

Izrada i strojna obrada sekcije 101

Piljić, Saša

Supplement / Prilog

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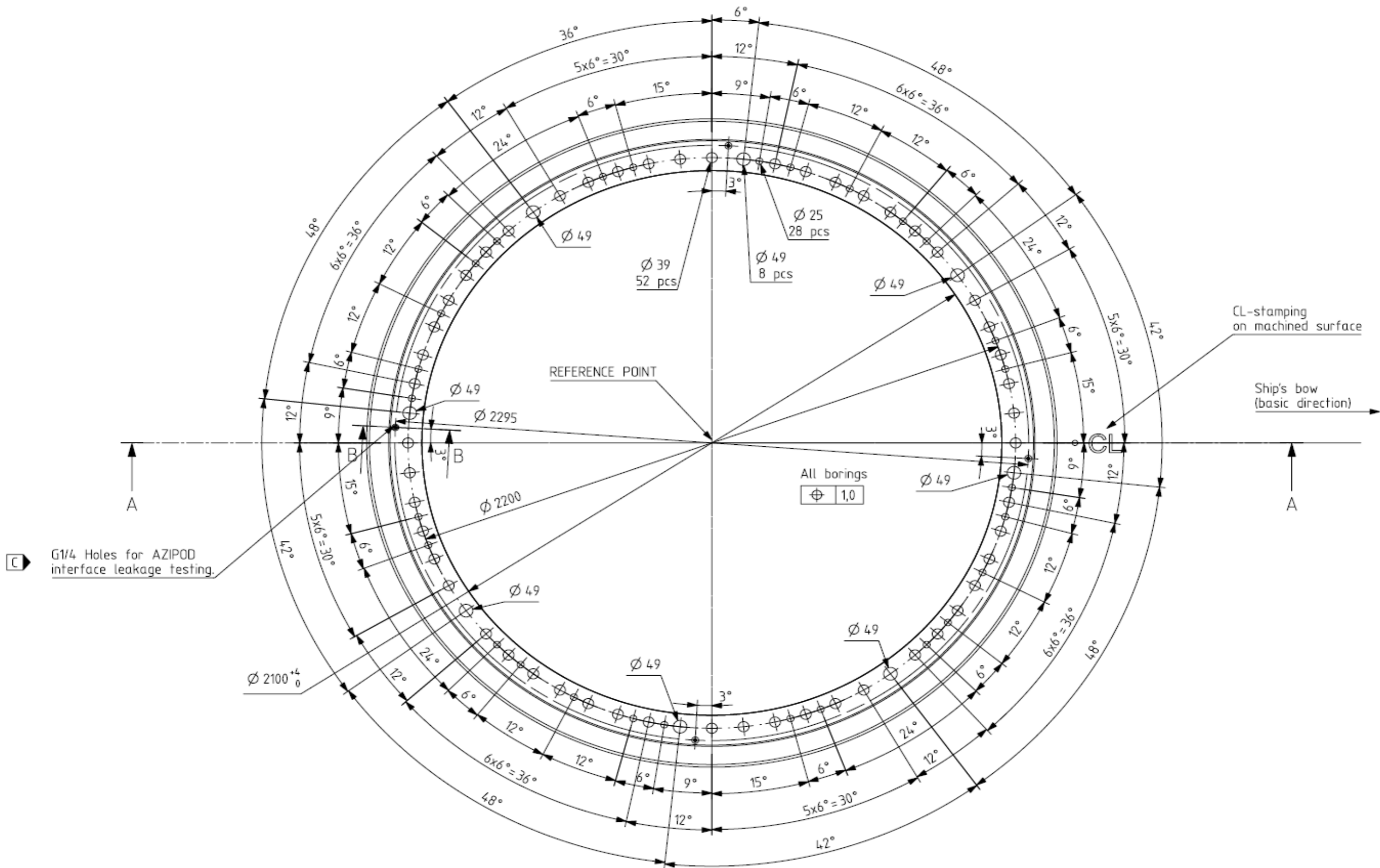
