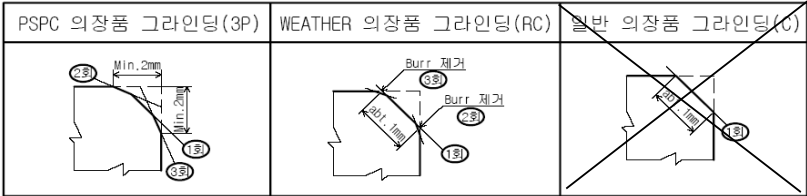


PLAN HISTORY					
DATE	REV. NO.	DESCRIPTION	DRAWN	CHECKED	APPROVED
2021. 10. 28	0	8070-8073, 8103,8104 호선 LADDER 제작 도면으로 작성함.	김 현 진	황 규 성	정 호 진

NOTE

1. 본도는 LADDER (NO.2F HOLD) 제작 도면임.
2. 모서리 부분은 하기와 같이 GRINDING 할 것.



3. 용접은 특기와 하기 표 참조하고 연속 용접 할 것.

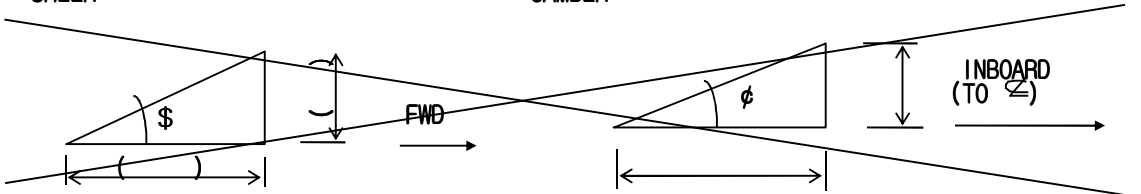
\* THE LEG LENGTH OF FILLET WELD TO BE AS FOLLOWS.

MAL'T THICKNESS	4.5	6	7~8	9~10	11~12	13	14~15	16~18	19~20
LEG LENGTH	3	4	4.5	5	5.5	6	7	7.5	9

4. 제작 시 DECK 상의 SHEER (\$ : / )와 CAMBER (φ : / )를 필히 적용할 것.

SHEER :

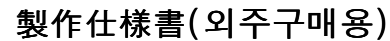
CAMBER :



5. 한 도면에서 서로 상이부분이 있거나 제작상 문제점 발생시 필히 당부와 협의/확정 후 제작 완료할 것.
6. 본 도면상에 표기된 자재 중 SS400 , 단조품(SF자재) 및 용접되는 주강품(SC42)은 탄소(C) 함유량이 0.23% 이하가 되어야 함에 유의할 것 (자재 MILL SHEET 제출 요). 또한, 주강품은 용접 시 PRE-HEATING(200℃) 한 후 용접하여 용접균열을 방지할 것.
7. BOLT 길이는 NUT 체결후 ABT. 2~3 산이 남도록 할 것.
8. 이름/경고판 시공기준 : 모든 이름/경고판은 전면에 페인트나 신나에 녹지않는 비닐테이프를 부착한 상태로 뒤집어 조립하고, 그 후면에 도어 또는 밴트(VENT) 이름을 매직펜으로 기록하여 입력하고, 야드에서 정방향 설치시 나사산의 위치가 불일치 되지 않도록 구멍의 간격을 잘 유지하여 입고 할 것.  
(이름, 경고판 재질: SUS316 & SUS316 SCREW BOLT)
9. 그리스 니플 : JIS B 1571 A-PT 1/8" BALL TYPE 러버캡을 씌울것( MAT'L : BRASS )
10. P.O.R NO. : JL7

11. TOTAL WEIGHT : 1504.7 KG/SHIP (표지 포함 08 매)

PAINTING SPEC.						PAINT SUPPLIER		
PAINT'G SYMBOL	PAINT ITEM OR AREA	MAT'L	SHOP PRIMER	표면 처리	BRAND NAME OF PAINT AND ITS COLOR SHADE	D.F.T (μ)	REMARK	
ALL	FINAL	SHOP PRIMER	PRIMER					



- 
- 우철 SPEC. PAINTING
- PAINT & GALV. : 15mm
- (SHOP PRIMER OR Alkyd Resin MP-120 (KCC))
- Dk

- 1) 용접선 있는 자재는 용접선 부근 50mm 이내 PAINT MARKER 마킹 적용  
(설치 후 언제 도장작업 쉽게 하기 위함)
- 2) 용접선 없는 자재는 자재 인식표(TAG) 또는 안티 울트라테이프에 마킹 후 부착  
(자재 TAG 및 안티 울트라테이프 제거는 의장 1,2부에서 실시함)
- 3) 적용대상 : 강재로 제작되는 모든 철의장품
- 4) MARKING 방법 : SHIP NO., BLOCK NO., POR NO., MARKING(PC'S) NO.

## 제품별 납기 LIST

<b>SHIP NO.</b>	8070-8073, 8103,8104
<b>DWG NO.</b>	T17T0-C26-56BB

01

[illegible]



# TYPICAL DWG.(INCLINED LADDER)

SHIP NO.	8070-8073 8103/8104	02
DWG NO.	T17T0-C26-56BB	

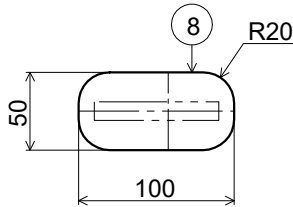
설치 BLOCK

T17P0

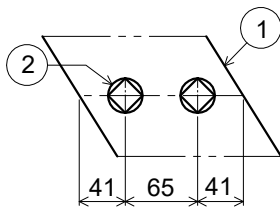
## NOTE

1. INCLINED LADDER의 각도가 58도임에 주의하여 제작할 것.
2. STEP PITCH는 240mm임에 주의 하여 제작할 것.  
(상이한 도면이 있으므로 해당 도면 참조하여 제작할 것)
3. 각 DETAIL은 해당 도면 참조하여 제작할 것.
4. ANTI-VIB. PIECE는 각 해당 도면 참조하여 제작할 것.

