

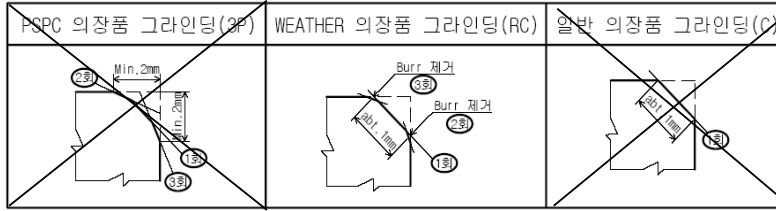
NOTE

PSPC 의장품

WEATHER 의장품

일반 의장품

1. 본도는 WATER BREAK FITTING 제작도임.
2. 모서리 부분은 하기와 같이 GRINDING 할 것. (RC)

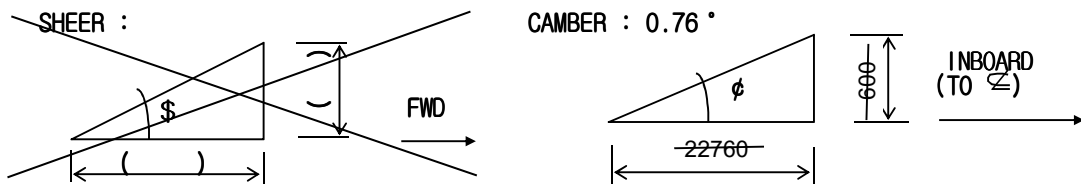


3. 용접은 특기와 하기 표 참조하고 연속 용접할 것.

* 필렛의 용접 각장은 아래를 따를 것.

재료의 두께	4.5	6	7~8	9~10	11~12	13	14~15	16~18	19~20
용접 각장	3	4	4.5	5	5.5	6	7	7.5	9


4. 제작시 DECK 상의 SHEER (\$: /)와 CAMBER (φ : 600/22760)를 필히 적용할 것.




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. 사용 자재의 MILL SHEET를 제출할 것.
8. 제작 시 정도관리를 철저히 하고, 제작 후 당사 자재 검사를 필할 것.
9. BOLT 길이는 NUT 체결후 ABT. 2~3 산이 남도록 할 것.
10. 모든 NAME PLATE는 상면에 GREASE COATING VINYL 3회 이상 감아서 청 TAP 부착하여 SET SCREW를 이용하여 정방향 부착 입고 할 것.
11. 도면 상 언급된 지시 사항 필히 준수하고 제작 TOLERANCE 준수할 것.
12. 소요부서 : 자재구매부, 대조립부, 판넬조립부
13. P.O.R NO. : J68
14. TOTAL WEIGHT : 921.8 Kg/SHIP

(표지 포함 14매)

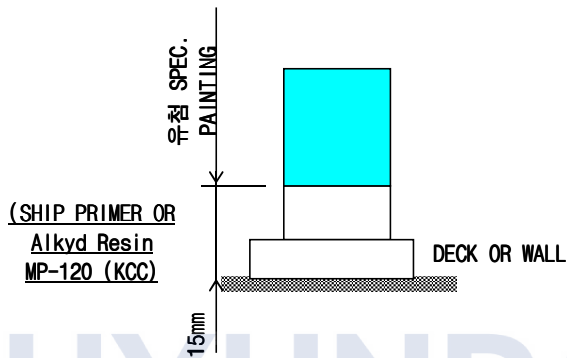
DEPT. B111	SHIP NO. 8158-8160	SHIP TYPE 7,900 TEU CLASS CONTAINER CARRIER
TEL. 2895	부서명 구 조 설 계 부	도 면 명
승 인 이 완 순	검 도 이 도 형	작 성
		WATER BREAK FITTING 제 작 도
		도 면 번 호 1511-H18B-0
		날 짜 2023년 01월 31일

	PLAN HISTORY		SHIP NO.	8158-8160	1
			DWG. NO.	1511-H18B	
DATE	REV. NO.	DESCRIPTION	DRAWN	CHECKED	APPROVED
2023.01.31	O	8158-8160호선 WATER BREAK FITTING 제작도임.	이도형		이완순

PAINTING SPEC.						PAINT SUPPLIER	JOTUN	
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
UD	VERTICAL LADDER (VLD-F**) HINGED COVER HANDGRIP	STEEL	NS	T3				
GD	HANDRAIL	GALV'D	—	DC				
	ITEM	IN SIDE & OUT SIDE			IN SIDE	OUT SIDE		
	ALL	FINAL	SHOP PRIMER	PRIMER				
		0						

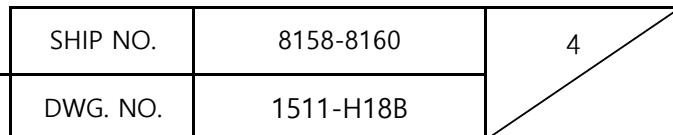
	製作仕様書(외주구매용)	SHIP NO.	8158-8160	2
		DWG NO.	1511-H18B	

1. GALV. 두께 : HOT DIP GALV. 55~80 μ (단, BOLT/NUT류는 45~65 μ 시공)
2. GREASE NIPPLE은 FULL GREASING하고 규정된 고무 CAP을 씌울것.
3. SS400이 아닌 재질의 BOLT/NUT는 재질을 PUNCHING할것.
4. 도장 : 유첨 SPEC.에 준하되 특히 DECK에 취부되는 부위는
DECK OR WALL에서 15mm까지는 SHOP PRIMER 시공할 것.
5. HOT GALV. : DECK/WALL에서 취부되는 부위는 DECK/WALL에서 15mm까지는
Alkyd Resin MP-120(KCC) Coating 하여 도금이 되지 않도록 할것.



