

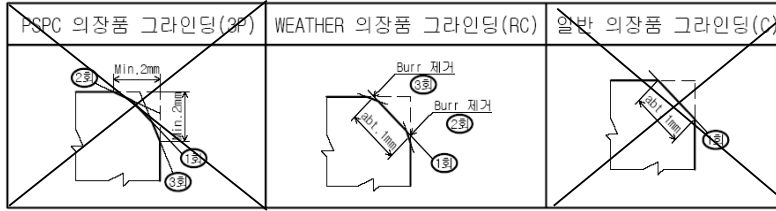
NOTE

PSPC 의장품

WEATHER 의장품

일반 의장품

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

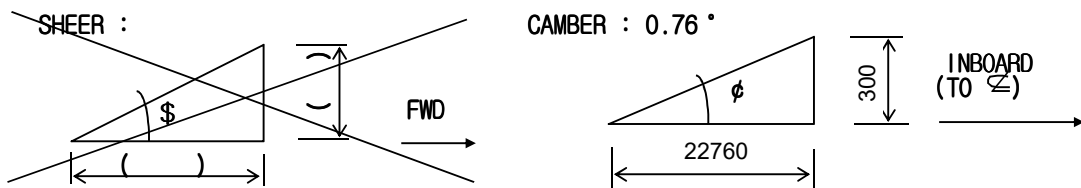


3. 용접은 특기와 하기 표 참조하고 연속 용접할 것.

* 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 : 300/22760)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, 판넬조립부, 가공부, 의장2부
13. P.O.R NO. : J63
14. TOTAL WEIGHT : 1694.2 Kg/SHIP

(표지 포함 10 매)

DEPT. B011000	SHIP NO. 8060/8061	SHIP TYPE 15,300 TEU CLASS CONTAINER CARRIER
TEL. 3326	부서명 구조설계부	도면명
승인 검토 작성	김성주 이완순 문지혁	VERTICAL LADDER 제작도
HYUNDAI SAMHO HEAVY INDUSTRIES CO., LTD. SAMHO SHIPYARD, KOREA		도면번호 1511-H13B-002
		날짜 2022년 05월 04일

	PLAN HISTORY		SHIP NO.	8060/8061	1
			DWG. NO.	1511-H13B	
DATE	REV. NO.	DESCRIPTION	DRAWN	CHECKED	APPROVED
2022.05.04	O	8060/8061 호선 VERTICAL LADDER 제작도임.	문지혁	이완순	김성주
2022.09.22	001	Vertical ladder Lug 위치 수정.(PAGE 06)-8061	문지혁	이완순	이완순
2022.10.04	002	VLD-S10P/S Vertical ladder 수정.(PAGE 08)	문지혁	이완순	이완순

PAINTING SPEC.						PAINT SUPPLIER	KCC	
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	ALL ITEM	STEEL	NS	T3				
	ITEM	IN SIDE & OUT SIDE			IN SIDE	OUT SIDE		
	ALL	FINAL	SHOP PRIMER	PRIMER				
		0						



製作仕様書(외주구매용)

SHIP NO.