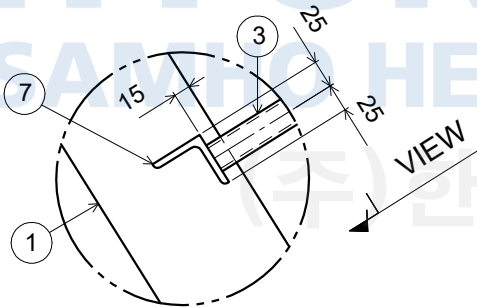
## DET. OF PAD



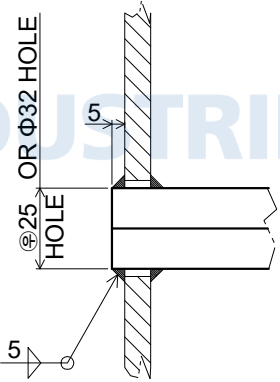
## DET. OF "C"



## DET. OF "D"

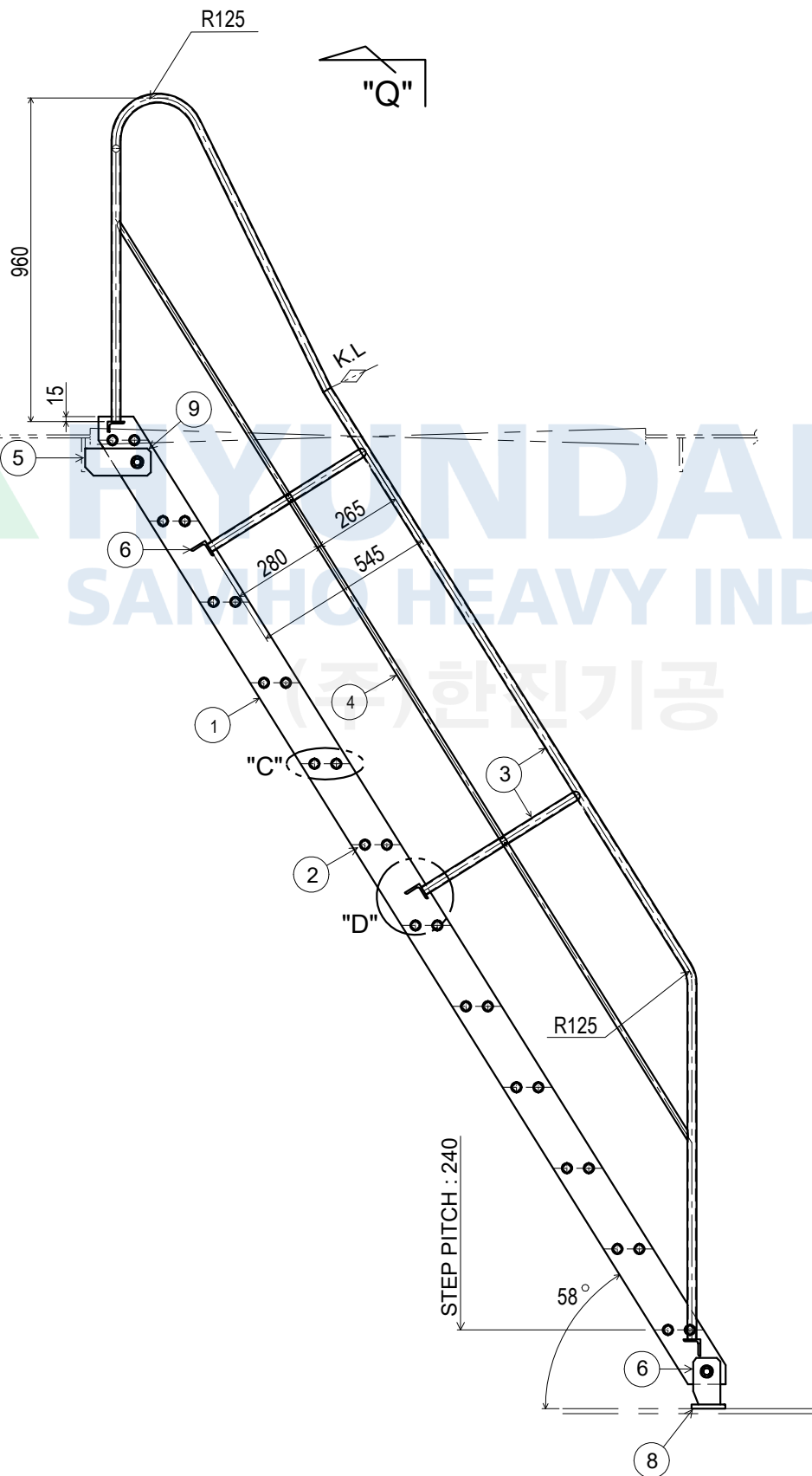


## DET. OF "E"

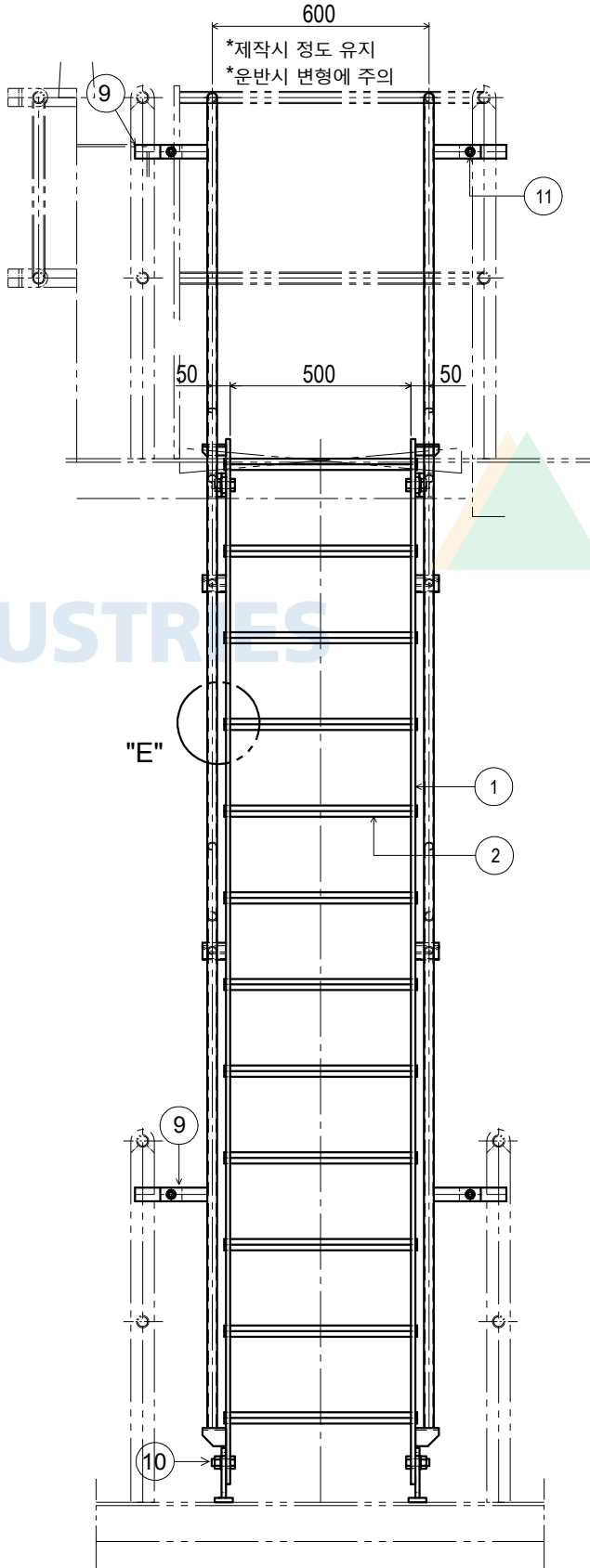


13	PAD	10t PLATE	SS400	AS SHOWN		
12	SUPPORT	75 X 75 X 9t E.A	SS400	AS SHOWN		
11	HEX BOLT NUT WITH SPRING WASHER	M12 - 32L	SUS304	4		
10	HEX BOLT NUT WITH SPRING WASHER	M20 - 51L	SUS304	4		
9	ANTI-VIB. PIECE	38 X 6t F.B	SS400	4		
8	PAD	12t PLATE	SS400	2		