6. GALV. 용 HOLE 시공할 경우는 GALV. 후 메공하고 GALV. 손상 부위 수정 후 입고할 것.
7. 납품시 P.O.R SHEET와 유첨도를 첨부할 것.
8. MAKER CERTIFICATE (특수 재료는 MILL SHEET)를 첨부할 것.
9. 무도장으로 입고되는 품목으로서 그 품목의 일부분이 도금이 되어있는 경우는
SHOT BLASTING으로부터 도금 부분이 훼손되지 않도록 보호 MASKING을 하여 입고할 것.
(단 도금 표면에 다시 PAINTING하는 경우는 제외됨)
10. 의장품 자재 PALLET 고박용 번선 및 고박 ITEM에 대한 묶음 WIRE (철사)는 필히
부식 방지용 COATING WIRE를 사용하여 입고 시킬 것.
11. 의장품 자재 입고시 상,하,좌,우로 움직일 수 있는 항목들은 상기 10)번항에 의거하여
반드시 고박하여 입고할 것. (안전사고 사전방지)
12. 납품시 하기 참고하여 입고할 것.
 - 1) 용접선 있는 자재는 용접선 부근 50mm 이내 PAINT MARKER 마킹 적용
(설치 후 은폐 도장 작업 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.

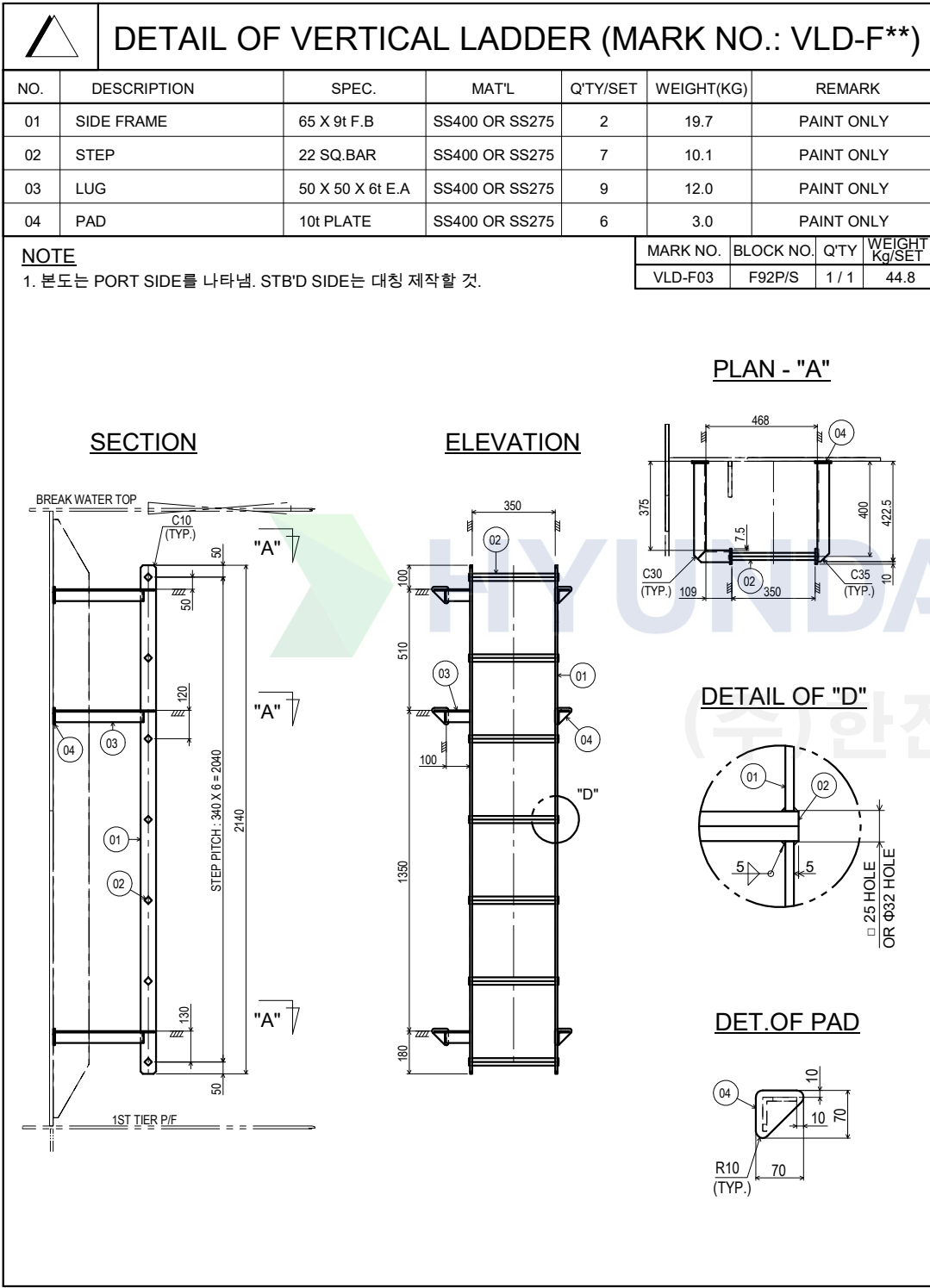
					SHIP NO.	8158-8160	3
제품품별 납기 LIST					DWG. NO.	1511-H18B	
P.O.R NO	SEQ NO.	BLOCK	STAGE	MARK NO.	DESCRIPTION	Q'TY /SHIP	WEIGHT (KG/SET)
J68	01	F61AL(P)	BS	HGR-A01	HANDGRIP	1	1.0
	02	F61AL(P)	BS	STP-A01	STEP	3	3.2
	03	F61AL(S)	BS	HGR-A01	HANDGRIP	1	1.0
	04	F61AL(S)	BS	STP-A01	STEP	3	3.2
	05	F61BL(P)	BS	VLD-F01	VERTICAL LADDER	1	38.8
	06	F61P0	MS	VLD-F02	VERTICAL LADDER	1	60.8
	07	F61BL(P)	BS	HG-F01	HANDGRIP	2	2.6
	08	F61BL(P)	BS	HC-F01P	HINGED COVER	1	23.3
	09	F61P0	MS	HRF-01P	HANDRAIL	1	32.6
	10	F61P0	MS	HRF-02P	HANDRAIL	1	33.4
	11	F61P0	MS	HRF-03P	HANDRAIL	1	33.4
	12	F61P0	MS	HRF-04P	HANDRAIL	1	34.8
	13	F61P0	MS	HRF-05P	HANDRAIL	1	32.3
	14	F61P0	MS	HRF-06P	HANDRAIL	1	32.4
	15	F61P0	MS	HRF-07	HANDRAIL	1	36.2
	16	F61BL(S)	BS	VLD-F01	VERTICAL LADDER	1	38.8
	17	F61S0	MS	VLD-F02	VERTICAL LADDER	1	60.8
	18	F61BL(S)	BS	HG-F01	HANDGRIP	2	2.6
	19	F61BL(S)	BS	HC-F01S	HINGED COVER	1	23.3
	20	F61S0	MS	HRF-01S	HANDRAIL	1	32.6
	21	F61S0	MS	HRF-02S	HANDRAIL	1	33.4
	22	F61S0	MS	HRF-03S	HANDRAIL	1	33.4
	23	F61S0	MS	HRF-04S	HANDRAIL	1	34.8
	24	F61S0	MS	HRF-05S	HANDRAIL	1	32.3
	25	F61S0	MS	HRF-06S	HANDRAIL	1	32.4
	26	F92P0	FS	VLD-F03	VERTICAL LADDER	1	44.8
	27	F92P0	FS	HG-F02	HANDGRIP	1	13.8
	28	F92P0	FS	HC-F02P	HINGED COVER	2	23.3
	29	F92S0	FS	VLD-F03	VERTICAL LADDER	1	44.8
	30	F92S0	FS	HG-F02	HANDGRIP	1	13.8



