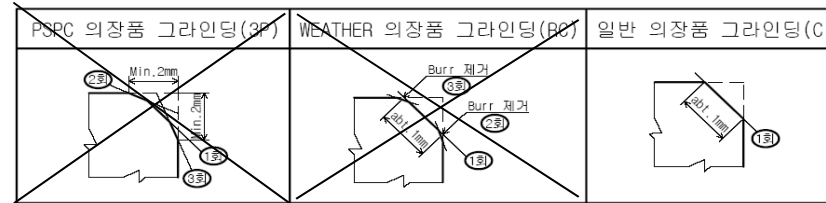


PLAN HISTORY					
DATE	REV. NO.	DESCRIPTION	DRAWN	CHECKED	APPROVED
2023. 02. 17	0	8140, 8198 / 8199, MFG. OF V/LADDER (FWD P/ROOM) 제작도면으로 작성함.	박 대 근	김 광 백	정 호 진

NOTE

- 본도는 MFG. OF V/LADDER (FWD P/ROOM) 제작 도면임.
- 모서리 부분은 하기와 같이 GRINDING 할 것.



- 용접은 특기와 하기 표 참조하고 연속 용접 할 것.

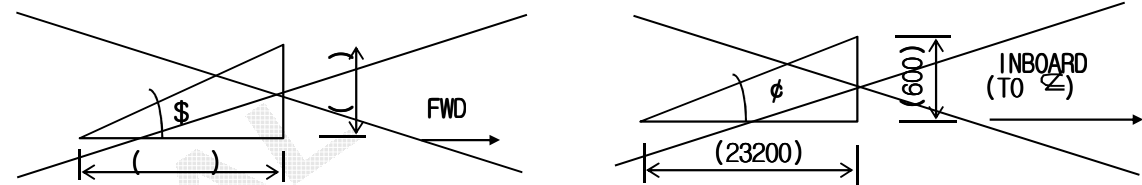
* THE LEG LENGTH OF FILLET WELD TO BE AS FOLLOWS.

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

- 제작 시 DECK 상의 SHEER (\$: /)와 CAMBER (φ : 600 / 23200)를 필히 적용할 것.

SHEER :

CAMBER : 0.99 °



- 한 도면에서 서로 상이부분이 있거나 제작상 문제점 발생시 필히 당부와 협의/확정 후 제작 완료할 것.
- 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.
- BOLT 길이는 NUT 체결후 ABT. 2-3 산이 남도록 할 것.
- 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-1575-A-PT 1/8" BALL TYPE 러버캡을 씌울것 (MAT'L : BRASS)


10. P.O.R NO. : JFK

11. TOTAL WEIGHT : 526.6 KG/SHIP (표지 포함 11 매)

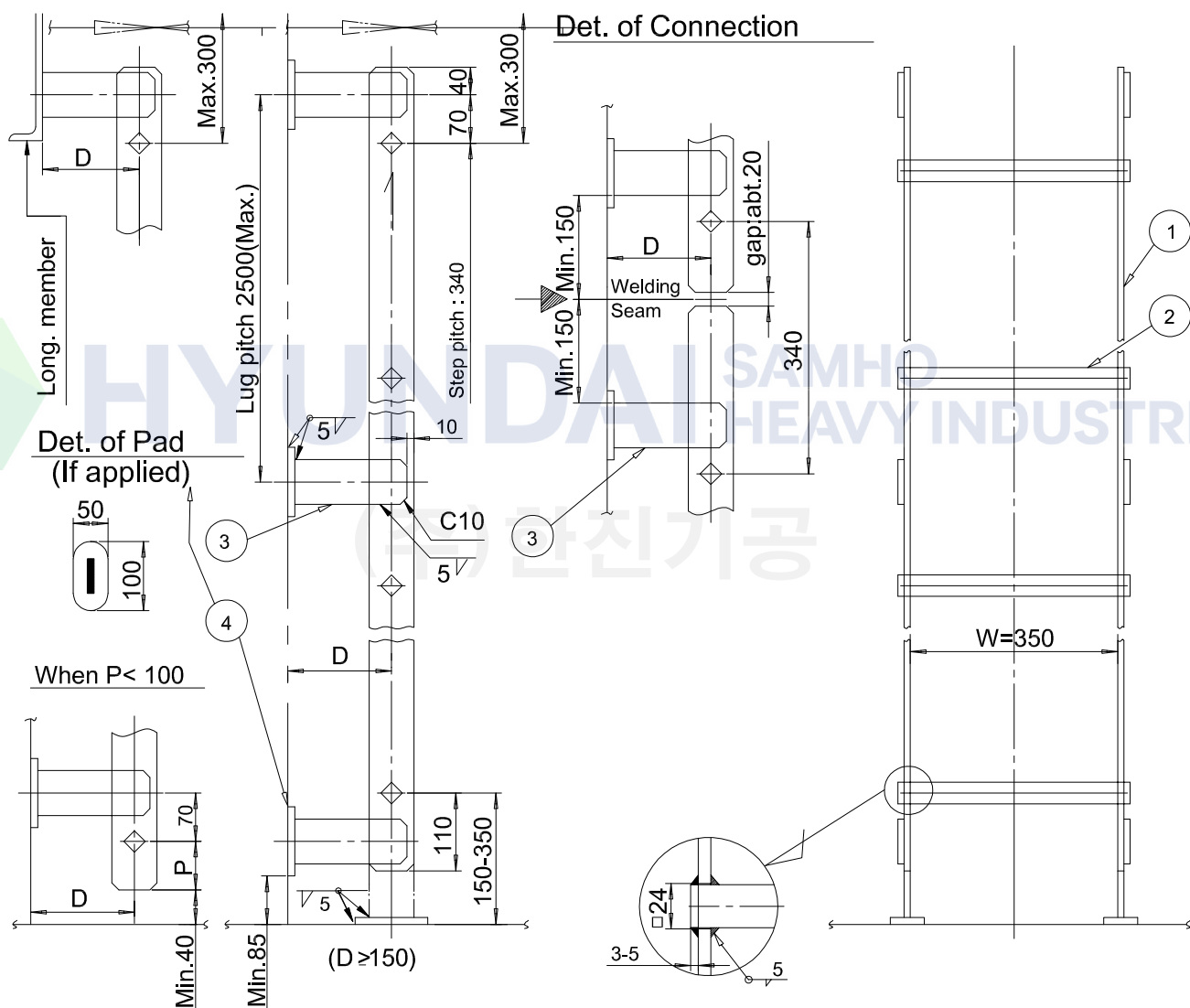
PAINTING SPEC. 특기사항						PAINT SUPPLIER	
PAINT'G SYMBOL	PAINT ITEM OR AREA	MAT'L	SHOP PRIMER	표면 처리	BRAND NAME OF PAINT AND ITS COLOR SHADE	D.F.T (μ)	REMARK
※ 납기 LIST에 표기된 PAINTING CODE에 따라 도장 적용 할 것.							
ITEM		IN SIDE & OUT SIDE			IN SIDE	OUT SIDE	
ALL		FINAL	SHOP PRIMER	PRIMER			

DEPT. B126	SHIP NO. 8140, 8198 / 8199	SHIP TYPE 174,000 CBM CLASS LNG C
TEL. 2898	부서명 선 장 설 계 부	도 면 명
승 인 정 호 진 검 도 김 광 백 작 성 박 대 근		MFG. OF V/LADDER (FWD P/ROOM)
HYUNDAI SAMHO HEAVY INDUSTRIES		도 면 번 호 F12F0B1052CB - 0
		날 짜 2023. 02. 17

