

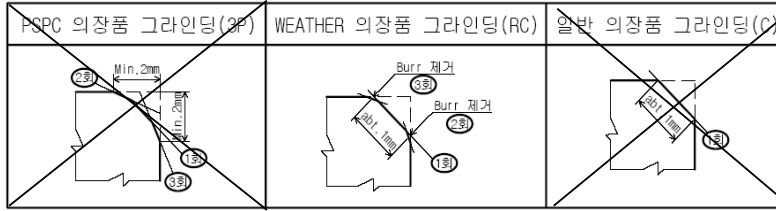
NOTE

PSPC 의장품

WEATHER 의장품

일반 의장품

1. 본도는 VERTICAL LADDER 제작도임.
2. 모서리 부분은 하기와 같이 GRINDING 할 것. (RC)

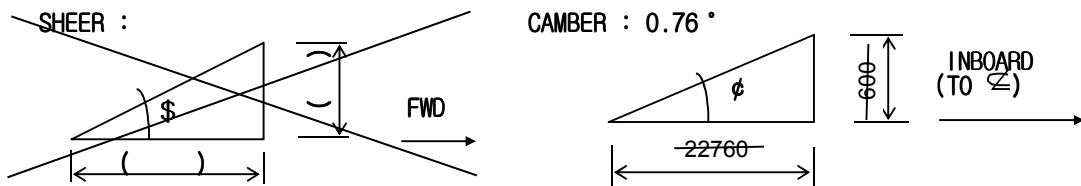


3. 용접은 특기외 하기 표 참조하고 연속 용접할 것.

* 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.

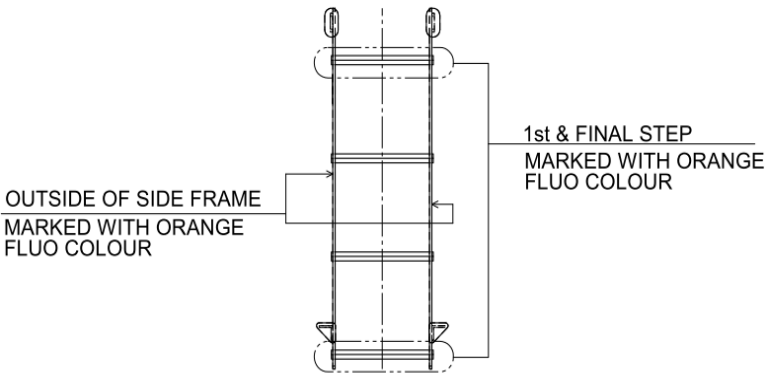


5. 한 도면에서 서로 상이부분이 있거나 제작상 문제점 발생시 필히 당부와 협의/확정 후 제작 완료할 것.
6. 본 도면상에 표기된 자재 중 SS400 , 단조품(SF자재) 및 용접되는 주강품(SC42)은 탄소(C) 함유량이 0.23% 이하가 되어야 함에 유의할 것 (자재 MILL SHEET 제출 요). 또한, 주강품은 용접 시 PRE-HEATING(200℃) 한 후 용접하여 용접균열을 방지할 것.
7. 사용 자재의 MILL SHEET를 제출할 것.
8. 제작 시 정도관리를 철저히 하고, 제작 후 당사 자재 검사를 필할 것.
9. BOLT 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. : J62
14. TOTAL WEIGHT : 992.0 Kg/SHIP

(표지 포함 10매)

DEPT. B111	SHIP NO. 8161-8163	SHIP TYPE 7,900 TEU CLASS CONTAINER CARRIER
TEL. 2722	부서명 구 조 설 계 부	도 면 명
승 인 검 도 작 성	이 완 순 신 충 길 원 혁 빈	VERTICAL LADDER 제 작 도
HYUNDAI SAMHO HEAVY INDUSTRIES		도 면 번 호 1511-H13B-0
		날 짜 2023년 06월 19일

	PLAN HISTORY		SHIP NO.	8161-8163	1
			DWG. NO.	1511-H13B	
DATE	REV. NO.	DESCRIPTION	DRAWN	CHECKED	APPROVED
2023.06.19	O	8161-8163호선 VERTICAL LADDER 제작도임.	원혁빈	신충길	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-S**)	STEEL	NS	T3			
UH	VERTICAL LADDER (VLD-S09)	STEEL	NS	T3			
* 하도 참조하여 Vertical Ladder의 Side Frame (outside only) 및 1st & Final Step에 Orange Fluo Colour (ORANGE 2280) Marking 시공할 것(단, VLD-S09는 1st & Final Step만 Marking 시공)							
<div> <div> <div>VERT. LADDER</div>  </div> </div>							
	ITEM	IN SIDE & OUT SIDE			IN SIDE	OUT SIDE	
	ALL	FINAL	SHOP PRIMER	PRIMER			
		0					



製作仕様書(외주구매용)

SHIP NO.

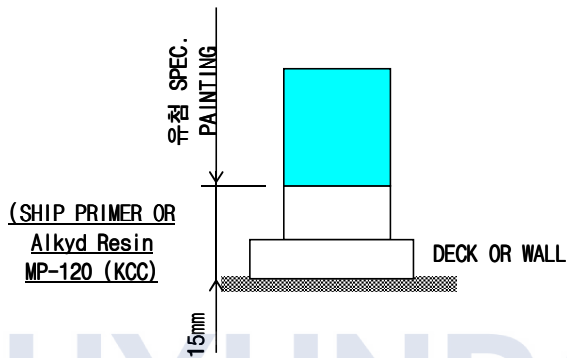
8161-8163

2

DWG NO.