7	SUPPORT WITH BRACKET	50 X 50 X 6t E.A	SS400	AS SHOWN		
6	LOWER LUG	80 x 12t PLATE	SS400	2		
5	UPPER LUG	80 x 12t PLATE	SS400	2		
4	MID RAIL	Ø16 R.B	SS400	2		
3	HANDRAIL & POST	20A PIPE	SPP	2		
2	STEP	□ 22 SQ. BAR	SS400	AS SHOWN		
1	SIDE FRAME	125 X 12t F.B	SS400	2		
NO	DESCRIPTION	SIZE	MAT'L	Q'TY/SET	WT(KG)/SET	REMARK

## SECTION



## ELEVATION (VIEW "Q")



## DETAIL OF INCLINED LADDER

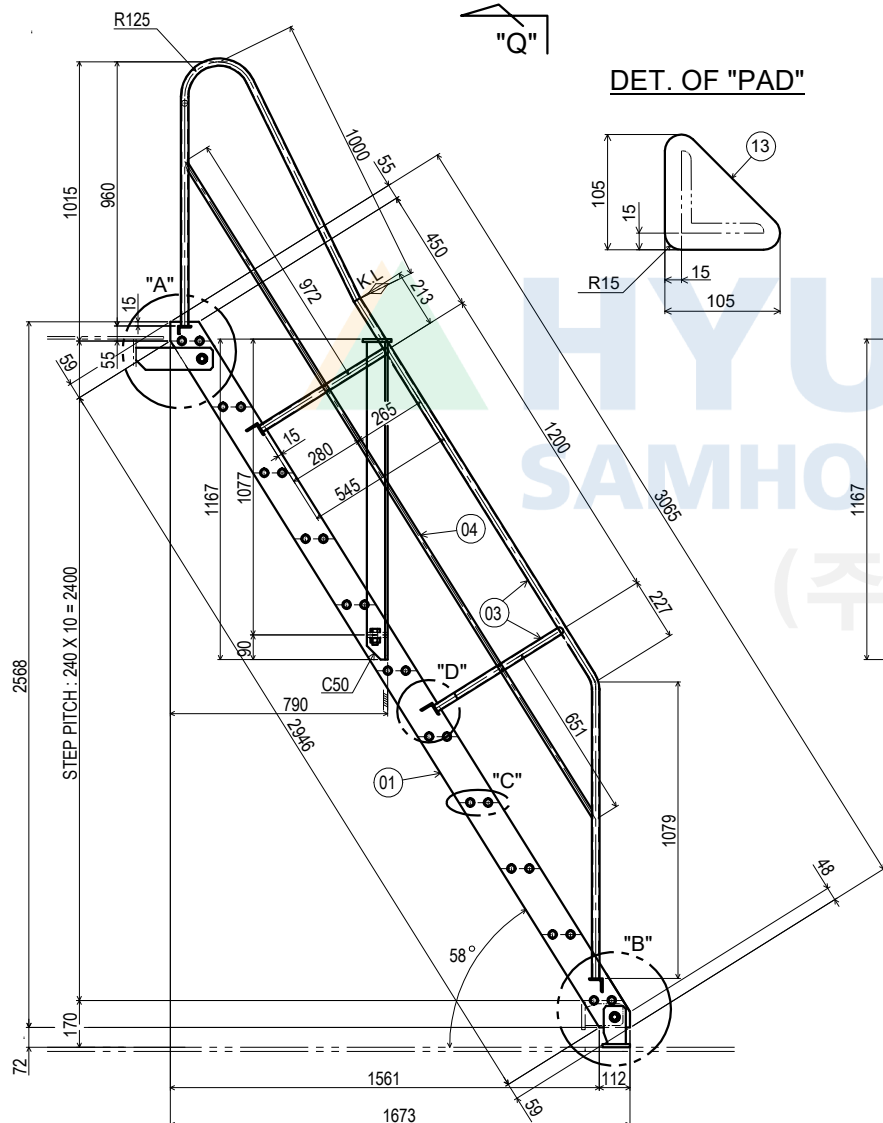
SHIP NO.	8070-8073 8103/8104	03
DWG NO.	T17T0-C26-56BB	