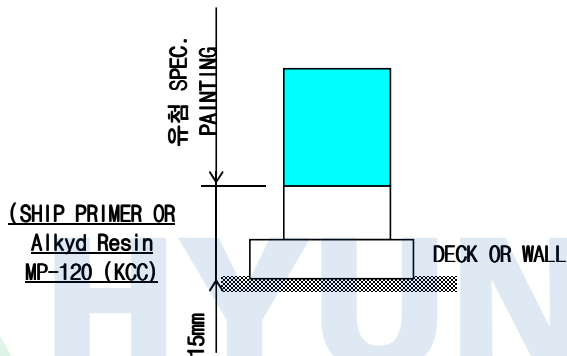
8060/8061

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.	8060/8061	3 3
제작품별 납기 LIST					DWG. NO.	1511-H13B	
P.O.R NO	SEQ NO.	BLOCK	STAGE	MARK NO.	DESCRIPTION	Q'TY /SHIP	WEIGHT (KG/SET)
J63	01	E55DL(P)	BF	VLD-S01P	VERTICAL LADDER	1	32.0
	02	E54DL(P)	BF	VLD-S02P	VERTICAL LADDER	1	31.7
	03	C16P0	GS	VLD-S03P	VERTICAL LADDER	1	26.5
	04	E51P0	CS	VLD-S04P	VERTICAL LADDER	1	26.0
	05	S11P0	CS	VLD-S04P	VERTICAL LADDER	1	26.0
	06	S12P0	CS	VLD-S04P	VERTICAL LADDER	1	26.0
	07	S13P0	CS	VLD-S04P	VERTICAL LADDER	2	26.0
	08	S14P0	CS	VLD-S04P	VERTICAL LADDER	1	26.0
	09	S15P0	CS	VLD-S04P	VERTICAL LADDER	1	26.0
	10	S16P0	CS	VLD-S04P	VERTICAL LADDER	1	26.0
	11	S19DL(P)	BF	VLD-S05P	VERTICAL LADDER	1	34.0
	12	S40DL(P)	BF	VLD-S06P	VERTICAL LADDER	1	34.1
	13	S61DL(P)	BF	VLD-S07P	VERTICAL LADDER	2	34.3
	14	C14AL(P)	BS	VLD-S08P	VERTICAL LADDER	1	34.4
	15	C13AL(P)	BS	VLD-S09P	VERTICAL LADDER	1	34.5
	16	E55DL(S)	BF	VLD-S01S	VERTICAL LADDER	1	32.0
	17	E54DL(S)	BF	VLD-S02S	VERTICAL LADDER	1	31.7
	18	C16S0	GS	VLD-S03S	VERTICAL LADDER	1	26.5
	19	E51S0	CS	VLD-S04S	VERTICAL LADDER	1	26.0
	20	S11S0	CS	VLD-S04S	VERTICAL LADDER	1	26.0
	21	S12S0	CS	VLD-S04S	VERTICAL LADDER	1	26.0
	22	S13S0	CS	VLD-S04S	VERTICAL LADDER	2	26.0
	23	S14S0	CS	VLD-S04S	VERTICAL LADDER	1	26.0
	24	S15S0	CS	VLD-S04S	VERTICAL LADDER	1	26.0
	25	S16S0	CS	VLD-S04S	VERTICAL LADDER	1	26.0
	26	S19DL(S)	BF	VLD-S05S	VERTICAL LADDER	1	34.0
	27	S40DL(S)	BF	VLD-S06S	VERTICAL LADDER	1	34.1
	28	S61DL(S)	BF	VLD-S07S	VERTICAL LADDER	2	34.3
	29	C14AL(S)	BS	VLD-S08S	VERTICAL LADDER	1	34.4
	30	C13AL(S)	BS	VLD-S09S	VERTICAL LADDER	1	34.5

					SHIP NO.	8060/8061	3 4
제작품별 납기 LIST					DWG. NO.	1511-H13B	
P.O.R NO	SEQ NO.	BLOCK	STAGE	MARK NO.	DESCRIPTION	Q'TY /SHIP	WEIGHT (KG/SET)
J63	31	D11P0	CS	VLD-T07AP	VERTICAL LADDER	1	45.0
	32	D11P0	MS	VLD-T07BP	VERTICAL LADDER	1	44.0
	33	D11S0	CS	VLD-T07AS	VERTICAL LADDER	1	45.0
	34	D11S0	MS	VLD-T07BS	VERTICAL LADDER	1	44.0
	35	D15P0	FS	VLD-S10P	VERTICAL LADDER	1	211.0
	36	D15P0	FS	HC-S01P	HINGED COVER	1	22.9
	37	D15S0	FS	VLD-S10S	VERTICAL LADDER	1	211.0
	38	D15S0	FS	HC-S01S	HINGED COVER	1	22.9
	39	F71P0	FS	VLD-T11P	VERTICAL LADDER	1	20.4
	40	F71S0	FS	VLD-T11S	VERTICAL LADDER	1	20.4
	41				합 계 (Q'TY, KG/SHIP)	42	1694.2
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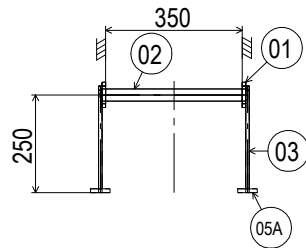