1511-H13B

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.	8161-8163	3
제품품별 납기 LIST					DWG. NO.	1511-H13B	
P.O.R NO	SEQ NO.	BLOCK	STAGE	MARK NO.	DESCRIPTION	Q'TY /SHIP	WEIGHT (KG/SET)
J62	01	E54DL(P)	BS	VLD-S01	VERTICAL LADDER	1	27.9
	02	E54DL(S)	BS	VLD-S01	VERTICAL LADDER	1	27.9
	03	S11P0	CS	VLD-S02	VERTICAL LADDER	1	27.8
	04	S11S0	CS	VLD-S02	VERTICAL LADDER	1	27.8
	05	S12P0	CS	VLD-S12	VERTICAL LADDER	1	27.8
	06	S12S0	CS	VLD-S12	VERTICAL LADDER	1	27.8
	07	S13P0	CS	VLD-S12	VERTICAL LADDER	1	27.8
	08	S13S0	CS	VLD-S12	VERTICAL LADDER	1	27.8
	09	S36DL(P)	BS	VLD-S03	VERTICAL LADDER	1	27.0
	10	S36DL(S)	BS	VLD-S03	VERTICAL LADDER	1	27.0
	11	S37DL(P)	BS	VLD-S04	VERTICAL LADDER	1	27.1
	12	S37DL(S)	BS	VLD-S04	VERTICAL LADDER	1	27.1
	13	S58DL(P)	BS	VLD-S05	VERTICAL LADDER	2	27.2
	14	S58DL(S)	BS	VLD-S05	VERTICAL LADDER	2	27.2
	15	C15AL(P)	BS	VLD-S06	VERTICAL LADDER	1	27.2
	16	C15AL(S)	BS	VLD-S06	VERTICAL LADDER	1	27.2
	17	C14AL(P)	BS	VLD-S07	VERTICAL LADDER	1	27.2
	18	C14AL(S)	BS	VLD-S07	VERTICAL LADDER	1	27.2
	19	F71AL(P)	BS	VLD-S08	VERTICAL LADDER	1	25.7
	20	F71AL(S)	BS	VLD-S08	VERTICAL LADDER	1	25.7
	21	D35P0	FS	VLD-S09	VERTICAL LADDER	1	196.1
	22	D35S0	FS	VLD-S09	VERTICAL LADDER	1	196.1
	23						
	24						
	25						
	26						
	27						
	28						
	29						
	합 계 (Q'TY, KG/SHIP)					24	992.0

H8161-1511H13B-04

DETAIL OF VERTICAL LADDER(MARK NO.: VLD-S**)							SHIP NO.		8161 - 8163		04		
							DWG NO.		1511-H13B				
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK	NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK
01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.5	PAINT ONLY	01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.0	PAINT ONLY
02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY	02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY
03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	1.6	PAINT ONLY	03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	2.1	PAINT ONLY
04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	6.0	PAINT ONLY	04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	5.9	PAINT ONLY
05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY	05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY

NOTE

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

MARK NO.

BLOCK NO.

Q'TY

WEIGHT
Kg/SET

VLD-S01

E54P/S

1 / 1

27.9

ELEVATION

SECTION

PLAN

VIEW - "A"

DETAIL OF "D"

DET.OF UPPER LUG

DET.OF PAD

ELEVATION

SECTION

PLAN

VIEW - "A"

DETAIL OF "D"

DET.OF UPPER LUG

DET.OF PAD



05

DWG NO.	1511-H13B
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NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK	NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK
01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.0	PAINT ONLY	01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.0	PAINT ONLY
02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY	02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY
03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	1.6	PAINT ONLY	03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	1.6	PAINT ONLY
04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	5.6	PAINT ONLY	04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	5.7	PAINT ONLY
05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY	05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY

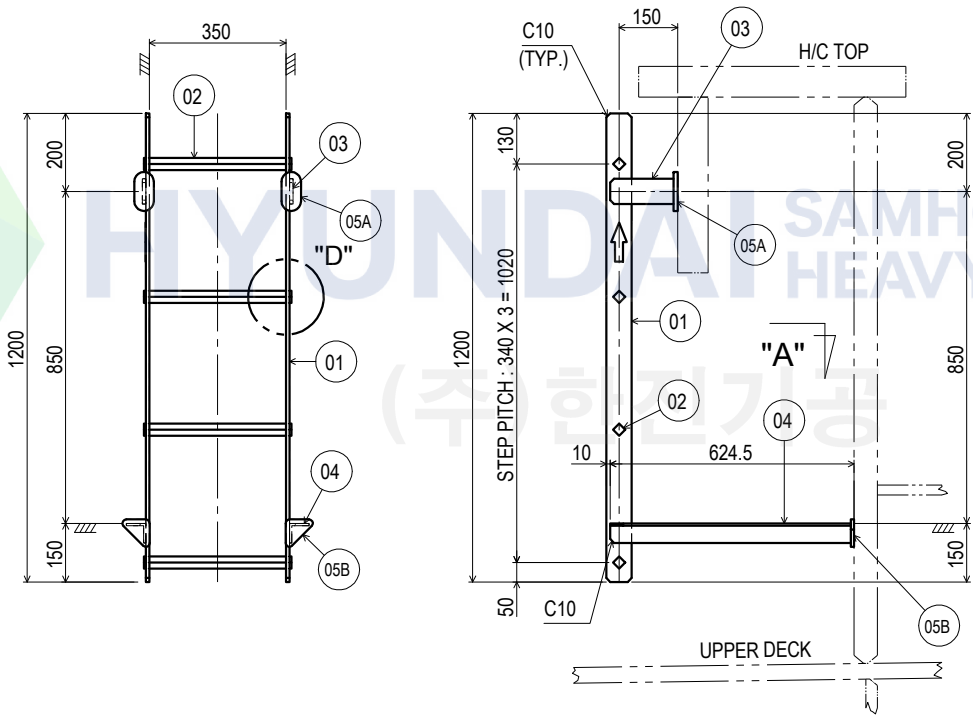
1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.

MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
VLD-S03	S36P/S	1 / 1	27.0

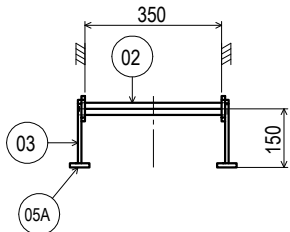
1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.

MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
VLD-S04	S37P/S	1 / 1	27.1

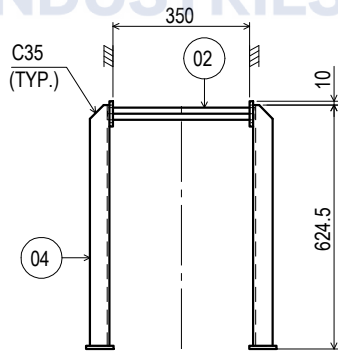
SECTION



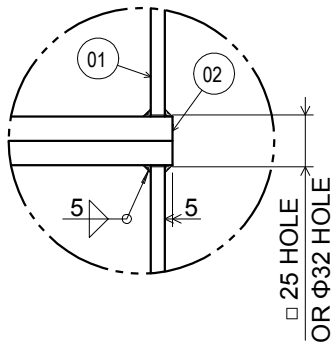
PLAN



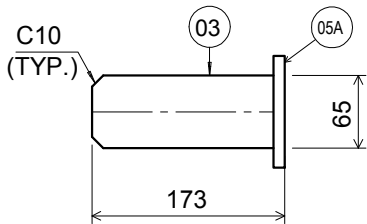
VIEW - "A"



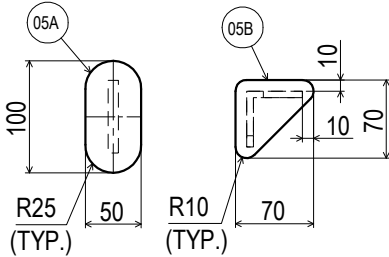
DETAIL OF "D"



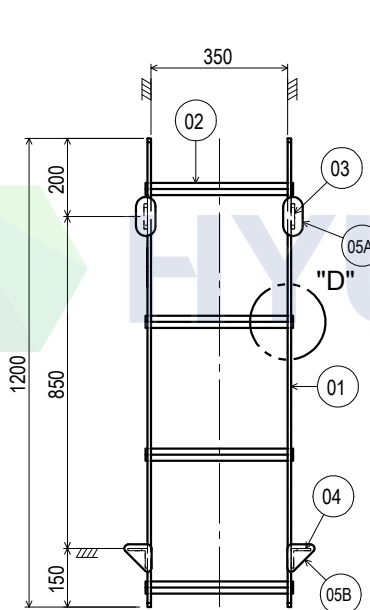
DET.OF UPPER LUG



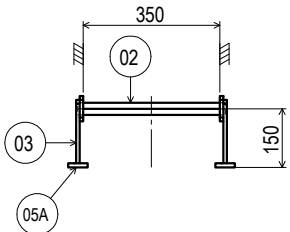
DET.OF PAD



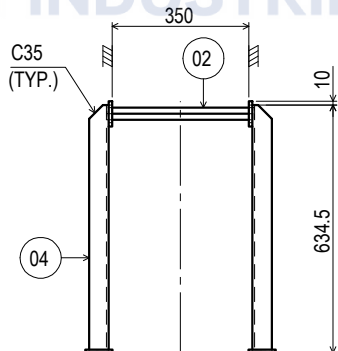
ELEVATION



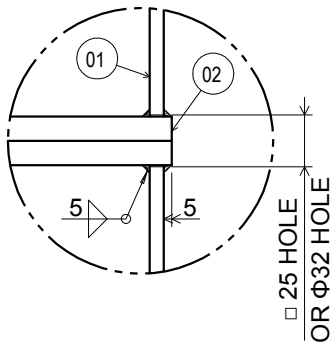
PLAN



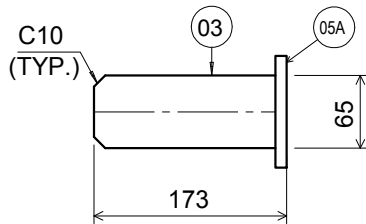
VIEW - "A"



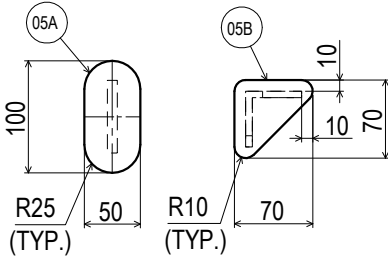
DETAIL OF "D"