BLOCK NO.	MARK NO.	Q'TY	WEIGHT(KG)	REMARK
T17P0	IL-21FP	1	178.6	본도제작

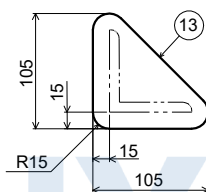
설치 BLOCK

T17P0

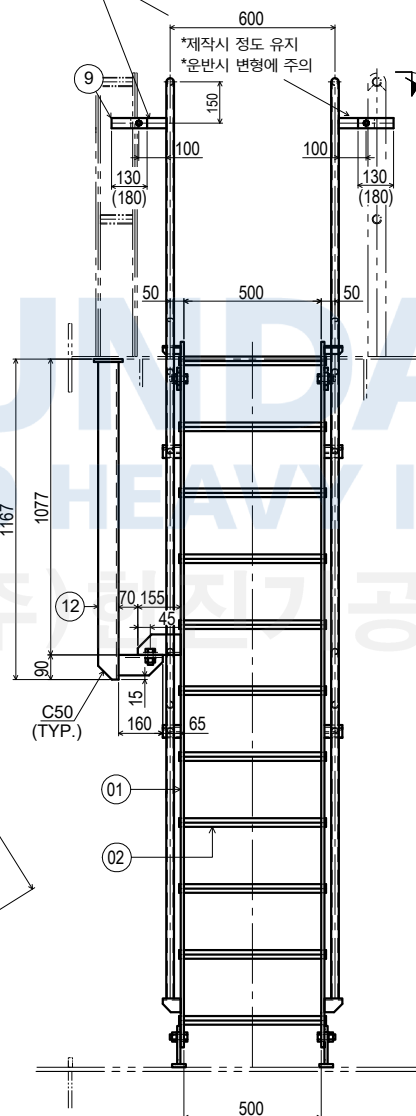
## SECTION



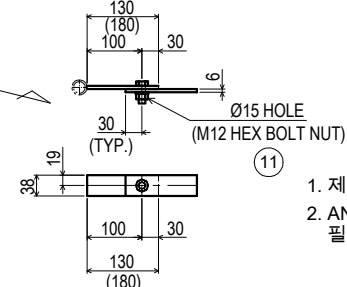
DET. OF "PAD"



ELEVATION  
(VIEW "Q")



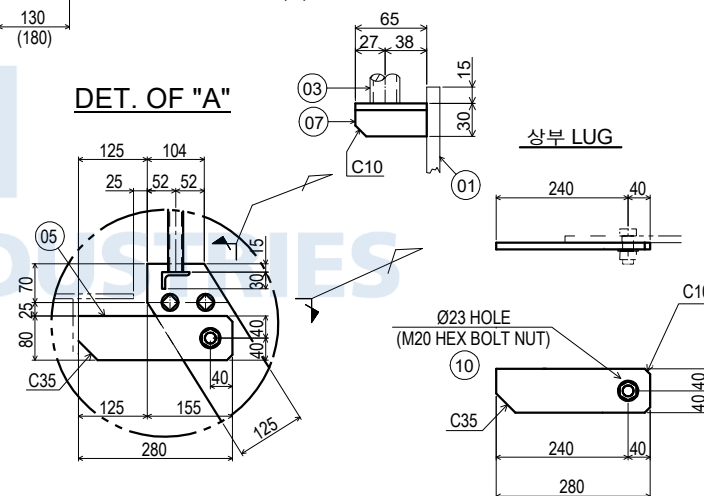
Anti- Vibration  
(I/LADDER 에 붙는 PC'S 130(TYP.))



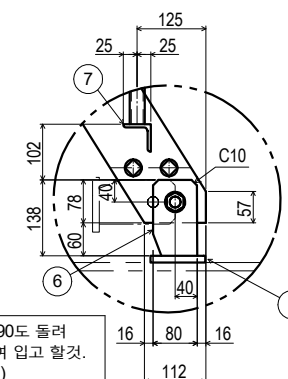
NOTE

1. 제작시 필히 02 PAGE(TYPICAL) 도면 참조 하여 제작할것.
2. ANTI-VIB. PIECE의 ( )안의 치수는 MARJIN 포함 치수이며 필히 ( ) 안의 치수로 제작 할것.