DETAIL OF VERTICAL LADDER

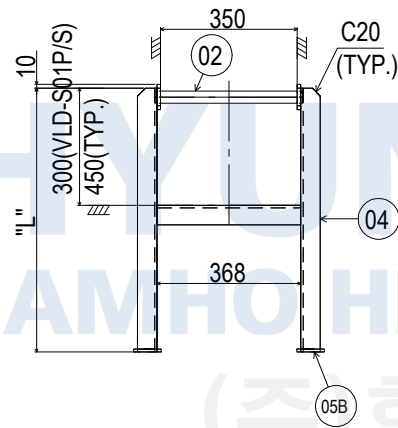
SHIP NO.	8060/8061	05
DWG NO.	1511-H13B	

MARK NO.	BLOCK NO.	"L"	Q'TY	WEIGHT Kg/SET
VLD-S01P	E55P0	675.5	1	32.0
VLD-S02P	E54P0	657.5	1	31.7
VLD-S05P	S19P0	923.5	1	34.0
VLD-S06P	S40P0	937.5	1	34.1
VLD-S07P	S61P0	957.5	2	34.3
VLD-S08P	C14P0	969.5	1	34.4
VLD-S09P	C13P0	982.5	1	34.5
VLD-S01S	E55S0	675.5	1	32.0
VLD-S02S	E54S0	657.5	1	31.7
VLD-S05S	S19S0	923.5	1	34.0
VLD-S06S	S40S0	937.5	1	34.1
VLD-S07S	S61S0	957.5	2	34.3
VLD-S08S	C14S0	969.5	1	34.4
VLD-S09S	C13S0	982.5	1	34.5

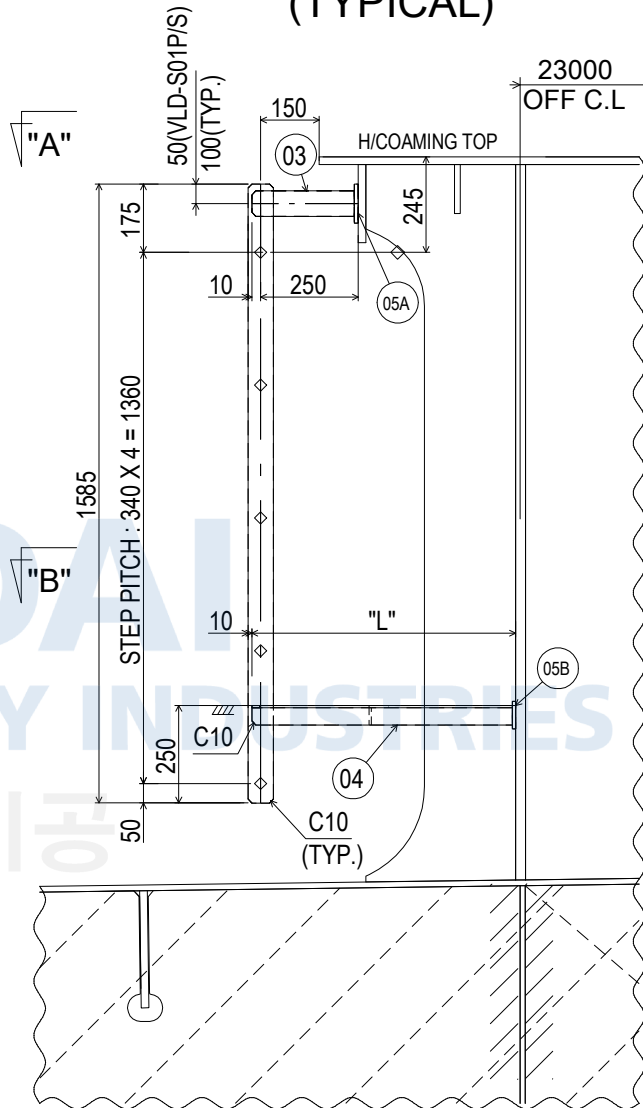
VIEW - "A"