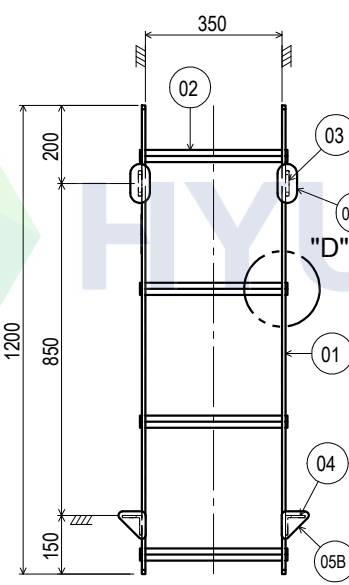
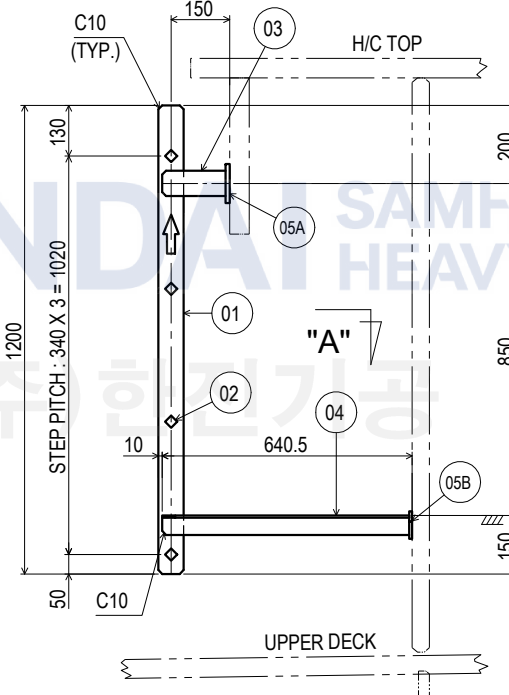
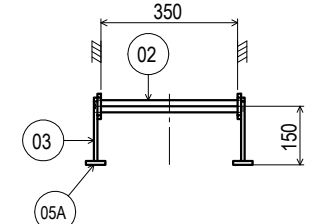
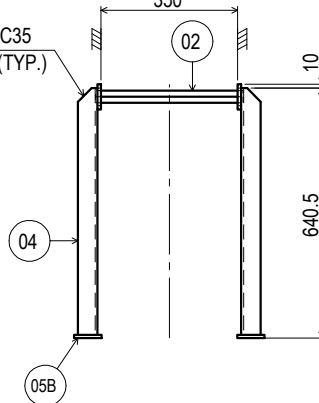
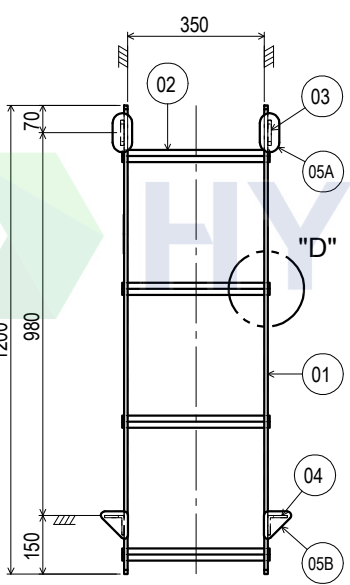
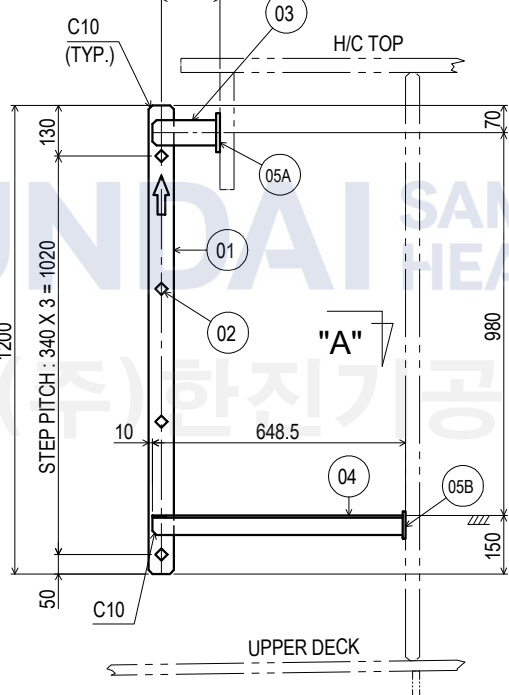
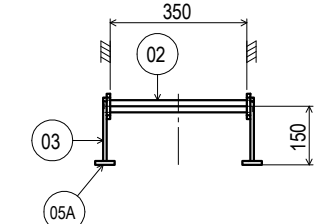
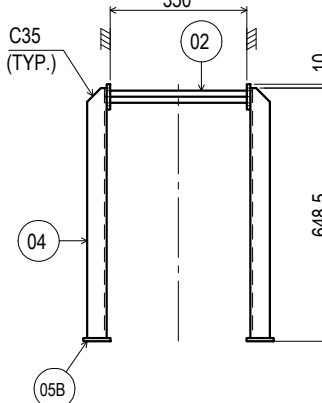
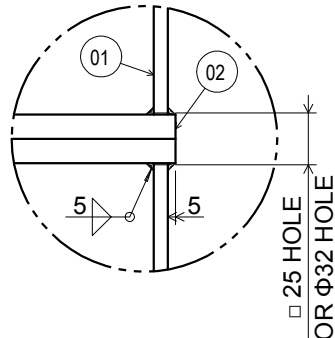
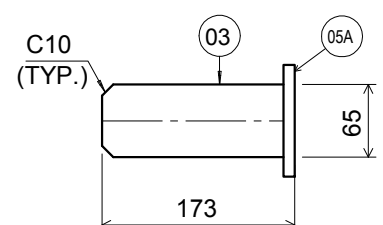
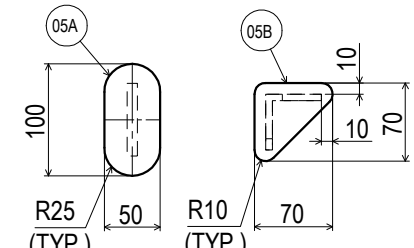
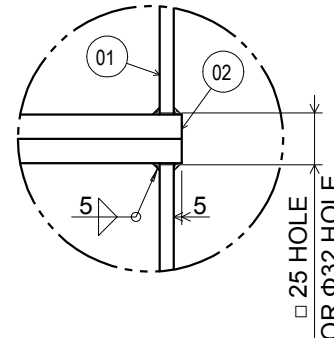
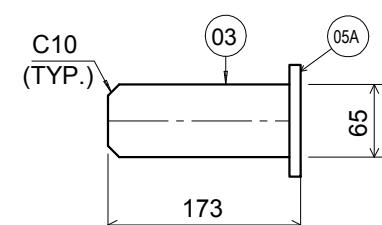
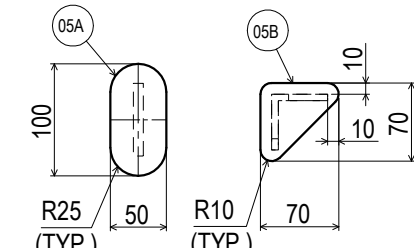
DET.OF UPPER LUG