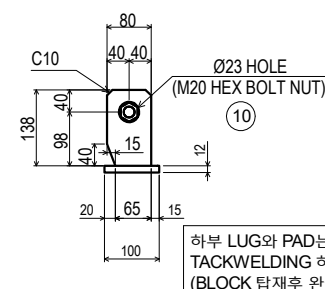
DET. OF "A"



DET. OF "B"



### 하부 LUG & PAD

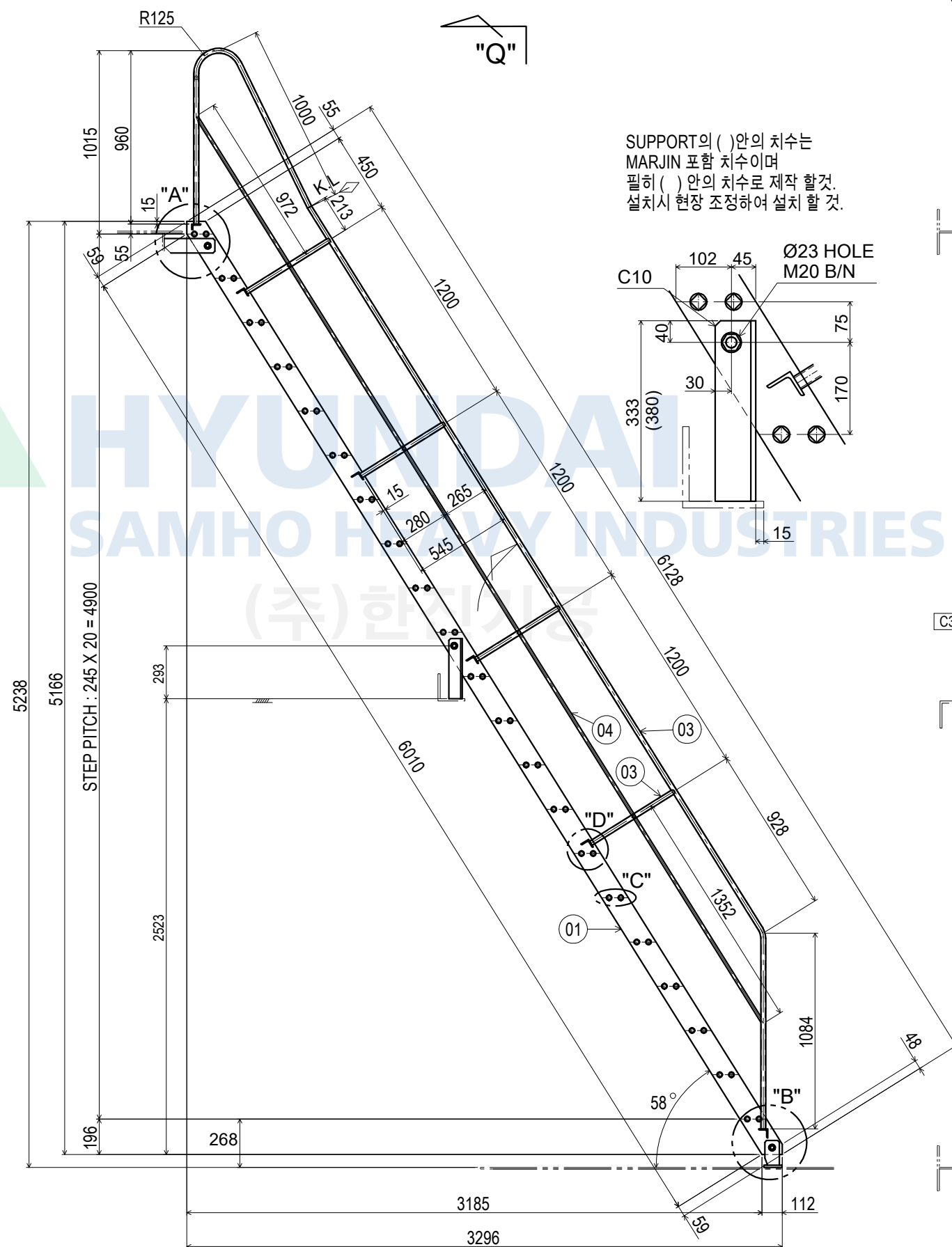


하부 LUG와 PAD는 90도 돌려  
TACKWELDING 하여 입고 할것.  
(BLOCK 탑재후 완설)

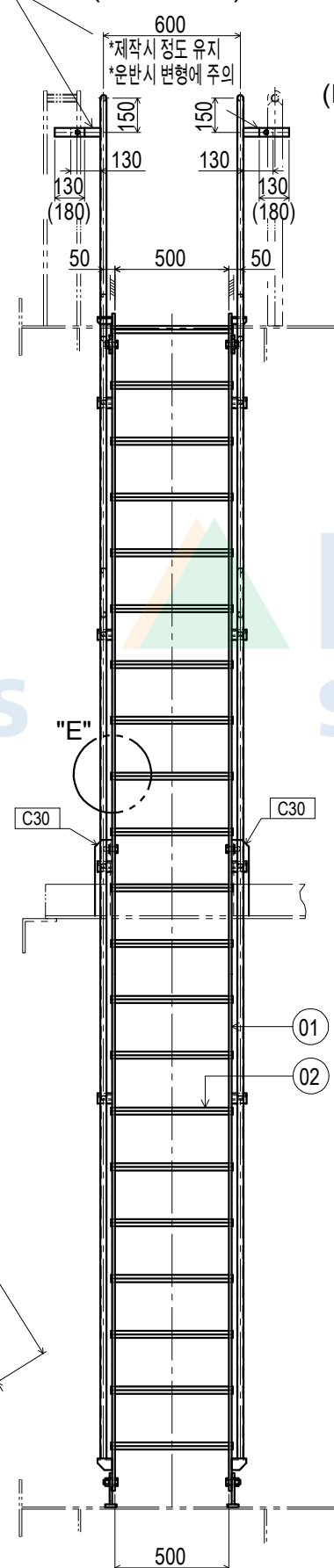


BLOCK NO.	MARK NO.	Q'TY	WEIGHT(KG)	REMARK
T17P0	IL-22FP	1	320.9	본도제작
T17P0	IL-23FP	1	320.9	본도제작
T17P0	IL-24FP	1	320.9	본도제작