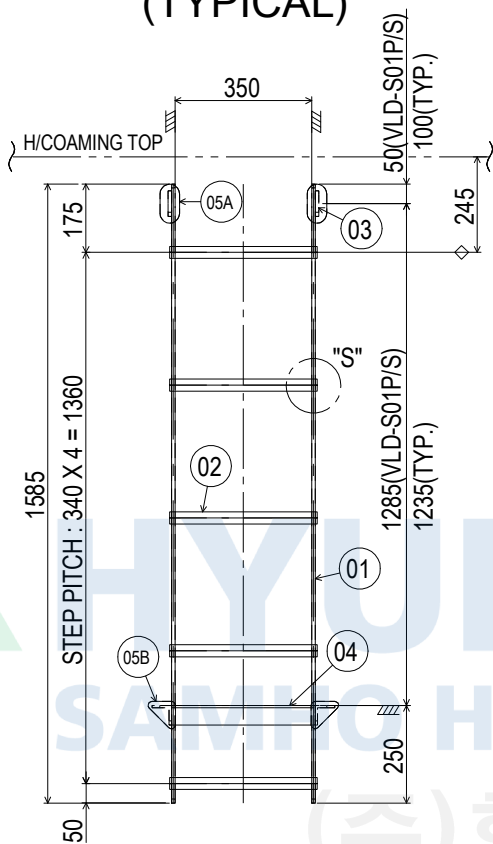
VIEW - "B"



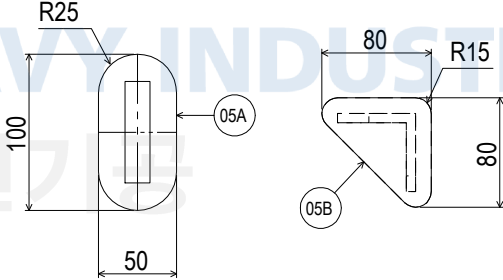
SECTION
(TYPICAL)



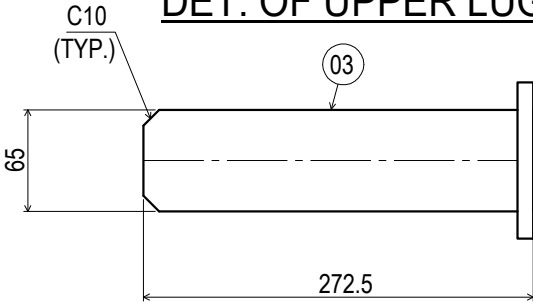
ELEVATION
(TYPICAL)



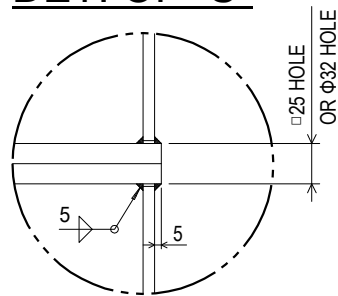
DET. OF PAD



DET. OF UPPER LUG



DET. OF "S"



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

NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(Kg)	REMARK
01	SIDE FRAME	65 x 9t F.B	SS400 OR SS275	2	-	PAINT
02	STEP	□ 22 SQ.BAR	SS400 OR SS275	5	-	PAINT
03	LUG	65 x 9t F.B	SS400 OR SS275	2	-	PAINT
04	SUPPORT	50 x 50 x 6t E.A	SS400 OR SS275	3	-	PAINT
05A 05B	PAD	10t PLATE	AH32	4	-	



DETAIL OF VERTICAL LADDER

SHIP NO.	8060/8061	06
DWG NO.	1511-H13B	

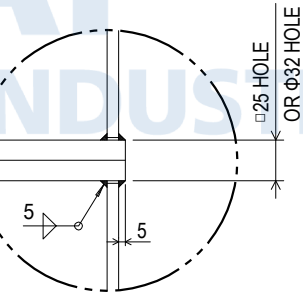
MARK NO.	BLOCK NO.	"L"	Q'TY	WEIGHT Kg/SET
VLD-S03P	C16P0	225	1	26.5
VLD-S03S	C16S0	225	1	26.5
VLD-S04P	E51P0	215	1	26.0
	S11P0	215	1	26.0
	S12P0	215	1	26.0
	S13P0	215	2	26.0
	S14P0	215	1	26.0
	S15P0	215	1	26.0
VLD-S04S	S16P0	215	1	26.0
	E51S0	215	1	26.0
	S11S0	215	1	26.0
	S12S0	215	1	26.0
	S13S0	215	2	26.0
	S14S0	215	1	26.0
	S15S0	215	1	26.0
	S16S0	215	1	26.0