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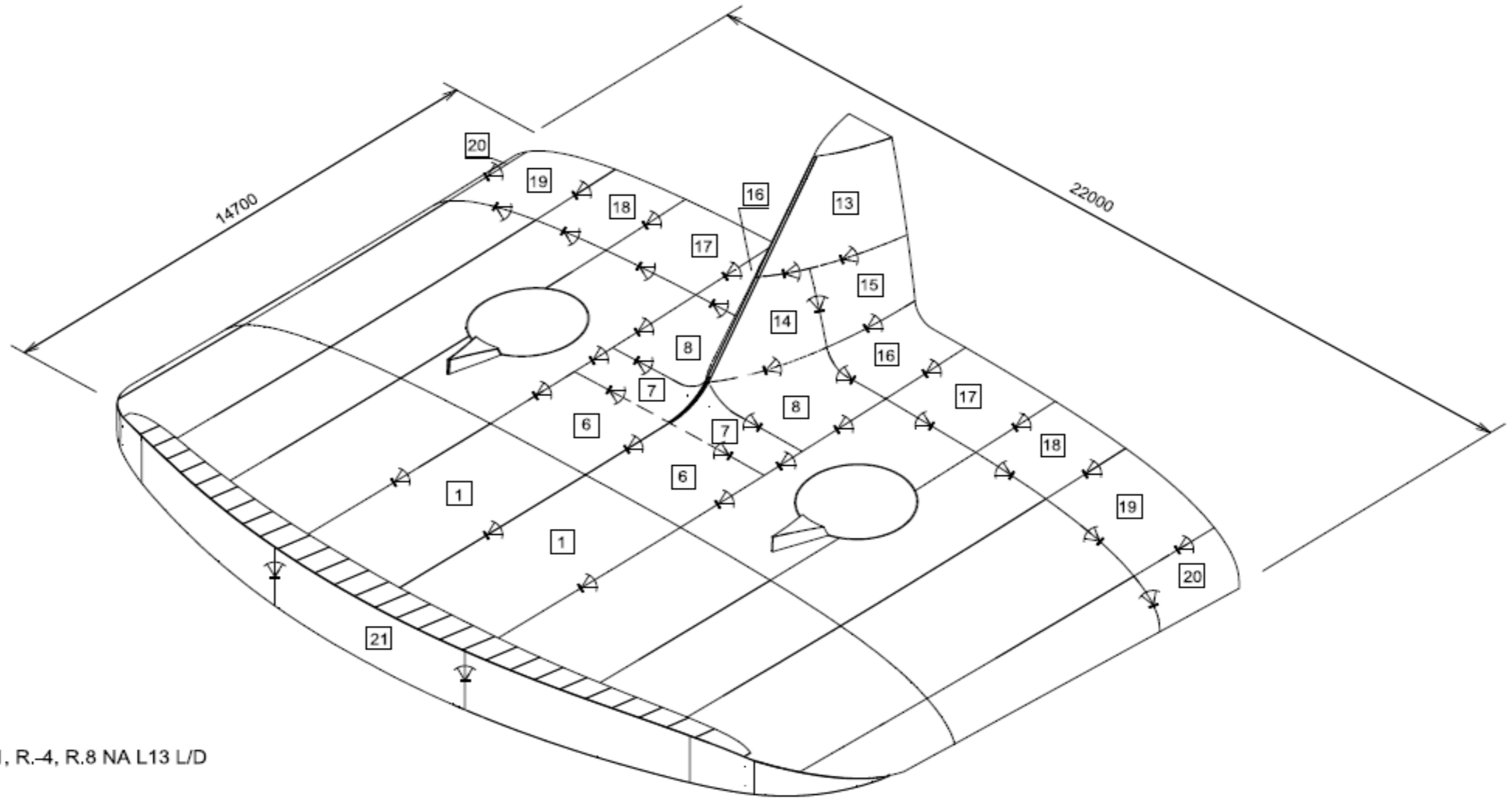
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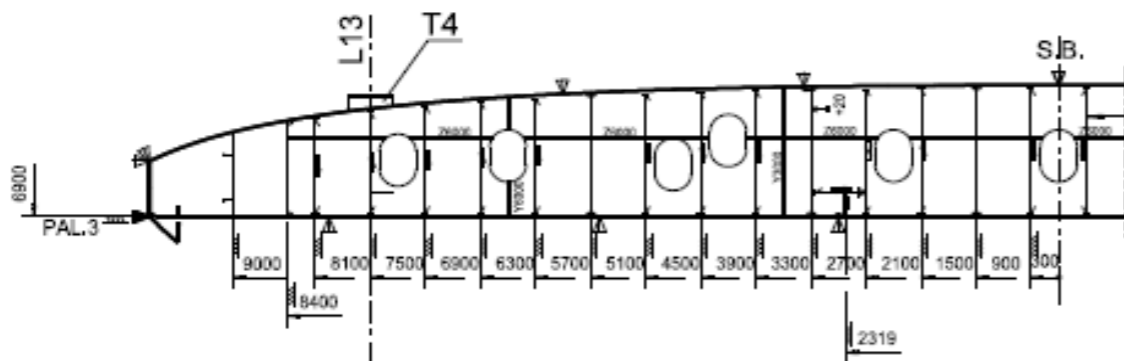