## SECTION

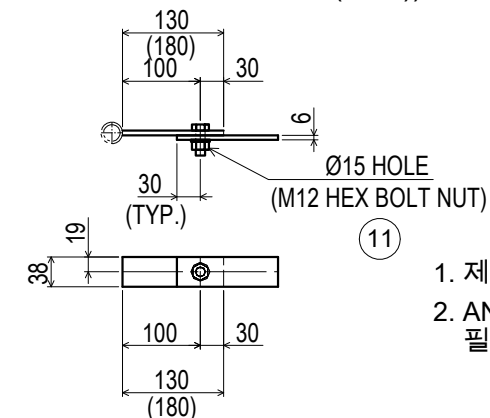


ELEVATION  
(VIEW "Q")



### Anti- Vibration

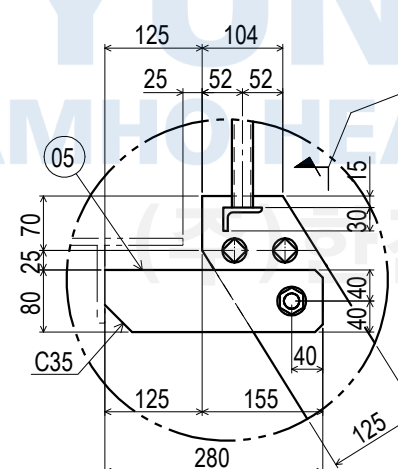
(I/LADDER 에 붙는 PC'S 130(TYP.))



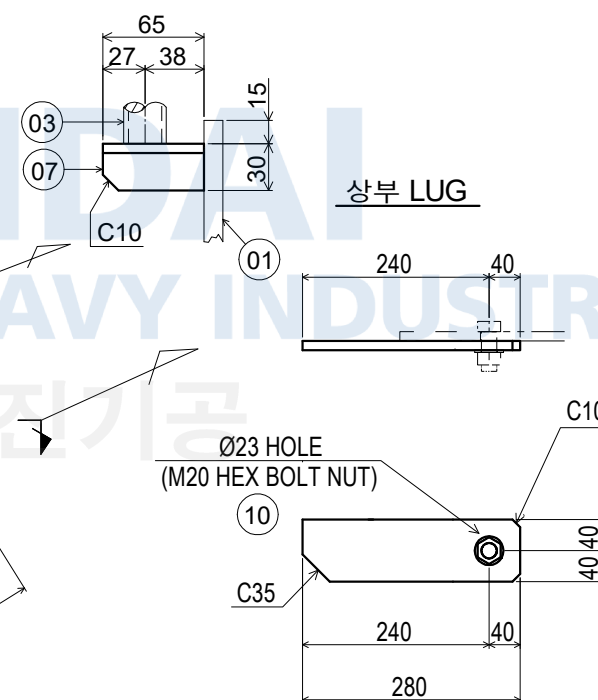
NOTE

1. 제작시 필히 04 PAGE(TYPICAL) 도면 참조 하여 제작할것.
2. ANTI-VIB. PIECE의 ( )안의 치수는 MARJIN 포함 치수이며 필히 ( )안의 치수로 제작 할것.

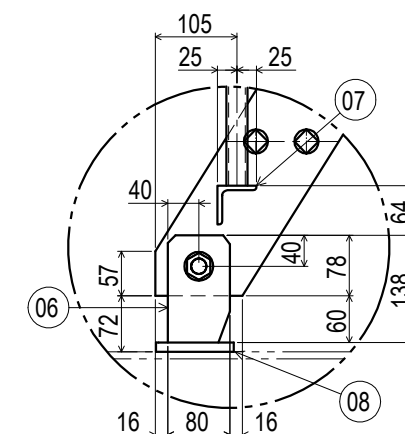
## DET. OF "A"



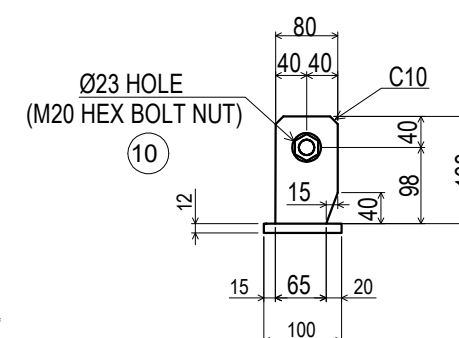
## 상부 LUG



## DET. OF "B"



### 하부 LUG & PAD







# DETAIL OF INCLINED LADDER

SHIP NO.	8070-8073 8103/8104	05
DWG NO.	T17T0-C26-56BB	

BLOCK NO.	MARK NO.	Q'TY	WEIGHT(KG)	REMARK
T17P0	IL-25FP	1	165.2	본도제작

설치 BLOCK

T17P0

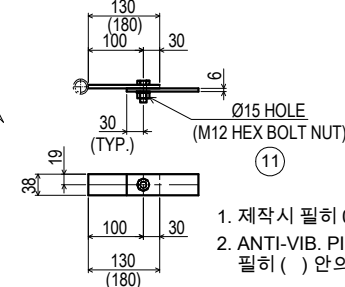
## SECTION

"Q"

ANTI-VIB. PIECE는 별도 분리하여 입고할 것.  
(ANTI-VIB. PIECE는 현장 조정 설치할 것.)

## ELEVATION (VIEW "Q")

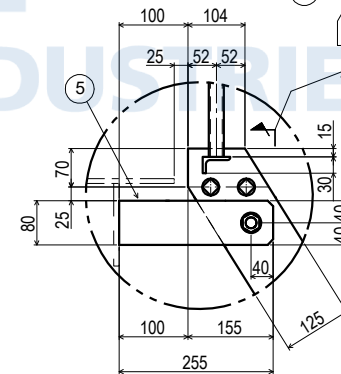
Anti-Vibration  
(//LADDER 에 붙는 PC'S 130(TYP.))