SECTION
(TYPICAL)

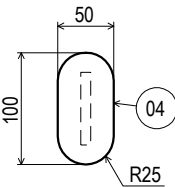
ELEVATION
(TYPICAL)

VIEW - "A"

DET. OF "S"



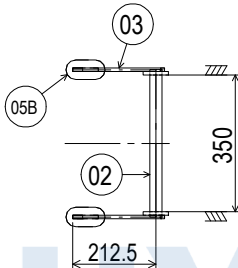
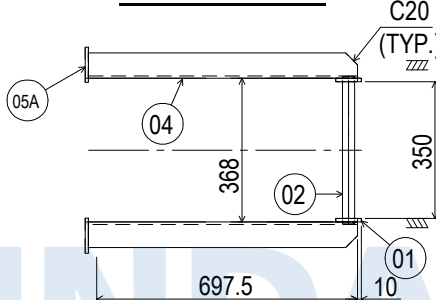
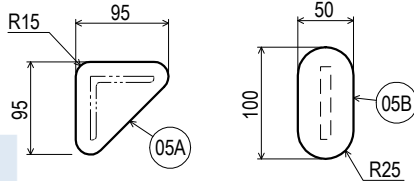
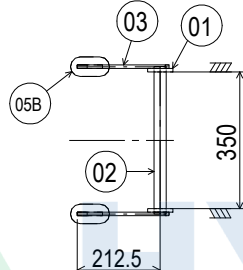
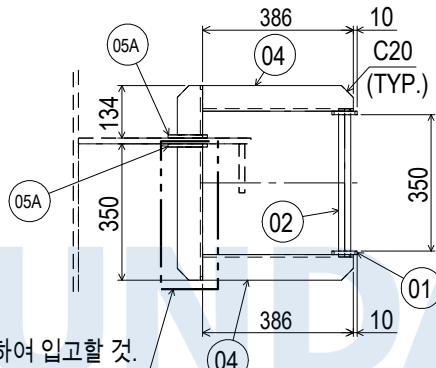
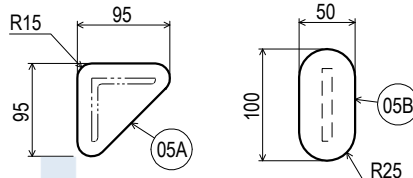
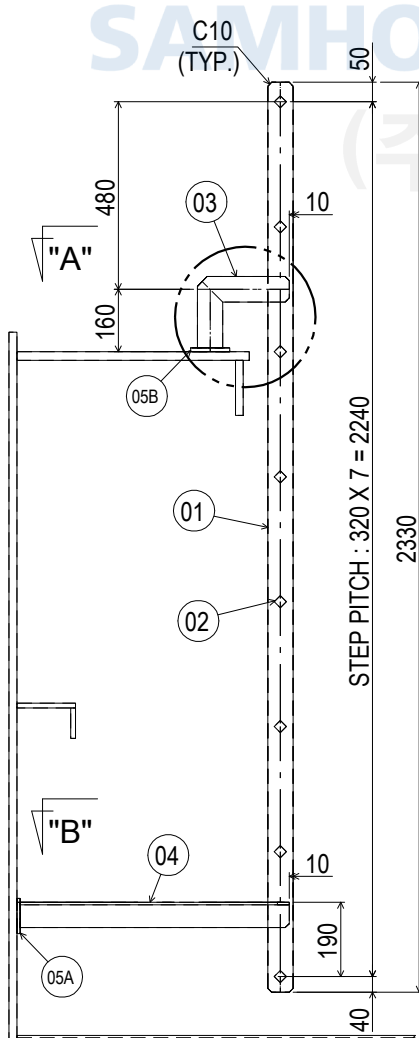
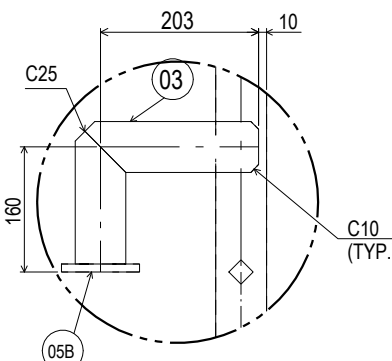
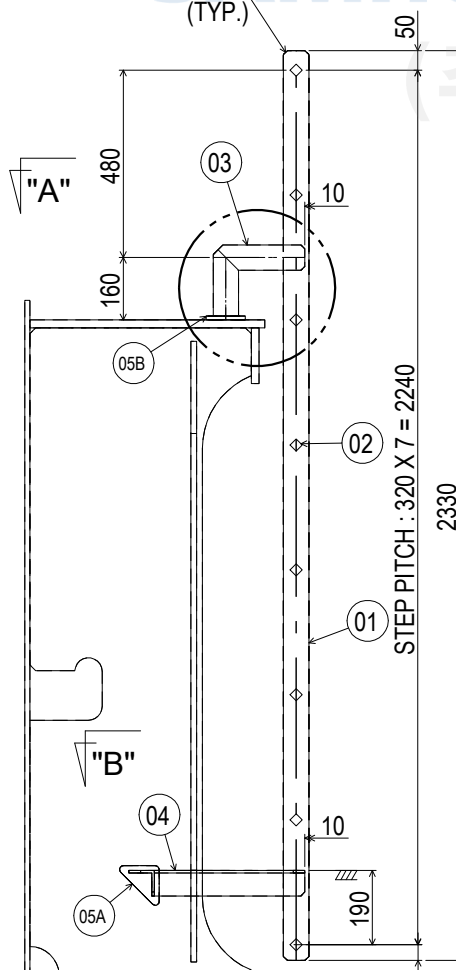
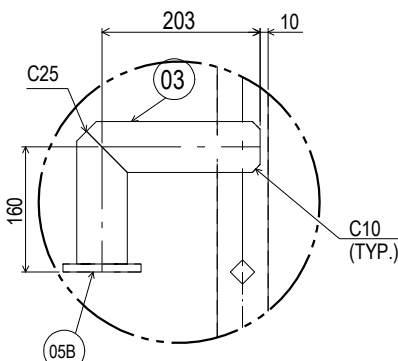
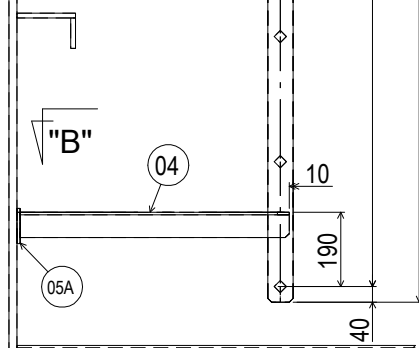
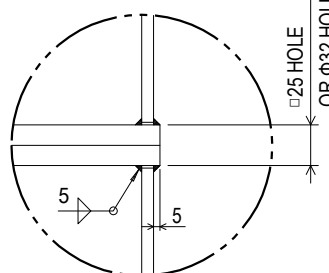
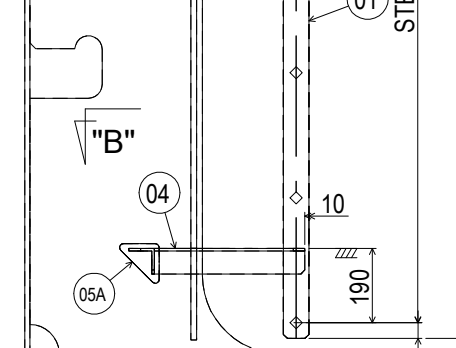
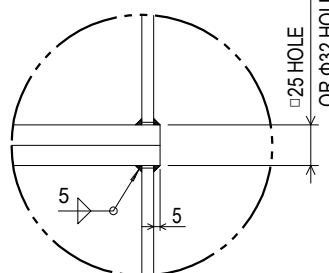
DET. OF PAD



NOTE

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

NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(Kg)	REMARK
01	SIDE FRAME	65 x 9t F.B	SS400 OR SS275	2	-	PAINT
02	STEP	□ 22 SQ.BAR	SS400 OR SS275	5	-	PAINT
03	LUG	65 x 9t F.B	SS400 OR SS275	2	-	PAINT
04	PAD	10t PLATE	AH32	4	-	PAINT