[illegible]

Ship No: 8140, 8198 / 8199				HDS NO: 3450-5/9				E3		
<div> HYUNDAI</div>	Vertical Ladder (VL-A) (Fixed type)				DATE	95	98	98	00	10
						6/13	10/12	12/8	1/11	3/4
NO	Description	Spec	Mat'l	Weight	Remark					
1	Side frame	65 X 9t F.B	SS400 or SS275	4.59/m						
2	Step	22 Sq.B	SS400 or SS275	3.80/m						
3	Lug	65 X 9t F.B	SS400 or SS275	0.76/ea						
4	Pad	9t Plate	SS400 or SS275	0.35/ea	If applied					
" "										

" "



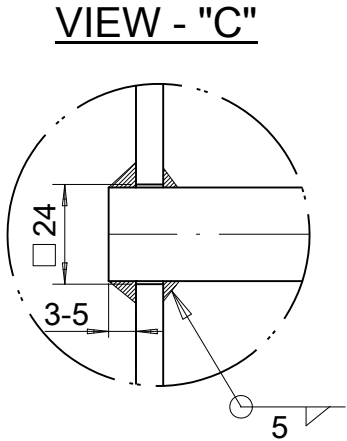
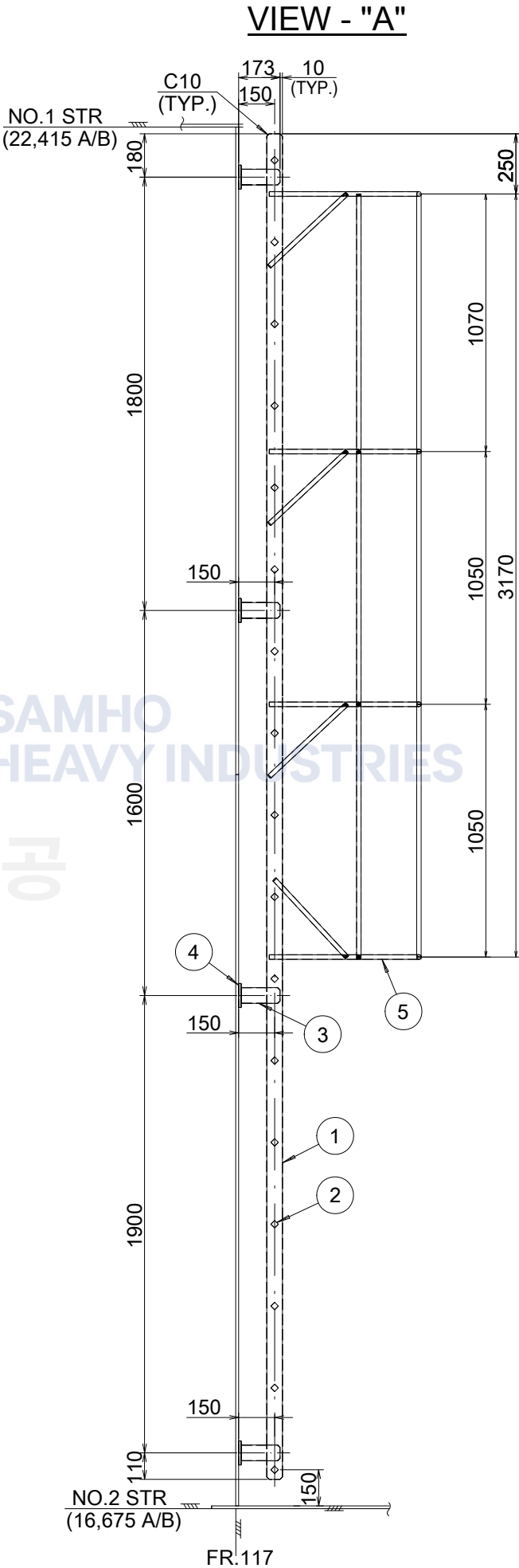
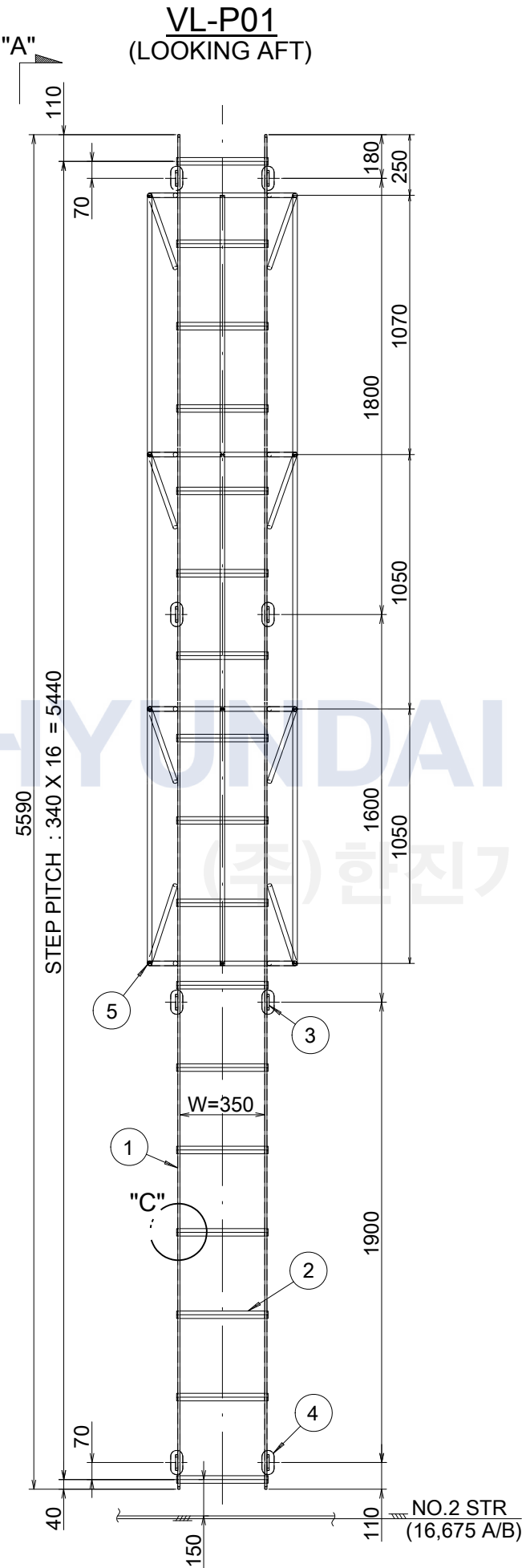
Note

1. Application : All space except vent mast
2. Surface treatment shall be done in accordance with painting specification.
3. Connection : Shall be applied between ladders when ladders are installed in way of block welding seam or fabrication welding seam of mast/post body.

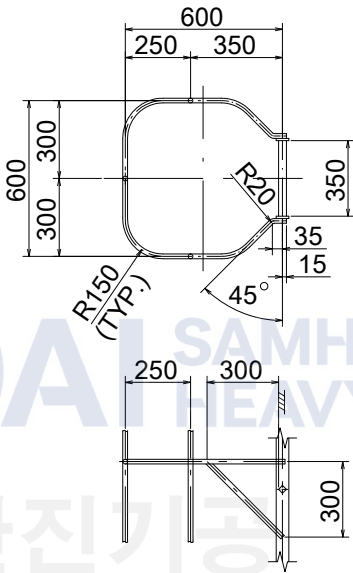
DETAIL OF VERTICAL LADDER

SHIP NO.	8140, 8198 / 8199
DWG NO.	

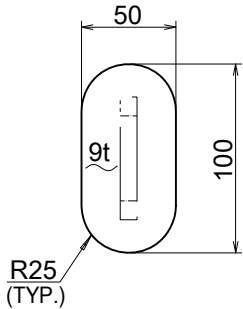
BLOCK NO.	MARK NO.	Q'TY/ SHIP	WEIGHT (KG/SHIP)	REMARK
F42P	VL-P01	1	130.0	본도제작



DETAIL OF SAFETY CAGE
(FOR SAFETY CAGE)



DETAIL OF PAD ④



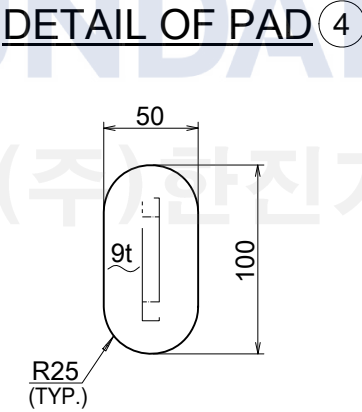
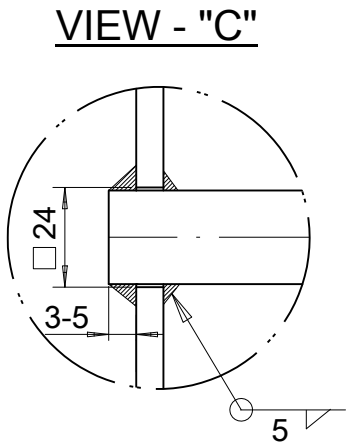
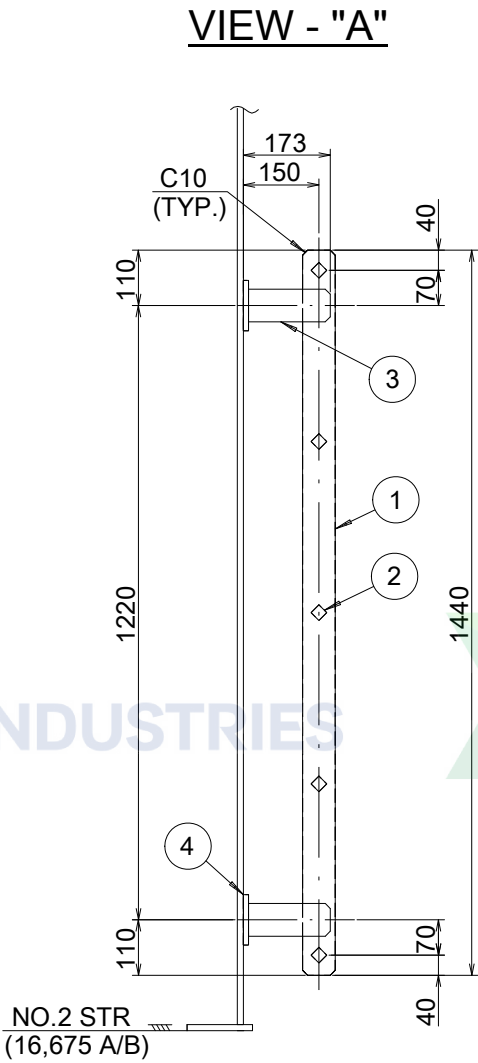
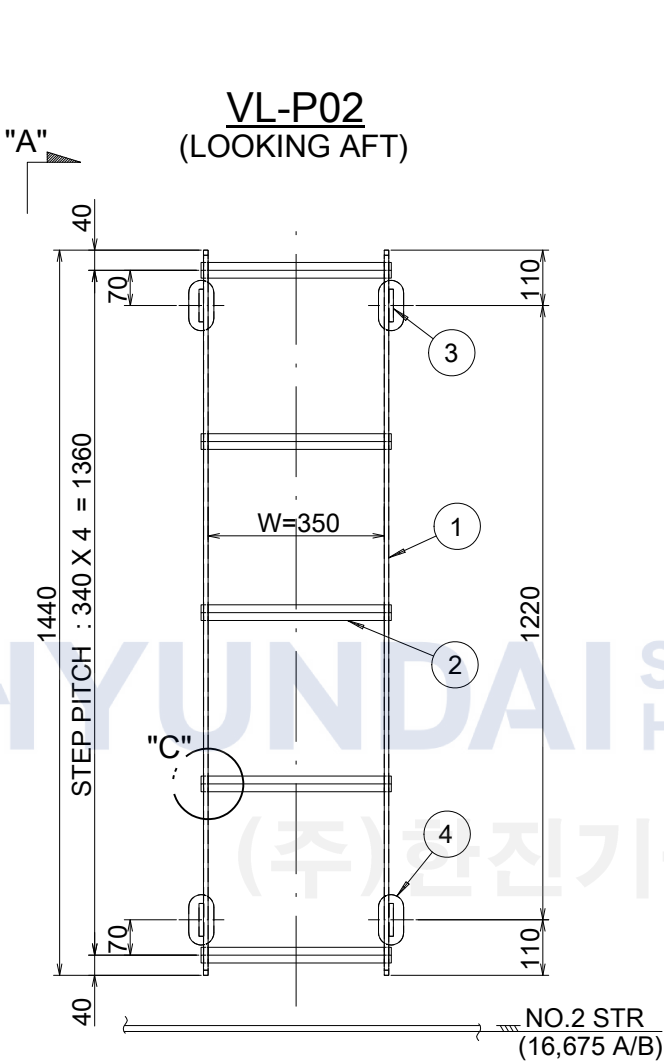
-TOTAL WEIGHT : 130.0 KG/SET

5	SAFETY CAGE	Ø19 R.B	SS400	1	45.5	PAINTED
4	PAD	9t PLATE	SS400	8	2.8	PAINTED
3	LUG	65x9t F.B	SS400	8	6.0	PAINTED
2	STEP	22 SQ.BAR	SS400	17	24.4	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	51.3	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK

DETAIL OF VERTICAL LADDER

SHIP NO.	8140, 8198 / 8199
DWG NO.	