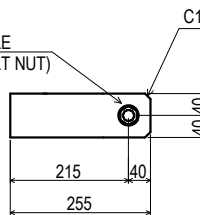
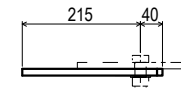
## NOTE

1. 제작시 필히 02 PAGE(TYPICAL) 도면 참조 하여 제작할것.
2. ANTI-VIB. PIECE의 ( )안의 치수는 MARJIN 포함 치수이며 필히 ( )안의 치수로 제작 할것.

## DET. OF "A"

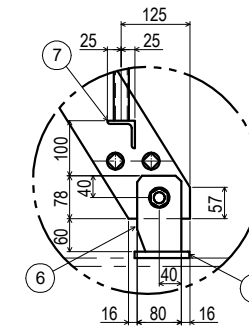
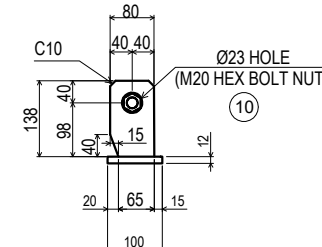


## 상부 LUG



## DET. OF "B"

## 하부 LUG & PAD



08070-T17T0C2656BB-005

## DETAIL OF VERTICAL LADDER

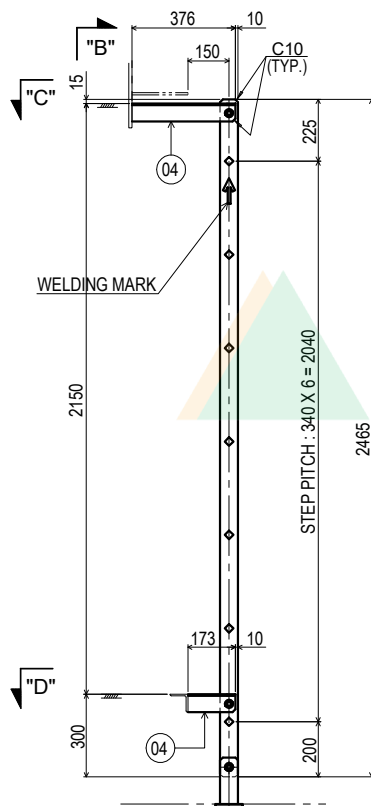
SHIP NO.	8070-8073 8103/8104	06
DWG NO.	T17T0-C26-56BB	

BLOCK NO.	MARK NO.	Q'TY	WEIGHT(KG)	REMARK
T17P0	VL-21FP	1	55.5	본도제작
T17S0	VL-21FS	1	55.5	대칭제작

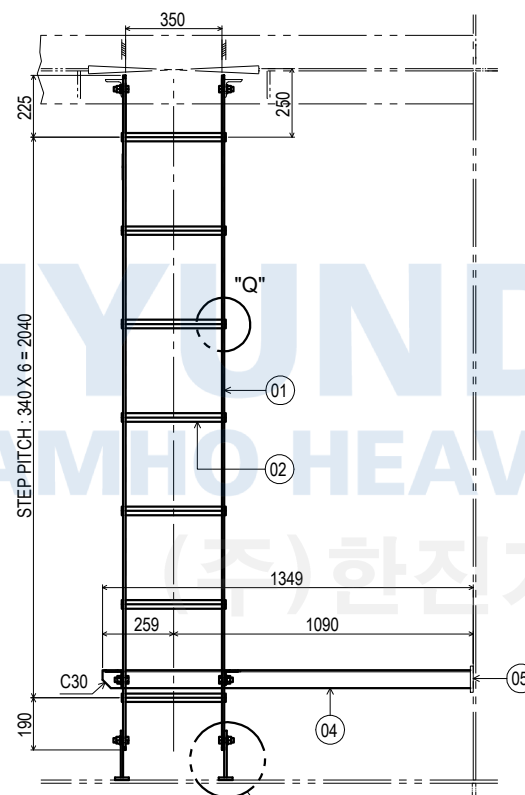
설치 BLOCK

T17P0  
T17S0

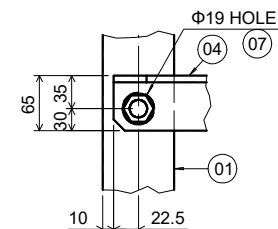
VIEW - "A"



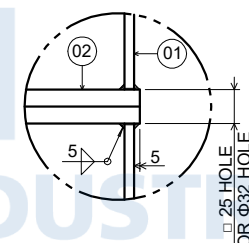
VIEW - "B"



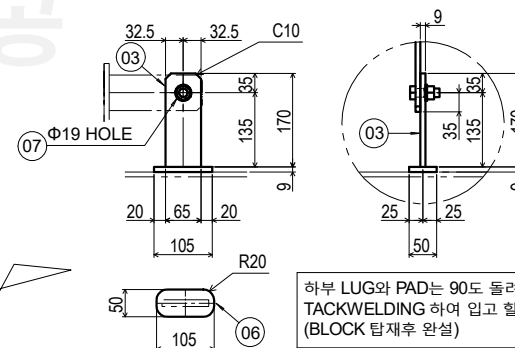
### DETAIL OF LUG



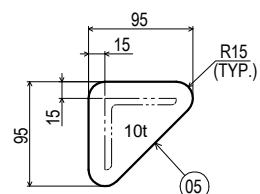
### DETAIL OF "Q"



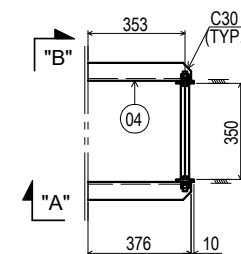
### DETAIL OF LUG



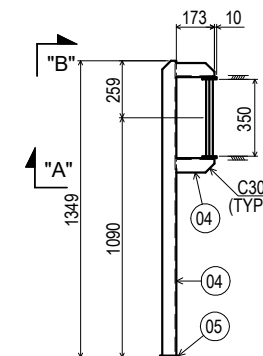
### DETAIL OF PAD



PLAN-"C"