<div><div></div><div>DETAIL OF VERTICAL LADDER (MARK NO. VLD-T07AP/S, T07BP/S)</div></div>												SHIP NO.		8060/8061		07																							
												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	-	PAINT	01	SIDE FRAME	65 x 9t F.B	SS400 OR SS275	2	-	PAINT																										
02	STEP	□ 22 SQ.BAR	SS400 OR SS275	8	-	PAINT	02	STEP	□ 22 SQ.BAR	SS400 OR SS275	8	-	PAINT																										
03	LUG	65 x 9t F.B	SS400 OR SS275	2	-	PAINT	03	LUG	65 x 9t F.B	SS400 OR SS275	2	-	PAINT																										
04	SUPPORT	65 x 65 x 6t E.A	SS400 OR SS275	2	-	PAINT	04	SUPPORT	65 x 65 x 6t E.A	SS400 OR SS275	2	-	PAINT																										
05A 05B	PAD	10t PLATE	SS400 OR SS275	4	-		05A 05B	PAD	10t PLATE	SS400 OR SS275	4	-																											
<div>NOTE</div> <div>1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.</div>						<table><tr><td>MARK NO.</td><td>BLOCK NO.</td><td>Q'TY</td><td>WEIGHT Kg/SET</td></tr><tr><td>VLD-T07AP</td><td>D11P0</td><td>1</td><td>45.0</td></tr><tr><td>VLD-T07AS</td><td>D11S0</td><td>1</td><td>45.0</td></tr></table>		MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET	VLD-T07AP	D11P0	1	45.0	VLD-T07AS	D11S0	1	45.0	<div>NOTE</div> <div>1. 본도는 PORT SIDE를 나타냄. STB'D SIDE는 대칭 제작할 것.</div>						<table><tr><td>MARK NO.</td><td>BLOCK NO.</td><td>Q'TY</td><td>WEIGHT Kg/SET</td></tr><tr><td>VLD-T07BP</td><td>D11P0</td><td>1</td><td>44.0</td></tr><tr><td>VLD-T07BS</td><td>D11S0</td><td>1</td><td>44.0</td></tr></table>		MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET	VLD-T07BP	D11P0	1	44.0	VLD-T07BS	D11S0	1	44.0
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DETAIL OF VERTICAL LADDER (MARK NO. VLD-S10P, S10S)

SHIP NO.	8060/8061	08
DWG NO.	1511-H13B	

MARK NO.	BLOCK NO.	Q'TY	WEIGHT Kg/SET
VLD-S10P	D15P0	1	211.0
VLD-S10S	D15S0	1	211.0

ELEVATION

SECTION

VIEW - "A"

DET. OF BACK BAND

VIEW - "B"