FAZA VI
IZRADA SEKCIJE VT01

masa sekcije VT01 - 173,6t



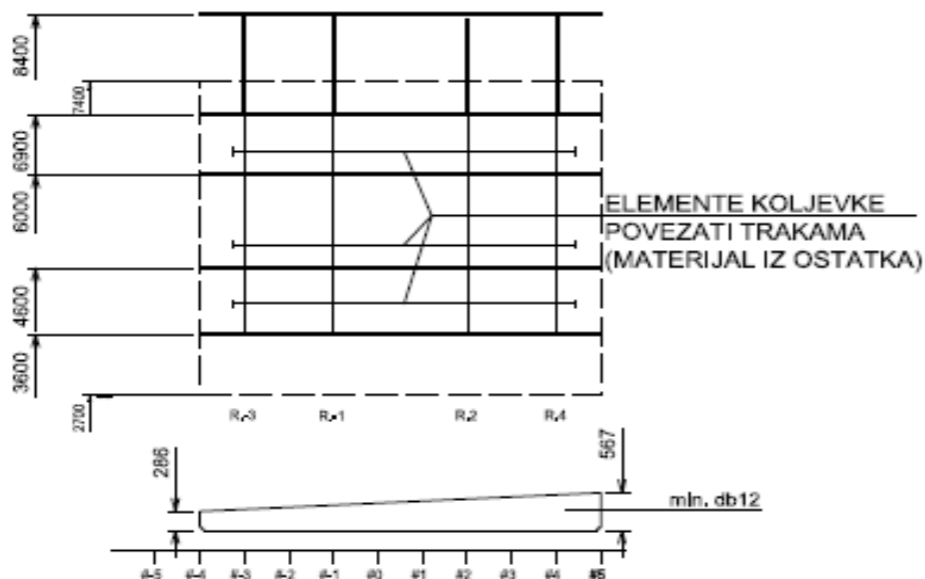
TEMELJ T4, POZICIJE: R.-11, R.-4, R.8 NA L13 L/D



IZRADA S11 (S21) U "PUNOJ" KOLJEVKI:

- UZD.PRESJEK NA 3600, 4600, 6000, 6900 | 8400 mm OD S.B. IZMEĐU R.-4 | R.5
- PRESJECI NA R.-3, R.-1, R.2 | R.4 IZMEĐU 6900 | 8400