DET.OF PAD



H8161-1511H13B-06

<div><div></div><div>DETAIL OF VERTICAL LADDER(MARK NO.: VLD-S**)</div></div>										SHIP NO.		8161 - 8163		06
										DWG NO.		1511-H13B		
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK	NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK	
01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.0	PAINT ONLY	01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.0	PAINT ONLY	
02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY	02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY	
03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	1.6	PAINT ONLY	03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	1.6	PAINT ONLY	
04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	5.8	PAINT ONLY	04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	5.8	PAINT ONLY	
05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY	05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY	
NOTE 1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.					MARK NO.		BLOCK NO.		Q'TY		WEIGHT Kg/SET		NOTE 1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.	
					VLD-S05		S58P/S		2 / 2		27.2			
<div><div><div>ELEVATION</div></div><div><div>SECTION</div></div><div><div>PLAN</div></div><div><div>VIEW - "A"</div></div></div> <div><div><div>ELEVATION</div></div><div><div>SECTION</div></div><div><div>PLAN</div></div><div><div>VIEW - "A"</div></div></div> <div><div><div>DETAIL OF "D"</div></div><div><div>DET.OF UPPER LUG</div></div><div><div>DET.OF PAD</div></div></div> <div><div><div>DETAIL OF "D"</div></div><div><div>DET.OF UPPER LUG</div></div><div><div>DET.OF PAD</div></div></div>														

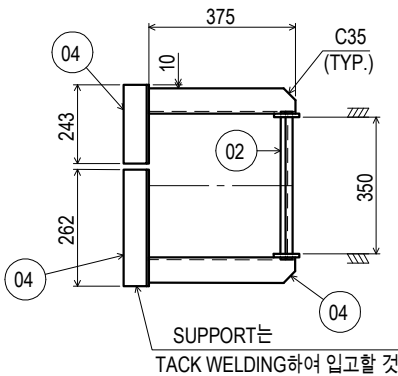
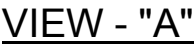
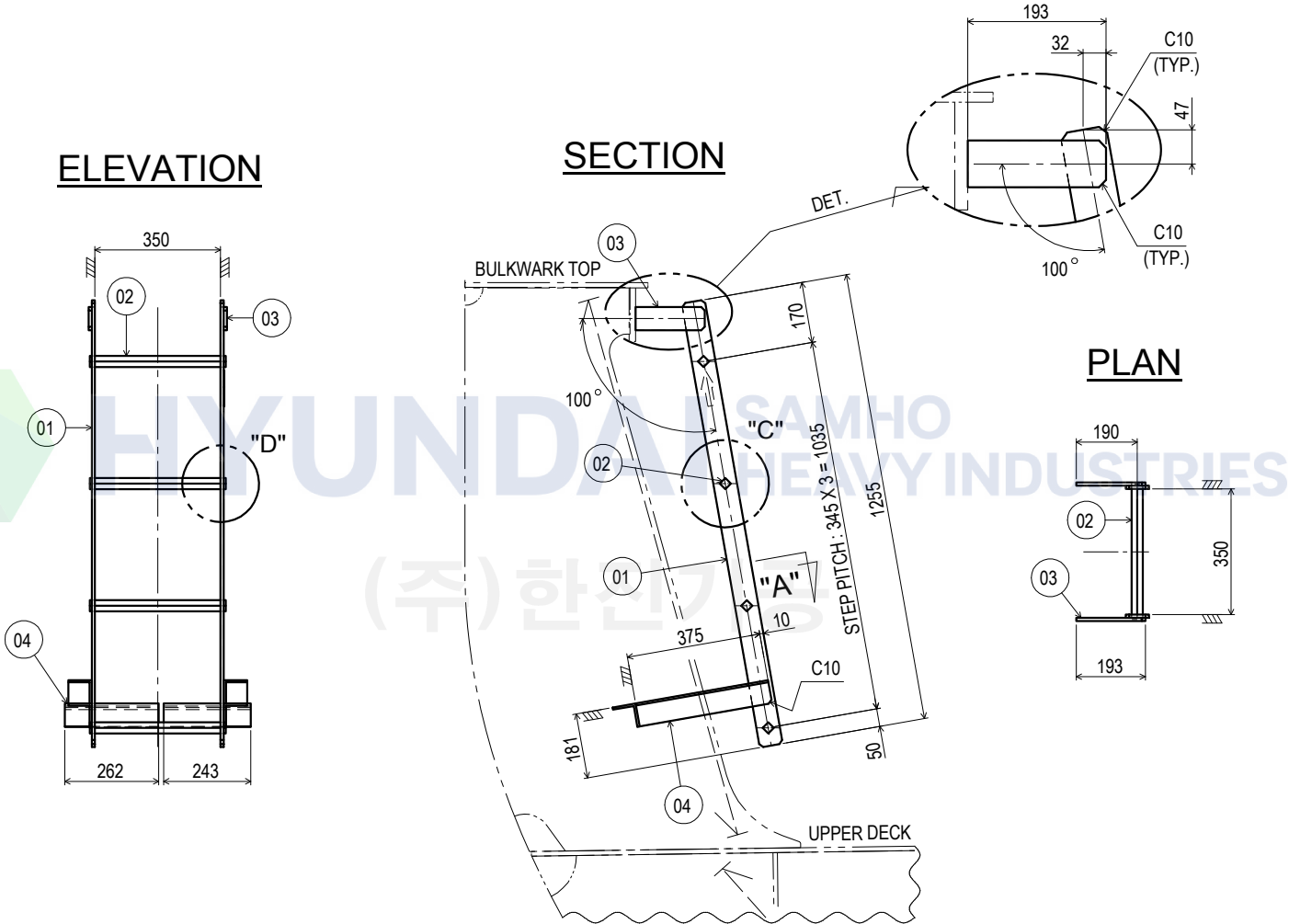


SHIP NO.	8161 - 8163	07 /
DWG NO.	1511-H13B	

NOTE 1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.	MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET	1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.
	VLD-S07	C14P/S	1 / 1	27.2	

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

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



SUPPORT는
TACK WELDING하여 입고할 것

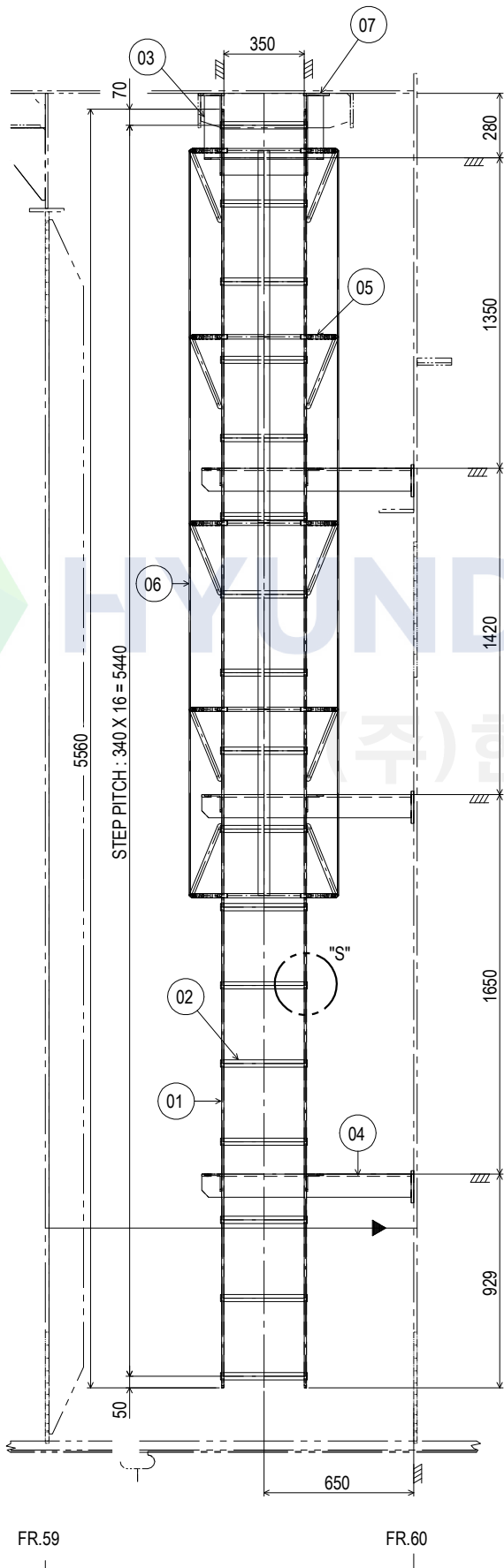


DETAIL OF VERTICAL LADDER (MARK NO.: VLD-S09)

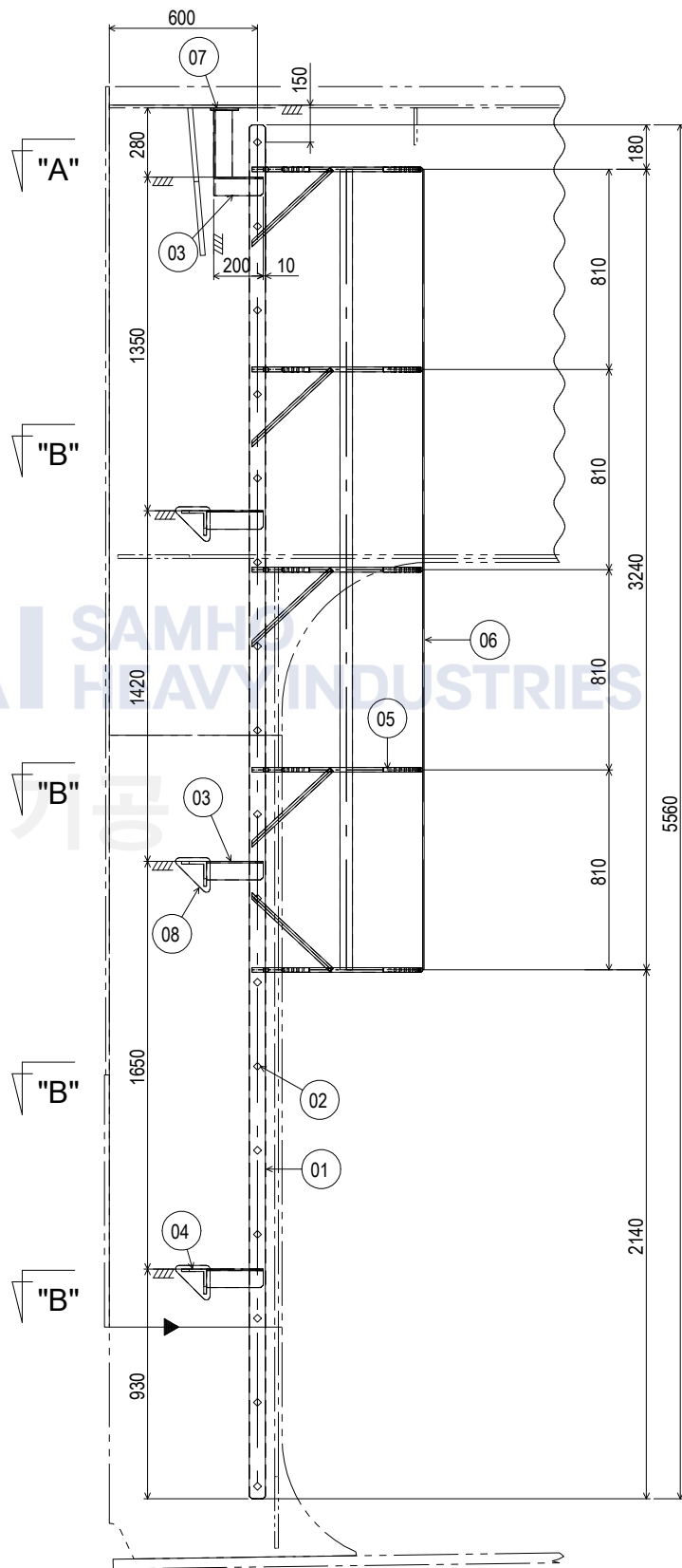
SHIP NO.	8161 - 8163	08
DWG NO.	1511-H13B	

MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
VLD-S09	D35P/S	1 / 1	196.1

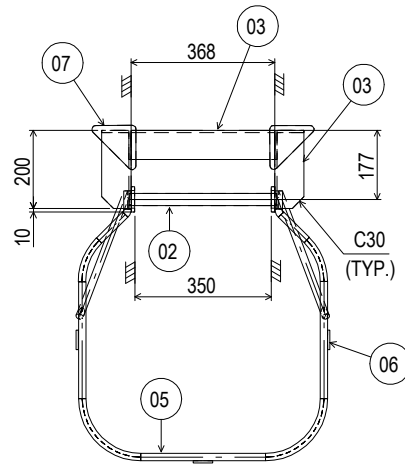
ELEVATION



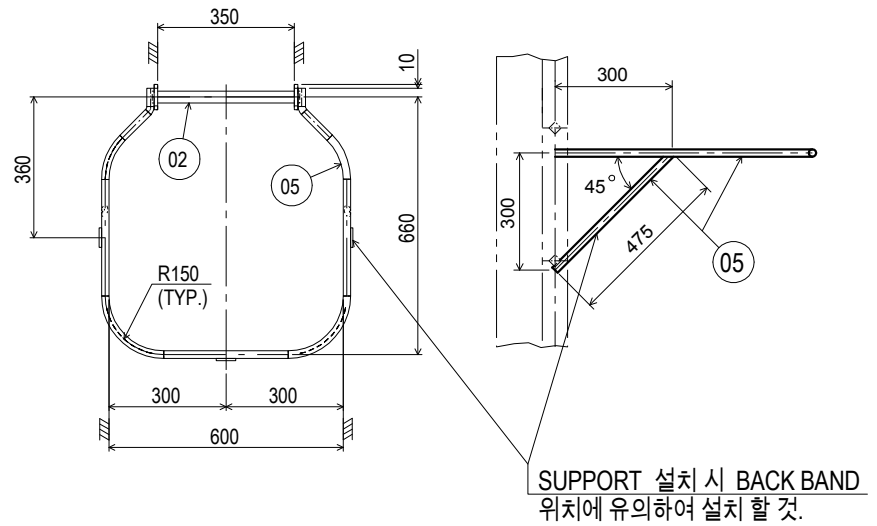
SECTION



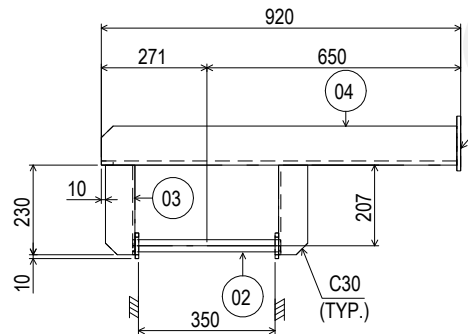
VIEW - "A"



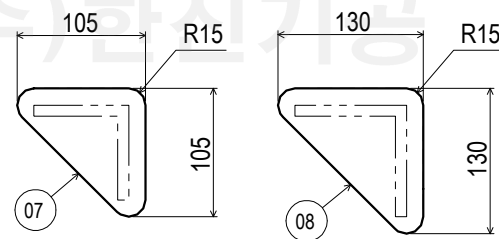
DET. OF BACK BAND



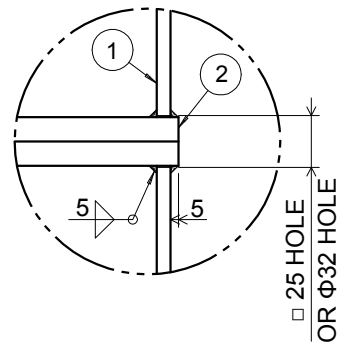
VIEW - "B"



DET. OF PAD



DETAIL OF "S"



NOTE

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

8	PAD	10t PLATE	SS400 OR SS275	3	3.6	PAINT ONLY
7	PAD	10t PLATE	SS400 OR SS275	2	2.0	PAINT ONLY
6	SAFETY CAGE	50 x 6t F.B	SS400 OR SS275	3	23.0	PAINT ONLY
5	BACK BAND	Φ19 R.BAR	SS400 OR SS275	4	26.0	PAINT ONLY
4	SUPPORT	100 x 100 x 10t E.A	SS400 OR SS275	3	43.5	PAINT ONLY
3	SUPPORT	75 x 75 x 6t E.A	SS400 OR SS275	2	22.6	PAINT ONLY
2	STEP	22 SQ.BAR	SS400 OR SS275	17	24.5	PAINT ONLY
1	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	50.9	PAINT ONLY
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK

H8161-1511H13B-09



VERTICAL LADDER (MARK NO.: VLD-S**)

SHIP NO.	8161 - 8163	09
DWG NO.	1511-H13B	END

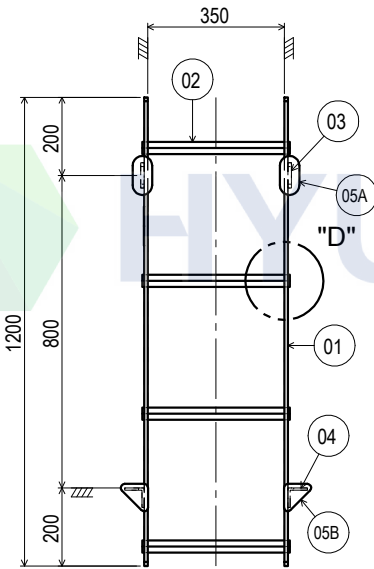
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(KG)	REMARK
01	SIDE FRAME	65 X 9t F.B	SS400 OR SS275	2	11.0	PAINT ONLY
02	STEP	22 SQ.BAR	SS400 OR SS275	4	5.8	PAINT ONLY
03	UPPER LUG	65 X 9t F.B	SS400 OR SS275	2	2.1	PAINT ONLY
04	LOWER LUG	50 X 50 X 6t E.A	SS400 OR SS275	2	5.9	PAINT ONLY
05A 05B	PAD	10t PLATE	AH32	4	3.0	PAINT ONLY

NOTE

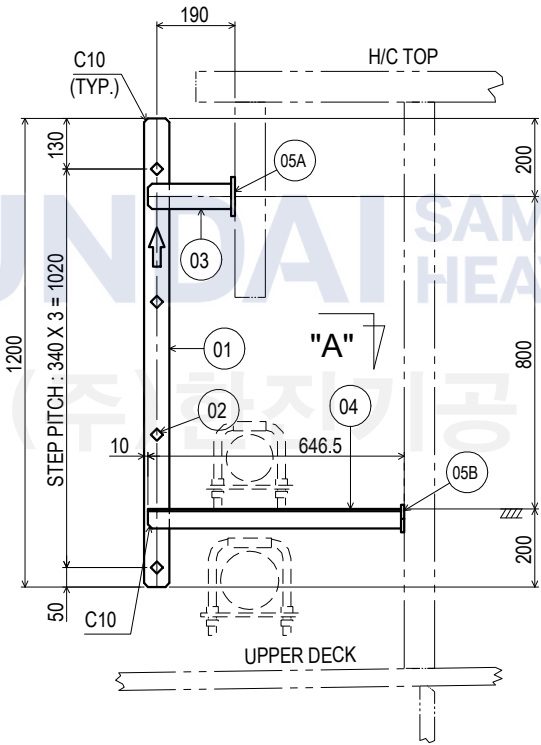
1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.

MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
VLD-S12	S12P/S	1 / 1	27.8
	S13P/S	1 / 1	

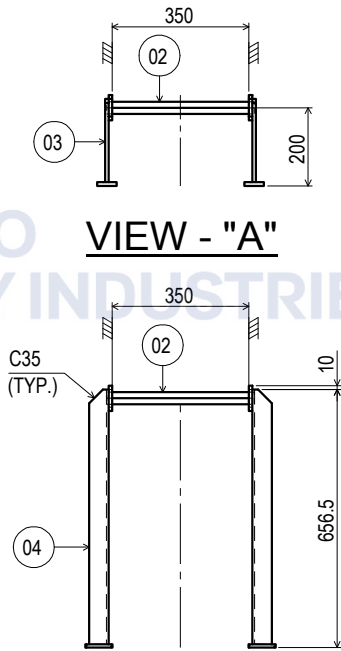
ELEVATION



SECTION

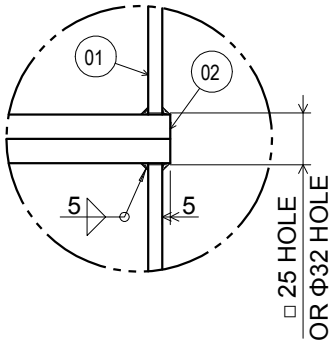


PLAN

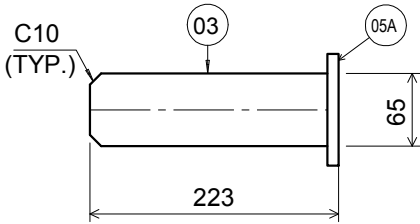


VIEW - "A"

DETAIL OF "D"



DET.OF UPPER LUG



DET.OF PAD