P.O.R NO	SEQ NO.	BLOCK	STAGE	MARK NO.	DESCRIPTION	Q'TY /SHIP	WEIGHT (KG/SET)	
J68	31	F92S0	FS	HC-F02S	HINGED COVER	2	23.3	
	합 계 (Q'TY, KG/SHIP)						39	921.8

DETAIL OF VERTICAL LADDER (MARK NO.: VLD-F**)

H8158-1511H18B-005





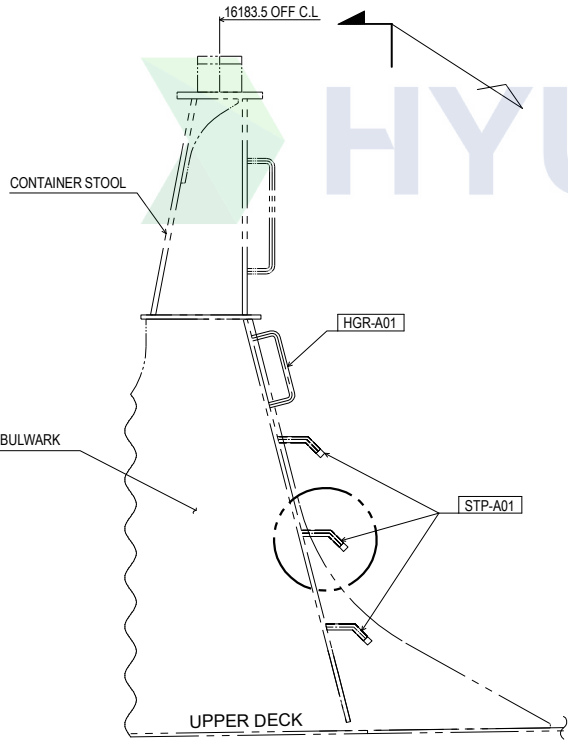
DETAIL OF HANDGRIP & STEP

SHIP NO.	8158/8159/8160	07
DWG NO.	1511-H18B	

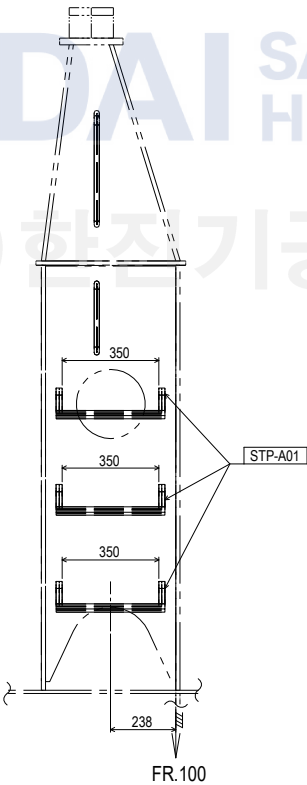
NOTE

1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.

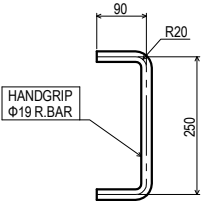
SECTION



ELEVATION

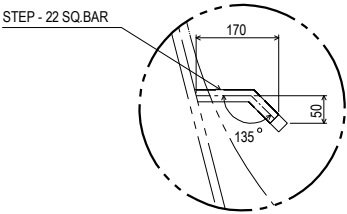


DET. OF HANDGRIP
(MARK NO. : HGR-A01)



MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
HGR-A01	F61P/S	1 / 1	1.0

DET. OF STEP
(MARK NO. : STP-A01)



MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
STP-A01	F61P/S	3 / 3	3.2

H8158-1511H18B-006



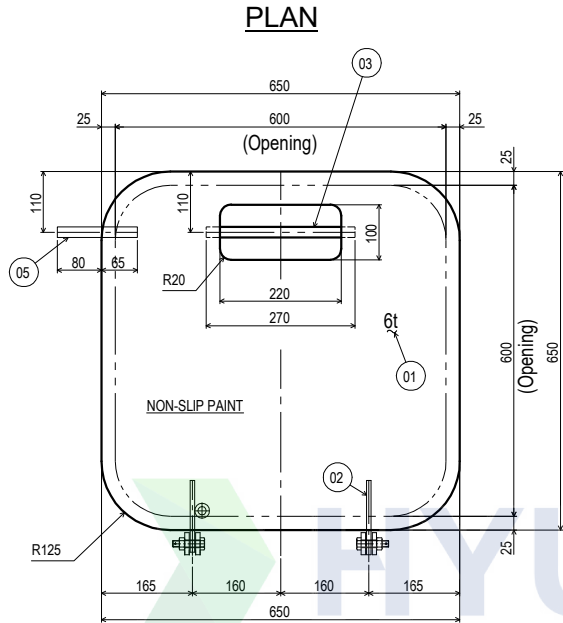
DETAIL OF HINGED COVER

SHIP NO.	8158/8159/8160	08
DWG NO.	1511-H18B	

NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(Kg)	REMARK
01	COVER	6t PLATE	SS400	1	20.4	
02	HINGE	8t PLATE	SS400	2	2.0	
03	HAND GRIP	Φ19 R.BAR, L=270	SS400	1	0.6	
04	HINGE PIN	M12X50L B/NUT	SUS316	2	-	
05	STOPPER	Φ19 R.BAR, L=145	SS400	1	0.3	

MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
HC-F01P	F61P	1	23.3
HC-F01S	F61S	1	23.3

* 본도는 PORT SIDE를 나타냄.
STB'D SIDE는 대칭 제작할 것.