SKICA KOLJEVKE

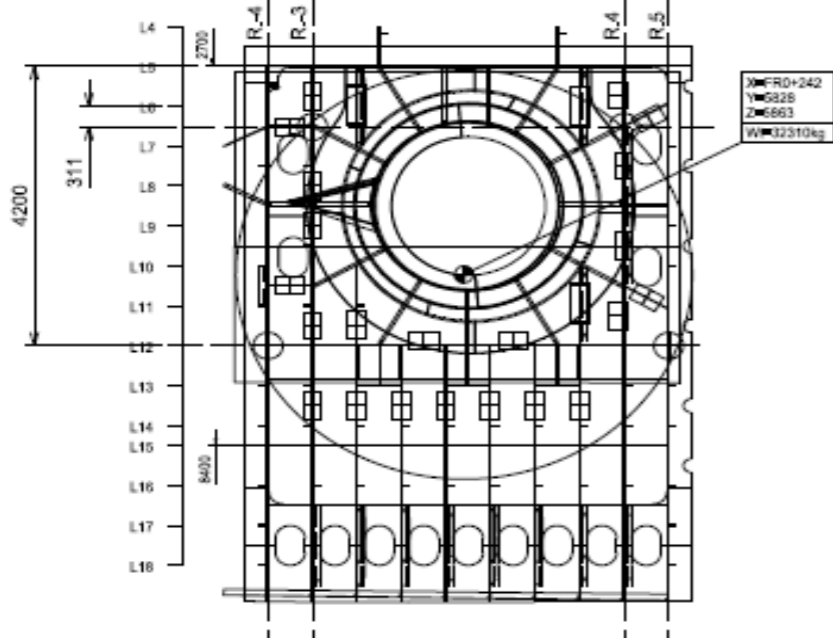


UŠKE ZA TRANSPORT SEKCIJE T11, T21



NAPOMENA:

UŠKE ZAVARITI NA LIMOVE VANJSKE OPLATE, U-A15, 4 KOM.

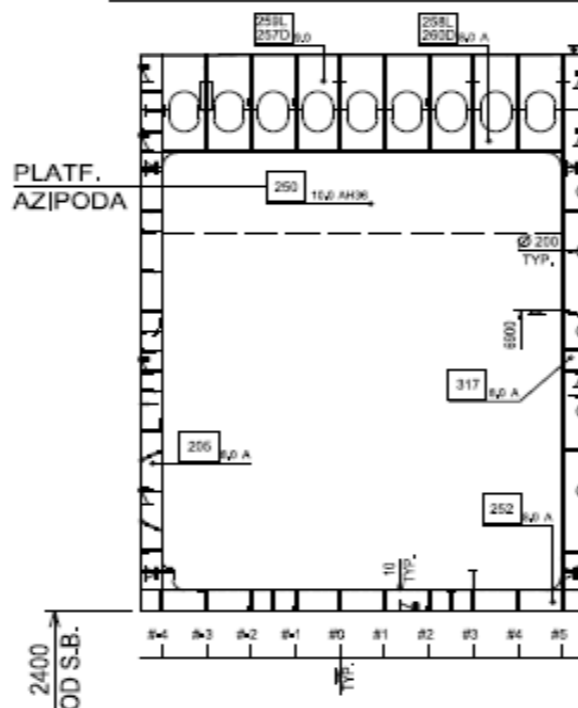


FAZA V

IZRADA SEKCIJE T11, T21

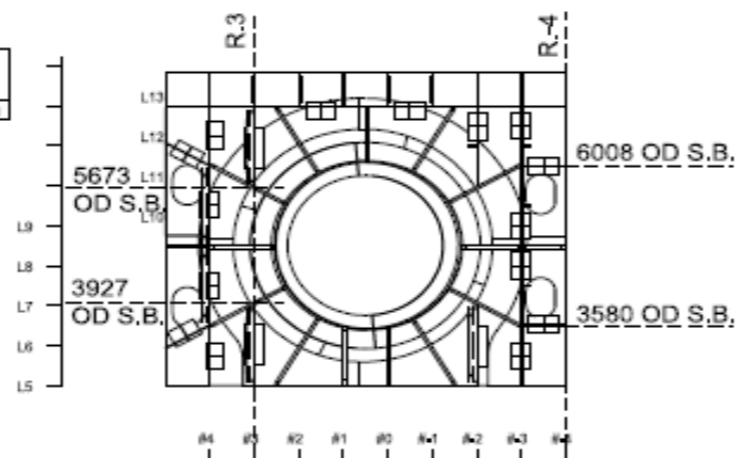
masa sekcije, T11 (T21) - 32,3t

PALUBA 6900mm IZNAD OSNOVICE



POLOŽAJ ČAHURA ZA MONTAŽU AZIPODA

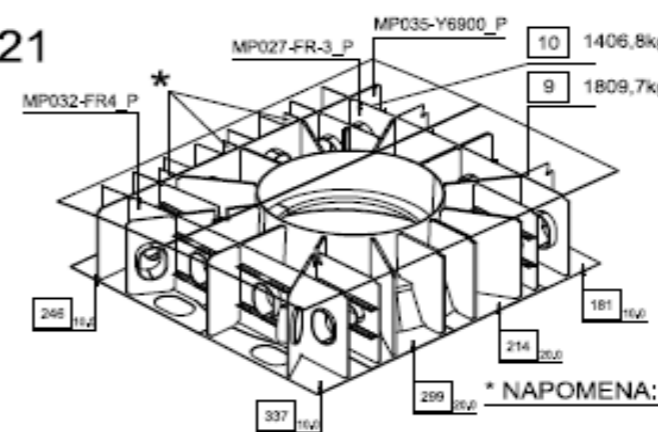
VIDI NACRT br. 1452608



NAPOMENA:

OBRADA NA STROJU - POZICIJE UŠKI ZA TRANSPORT TE POZICIJE NOGICA ZA TRANSPORT I OSLANJANJE - PREMA 4-635-405

S11 (S21) ZA STROJNU OBRADU



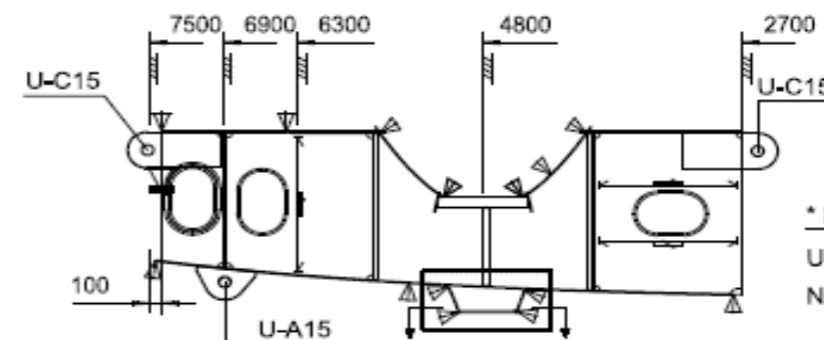
masa sekcije, S11 (S21) - 22,0t

- uključuje:
- masa strukture
 - R.M.9,10 (limove V,O.)
 - R.M.46,47,48,191,502,678,691,699 (elementi "lepeze")
 - struktura prema IP 734/T3/338
 - noglice, 4kom.
 - ukrućenja (C300, profil l=5m)
 - uške: B15-4 kom., A15-2 kom.

*** NAPOMENA:**

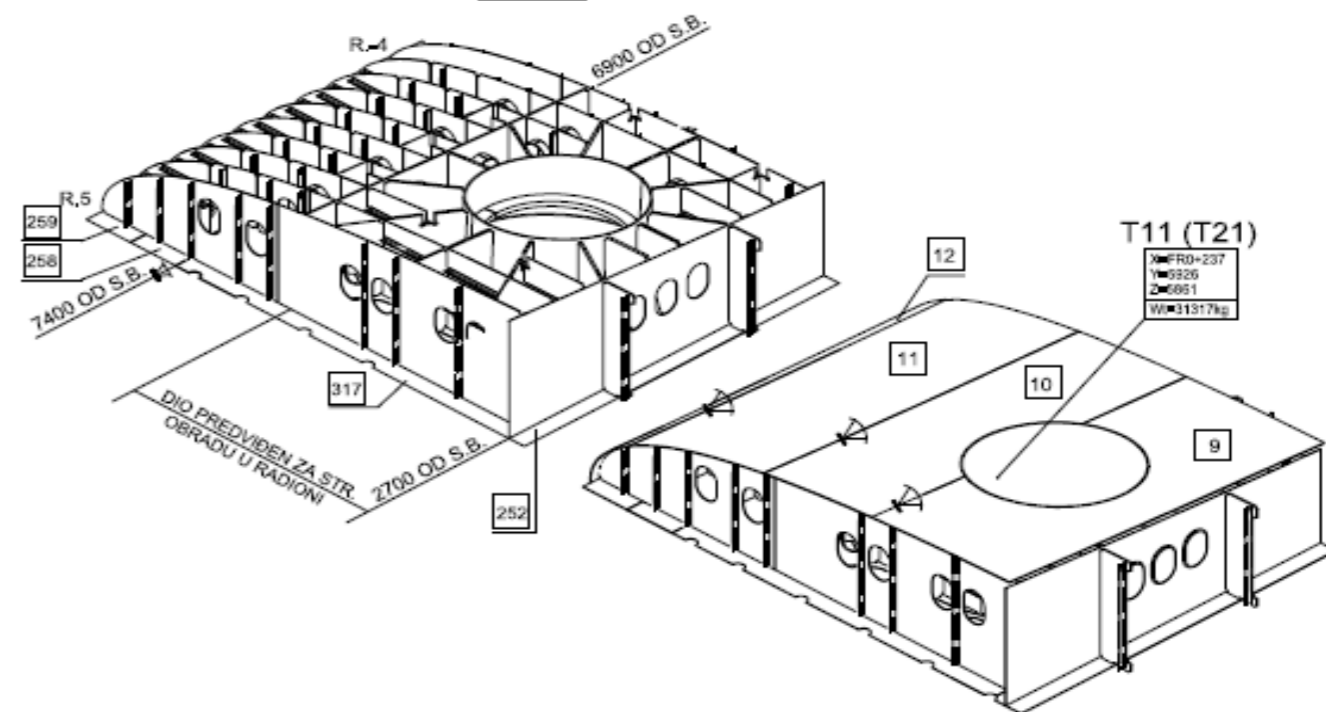
- NE MONTIRATI U MP035-Y6900 ZA S11 (S21):
R.M.302 (PRESJEK A-A)
R.M.209 (PRESJEK D-D)
R.M.255 (R,0+300)
- MONTIRATI NAKON IZVRŠENE STROJNE OBRADU

**PRESJEK R.-2
VRIJEDI I ZA R.3**



*** NAPOMENA:**

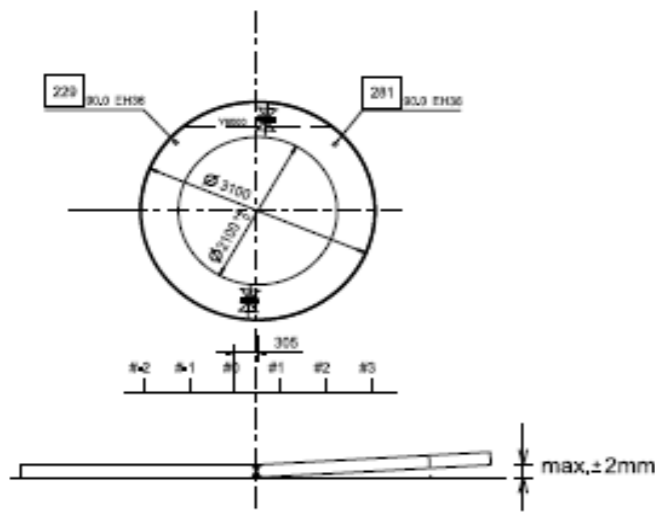
UŠKE C15 ODREZATI NAKON OKRETANJA



FAZA IV IZRADA SKLOPOVA ZA AZIPOD

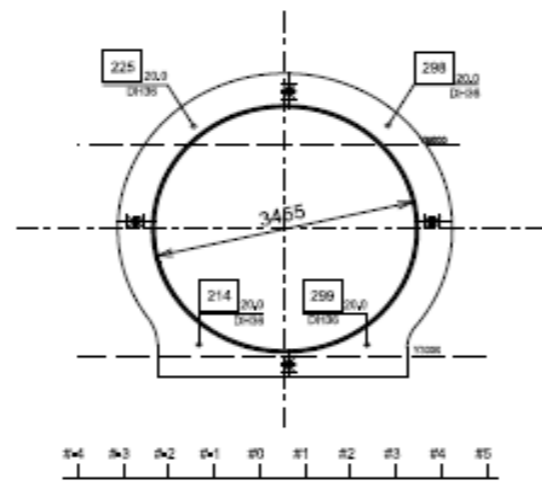
PRSTEN TEMELJA

masa - 3t



"Ω" PRSTEN PLATFORME

masa - 1t

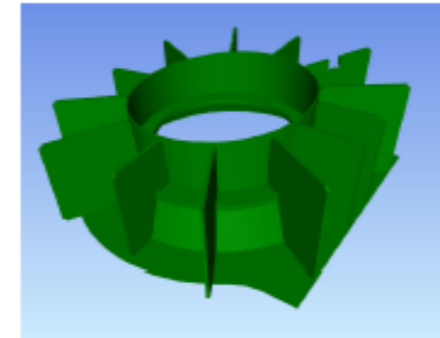