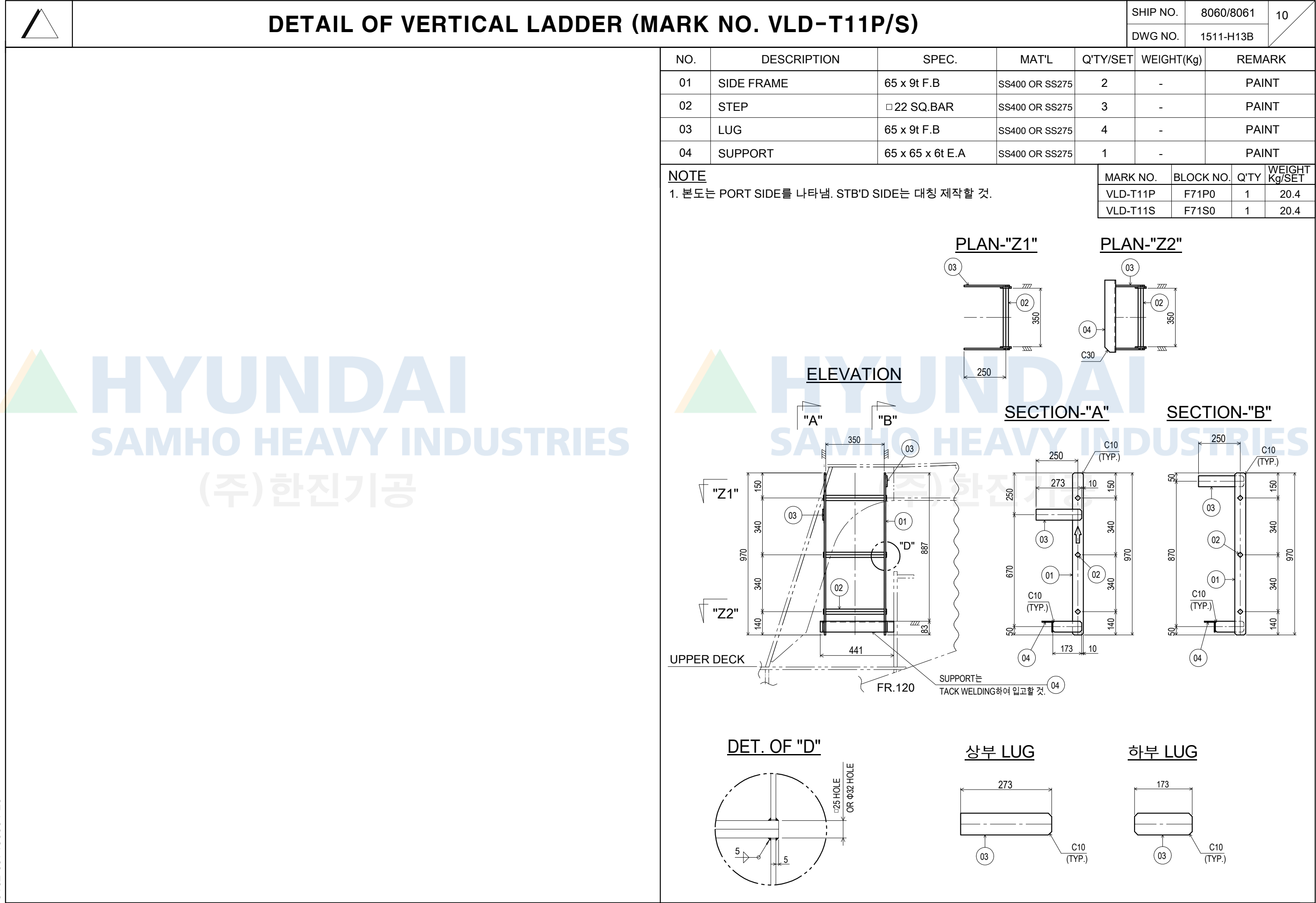
DET. OF PAD

DET. OF "S"

NOTE

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

NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	WEIGHT(Kg)	REMARK
01	SIDE FRAME	65 x 9t F.B	SS400 OR SS275	2	-	PAINT
02	STEP	□ 22 SQ.BAR	SS400 OR SS275	17	-	PAINT
03	SUPPORT	75 x 75 x 6t E.A	SS400 OR SS275	13	-	PAINT
04	SUPPORT	100 x 100 x 10t E.A	SS400 OR SS275	4	-	PAINT
05	BACK BAND	Φ19 R.BAR	SS400 OR SS275	5	-	PAINT
06	SAFETY CAGE	50 x 6t F.B	SS400 OR SS275	3	-	
07A 07B	PAD	10t PLATE	SS400 OR SS275	6	-	



PAD

						B/M LIST													
8060	호선	PAD LOT				BLOCK : 구조문지혁				선급 : NV					W/C Date : 20220513				
SUB LOT	W/C Date	MARKNO	SUB ACT	TYPE	상 고	품명	재질	두께1	두께2	폭1	폭2	길이1	길이2	수정전 수량	수정후 수량	수정전중량	수정후중량	도면	발행일
						잔재B/M													
FL	20220513	A68071B5410501		11	1	잔재	AAH36	10.5	0	1450	0	1290	0	0	1	0	154	NCA01	20220510
FL	20220513	A68073B1710501		11	6	잔재	AAH36	10.5	0	1700	740	620	530	0	1	0	80	NCA02	20220510
FL	20220513	A68073T2510502		11	6	잔재	AAH36	10.5	0	1070	750	1210	530	0	1	0	89	NCA03	20220510
		잔재 수량 :			0		잔재 중량 :		3										

8060/8061 V/LADDER PAD용
사급강재 BM LIST 임.