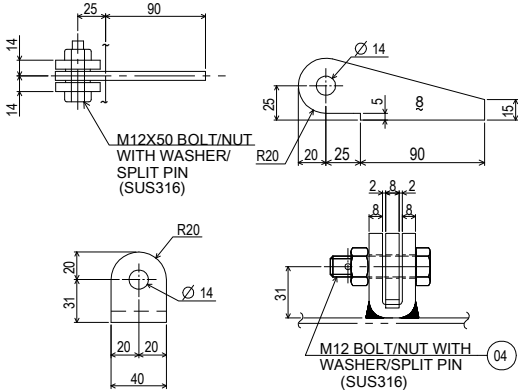
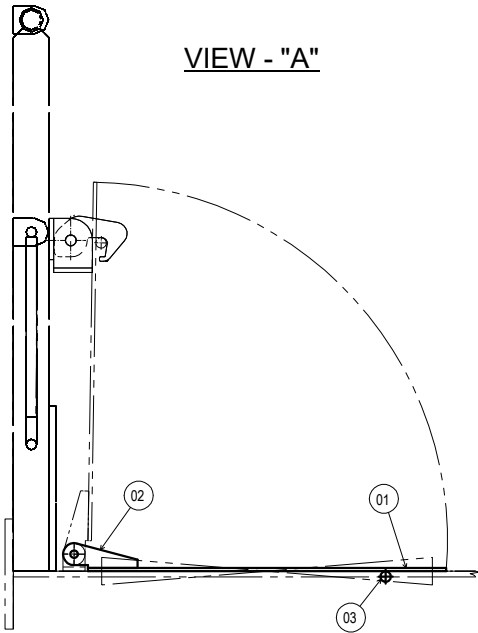


대칭제작 기준선

"A"

DET. OF HINGE

VIEW - "A"



H8158-1511H18B-007



SHIP NO.	8158/8159/8160	09
DWG NO.	1511-H18B	

[illegible]

대청제작 기준선

"A"

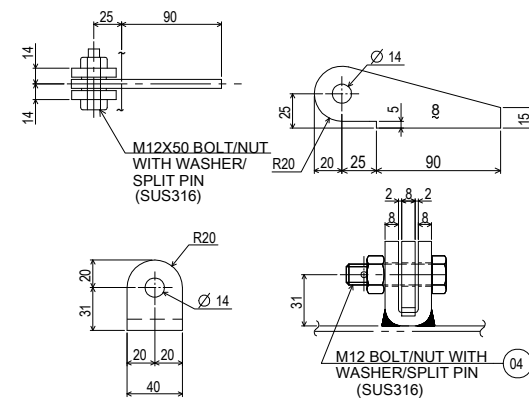
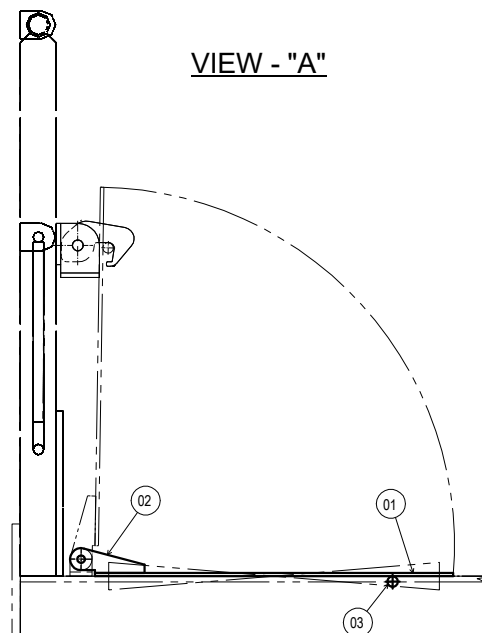
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(Kg)	REMARK
01	COVER	6t PLATE	SS400	1	20.4	
02	HINGE	8t PLATE	SS400	2	2.0	
03	HAND GRIP	Φ19 R.BAR, L=270	SS400	1	0.6	
04	HINGE PIN	M12X50L B/NUT	SUS316	2	-	
05	STOPPER	Φ19 R.BAR, L=145	SS400	1	0.3	

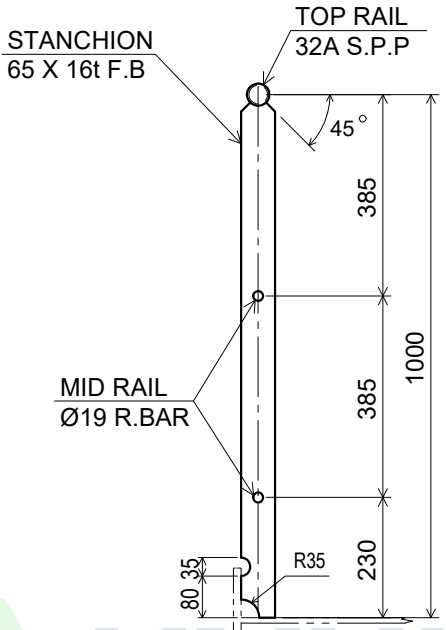
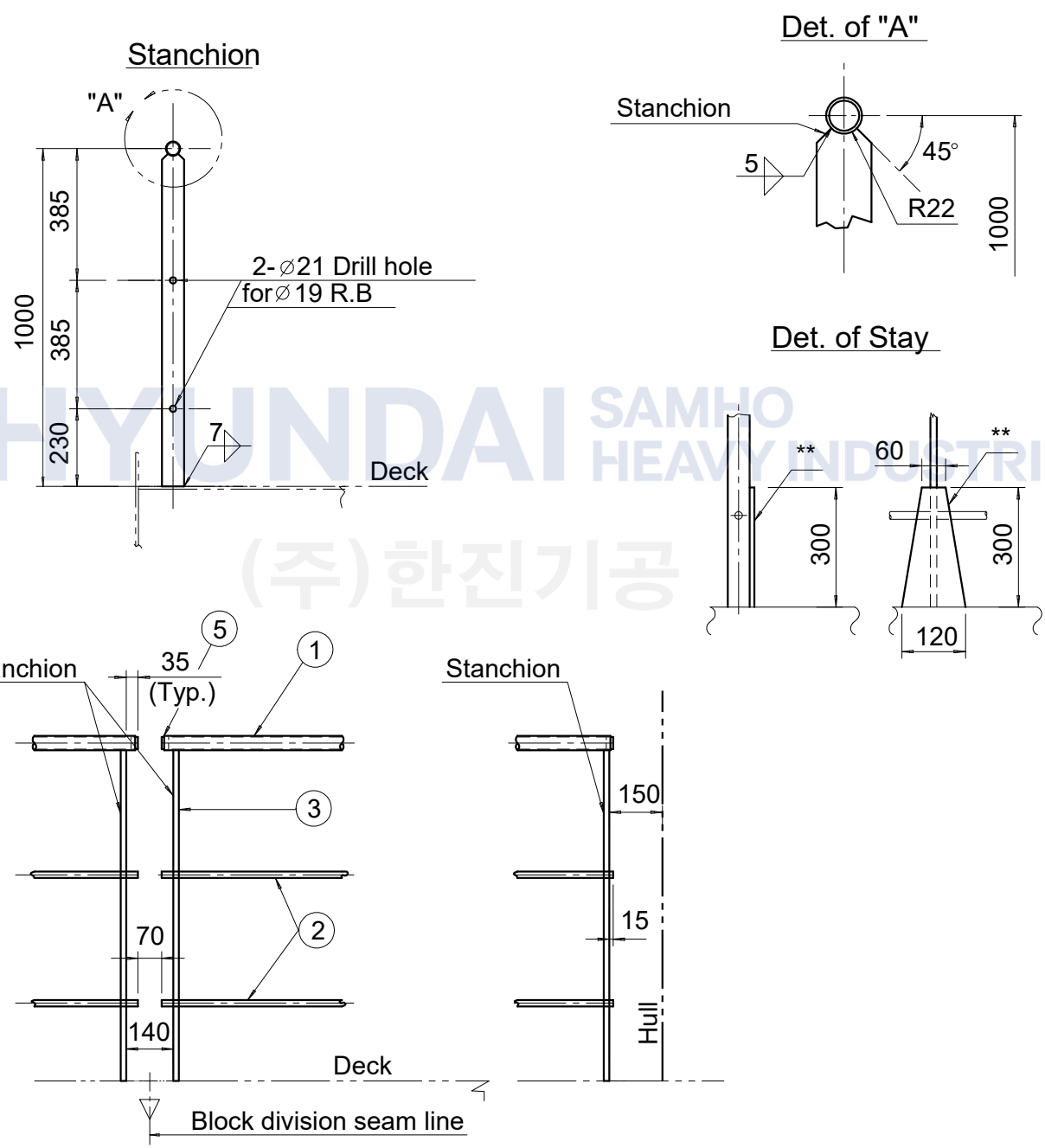
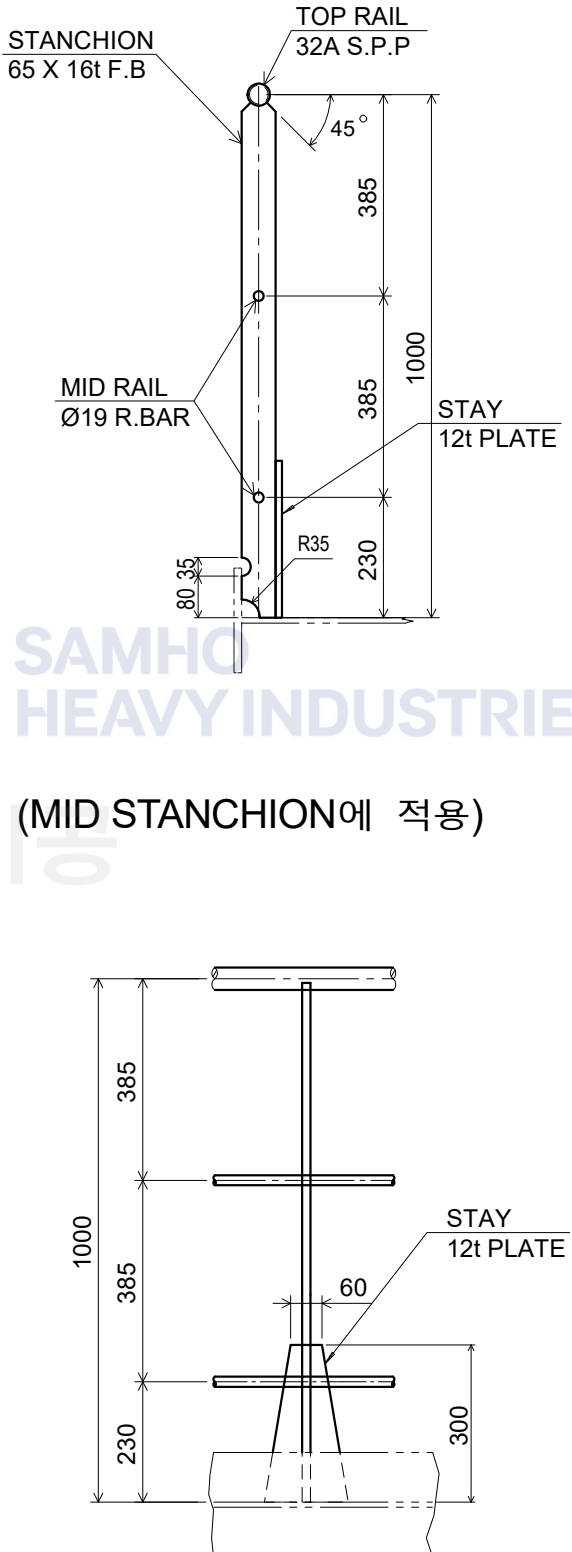
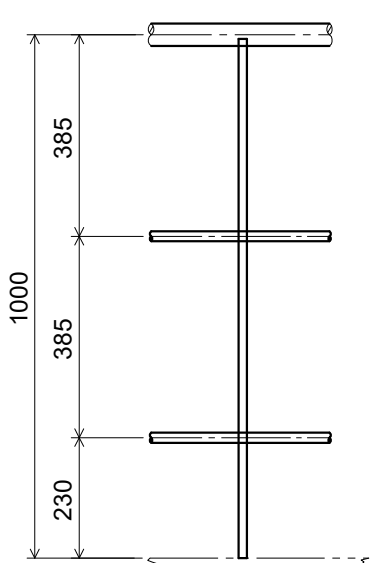
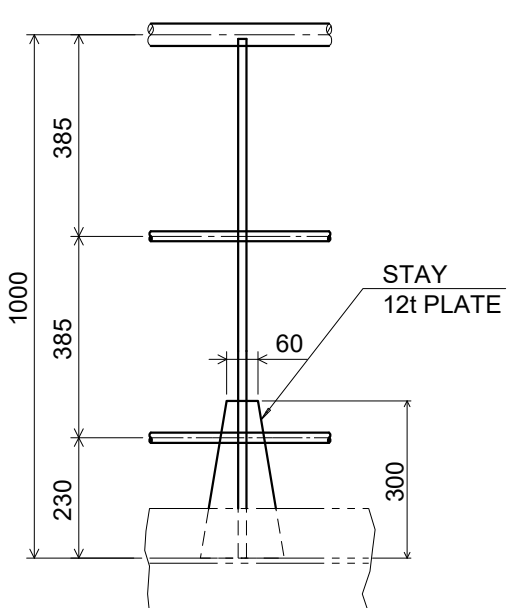
MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
HC-F02P	F92P	2	23.3
HC-F02S	F92S	2	23.3

* 본도는 PORT SIDE를 나타냄.
STB'D SIDE는 대칭 제작할 것.

DET. OF HINGE

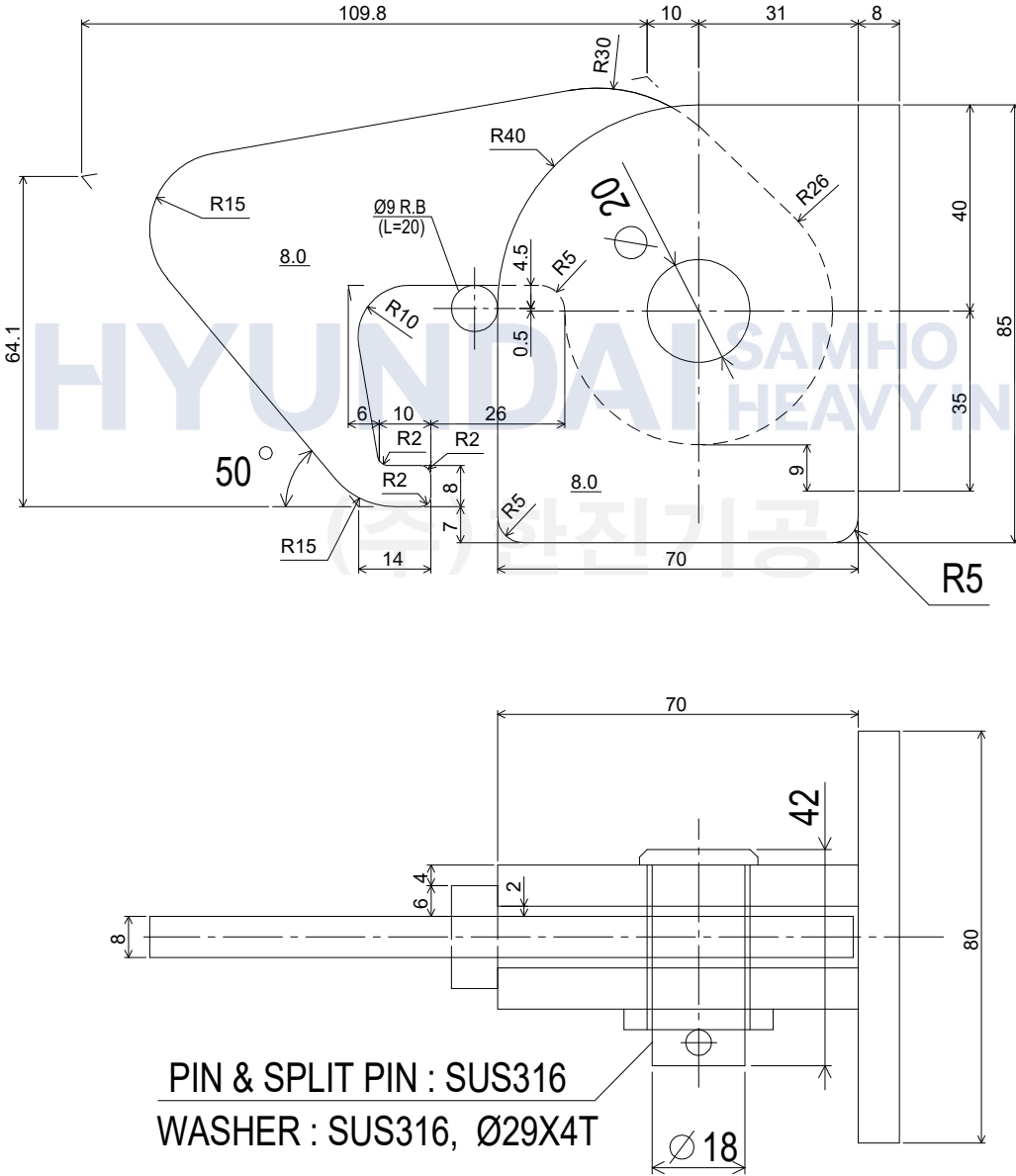
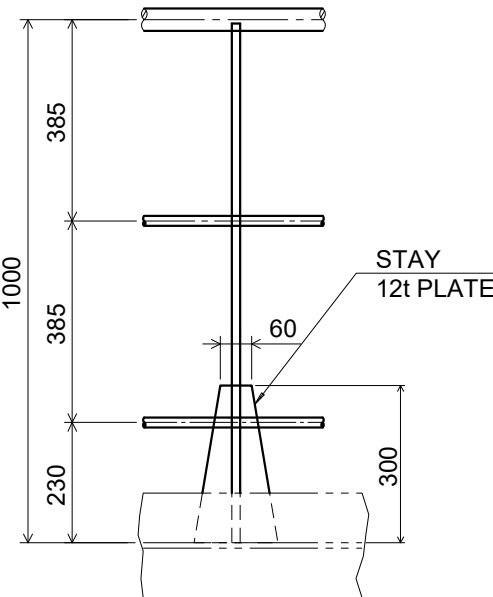
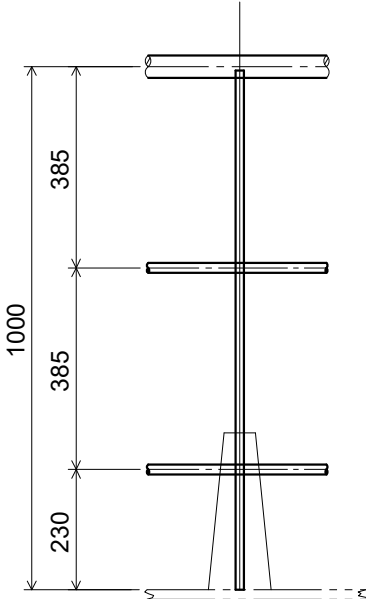
VIEW - "A"



HANDRAIL (TYPE-A1)							DETAIL OF STANCHION FOR RAIL		
							SHIP NO.	8158/8159/8160	10
							DWG NO.	1511-H18B	
No.	Description	Size	Mat'l	Qty /Set	Wt(kg)	Remark	TYPE - M		
1	Top rail	32A(O.D Ø 42.7)	SPP	1		Galv.	 <p>(MID STANCHION에 적용)</p>		
2	Mid rail	Ø 19 R.B	SS400 or SS275	2		Galv.			
3	Stanchion	65X16t F.B	SS400 or SS275	1		Galv.			
4	Stay	12t Plate	SS400 or SS275	1		Galv.			
5	End plate	6t Plate	SS400 or SS275	1		Galv.			
							TYPE - MS		
 <p>Stanchion</p> <p>1000</p> <p>385</p> <p>230</p> <p>7</p> <p>2-Ø21 Drill hole for Ø19 R.B</p> <p>Deck</p> <p>Det. of "A"</p> <p>Stanchion</p> <p>5</p> <p>45°</p> <p>R22</p> <p>1000</p> <p>Det. of Stay</p> <p>60</p> <p>300</p> <p>120</p> <p>300</p> <p>Stanchion</p> <p>35 (Typ.)</p> <p>1</p> <p>3</p> <p>2</p> <p>70</p> <p>140</p> <p>Deck</p> <p>Block division seam line</p> <p>Stanchion</p> <p>150</p> <p>15</p> <p>Hull</p>							 <p>(MID STANCHION에 적용)</p>		
							 <p>TOP RAIL : 32A PIPE (SPP)</p> <p>MID RAIL : Ø19 R.BAR</p>		
							 <p>STANCHION : 65 X 16t F.BAR</p> <p>STAY : 12t PLATE</p>		

Note

- 1.Stanchion space : Abt. 1200mm interval.
- 2.Stay space : At every third stanchion pitch.
- 3.Application : working platform on braekwater
- 4.(*, ** Mark) Stay shall be applied in way of narrow passageway space.
(Stay space : Two stanchion pitch)

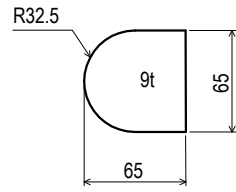
<div><div></div></div>		DETAIL OF STANCHION FOR RAIL		DET. OF SELF-LOCKING STOPPER		SHIP NO. 8158/8159/8160		11			
						DWG NO. 1511-H18B					
TYPE - MS1		TYPE - ML		<div>DET. OF SELF-LOCKING STOPPER</div> <div>(HOT DIP GAL'V)</div> <div>* HOOK 작동여부 확인 및 고착되지 않도록 제작할 것.</div> <div></div> <div>PIN & SPLIT PIN : SUS316 WASHER : SUS316, Ø29X4T</div>							
<div><div>STANCHION 65 X 16t F.B</div><div>TOP RAIL 32A S.P.P</div><div>45°</div><div>385</div><div>1000</div><div>MID RAIL Ø19 R.BAR</div><div>385</div><div>STAY 12t PLATE</div><div>230</div><div>65</div></div> <div>(MID STANCHION에 적용)</div> <div></div>		<div><div>STANCHION 65 X 16t F.B</div><div>TOP RAIL 32A S.P.P</div><div>45°</div><div>385</div><div>1000</div><div>MID RAIL Ø19 R.BAR</div><div>385</div><div>STAY 12t PLATE</div><div>230</div><div>80 35</div><div>R35</div><div>650</div></div> <div>SELF-LOCKING STOPPER는 TACK WELDING 하여 입고할 것. (주의할 것.)</div> <div>(MID STANCHION에 적용)</div> <div></div>		TOP RAIL : 32A PIPE (SPP)		STANCHION : 65 X 16t F.BAR		MID RAIL : Ø19 R.BAR			



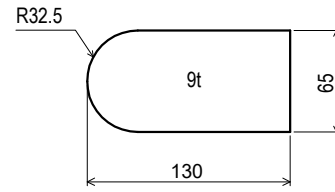
DETAIL OF HANDRAIL

SHIP NO.	8158/8159/8160	12
DWG NO.	1511-H18B	

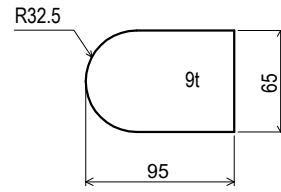
TYPE - EP



TYPE - EP1

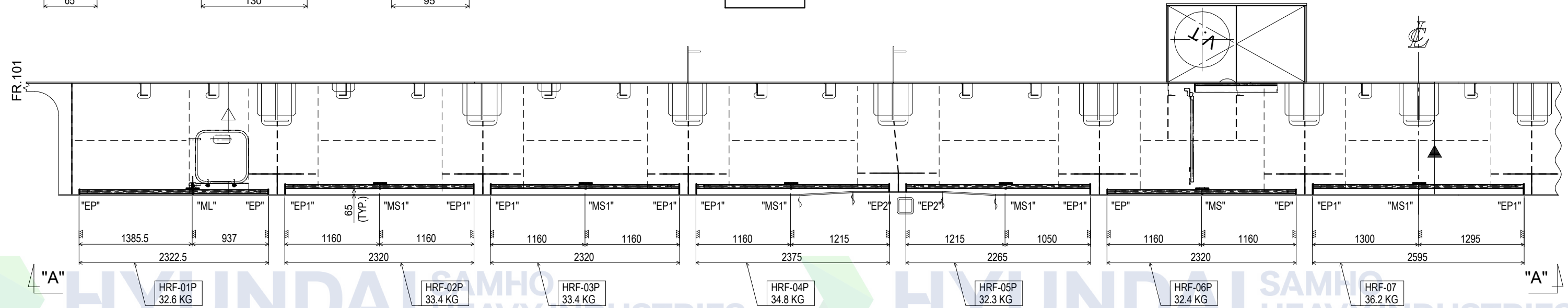


TYPE - EP2

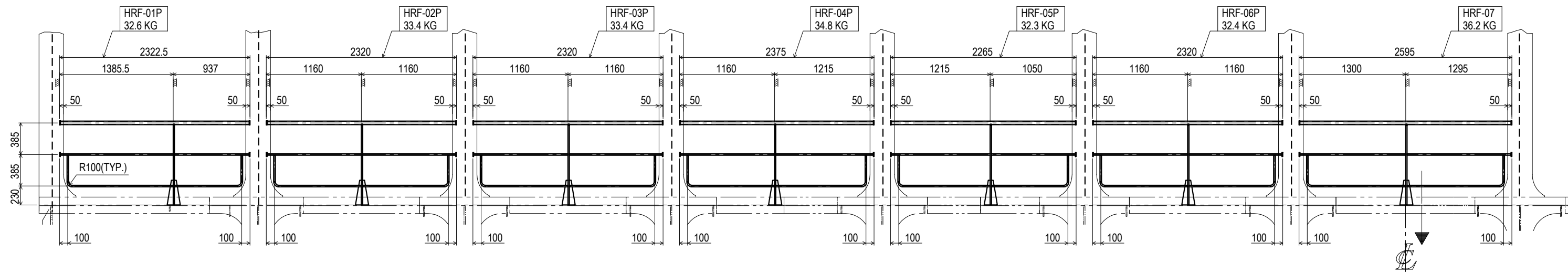


WORKING PLATFORM PLAN

F61P



VIEW "A" - "A"



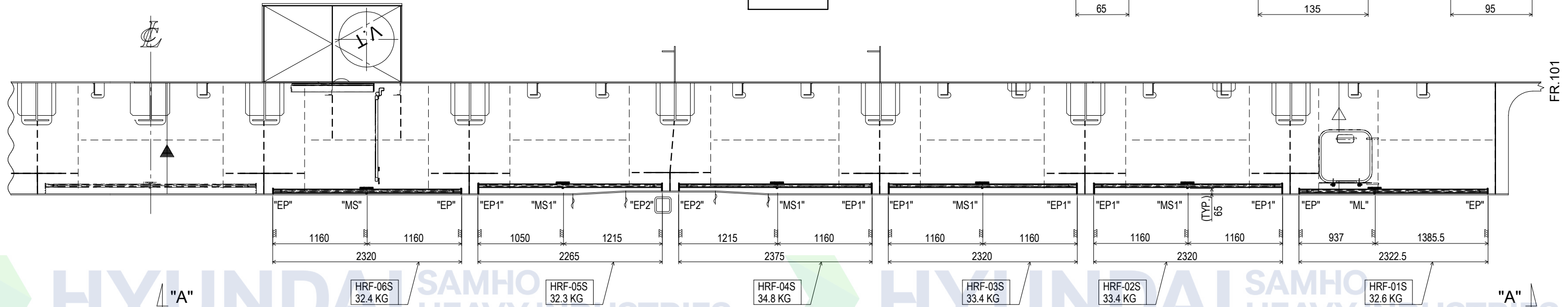
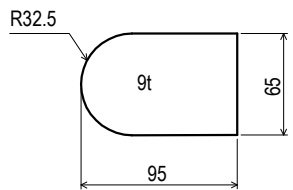


SHIP NO.	8158/8159/8160	13
DWG NO.	1511-H18B	END

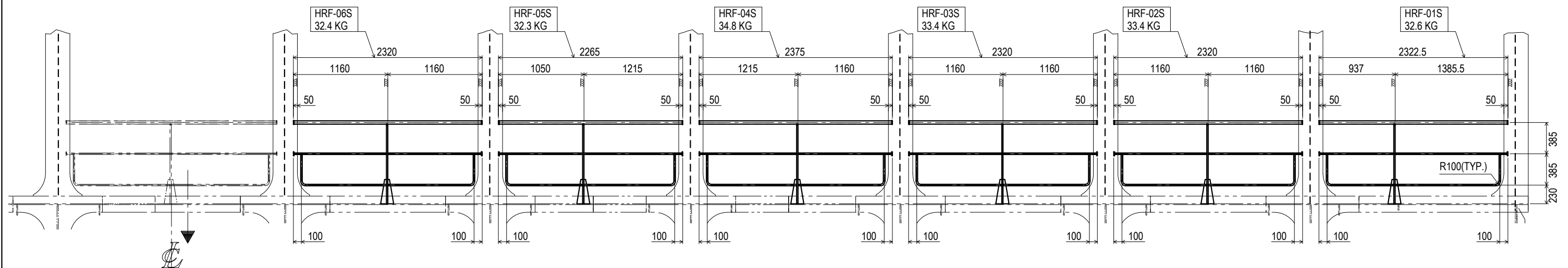
WORKING PLATFORM PLAN

F61S

TYPE - EP



VIEW "A" - "A"



H8158-1511H18B-012