PLAN-"D"



7	HEX.B/N WITH S/WASHER	M16 x 45L	SUS304	6	1.2	
6	PAD	9t PLATE	SS400	2	0.8	
5	PAD	10t PLATE	SS400	1	0.5	
4	LUG	65 X 65 X 8t E.A	SS400	5	18.7	
3	LUG	65 X 9t F.Bar	SS400	2	1.6	
2	STEP	22 SQ.Bar	SS400	7	10.1	
1	SIDE FRAME	65 X 9t F.Bar	SS400	2	22.6	
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK



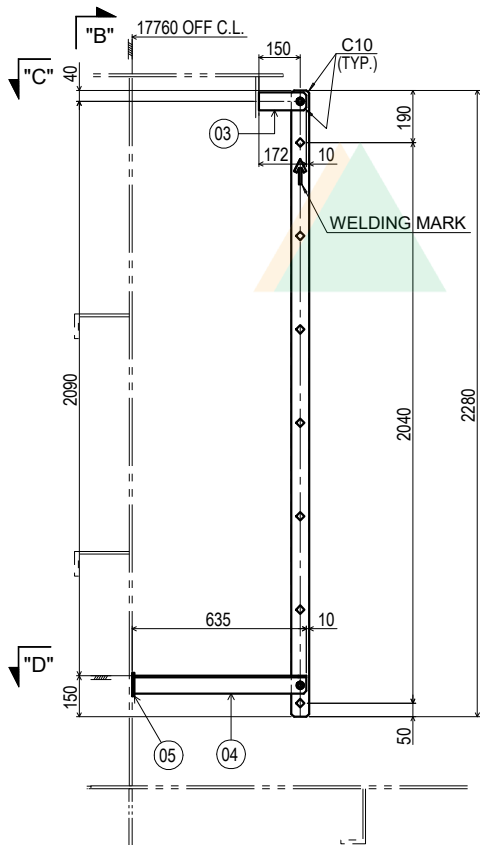
# DETAIL OF VERTICAL LADDER

SHIP NO.	8070-8073 8103/8104	07
DWG NO.	T17T0-C26-56BB	END

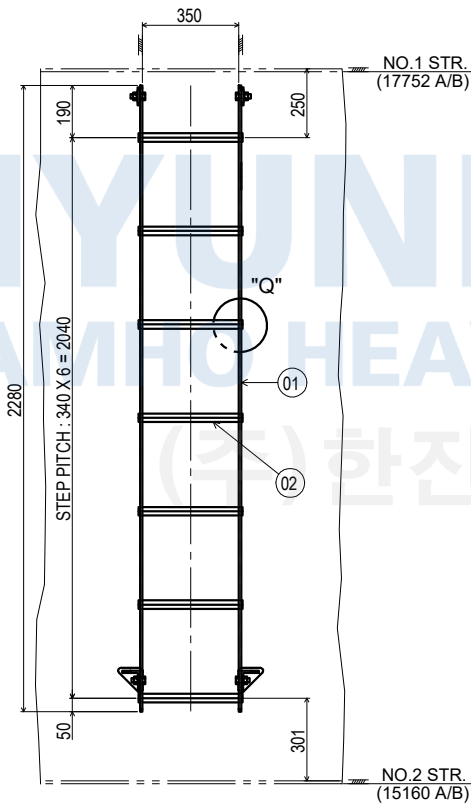
BLOCK NO.	MARK NO.	Q'TY	WEIGHT(KG)	REMARK
S19P0	VL-22FP	1	43.6	본도제작
S19S0	VL-22FS	1	43.6	대칭제작

S19P0  
S19S0

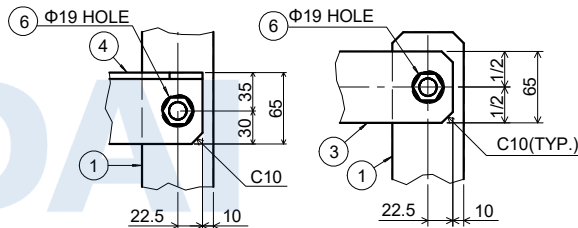
VIEW - "A"



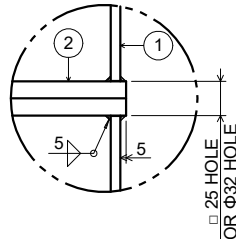
VIEW - "B"



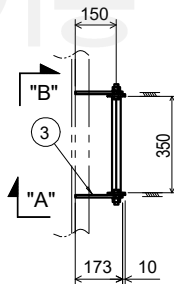
DETAIL OF LUG



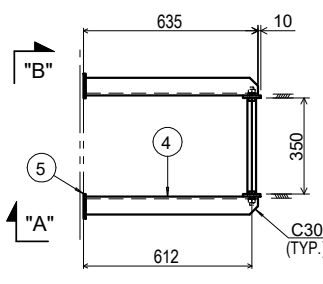
DETAIL OF "Q"



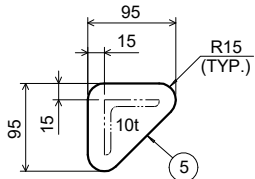
PLAN-"C"



PLAN-"D"



DETAIL OF PAD



6	HEX.B/N WITH S/WASHER	M16 x 45L	SUS304	4	0.8	
5	PAD	10t PLATE	SS400	2	1.0	
4	LUG	65 X 65 X 8t E.A	SS400	2	9.2	
3	LUG	65 X 9t F.B	SS400	2	1.6	
2	STEP	22 SQ.BAR	SS400	7	10.1	
1	SIDE FRAME	65 X 9t F.B	SS400	2	20.9	
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK