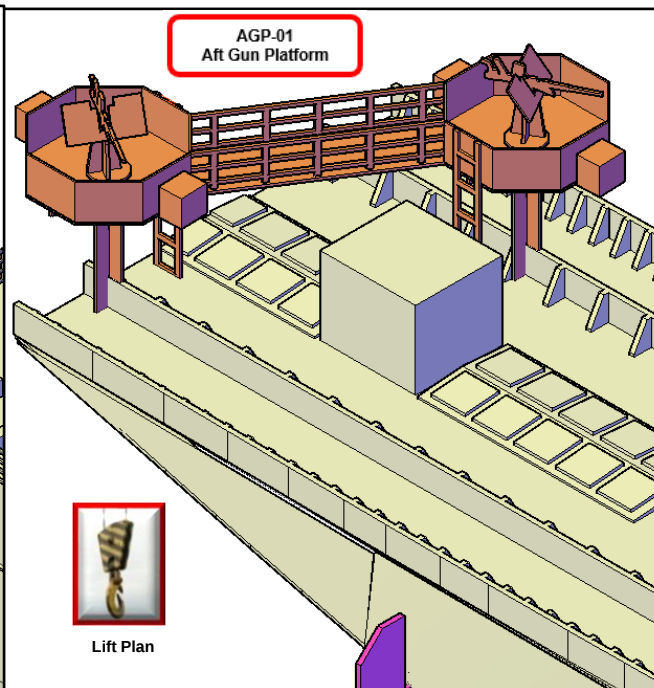
Stage 1 Fit Assembly parts in sequence



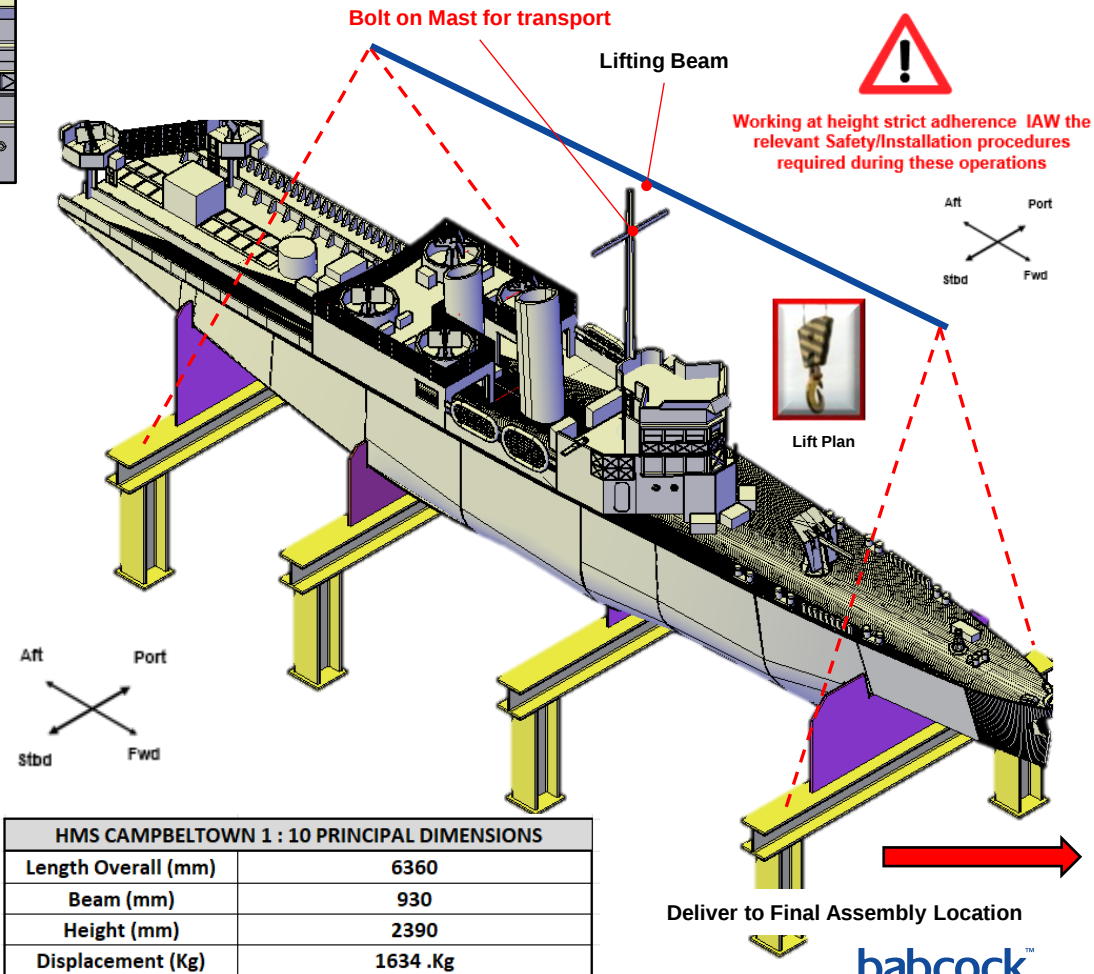
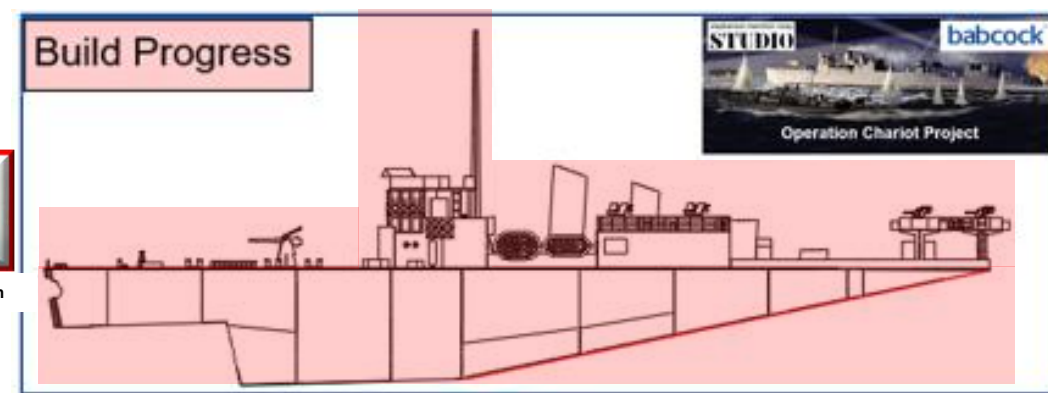
Stage 2 Fit Assembly parts in sequence



Stage 3 Fit Assembly parts in sequence



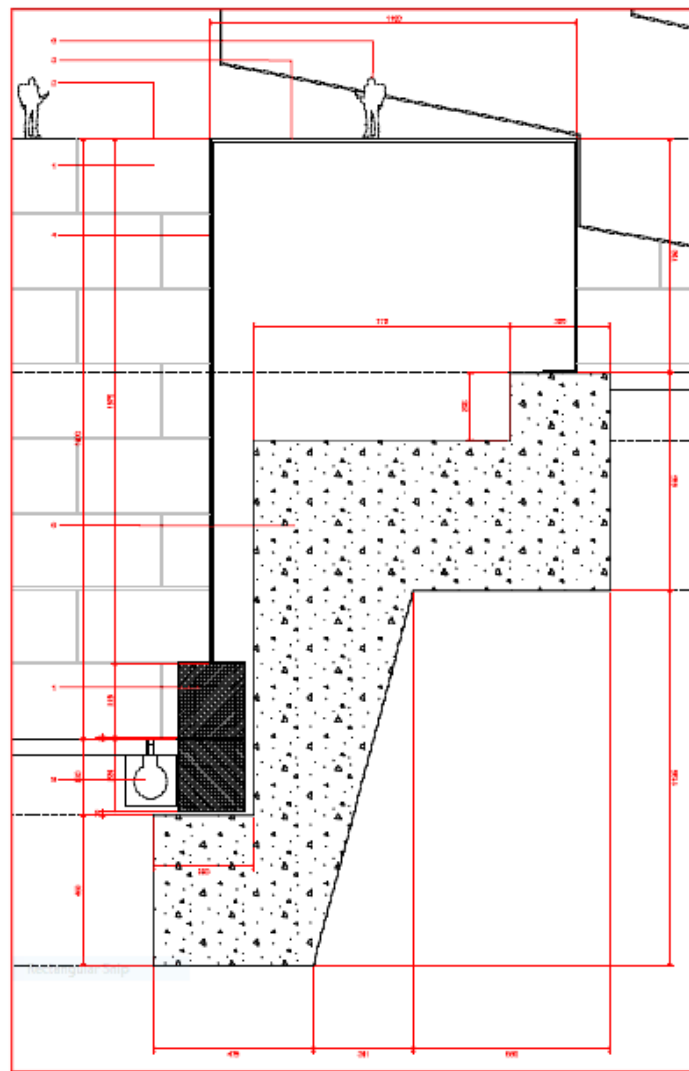
Stage 4 Fit Assembly parts in sequence



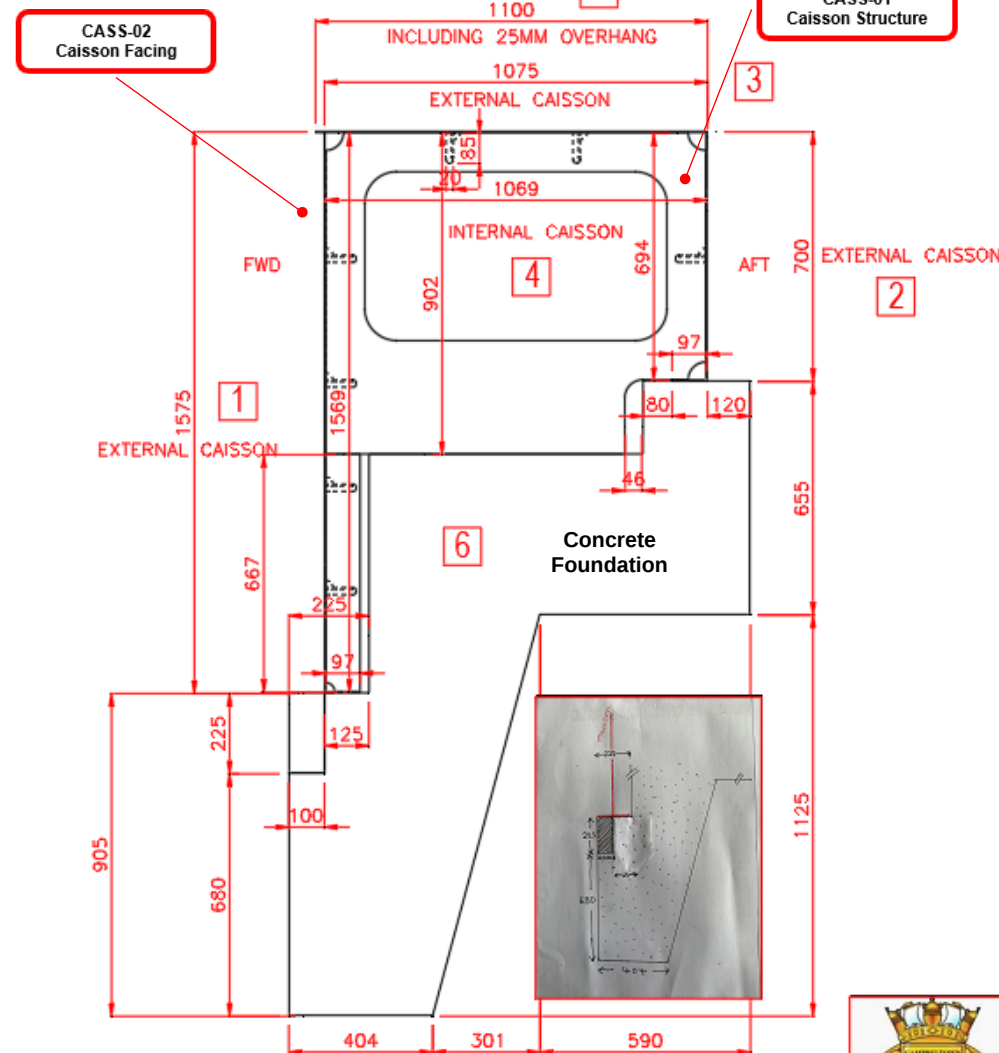
Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Build Method CASS-01 CASS-02



CONCRETE FOUNDATIONS / CAISSON DIMENSION CHECK



CONCRETE FOUNDATIONS / CAISSON DIMENSION CHECK

1 - DIMENSION QUERY



OPERATION CHARIOT
CASS-01 Sheet 1

Manufacture Notes

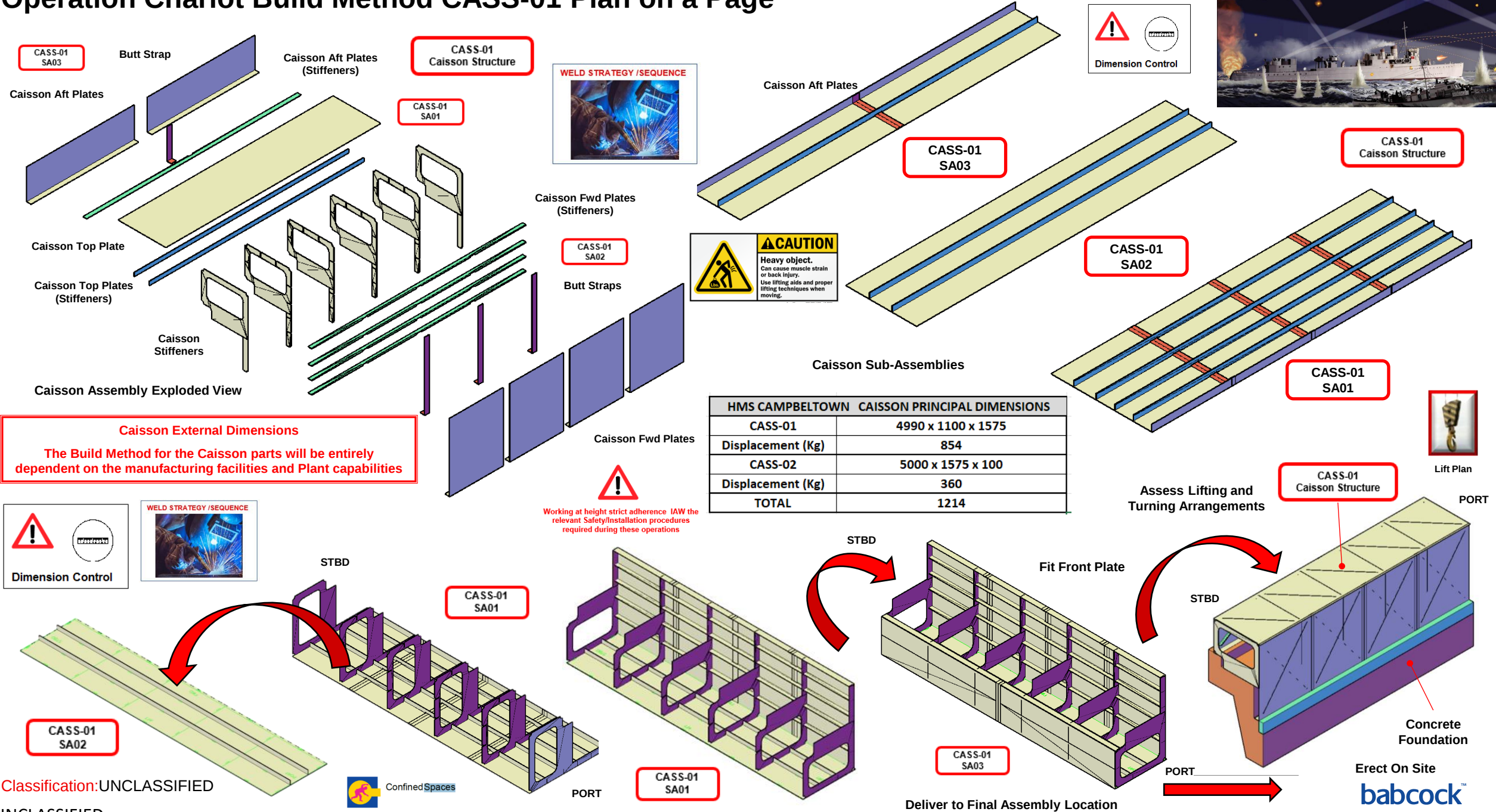
1. Can we achieve the flanging operation of CASS-01 in one piece, check on facilities and plant available.
2. The full extent of the Caisson is 5000 wide. How do we fit this into the space between the Piers i.e. do we leave gaps that are grouted up post installation, check with experts.
3. Do we need access hatches into the body of the caisson for installation.
4. How will the Caisson be secured to the concrete foundations.
5. How do we install the Caisson eg Forklift via structural "pockets" mobile crane, expert opinion required.
6. We can not provide a service to etch the OPERATION CHARIOT details on the Caisson Facing need expert advice on the process and the thickness of material.
7. How do we fix the Caisson facing to the Caisson body, bolts, rivets.



Caisson Front Panel Sub-Con Supply

babcock

Operation Chariot Build Method CASS-01 Plan on a Page

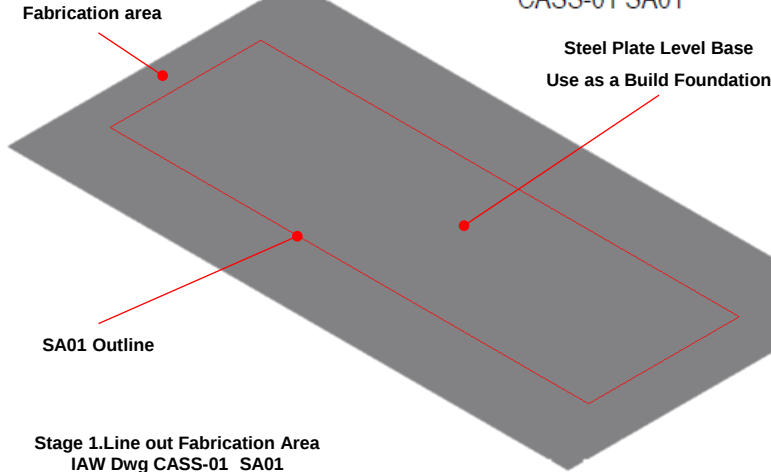


Classification: UNCLASSIFIED
UNCLASSIFIED

Operation Chariot Build Method CASS-01-SA01

Marshall all required parts to the Fabrication Area

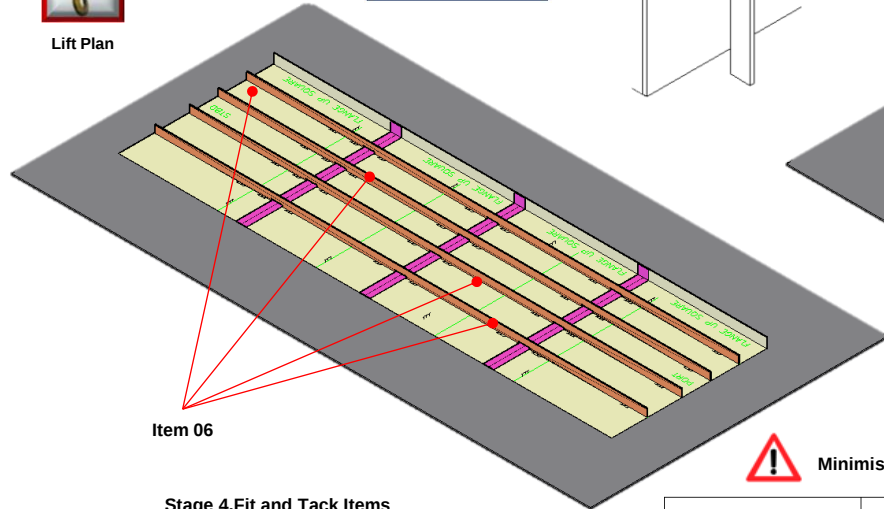
OPERATION CHARIOT CASS-01 SA01



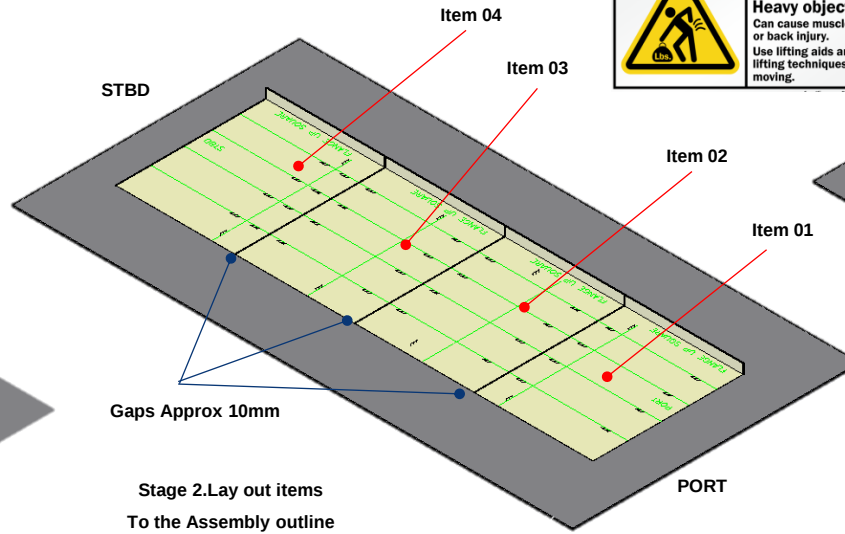
Stage 1.Line out Fabrication Area
IAW Dwg CASS-01 SA01



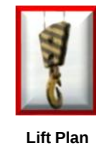
Lift Plan



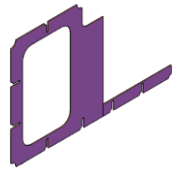
Stage 4.Fit and Tack Items



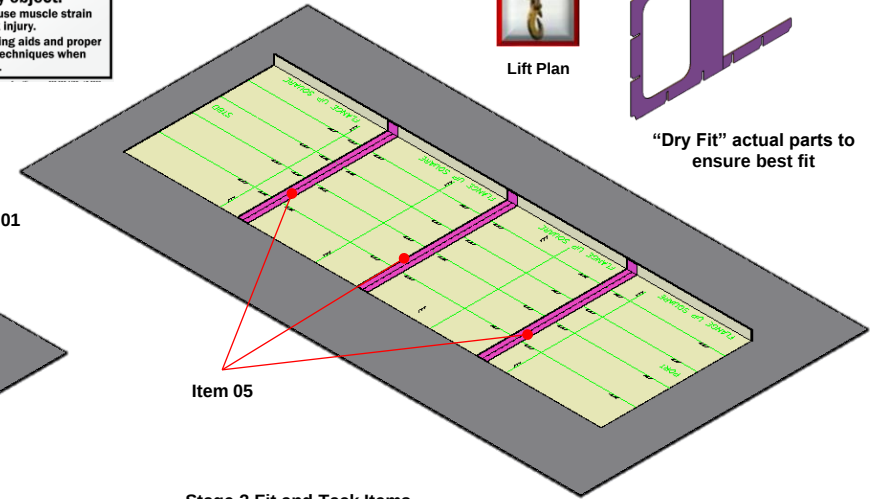
Stage 2.Lay out items
To the Assembly outline



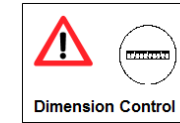
Lift Plan



"Dry Fit" actual parts to ensure best fit



Stage 3.Fit and Tack Items



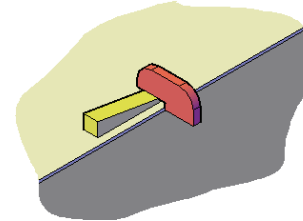
Working at height strict adherence IAW the relevant Safety/Installation procedures required during these operations

CASS-01 SA01 PRINCIPAL DIMENSIONS	
4990 x 1572 x 100	
289.4.Kg	

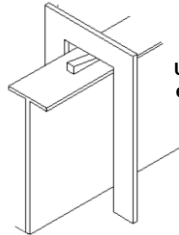
Temporary tie down the free edges to maintain Dim-Con and minimise distortion



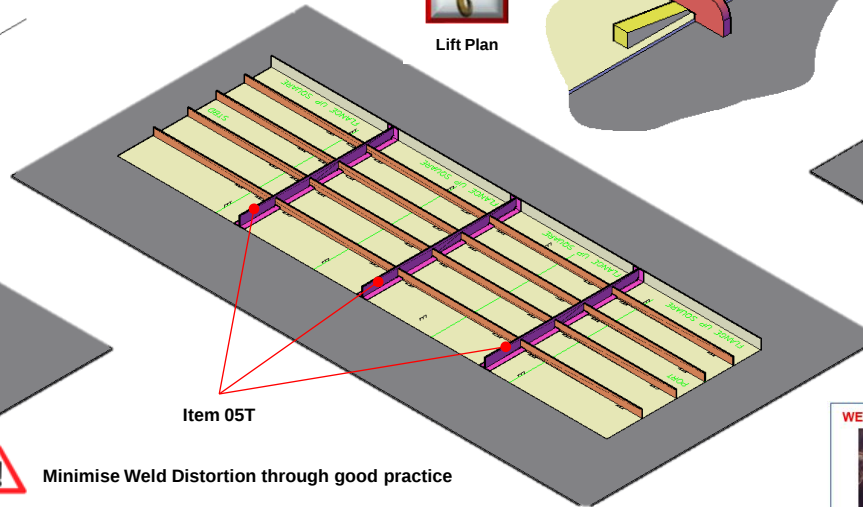
Lift Plan



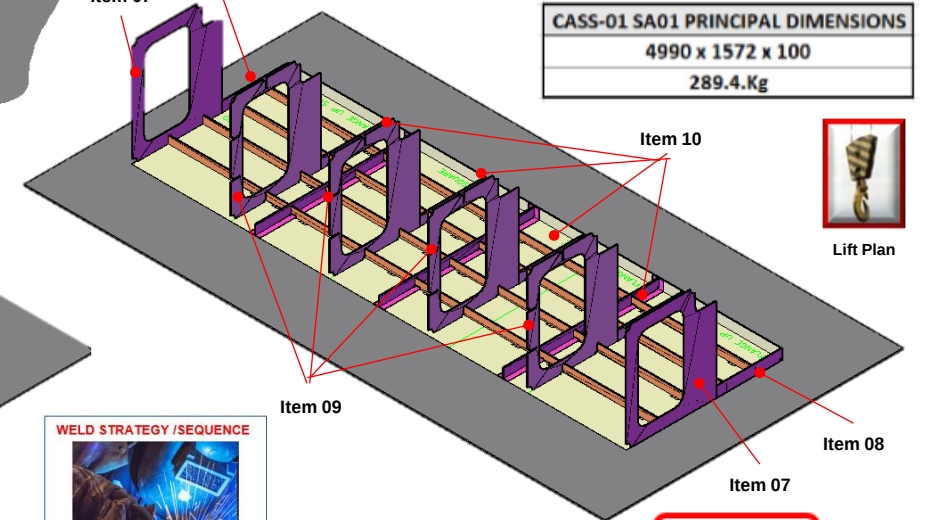
Utilise Fabrication Aids to ensure minimal distortion



Minimise Weld Distortion through good practice



Stage 5.Fit and Tack Items



Stage 6 .Fit and Tack Items
Complete all welding
Assembly complete



Lift Plan

CASS-01
SA01

babcock

 Classification: UNCLASSIFIED	Weld Distortion Reduction Welder Guidelines		DOC No:	TSC-DC-01
			REVISION:	0
CONTRACT:	TYPE 31 Project	FABRICATION CODE:	Lloyds 2017	

Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Build Method CASS-01-SA02 – SA03

Marshall all required parts to the Fabrication Area

OPERATION CHARIOT
CASS-01 SA03

Fabrication area

Steel Plate Level Base
Use as a Build Foundation

SA02 Outline

OPERATION CHARIOT
CASS-01 SA02

Stage 1.Line out Fabrication Area
IAW Dwg's CASS-01 SA02 & SA03

SA03 Outline

STBD

CASS-01 SA03 PRINCIPAL DIMENSIONS	
4990 x 697 x 100	
113.1 Kg	

Item 14

Gap Approx 10mm

Item 13

Item 11

Stage 2.Lay out items
To the Assembly outline

CASS-01 SA02 PRINCIPAL DIMENSIONS	
4990 x 1100 x 78	
158.6.Kg	

CASS-01
SA03

PORT

CASS-01
SA02

Item 12

Stage 3.Fit and Tack Items

Lifting and turning assessment
required at this stage

Lift Plan

Dimension Control

Working at height strict adherence IAW the
relevant Safety/Installation procedures
required during these operations

CASS-01
SA01

Utilise Fabrication Aids to
ensure minimal distortion

Lift Plan

Threaded
Padeye

Bolted
Padeye

Welded Padeye

Bolted
Padeye

Magnetic
Lift

CASS-01
SA01

CASS-01
SA02

Stage 5.Prepare to Lift and Turn SA01 to SA02

Minimise Weld Distortion through good practice

Classification: UNCLASSIFIED 	Weld Distortion Reduction Welder Guidelines		DOC No:	TSC-DC-01
			REVISION:	0
CONTRACT:	TYPE 31 Project	FABRICATION CODE:	Lloyds 2017	

Lift Plan

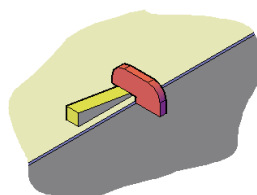
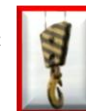
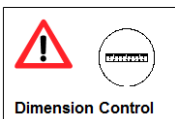
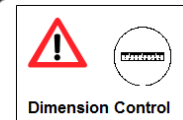
WELD STRATEGY /SEQUENCE

CASS-01
SA03

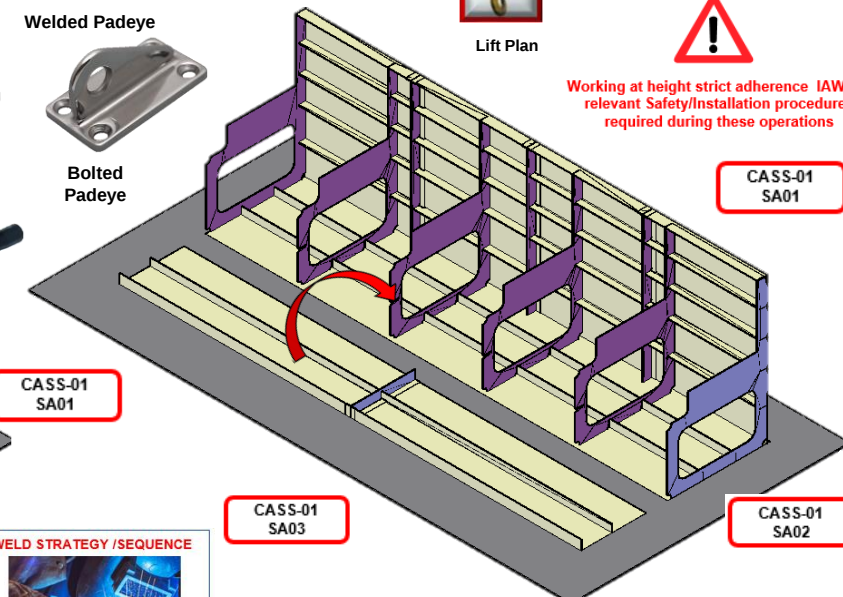
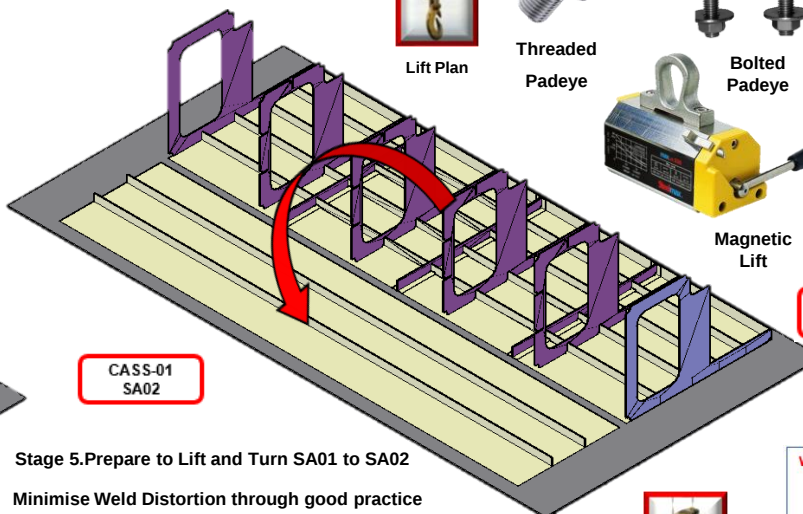
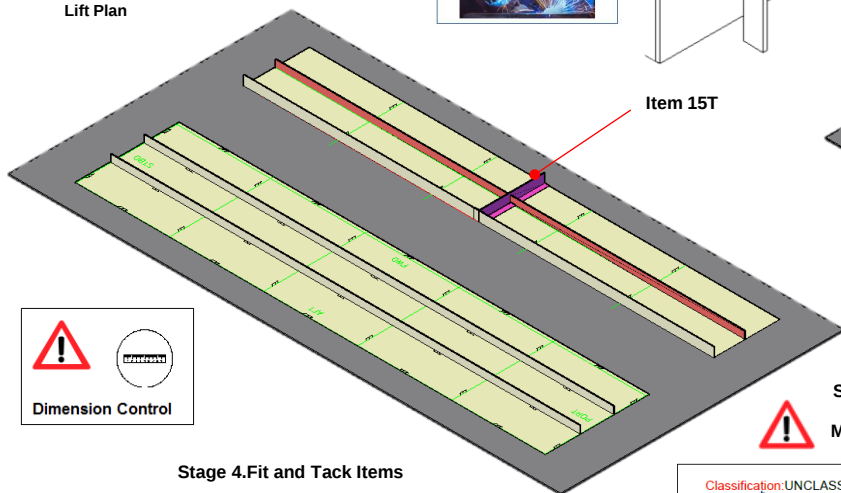
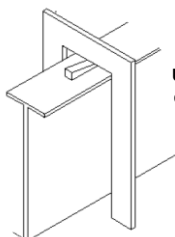
Stage 6.Prepare to Lift and Turn
SA03 to SA01/2 Assembly
Complete all welding
requirements

CASS-01
SA02





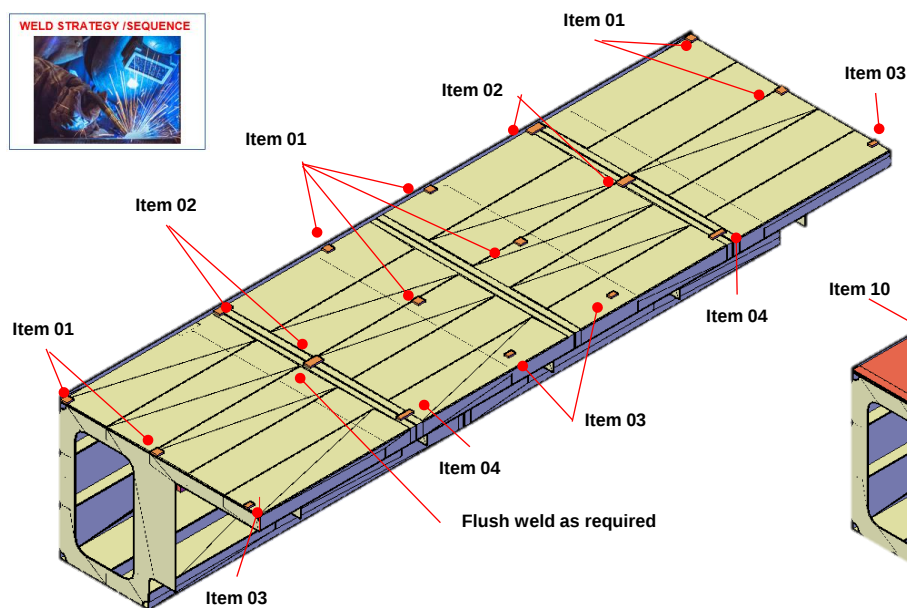
Temporary tie down the free edges to maintain
Dim-Con and minimise distortion



Classification: UNCLASSIFIED

UNCLASSIFIED

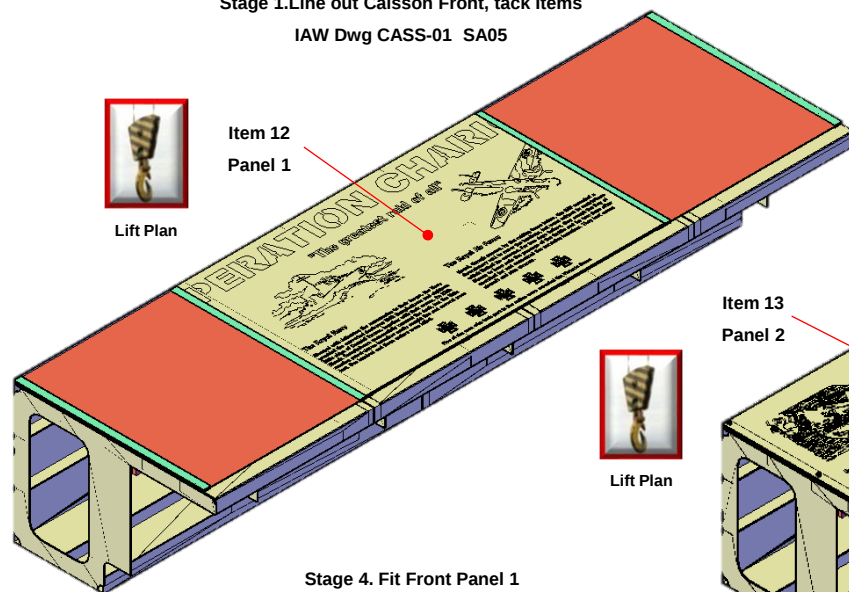
Operation Chariot Build Method CASS-01



Stage 1.Line out Caisson Front, tack Items
IAW Dwg CASS-01 SA05



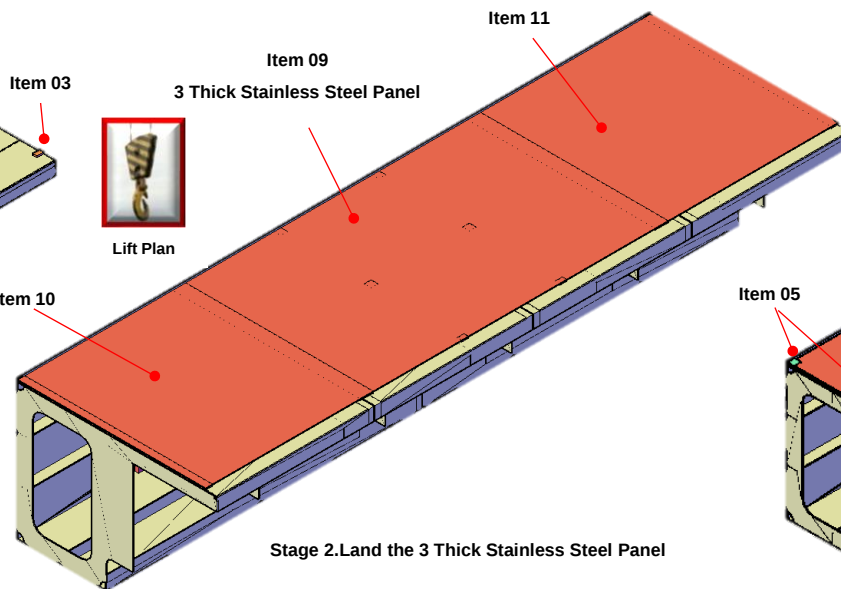
Lift Plan



Stage 4. Fit Front Panel 1



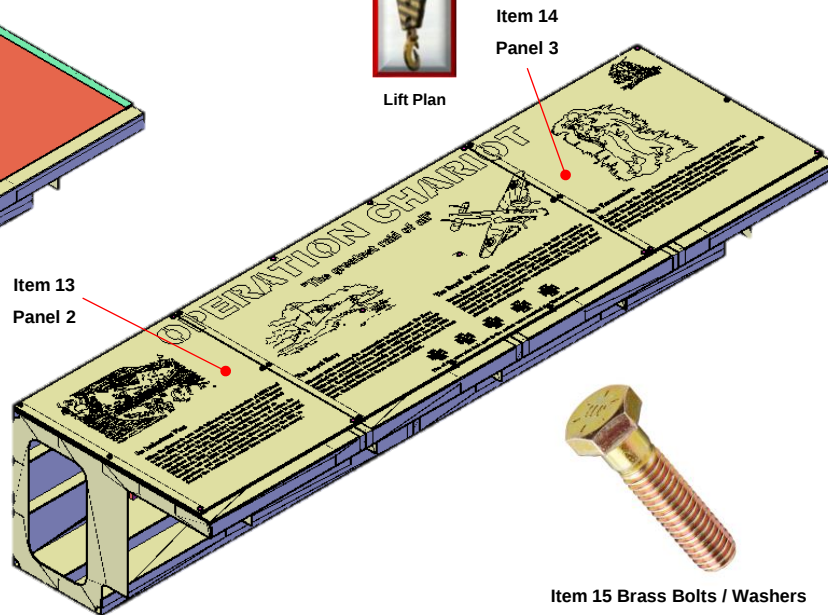
Lift Plan



Stage 2.Land the 3 Thick Stainless Steel Panel



Lift Plan



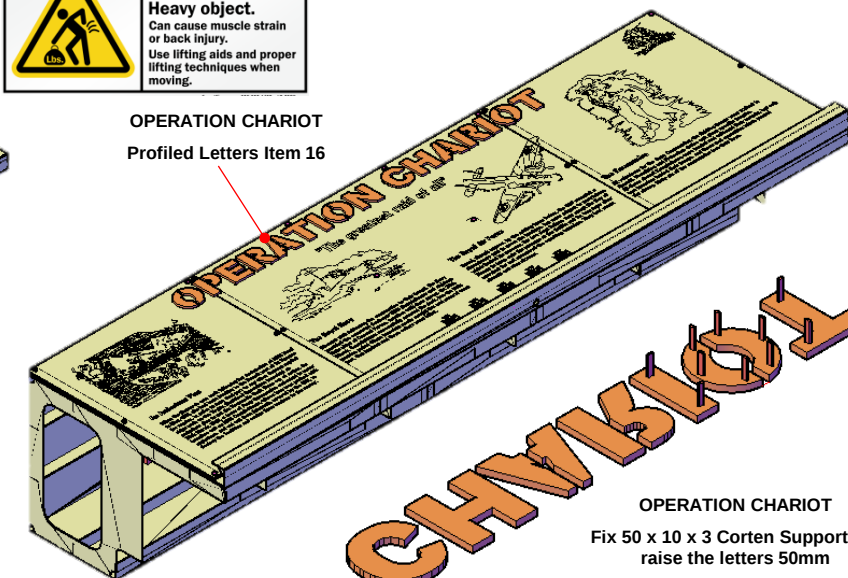
Stage 5. Fit Front Panels 2 and 3



Item 15 Brass Bolts / Washers
3/8 UNC x 2" Long



OPERATION CHARIOT
Profiled Letters Item 16

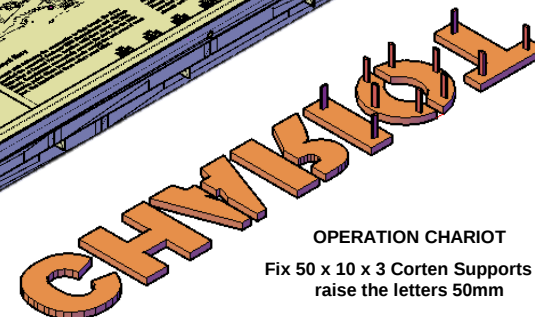


Stage 6. Fit OPERATION CHARIOT letters



Working at height strict adherence IAW the relevant Safety/Installation procedures required during these operations

Stage 3.Line out Caisson Front, tack Items
IAW Dwg CASS-01 SA05



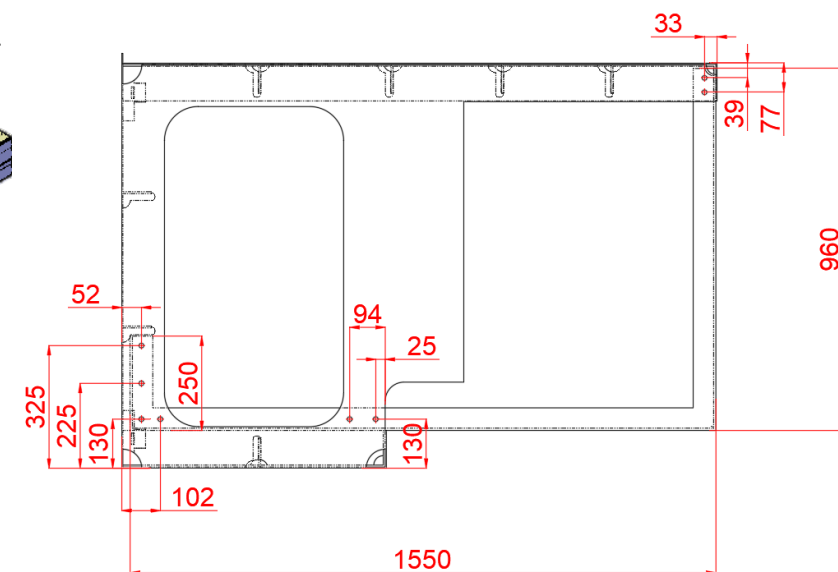
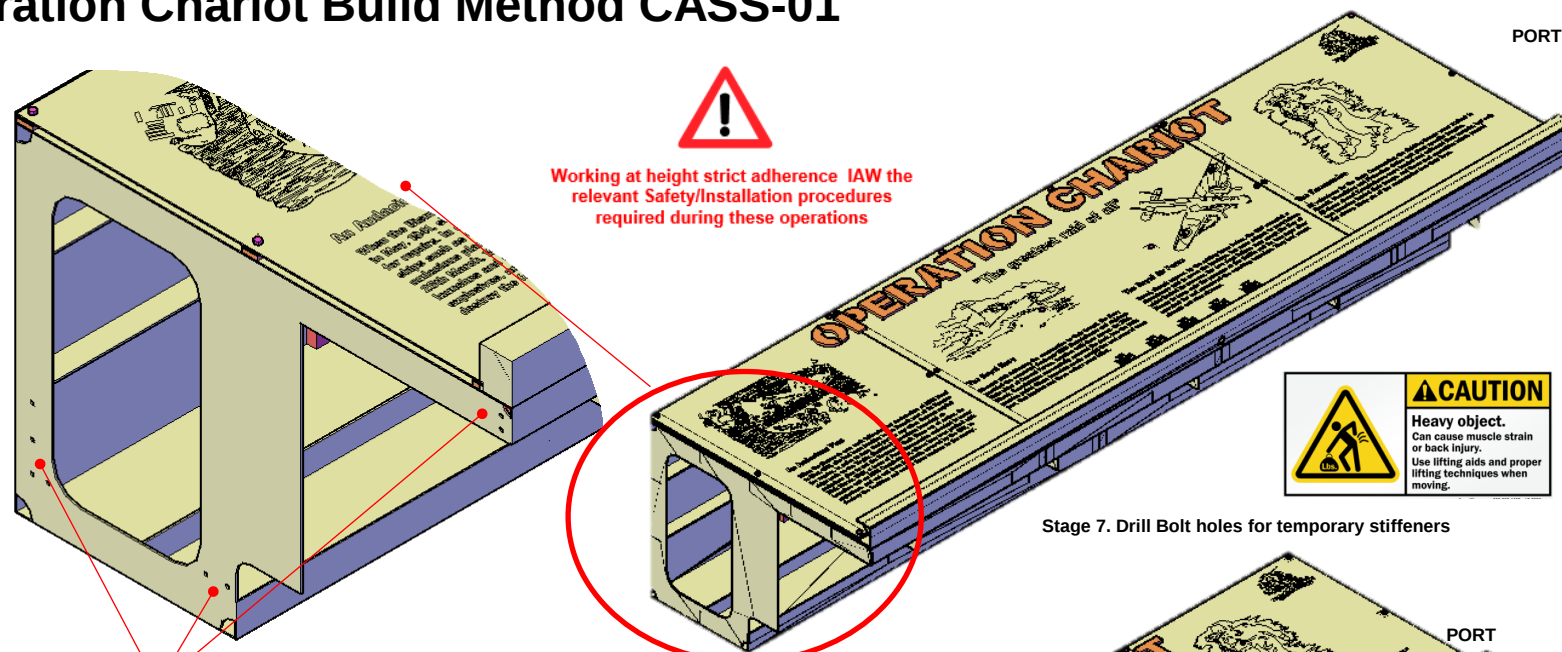
OPERATION CHARIOT
Fix 50 x 10 x 3 Corten Supports to raise the letters 50mm

HMS CAMPBELTOWN CAISSON PRINCIPAL DIMENSIONS	
CASS-01	4990 x 1100 x 1575
Displacement (Kg)	1500

Classification: UNCLASSIFIED

UNCLASSIFIED

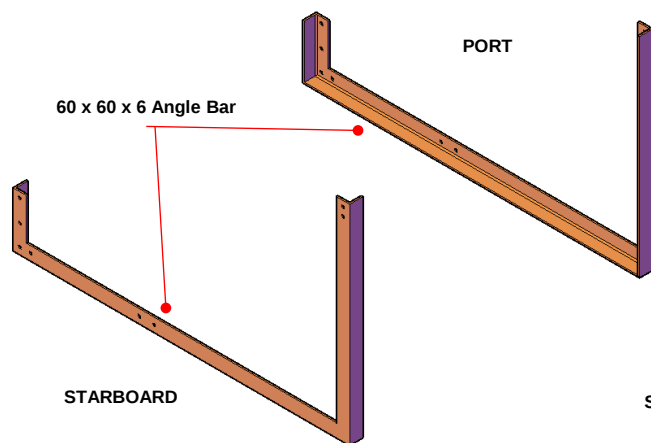
Operation Chariot Build Method CASS-01



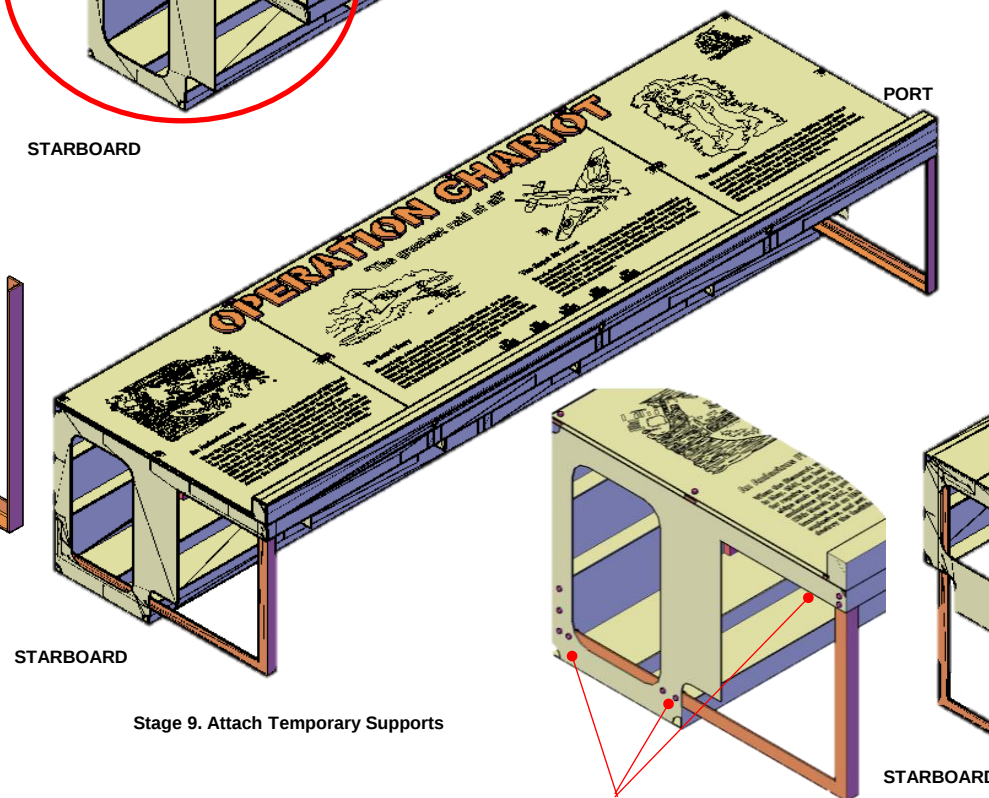
Position holes IAW Drawing



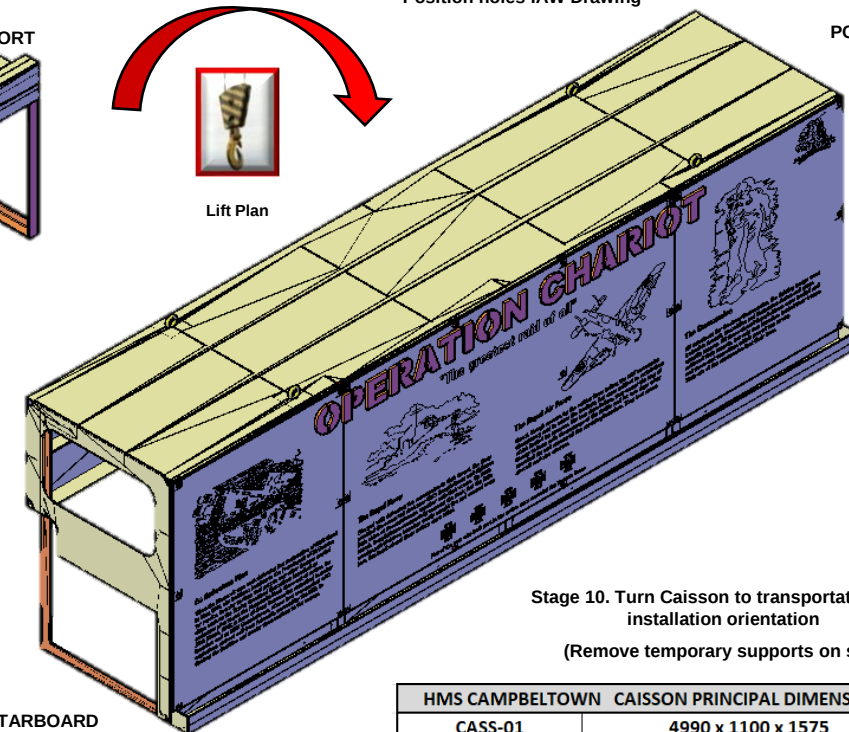
8 x holes in Caisson Port and Stbd Side typical



Stage 8. Manufacture Temporary Supports



Stage 9. Attach Temporary Supports



Stage 10. Turn Caisson to transportation and installation orientation
(Remove temporary supports on site)

HMS CAMPBELTOWN CAISSON PRINCIPAL DIMENSIONS	
CASS-01	4990 x 1100 x 1575
Displacement (Kg)	1500

Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Scale Model 1:100 Build Method

Manufacture Notes

A 3D printed model kit is available and will build up to a 1:100 scale model
This will allow the builders to familiarise themselves with the actual build and plan ahead for construction

OPERATION CHARIOT MODEL 1:100						
Nest	Afte	Jo	College	3D Printer	Quantity	Comment
HULLXFW				Crealty	1	Fwd Hull
HULLXMID				Crealty	1	Mid Hull
HULLXAFT				Crealty	1	Aft Hull
2DECK				Ultimaker	1	2 Deck Part
FRX1				Ultimaker	1	Fwd Frame
KEELX1				Ultimaker	1	Fwd Keel
KEELX2				Ultimaker	1	Aft Keel
BRIDGENEST2				Crealty	1	Bridge Parts
DECKFIT2				Crealty	1	Deck Fixtures
AFTPLAT2				Crealty	1	Aft Gun Platform
CAISSON				Crealty	5	Caisson Parts
					15	



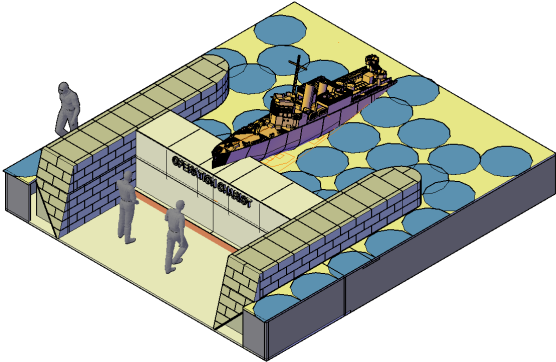
Deck ,Keel and Frames



Shell Fitted



Caisson

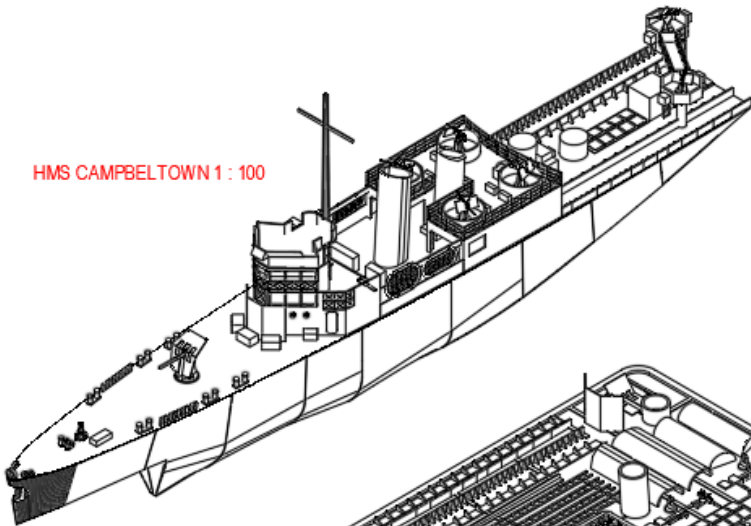


Manufacture Notes

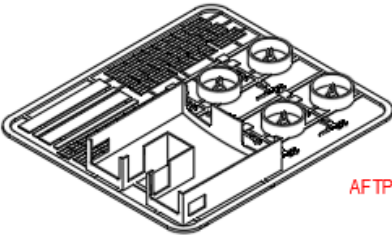
A 1:100 Scale Model of Operation Chariot and the surrounding location (as shown above) will be available at the Rosyth meeting

DATE TBD

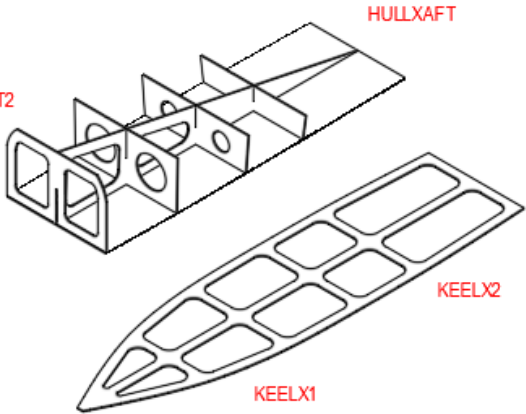
babcock



HMS CAMPBELTOWN 1 : 100



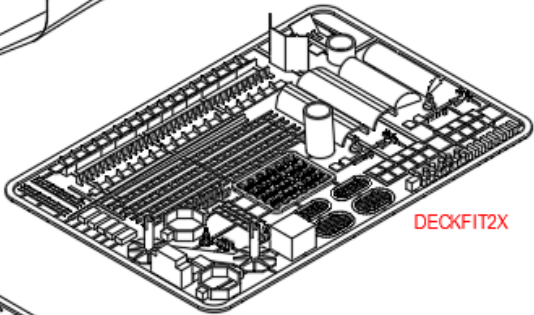
AFTPLATNEST2



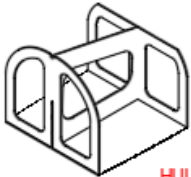
HULLXAFT

KEELX2

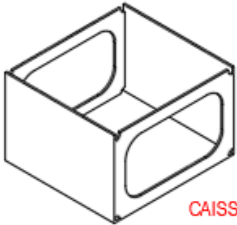
KEELX1



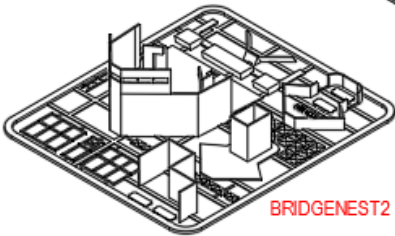
DECKFIT2X



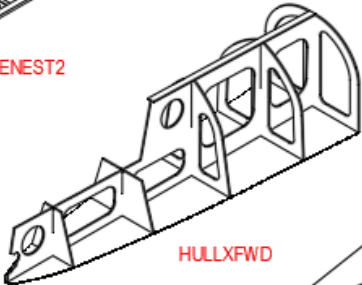
HULLXMID



CAISSON



BRIDGENEST2



HULLXFW



2DECK

FRX1



OPERATION CHARIOT
MODEL NESTS

Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Transportation and Installation

Manufacture Notes

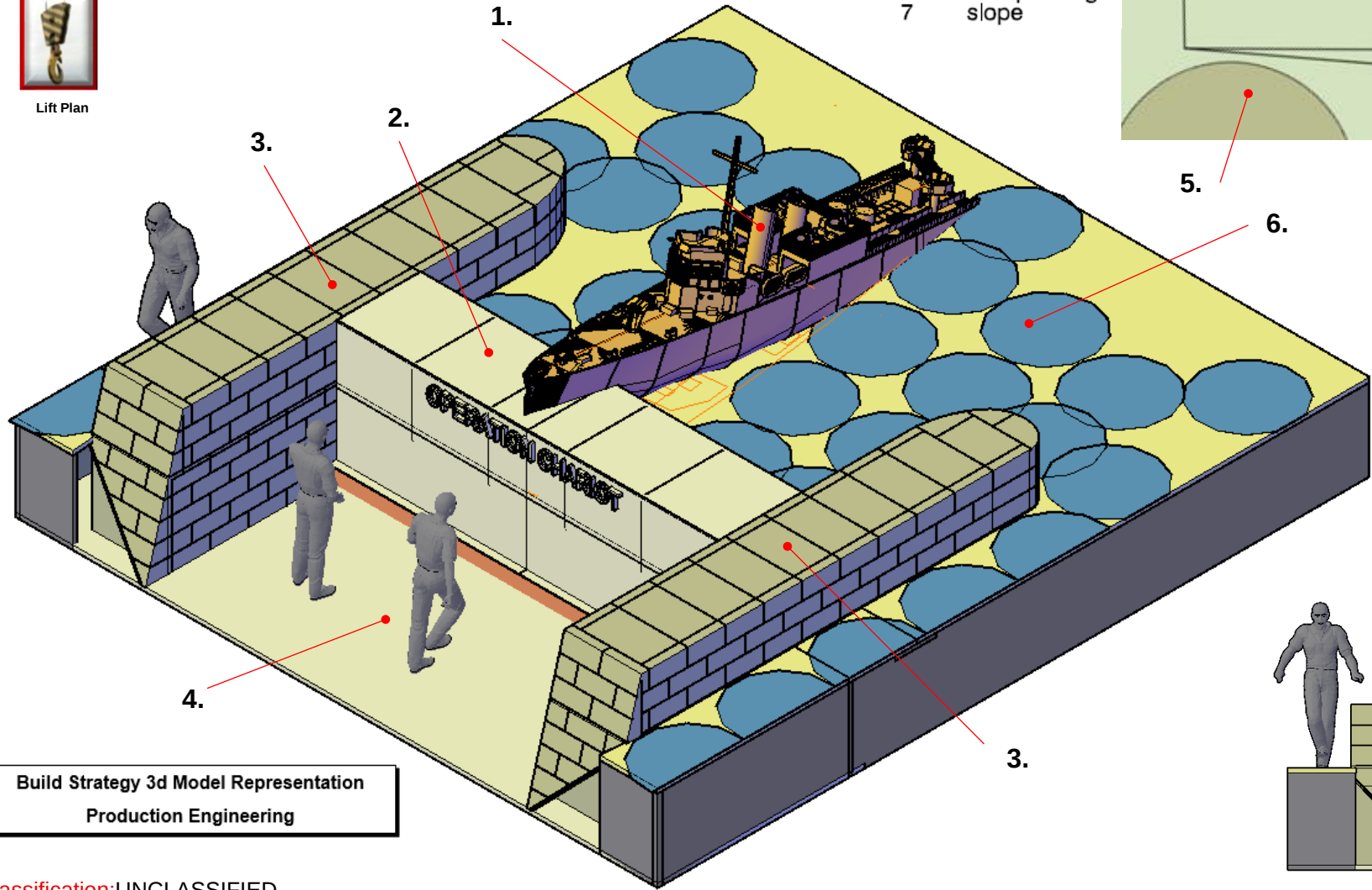
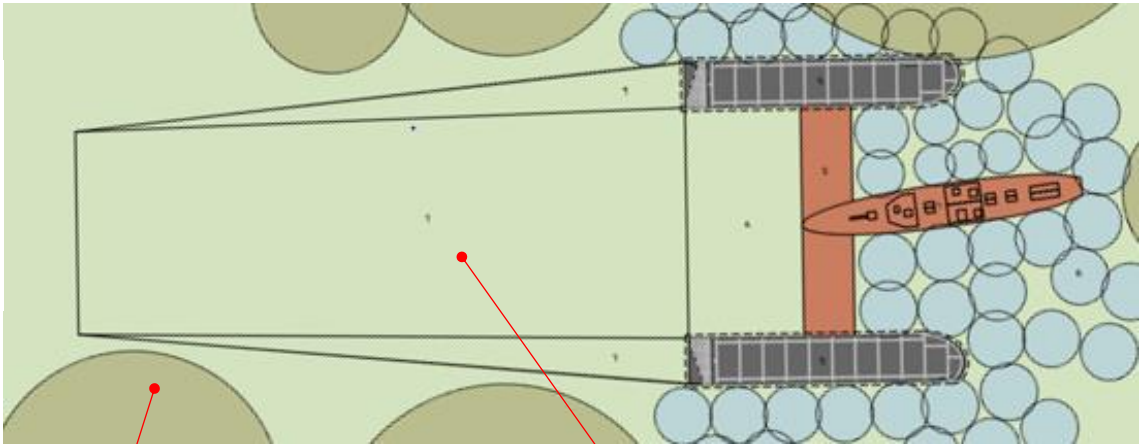
A 3D model is available showing a part section of the memorial location this will allow us to plan the logical sequence of events And logistics around the memorial build



Lift Plan

key

- 1 ship
- 2 caisson
- 3 dock walls
- 4 viewing area
- 5 existing trees
- 6 new planting
- 7 slope

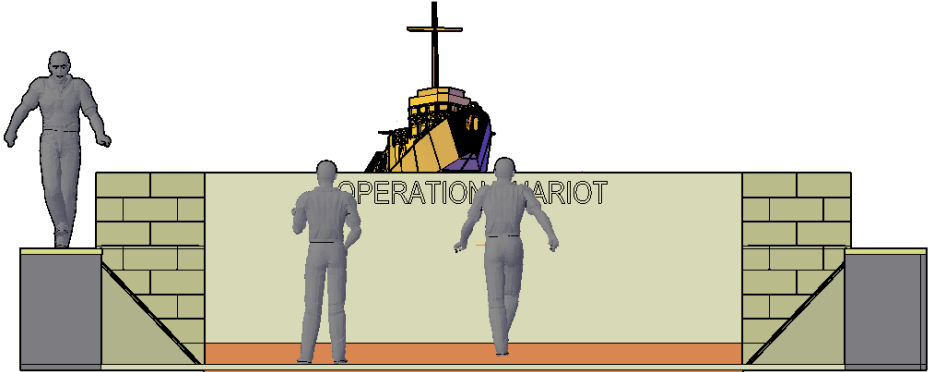


Build Strategy 3d Model Representation
Production Engineering

project
operation chariot
job no.
OPCH
title
site plan
scale
1:100 @ A3
drawing no.
SK 0005

stephenson hamilton risley
STUDIO

3 riverside mews
4 commercial street
manchester, M15 4RQ
www.shr.studio
email@shr.studio
0161 832 0244



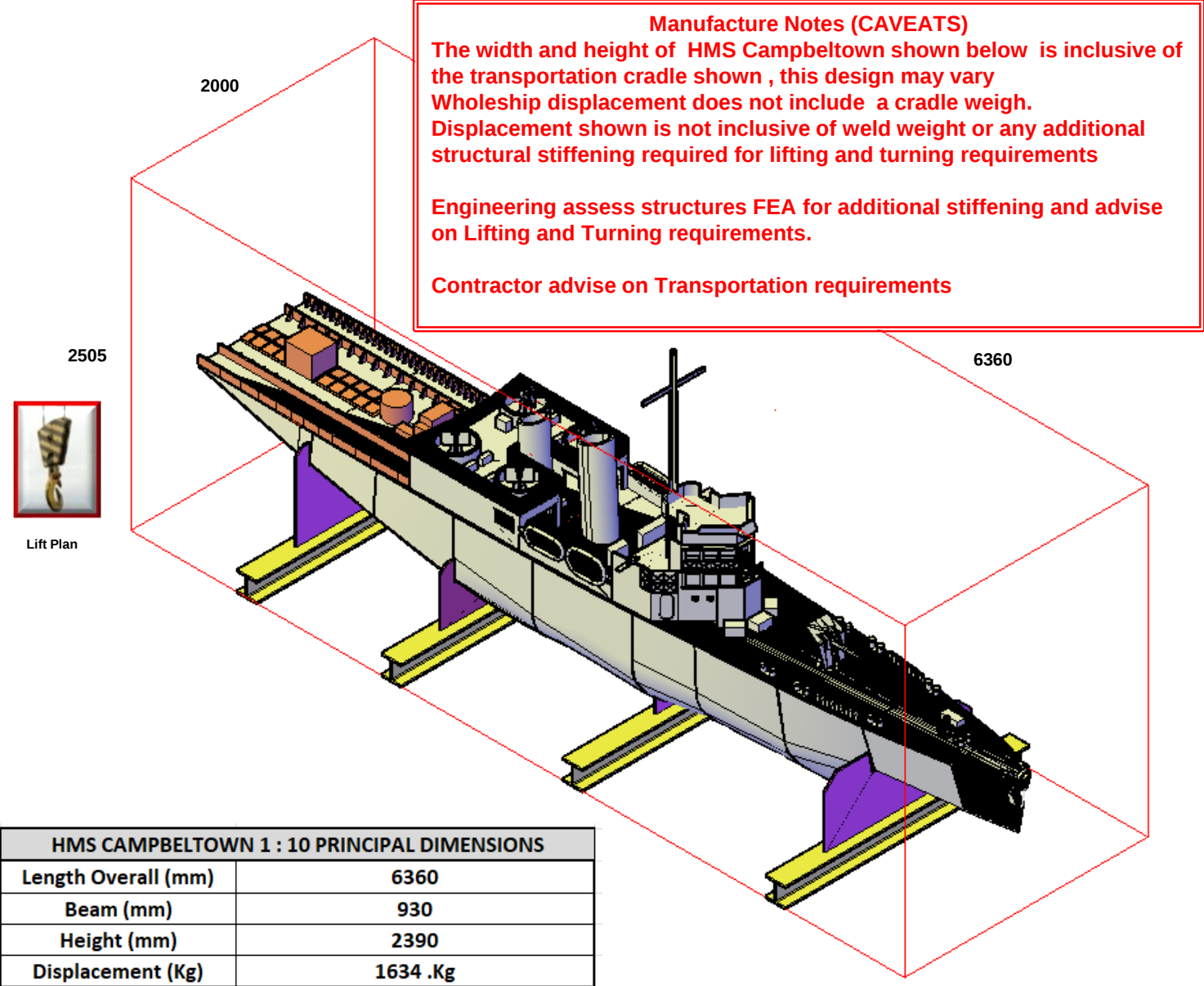
Front Elevation

babcock™

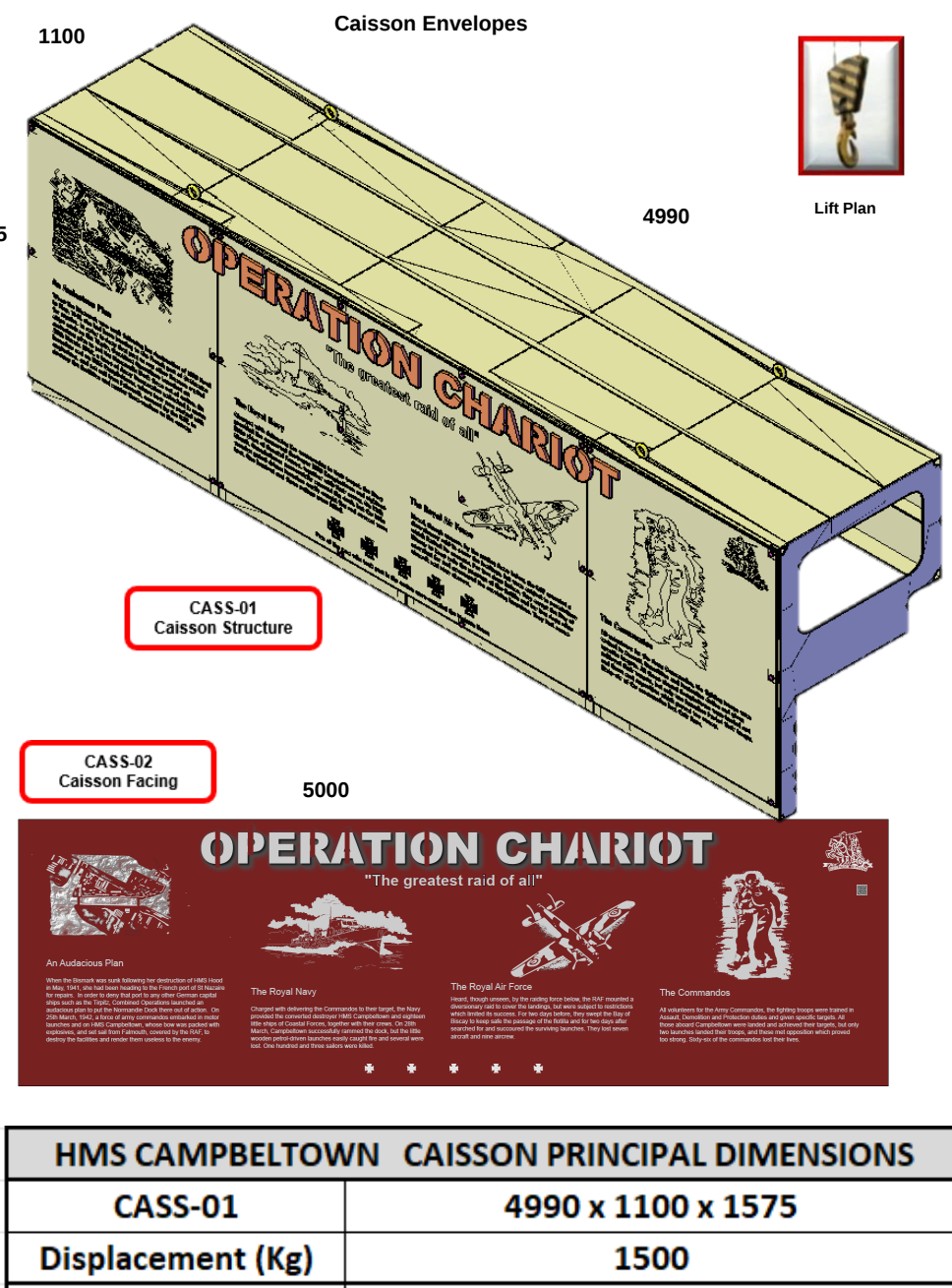
Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Transportation and Installation



Wholeship Envelope



Classification: UNCLASSIFIED

UNCLASSIFIED

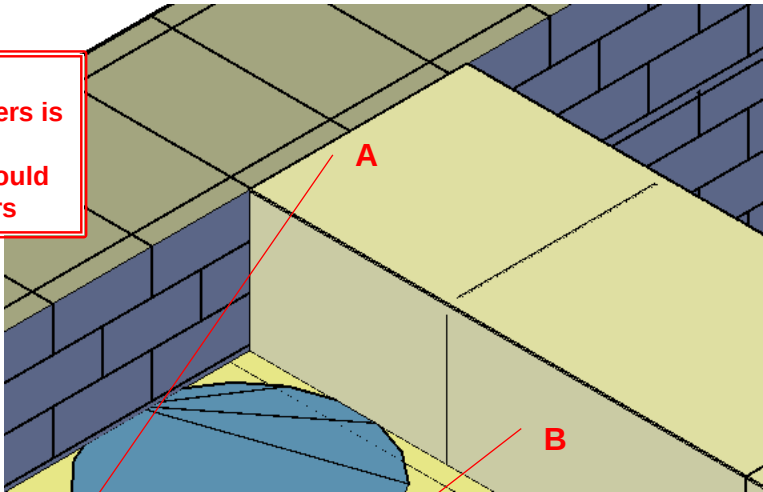
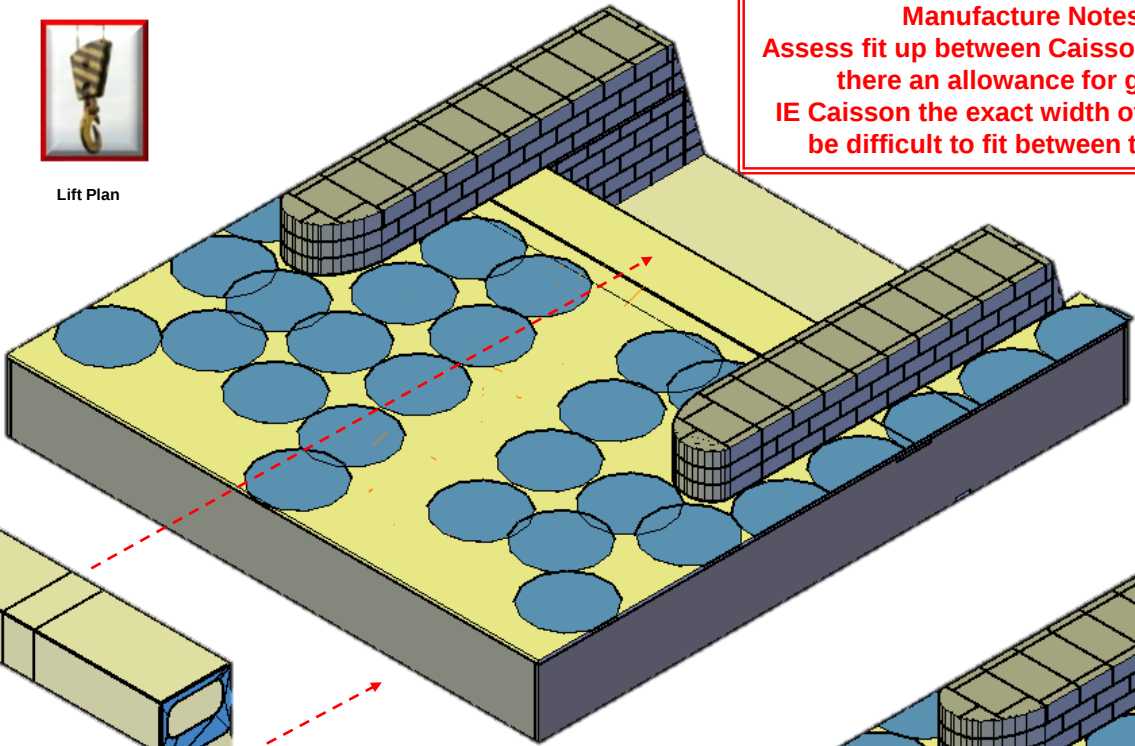
Operation Chariot Transportation and Installation



HIAB Installation



Lift Plan



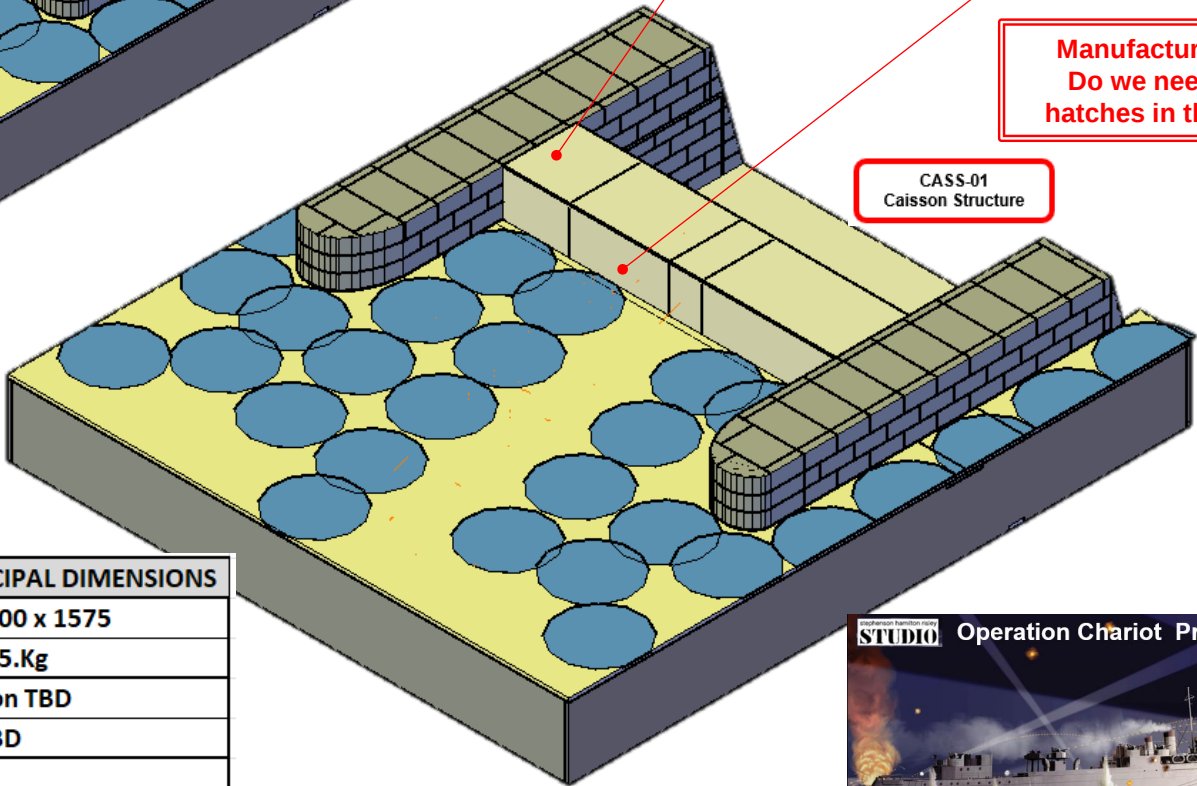
Fork Lift

CASS-01 Caisson Structure



Manitou

Stage 1. Manoeuvre Caisson into Location



Stage 2. Secure Caisson into Location

HMS CAMPBELTOWN 1 : 10 CAISSON PRINCIPAL DIMENSIONS	
CASS-01	4990 x 1100 x 1575
Displacement (Kg)	675.5.Kg
CASS-02	Sub-Con TBD
Displacement (Kg)	TBD
TOTAL	



Working at height strict adherence IAW the relevant Safety/Installation procedures required during these operations

Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Transportation and Installation



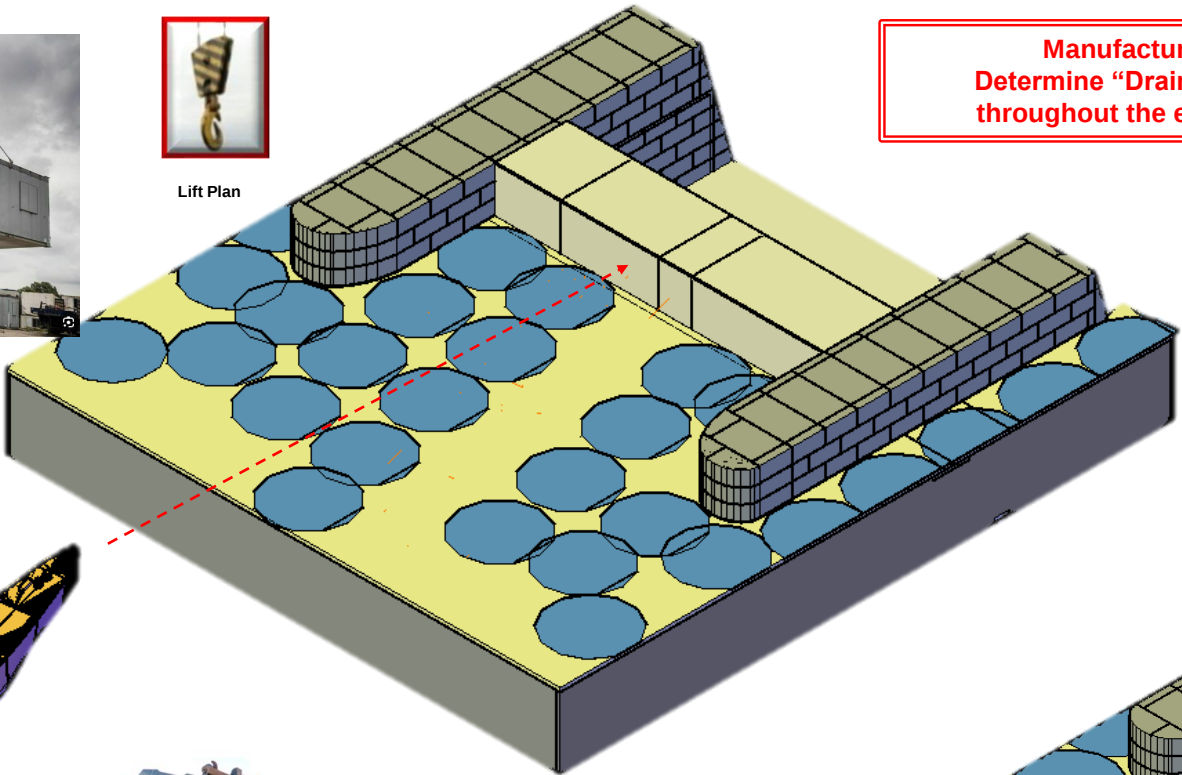
HIAB Installation



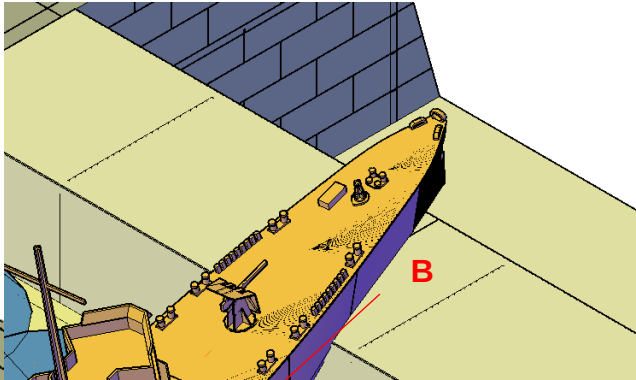
Fork Lift



Lift Plan

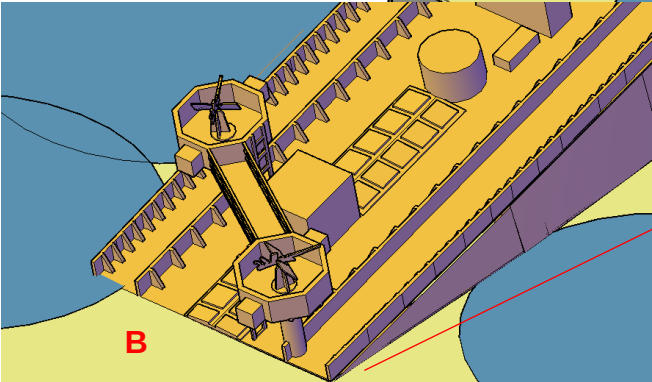


Manufacture Notes A
Determine “Drainage” locations
throughout the entire assembly



Manitou

Stage 3. Manoeuvre Ship into Location




Working at height strict adherence IAW the
relevant Safety/Installation procedures
required during these operations

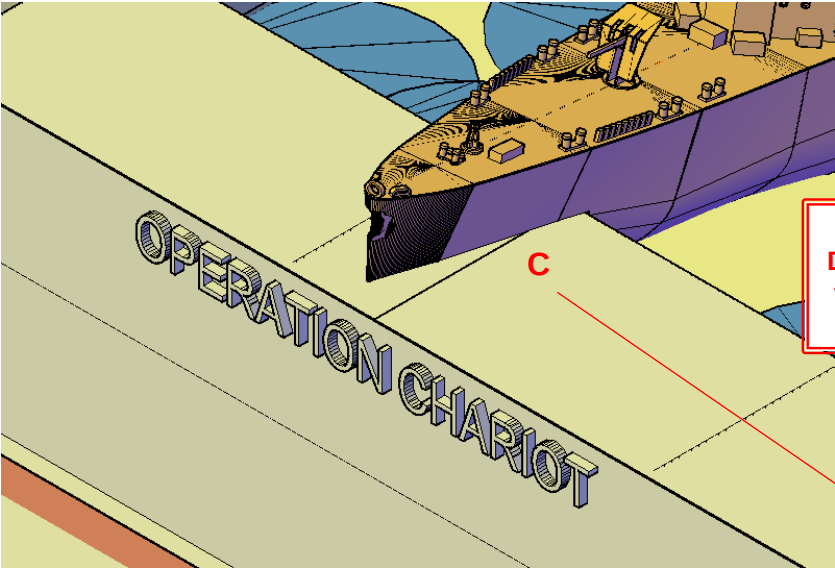
HMS CAMPBELTOWN 1 : 10 PRINCIPAL DIMENSIONS	
Length Overall (mm)	6360
Beam (mm)	930
Height (mm)	2390
Displacement (Kg)	1634 .Kg

Manufacture Notes B
Determine the best way to attach
HMS Campbeltown to the Caisson
and at the Aft end location eg
Welded or bolted

Classification: UNCLASSIFIED

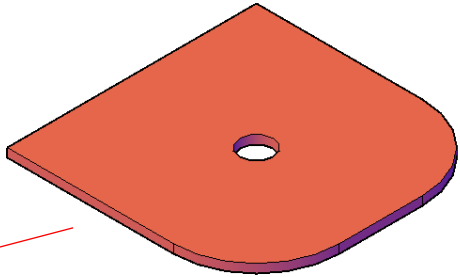
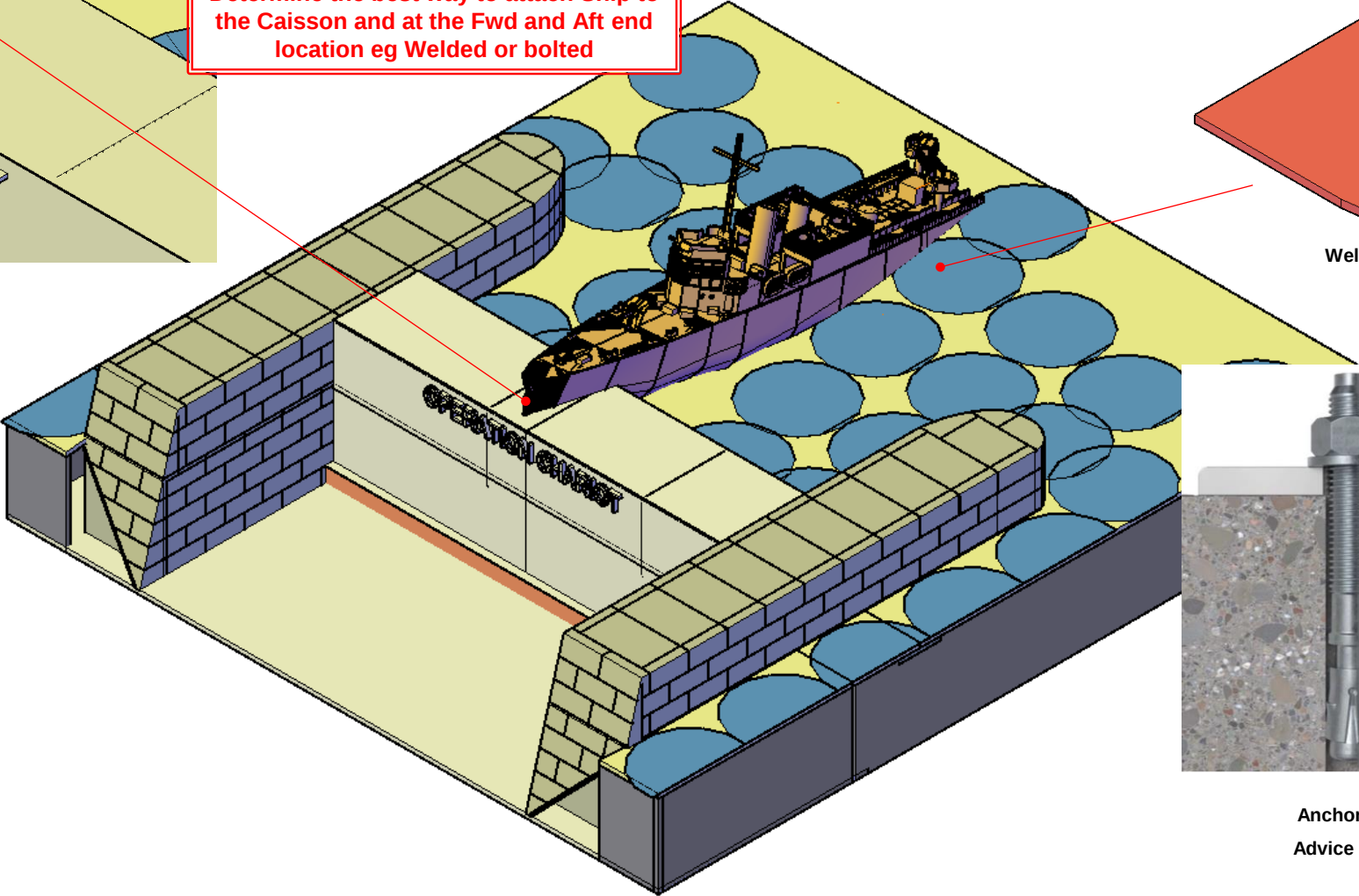
UNCLASSIFIED

Operation Chariot Transportation and Installation



HMS CAMPBELTOWN 1 : 10 CAISSON PRINCIPAL DIMENSIONS	
CASS-01	4990 x 1100 x 1575
Displacement (Kg)	675.5.Kg
CASS-02	Sub-Con TBD
Displacement (Kg)	TBD
TOTAL	

Manufacture Notes C
Determine the best way to attach Ship to the Caisson and at the Fwd and Aft end location eg Welded or bolted



Welded Plates connect hull to concrete foundation



Anchor Bolts ?
Advice required



Lift Plan



Working at height strict adherence IAW the relevant Safety/Installation procedures required during these operations



HIAB Installation

Classification: UNCLASSIFIED

UNCLASSIFIED



HMS Campbeltown Ship 5



A new breed of frigate

Also known as Type 31 frigates, the Inspiration Class will comprise of five ships in total – namely the HMS Venturer, Active, Formidable, Bulldog and Campbeltown. These impressive vessels are currently under construction with HMS VENTURER as the first in Class, scheduled to be In Service and ready for operations by the end of the decade.

All 5 ships are planned to be in service with the Royal Navy by the early 2030s.

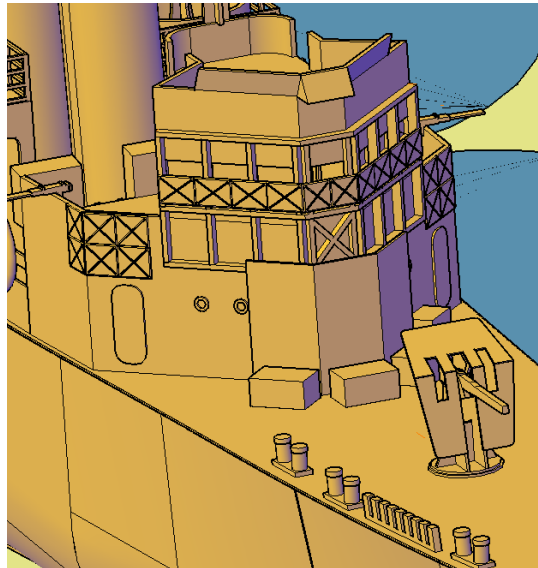
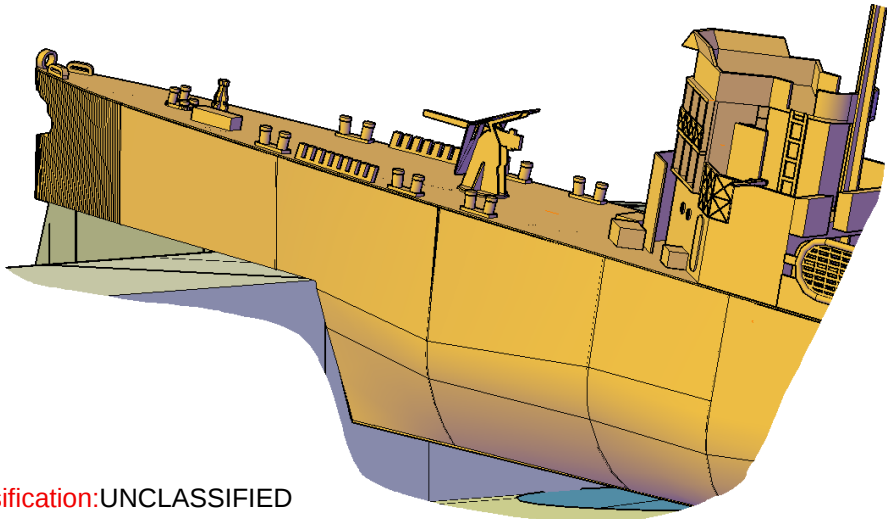
EQUIPMENT / SHIPS

INSPIRATION CLASS

- HMS Campbeltown: Named after the wartime destroyer which led the 'greatest commando raid of all': St Nazaire in France. In March 1942, the ship rammed the dock gates and hidden explosives aboard blew up, wreaking havoc in the port and denying its use to major German warships for the rest of WW2. The action epitomises the raiding ethos driving the Royal Marines' Future Commando Force.



Operation Chariot The Greatest Raid Of All LEST WE FORGET



Classification: UNCLASSIFIED

UNCLASSIFIED

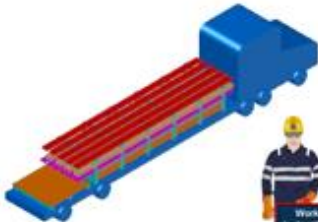
Operation Chariot Build Method Build Updates



Operation Chariot Progress August 2025

OPERATION CHARIOT - SCHEDULE		
TASK	Date	Date

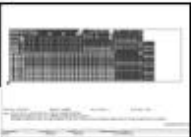
1. Prepare Work Schedule



Raw material delivery to Rosyth C/W
Material Certificates log into system
clear Quality checks and prepare to issue.



Work instruction



Profile Plate Nesting



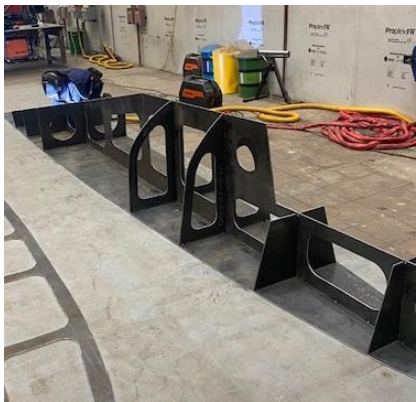
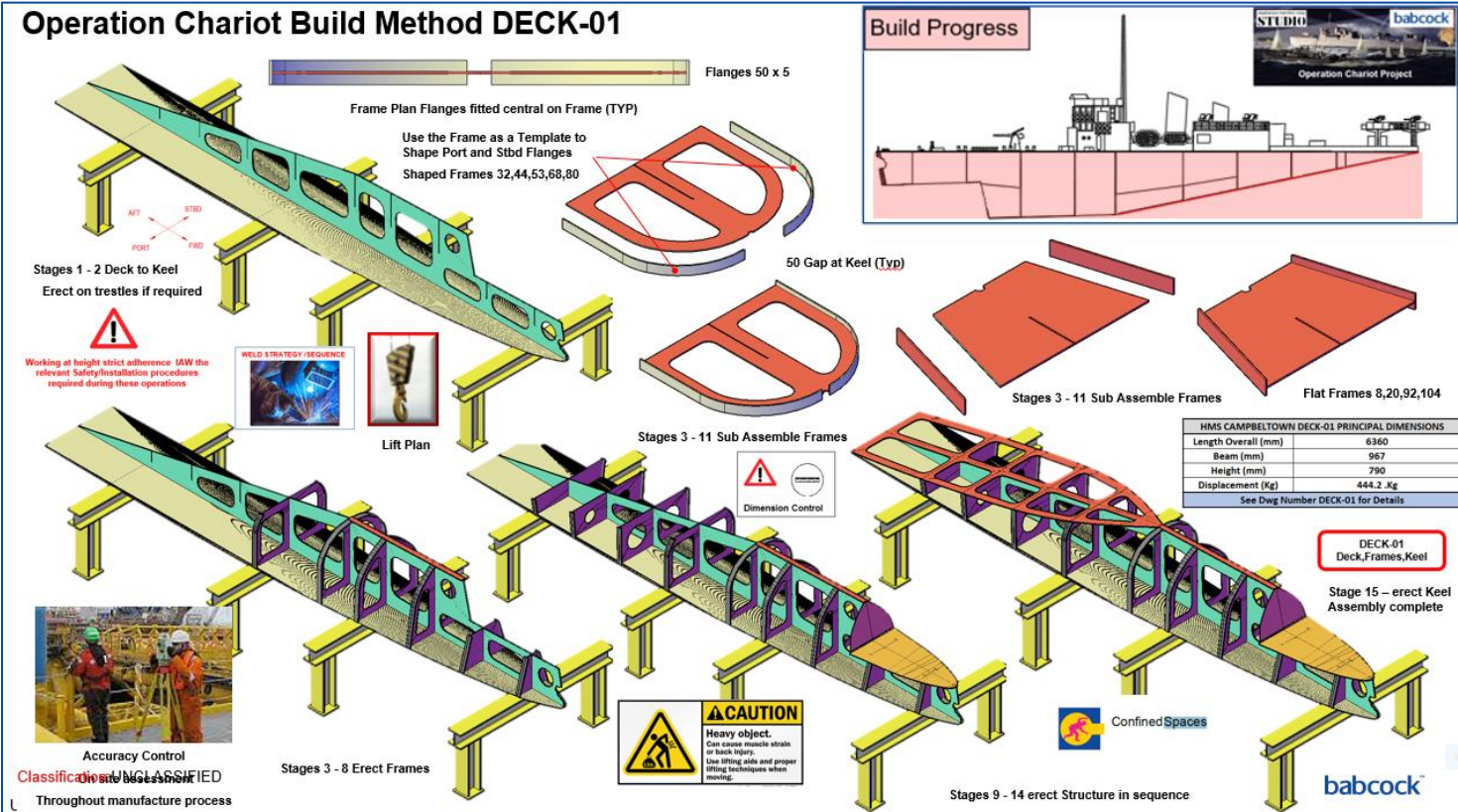
Profile Plate Cutting

2.Receipt Material Mark Cut And Prep (MCP)



Operation Chariot Progress August 2025

Operation Chariot
HMS Campbeltown is being
manufactured in Bay 3
SHIP 5
HMS Campbeltown
Fabrication Bay



Classification: UNCLASSIFIED
UNCLASSIFIED

Build Method for DECK-01 begins to take shape

babcock

Traditional Ship Building practices

babcock™

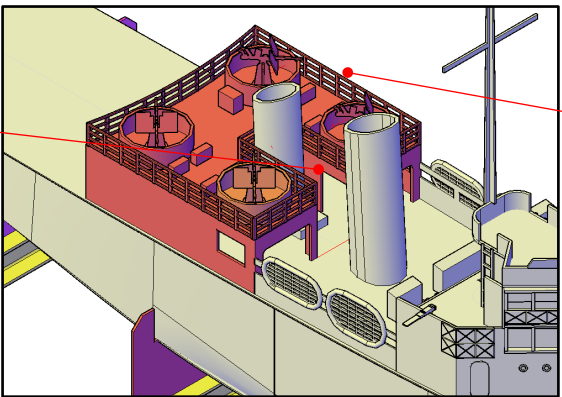
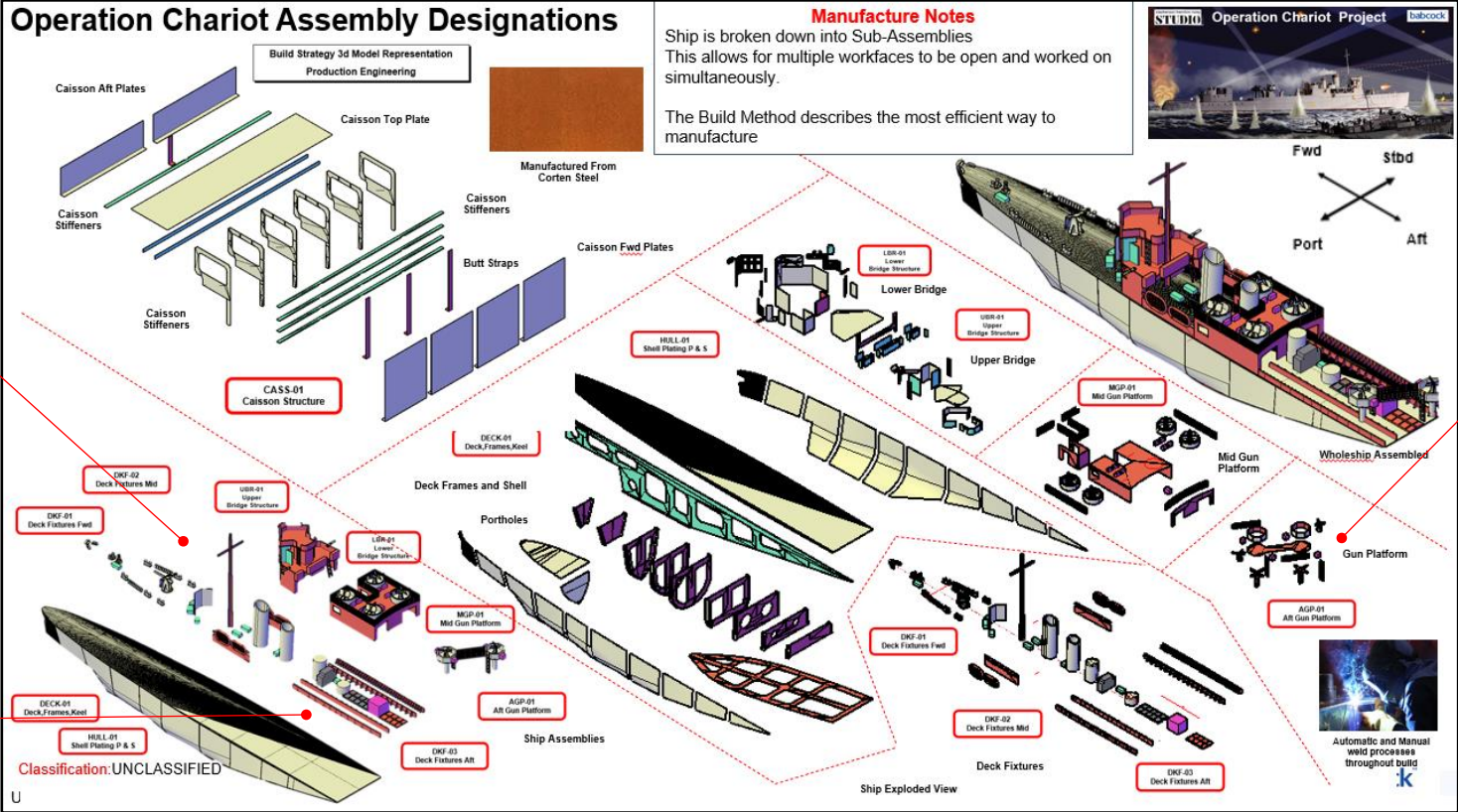
Operation Chariot Progress August 2025



Deck Fittings



Deck Fittings



Mid Gun Platform MGP-01



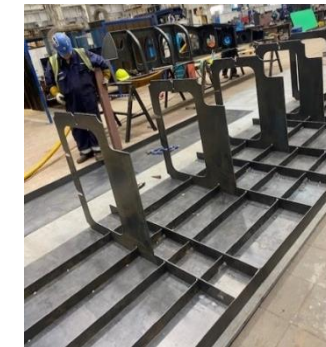
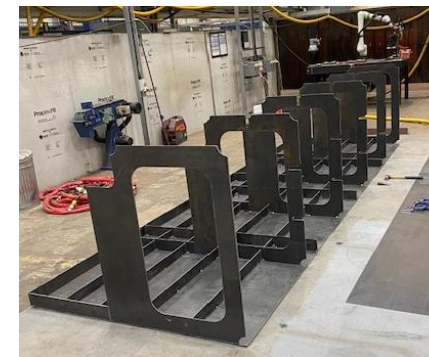
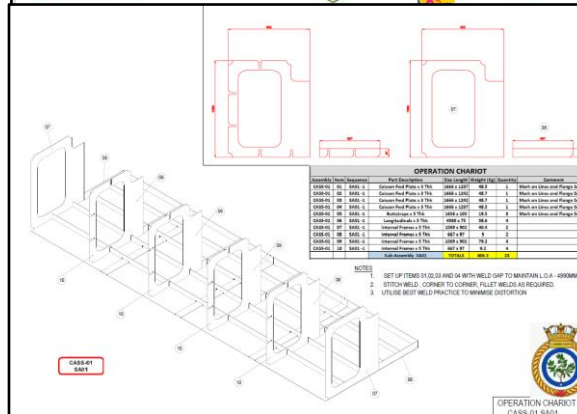
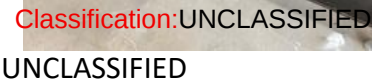
Aft Gun Platform AGP-01



Deck Fittings
20MM OERLIKENS
CARLEY RAFTS



A large, dark, rectangular metal mold or frame is shown resting on a wooden pallet. The mold has a complex shape with a large central rectangular opening and several smaller rectangular protrusions and recesses along its edges. It appears to be made of a heavy, dark metal, possibly steel or cast iron. The background shows a workshop floor with other wooden pallets and some debris.

babcockTM

Operation Chariot Progress August/September 2025



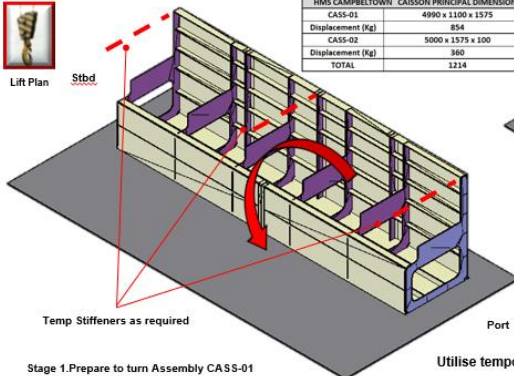
Classification: UNCLASSIFIED
UNCLASSIFIED

Operation Chariot Build Method CASS-01



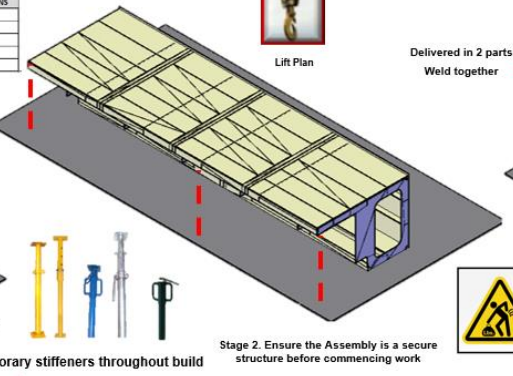
Lift Plan

HMS CAMPBELTOWN CAISSON PRINCIPAL DIMENSIONS	
CASS-01	4990 x 1100 x 1575
Displacement (kg)	854
CASS-02	5000 x 1575 x 100
Displacement (kg)	360
TOTAL	1214



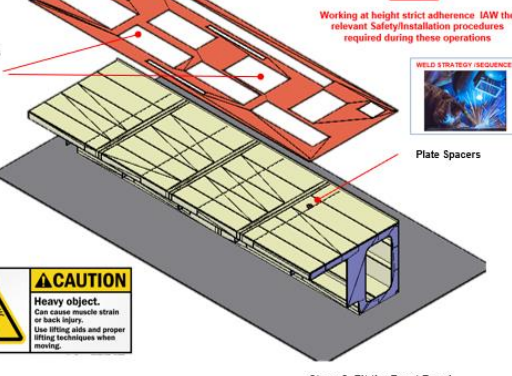
Temp Stiffeners as required

Stage 1. Prepare to turn Assembly CASS-01



Port

Stage 2. Ensure the Assembly is a secure structure before commencing work



Caisson Front Panel

Delivered in 2 parts
Weld together

Plate Spacers

Working at height strict adherence IAW the relevant safety/installation procedures required during these operations

WELD IS TRUTH / SEQUENCE

CAUTION
Heavy object.
Can cause muscle strain or back injury.
Use lifting aids and proper lifting techniques when moving.

Stage 3. Fit the Front Panel

Minimise Weld Distortion through good practice

Weld Distortion Reduction Welder Guidelines

DOC No: TSC-DC-01

REVISION: 0

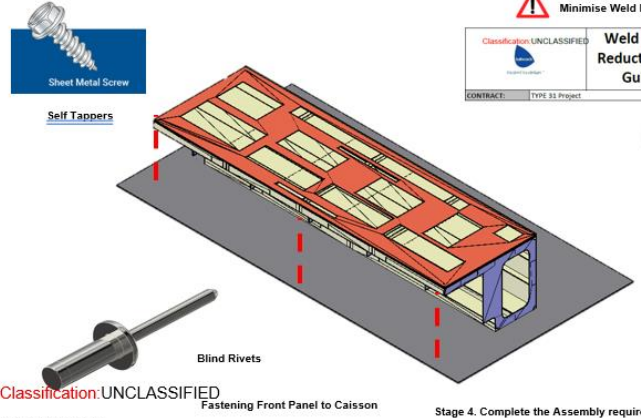
FABRICATION CODE: Lloyd's 2017

NCA Operation Chariot Caisson cover with Raid details

Fabricate and supply Laser cut Operation Chariot Caisson cover with Raid details

Scope of Works

Caisson cover 5000 x 1500 x 3mm Corten sheet supplied in 2 No sections, fixed on site by others. Laser cut text and silhouettes as per the artwork supplied. Operation Chariot letters to be supplied as separate characters to be fixed on site by others. In the event of an order being placed an artwork proof will be submitted for approval prior to any works commencing. Price includes for the delivery to Dunfermline Scotland. Costs are subject to final confirmation of details and specification. 50% deposit would be required if an order is placed.



Sheet Metal Screw

Self Tappers

Blind Rivets

Nuts and Bolts

Classification: UNCLASSIFIED

Pastening Front Panel to Caisson

Stage 4. Complete the Assembly requirements



OPERATION CHARLOT
"The greatest raid of all"

An Audacious Plan

The Royal Navy

The Royal Air Force

The Commandos

babcock



CASS-01 nearing completion



Secondary Operations (Rolling Parts)

"Green" (Additional material required for rolling to shape)

Part Development

Shape up the ends to the Template

Template

Mark on Datums IAW relevant drawings

Part Development

Stage 2. Start shaping the Part Development to the Template

Stage 1. Manufacture template to Internal Diameter

Minimise Weld Distortion through good practice

Weld Distortion Reduction Welder Guidelines

DOC No: TSC-DC-01

REVISION: 0

CONTROLS: TSC-DC-01

STAGE 1.1

Stage 3. Remove the "Green"

Stage 4. Complete the rolling process

Stage 5. Assembly complete

Classification: UNCLASSIFIED

UNCLASSIFIED

babcock



Secondary Operations (Flanging)

Part Development

Mark on Datums IAW relevant drawings

Stage 1. Manufacture template to shape

Lift Plan

Part Development

Stage 2. Start shaping the Part Development to the Templates

Stage 3. Complete the shaping process

Stage 4. Part complete ready for next assembly phase

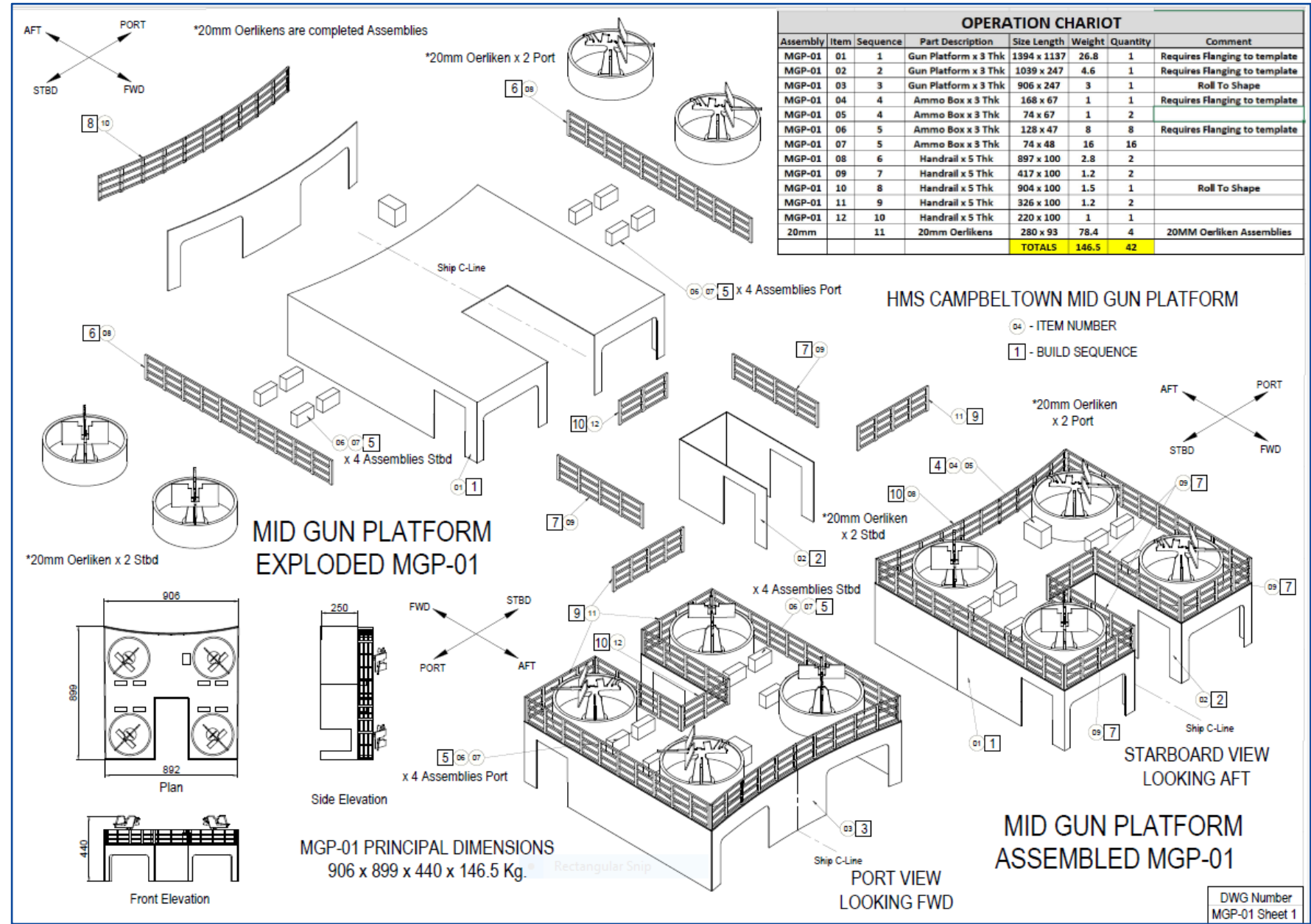
Classification: UNCLASSIFIED

UNCLASSIFIED

babcock



Operation Chariot Progress September 2025



Classification: UNCLASSIFIED

UNCLASSIFIED

MGP-01 nearing completion

Operation Chariot Progress September 2025



Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Progress September 2025



Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Progress September 2025



Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Progress September 2025



Classification: UNCLASSIFIED

UNCLASSIFIED

Operation Chariot Progress September 2025

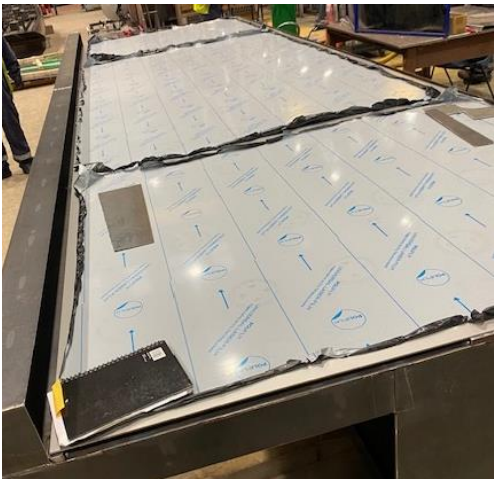


Classification: UNCLASSIFIED

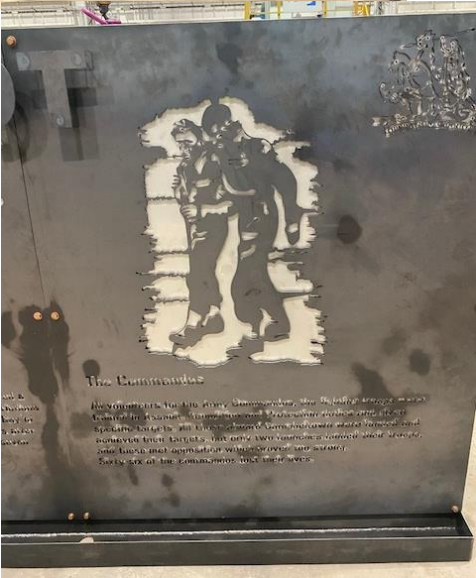
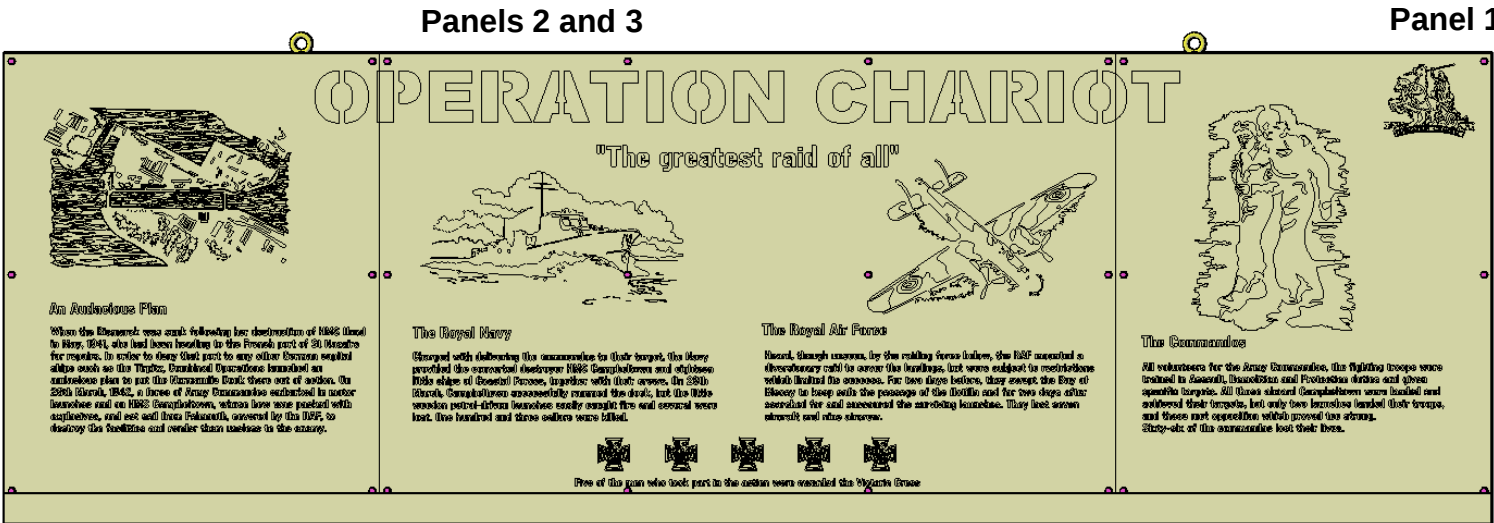
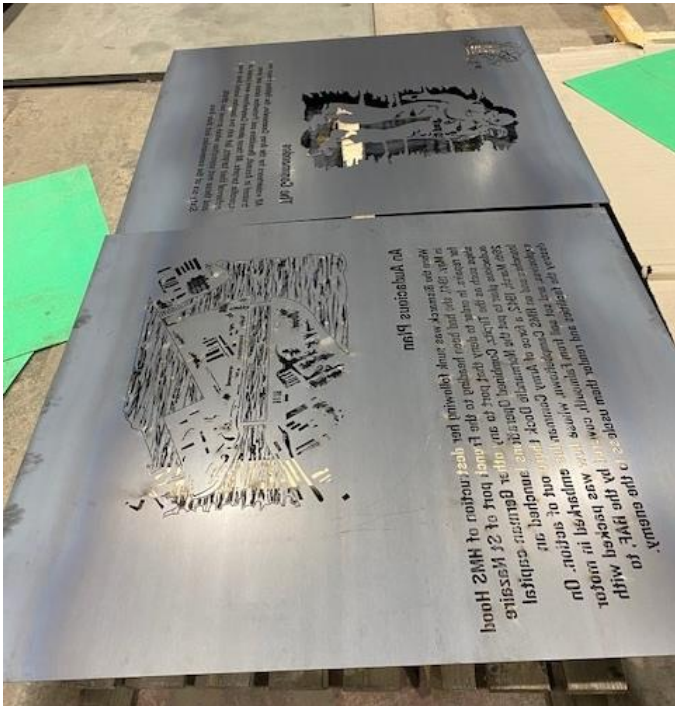
UNCLASSIFIED

Bow Damage

Operation Chariot Progress October 2025



Stainless Steel Plates



Classification: UNCLASSIFIED
UNCLASSIFIED

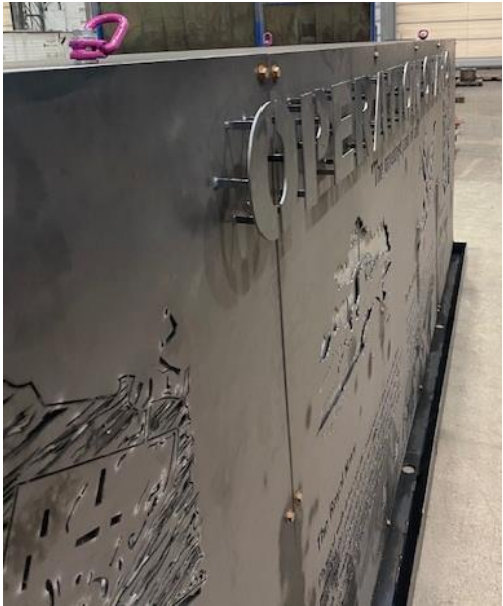
Panel 2

Panel 1

Panel 3



Caisson / Project Operation Chariot complete 28/10/2025



All Lifting Points tested and certified

Classification: UNCLASSIFIED

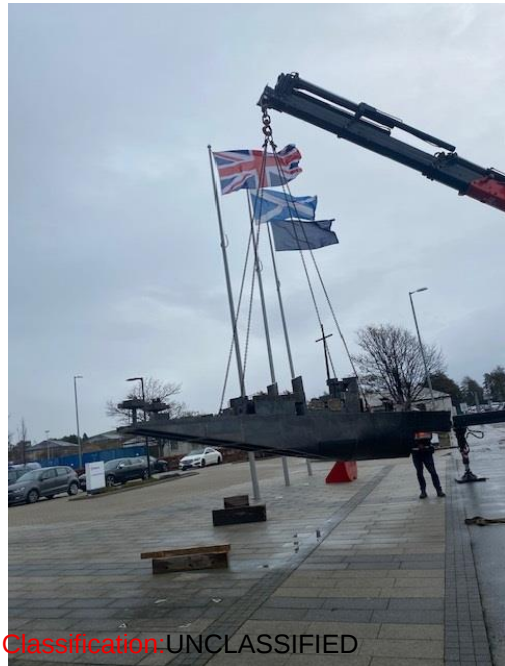
UNCLASSIFIED

Classification: IN-CONFIDENCE - LIMITED CIRCULATION		
 Operation Chariot 		
C 308		
RECORD OF TEST AND/OR THOROUGH EXAMINATION OF LIFTING PLANT & EQUIPMENT TEST AND THOROUGH EXAMINATION		
Name and address of owner of equipment: BABCOCK ROSYTH		Identification mark of the test equipment: Gauge RSW10181 due 26/03/26, Jack Rosh 1434 due 11/07/26, Pump ROSH1549 due 29/11/25.
Equipment description: 4 in No Load ring VLBG-PLUS M12 screwed in the Caisson.		
Details of test or tests & examination carried out: Area: Bay 3 Date of Manufacture: Unknown Angle/Method of Test: Visual survey and Hydraulic pull test. Proof Load Test Notes: Visual survey and pull test were satisfactory		Loads applied: 2.025 Te. 2025 kg safety factor of 1.5 applied Date of completion: 28/10/2025
Witnessed By: Gordon Murray (Com Eng.)		Location: Bay 3, Rosyth Dockyard.
Safe working loads or loads and (where relevant) corresponding radii: 1.35 Te (1350 kgs)		
Details of any defects found (if none state NONE): None		
Date(s) by which defects as described above must be rectified:		
Date of most recent test and examination: 28/10/2025		Identification number or other issued on that occasion: ID: C1-C2-C3-C4
Is this the first examination after installation or after assembly at a new site or location?	YES	Was the examination carried out within an interval of 6 months? Within an interval of 12 months?
		NO YES
If the answer to the above question is YES, has the equipment been installed correctly?	YES	In accordance with an examination scheme? After the occurrence of exceptional circumstances
		NO NO
Other observations: None		
IS THIS EQUIPMENT SAFE TO OPERATE? YES		
Name of the person making this report: Luan Luku	This is an electronic record. No signature required.	Latest date by which next thorough examination must be carried out: 28/10/2026
Name and address of employer of persons making and authenticating this report: Babcock Marine, Building 317, Salvage Road, Rosyth, Scotland, Ky11 2yd, Telephone 01383412131 ex 53577		
This document is in accordance with the Lifting Operations & Lifting Equipment Regulations (L.O.L.E.R 1998)		

Classification: IN-CONFIDENCE - LIMITED CIRCULATION		
 Operation Chariot 		
C 308		
RECORD OF TEST AND/OR THOROUGH EXAMINATION OF LIFTING PLANT & EQUIPMENT TEST AND THOROUGH EXAMINATION		
Name and address of owner of equipment: BABCOCK ROSYTH		Identification mark of the test equipment: Gauge RSW10181 due 26/03/26, Jack Rosh 1434 due 11/07/26, Pump ROSH1549 due 29/11/25.
Equipment description: 4 in No Load ring VLBG-PLUS M12 screwed in the HMS Campbelltown Scale model 1:100.		
Details of test or tests & examination carried out: Area: Bay 3 Date of Manufacture: Unknown Angle/Method of Test: Visual survey and Hydraulic pull test. Proof Load Test Notes: Visual survey and pull test were satisfactory		Loads applied: 2.025 Te. 2025 kg safety factor of 1.5 applied Date of completion: 28/10/2025
Witnessed By: Gordon Murray (Com Eng.)		Location: Bay 3, Rosyth Dockyard.
Safe working loads or loads and (where relevant) corresponding radii: 1.35 Te (1350 kgs)		
Details of any defects found (if none state NONE): None		
Date(s) by which defects as described above must be rectified:		
Date of most recent test and examination: 28/10/2025		Identification number or other issued on that occasion: ID: S1-S2-S3-S4
Is this the first examination after installation or after assembly at a new site or location?	YES	Was the examination carried out within an interval of 6 months? Within an interval of 12 months?
		NO YES
If the answer to the above question is YES, has the equipment been installed correctly?	YES	In accordance with an examination scheme? After the occurrence of exceptional circumstances
		NO NO
Other observations: None		
IS THIS EQUIPMENT SAFE TO OPERATE? YES		
Name of the person making this report: Luan Luku	This is an electronic record. No signature required.	Latest date by which next thorough examination must be carried out: 28/10/2026
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This document is in accordance with the Lifting Operations & Lifting Equipment Regulations (L.O.L.E.R 1998)		



Caisson / Project Operation Chariot heading home 13/11/2025



Caisson / Project Operation Chariot Work in progress 14/11/2025



Classification: UNCLASSIFIED

UNCLASSIFIED

Caisson / Project Operation Chariot Work in progress 14/11/2025



Classification: UNCLASSIFIED

UNCLASSIFIED

The Greatest Raid Of All



15



3

Classification: UNCLASSIFIED

UNCLASSIFIED



A model of the former HMS Campbeltown, built by our talented teams at Rosyth – more below

Apprentices build memorial for National Memorial Arboretum

A group of our Fabrication and Welding apprentices at Rosyth have been busy building a model of the former HMS Campbeltown that will form part of a new memorial at the National Memorial Arboretum. The project came about after the St Nazaire Society approached Babcock for support. With the latest HMS Campbeltown to be built as part of the Type 31 programme, it was the perfect fit.

The group of around 30 apprentices, supported by our experienced tradespeople, worked on the steel model in our Manufacturing Bays, allowing them to gain hands-on experience using the same techniques that we use to build real ship modules.

The model is now complete, with plans to display it at Rosyth until it takes pride of place at the National Memorial Arboretum – a lasting tribute to the original HMS Campbeltown and a great showcase of the skills and dedication of our people.



Arboretum Visit 26/02/2026



Remembering ⇒ Learning ⇒ Inspiring

Patron:
Vice Admiral Sir Adrian Johns KCB CBE DL

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VCs

Sir Nick Hine KCB
Chief Executive, Marine
Babcock International Group
Rosyth Dockyard
Rosyth
Dunfermline
KY11 2YD

27th February 2026

Dear Nick,

St Nazaire Memorial

We missed you at the Arboretum on Thursday, but I fully appreciate just how busy you must be at the moment. I hope it is all going well.

On your behalf, Gareth Hedicker led a strong team which gave us the opportunity to express our sincere thanks to Babcock for a job brilliantly well done. I personally was able to thank all those present but particularly Joe Doogan and Alfie Ramsey whose leadership and expertise have been instrumental in producing a truly iconic memorial. The attention to design detail and the skill with which the model of the original HMS CAMPBELTOWN has been constructed has set the St Nazaire memorial apart from all others. It is a tribute to the heroes of the day and will be an inspiration for future generations. Plenty of photographs were taken on the day, some of which will, I hope, cross your desk.

While there are many Associate Members such as me (I commanded HMS CAMPBELTOWN in the mid-90s), the core of the St Nazaire Society is made up of direct descendants of the raiders. It is difficult to express just how much this enduring memorial means to them. Thank you.

Looking ahead, we are all keen to see the third CAMPBELTOWN build and very much hope that the Society might be involved in some way at the key milestones.

With renewed thanks and best wishes.

As ever,
Adrian

Vice-Admiral Sir Adrian Johns KCB CBE DL

www.stnazaireraid.org
A St Nazaire Raid Memorial Trust project
Charity number: 1208309

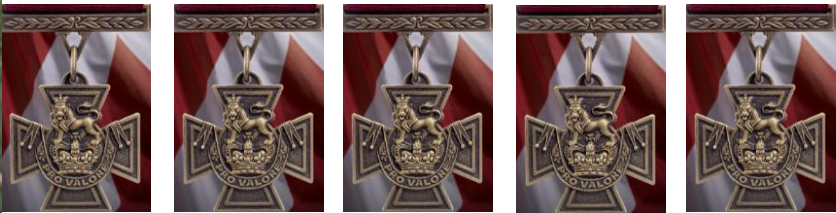


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Operation Chariot The Greatest Raid Of All

LEST WE FORGET



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UNCLASSIFIED