BLOCK NO.	MARK NO.	Q'TY/ SHIP	WEIGHT (KG/SHIP)	REMARK
F42P	VL-P02	1	24.8	본도제작



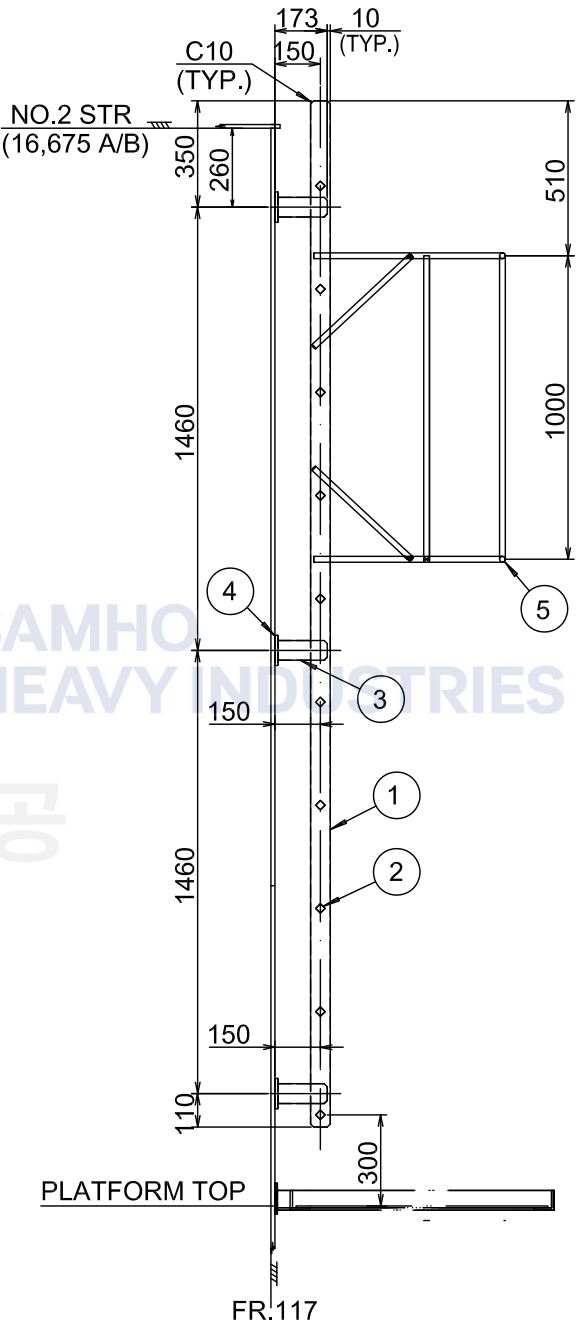
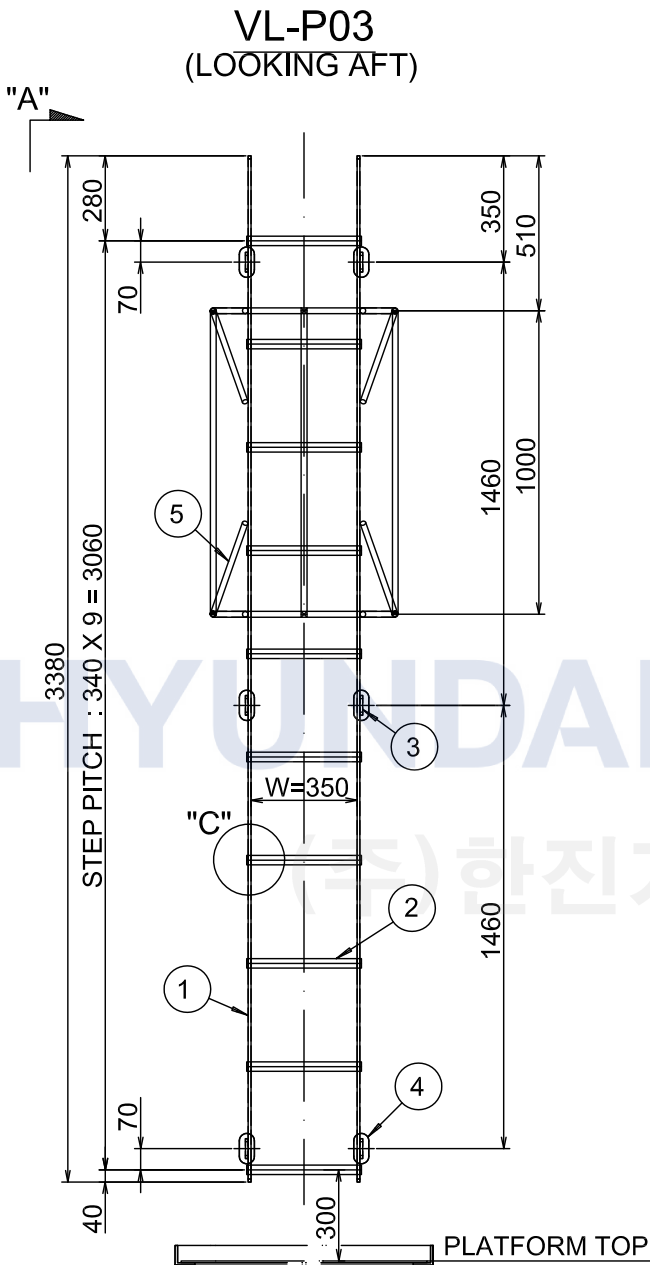
-TOTAL WEIGHT : 24.8 KG/SET

4	PAD	9t PLATE	SS400	4	1.4	PAINTED
3	LUG	65x9t F.B	SS400	4	3.0	PAINTED
2	STEP	22 SQ.BAR	SS400	5	7.2	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	13.2	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK

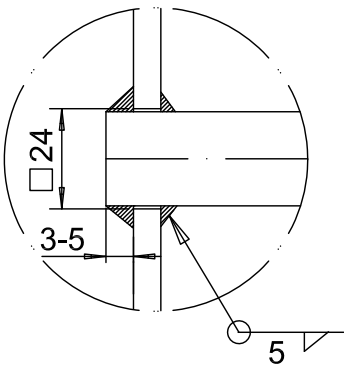
DETAIL OF VERTICAL LADDER

SHIP NO.				
DWG NO.				
BLOCK NO.	MARK NO.	Q'TY/ SHIP	WEIGHT (KG/SHIP)	REMARK
F33C	VL-P03	1	70.7	본도제작

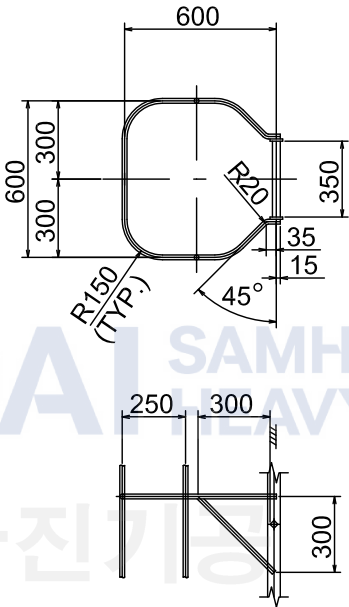
VIEW - "A"



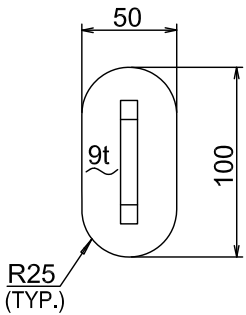
VIEW - "C"



DETAIL OF BACK BAND
(FOR SAFETY CAGE)

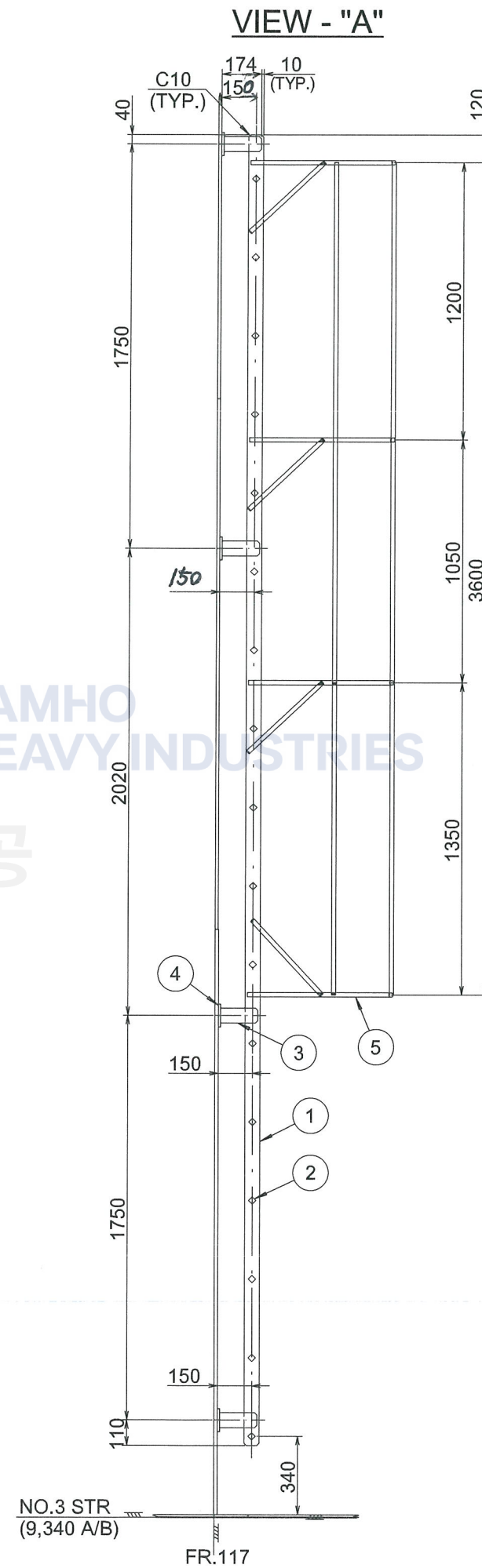
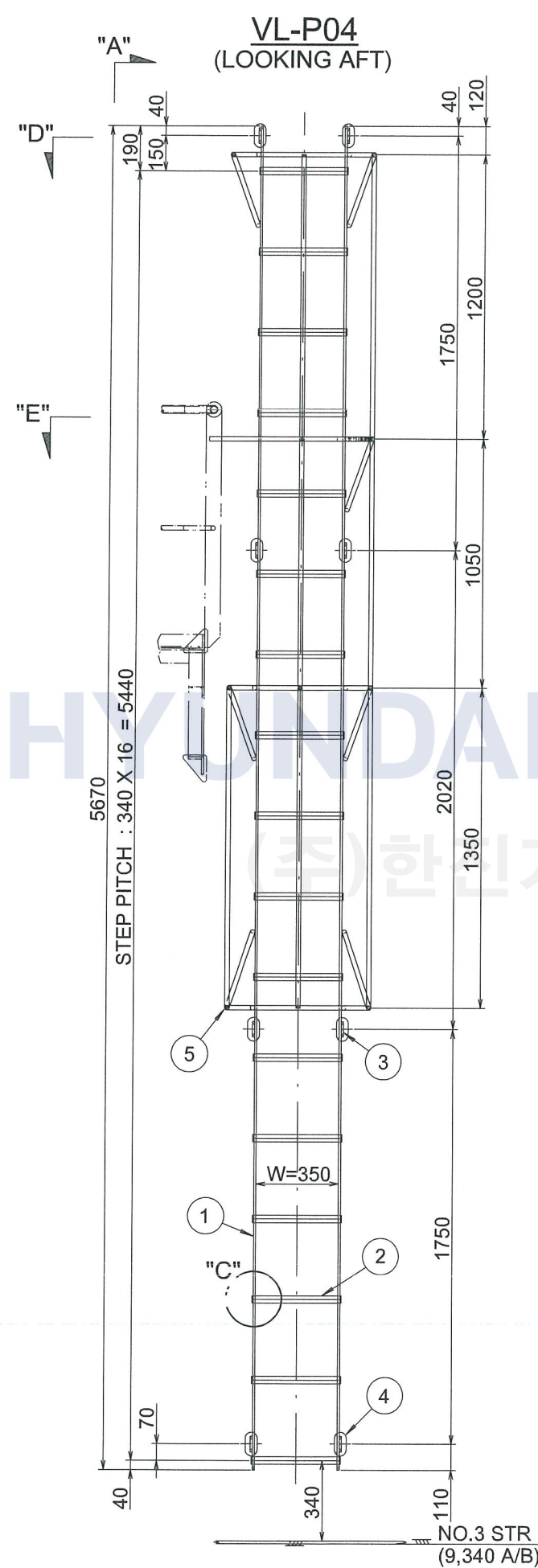


DETAIL OF PAD ④



-TOTAL WEIGHT : 70.7 KG/SET

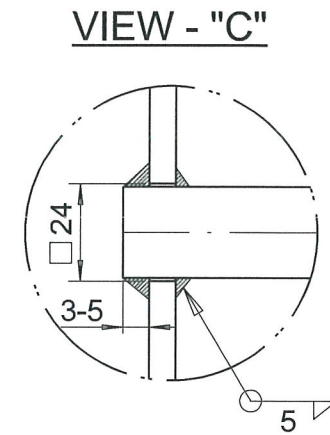
5	SAFE CAGE	Ø19 R.B	SS400	2	18.7	PAINTED
4	PAD	9t PLATE	SS400	6	2.1	PAINTED
3	LUG	65x9t F.B	SS400	6	4.5	PAINTED
2	STEP	22 SQ.BAR	SS400	10	14.4	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	31.0	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK



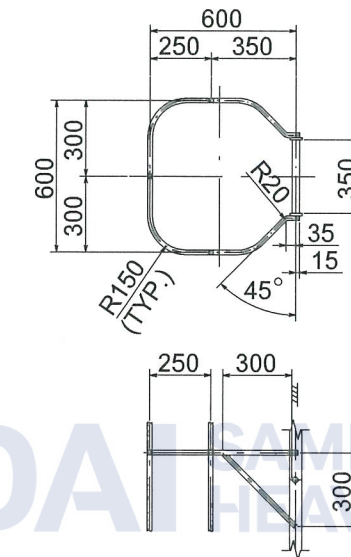
DETAIL OF VERTICAL LADDER

DRAWING ADDER		SHIP NO.			
		DWG NO.			
BLOCK NO.	MARK NO.	Q'TY/ SHIP	WEIGHT (KG/SHIP)	REMARK	
F33C	VL-P04	1	128.3	본도제작	

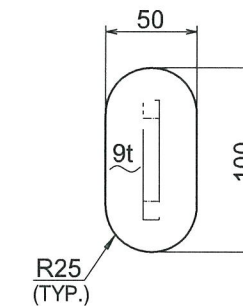
DETAIL OF BACK BAND (FOR SAFETY CAGE)



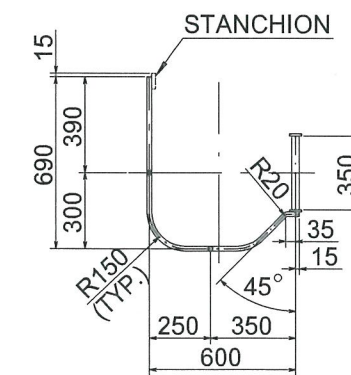
VIEW - "D"



DETAIL OF PAD 4



VIEW - "E"

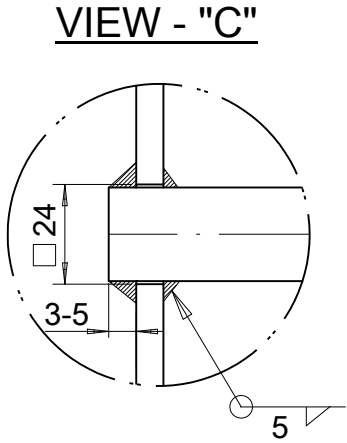
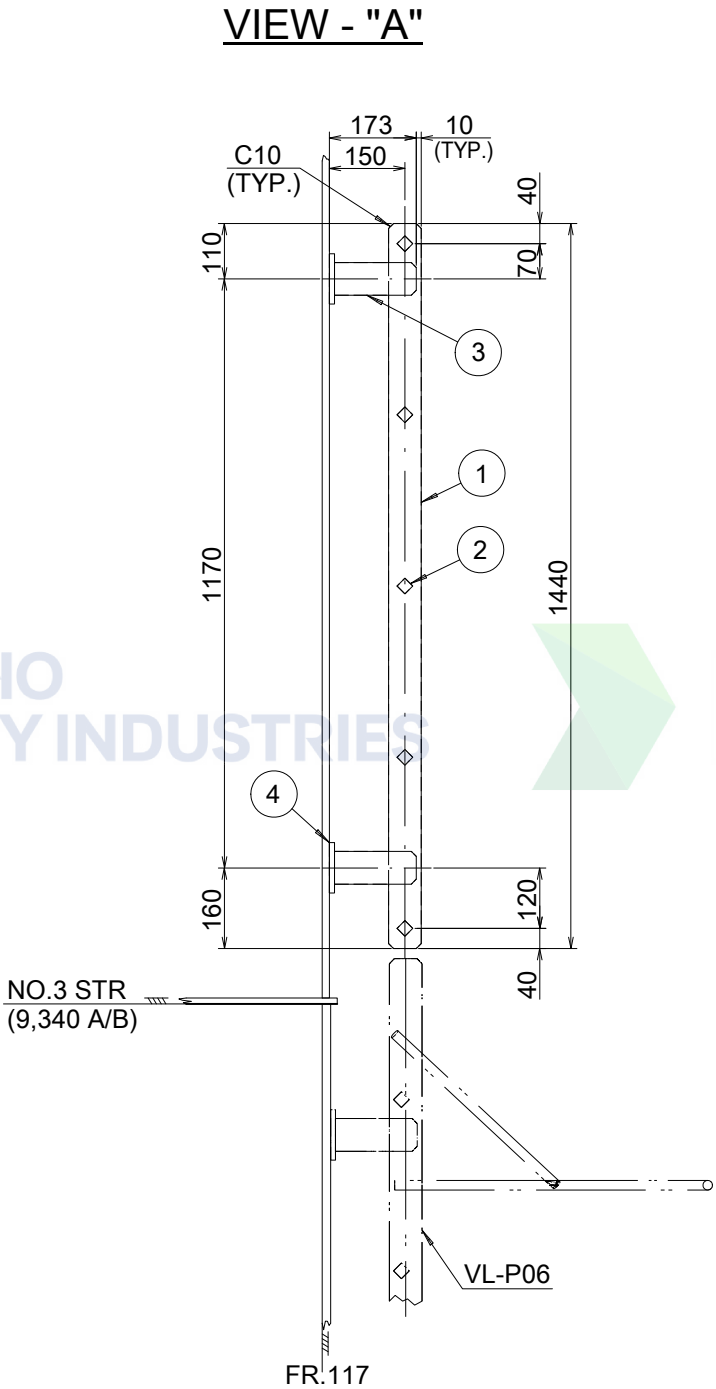
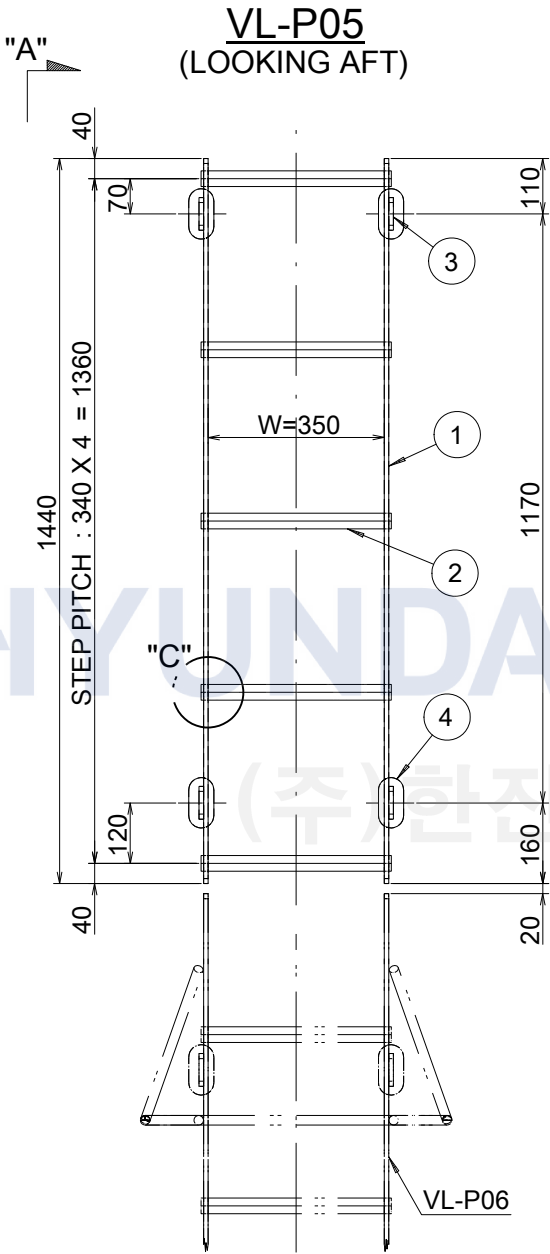


-TOTAL WEIGHT : 128.3 KG/SET

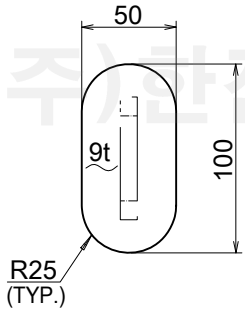
5	SAFETY CAGE	Ø19 R.B	SS400	1	43.0	PAINTED
4	PAD	9t PLATE	SS400	8	2.8	PAINTED
3	LUG	65x9t F.B	SS400	8	6.0	PAINTED
2	STEP	22 SQ.BAR	SS400	17	24.4	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	52.1	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK

DETAIL OF VERTICAL LADDER

SHIP NO.			
DWG NO.			
MARK NO.	Q'TY/ SHIP	WEIGHT (KG/SHIP)	REMARK
VL-P05	1	24.8	본도제작



DETAIL OF PAD ④

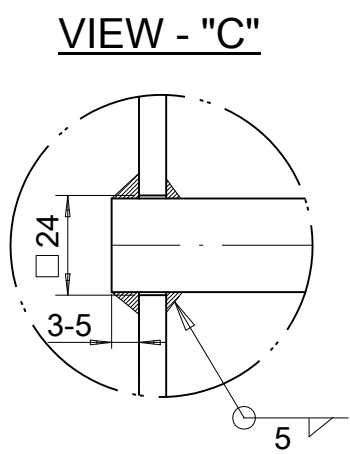
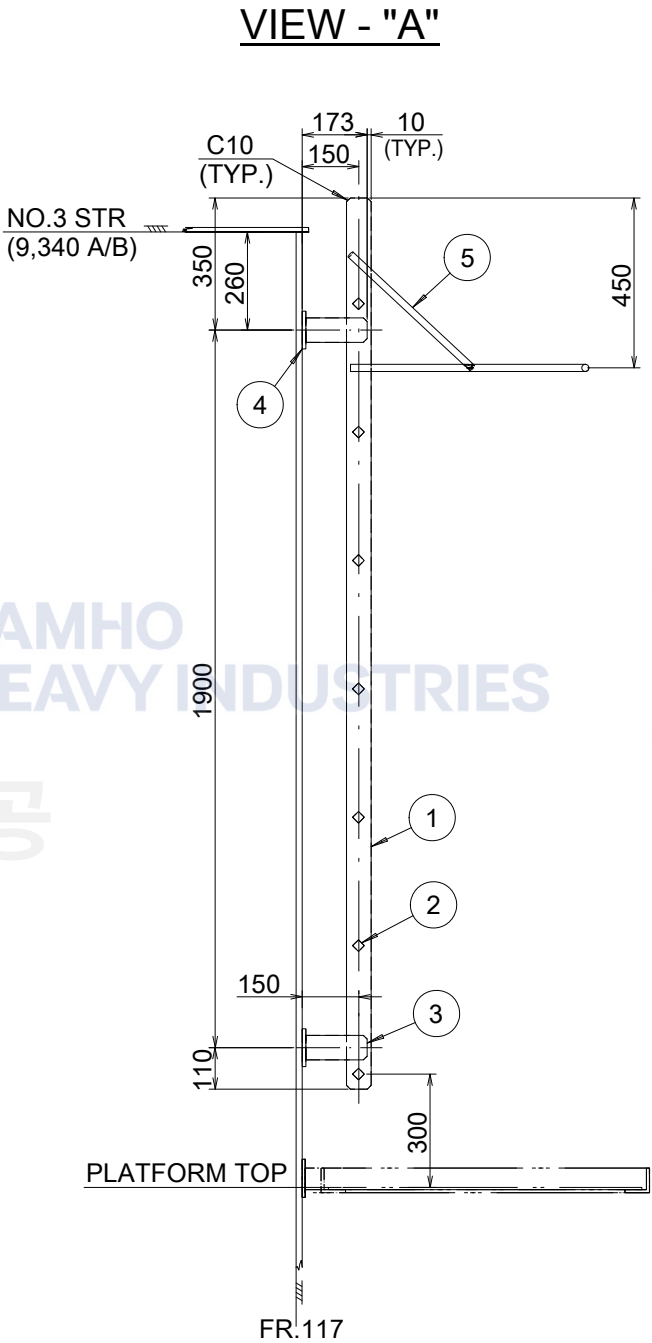
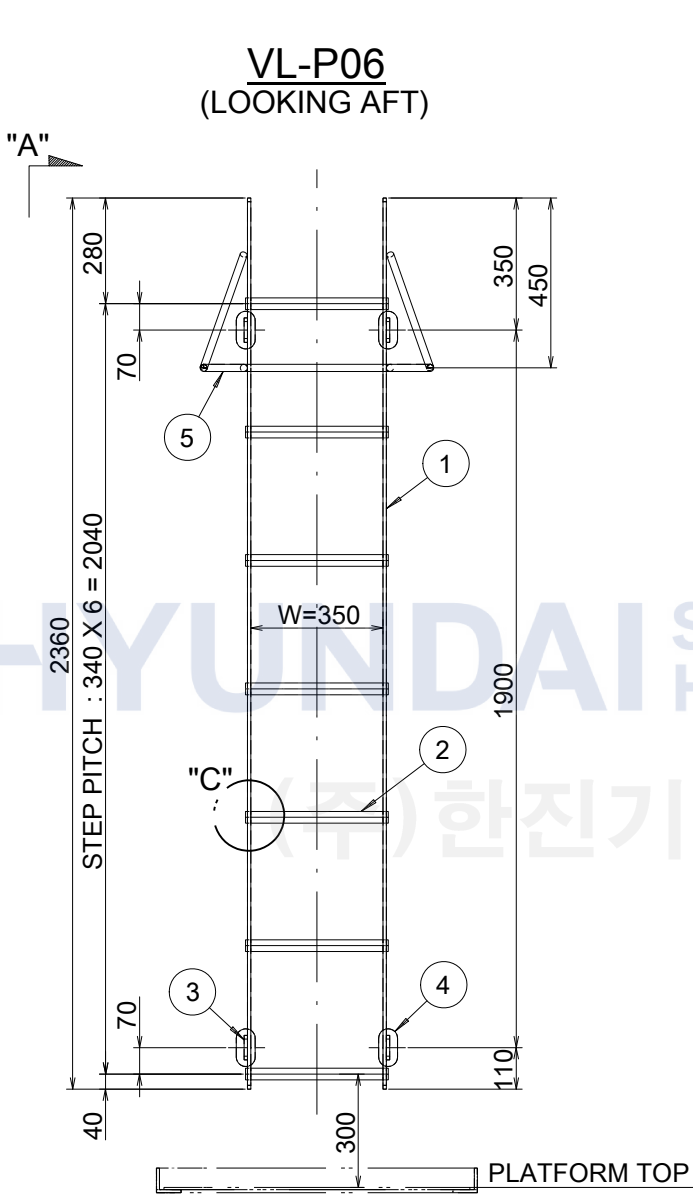


-TOTAL WEIGHT : 24.8 KG/SET

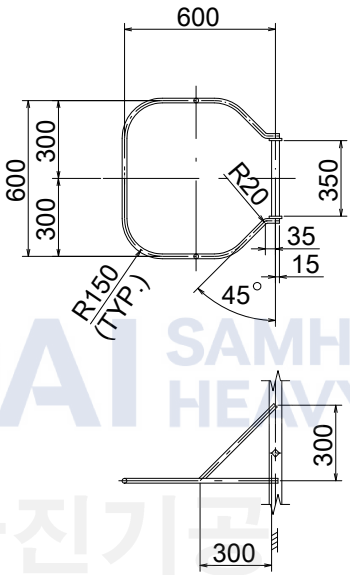
4	PAD	9t PLATE	SS400	4	1.4	PAINTED
3	LUG	65x9t F.B	SS400	4	3.0	PAINTED
2	STEP	22 SQ.BAR	SS400	5	7.2	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	13.2	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK

DETAIL OF VERTICAL LADDER

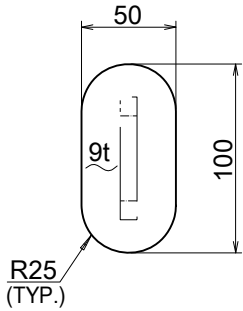
SHIP NO.			
DWG NO.			
MARK NO.	Q'TY/ SHIP	WEIGHT (KG/SHIP)	REMARK
VL-P06	1	42.2	본도제작



DETAIL OF BACK BAND



DETAIL OF PAD ④



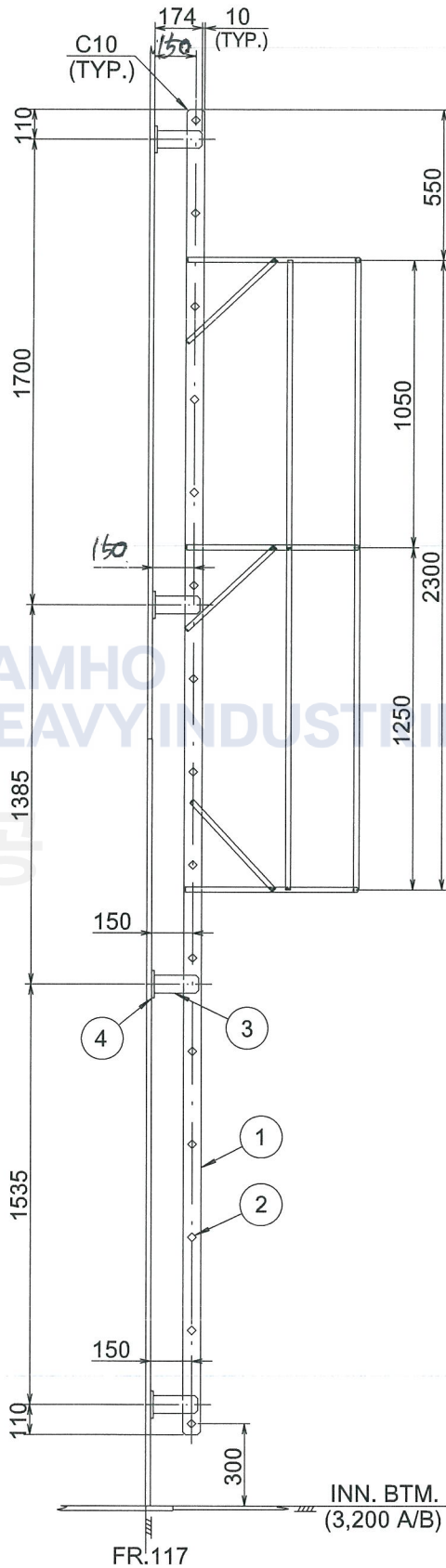
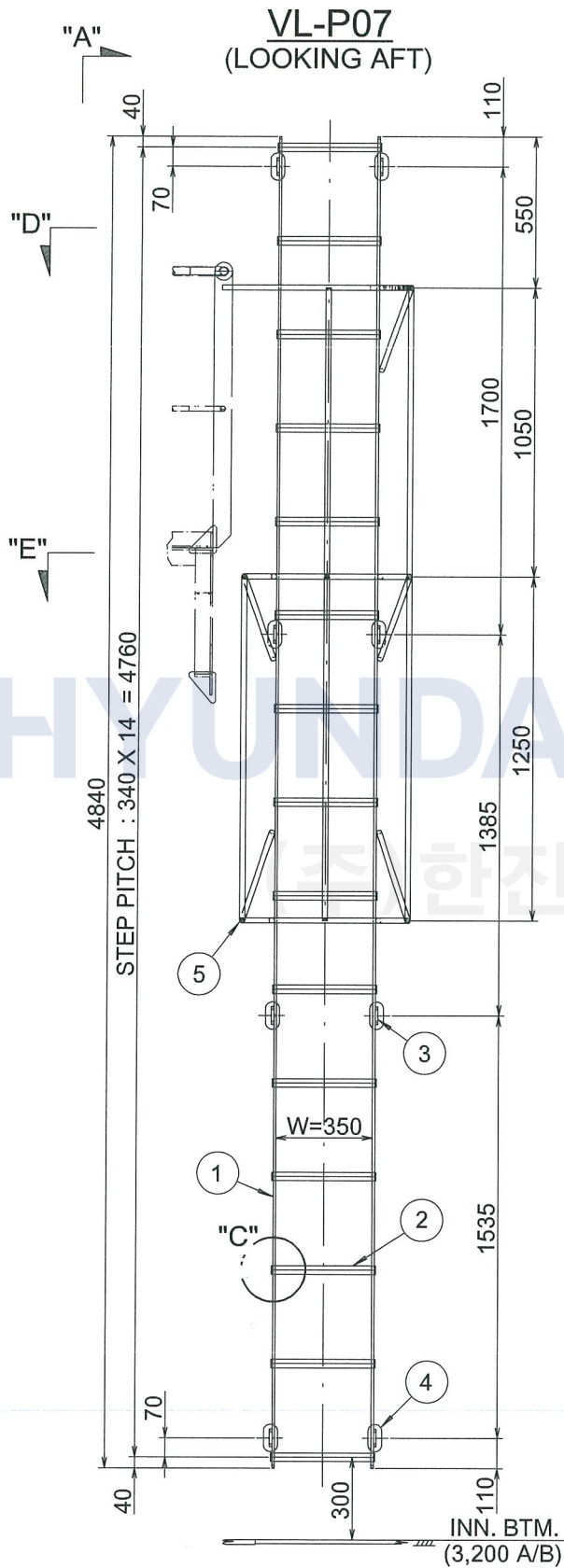
-TOTAL WEIGHT : 42.2 KG/SET

5	BACK BAND	Ø19 R.B	SS400	1	6.0	PAINTED
4	PAD	9t PLATE	SS400	4	1.4	PAINTED
3	LUG	65x9t F.B	SS400	4	3.0	PAINTED
2	STEP	22 SQ.BAR	SS400	7	10.1	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	21.7	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK

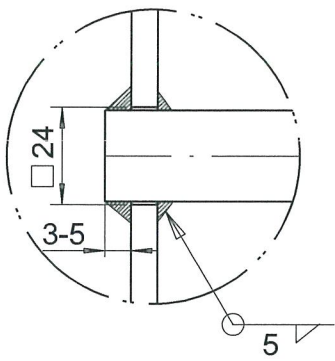
DETAIL OF VERTICAL LADDER

SHIP NO.		
DWG NO.		
BLOCK NO.	MARK NO.	Q'TY/ SHIP
F13C	VL-P07	1
		WEIGHT (KG/SHIP)
		105.8
		REMARK
		본도제작

VIEW - "A"

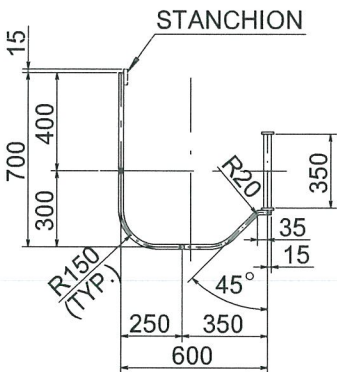


VIEW - "C"

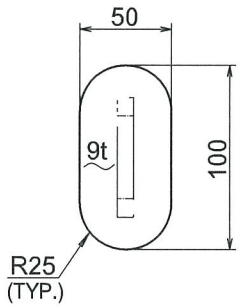


DETAIL OF BACK BAND
(FOR SAFETY CAGE)

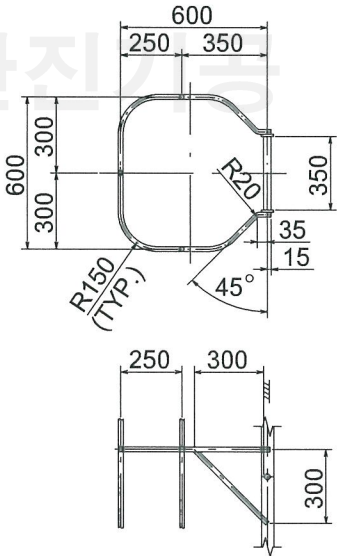
VIEW - "D"



DETAIL OF PAD ④



VIEW - "E"



-TOTAL WEIGHT : 105.8 KG/SET

5	SAFETY CAGE	Ø19 R.B	SS400	1	31.1	PAINTED
4	PAD	9t PLATE	SS400	8	2.8	PAINTED
3	LUG	65x9t F.B	SS400	8	6.0	PAINTED
2	STEP	22 SQ.BAR	SS400	15	21.5	PAINTED
1	SIDE FRAME	65x9t F.B	SS400	2	44.4	PAINTED
NO.	DESCRIPTION	SPEC.	MAT'L	Q'TY/SET	W.T (KG)	REMARK