R.M.42.43
44,45
SKLOP A

FAZA IV.2

SKLOP B
KOLJENO
SKLOP C

FAZA IV.5

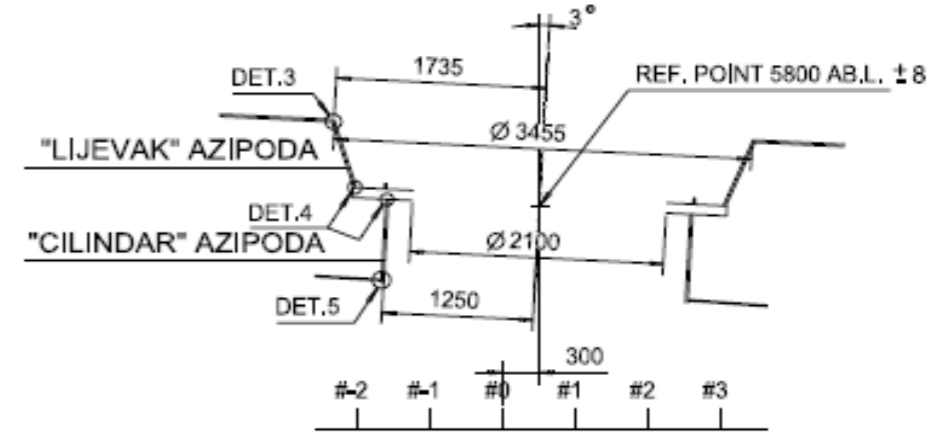
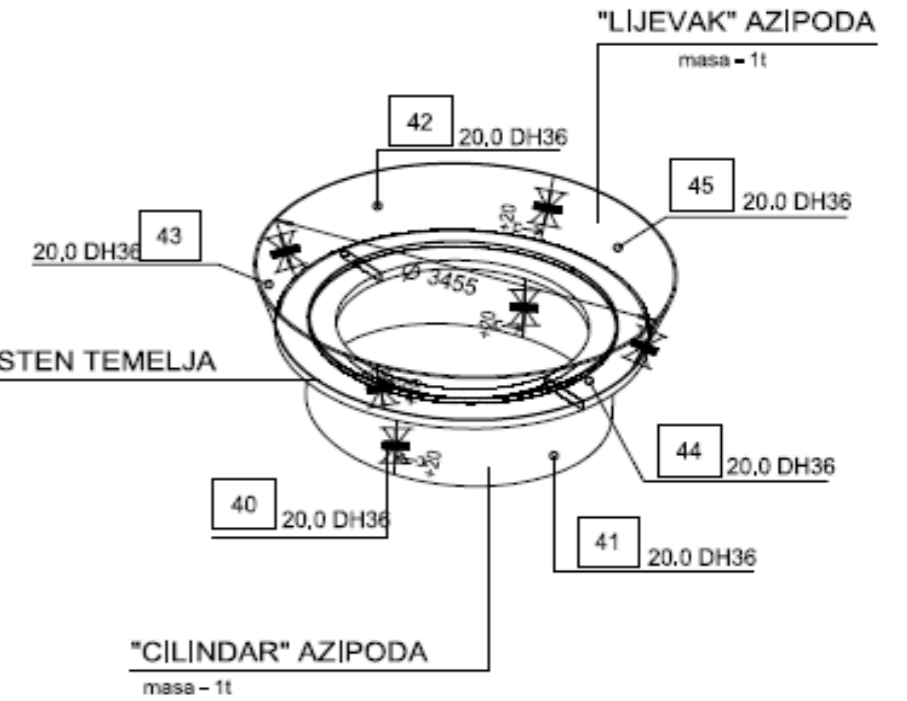


FAZA IV.6

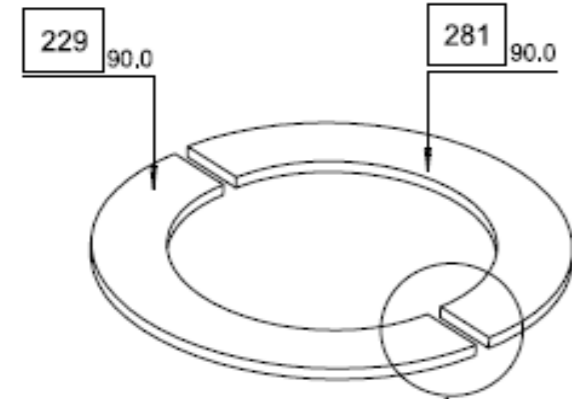
PRSTEN TEMELJA

"CILINDAR" AZIPODA

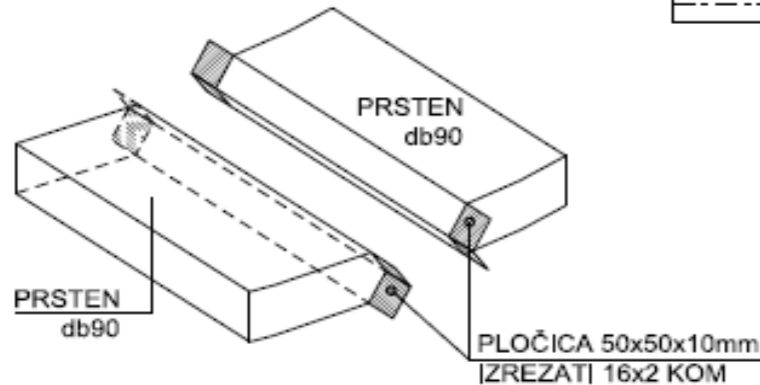
masa - 1t



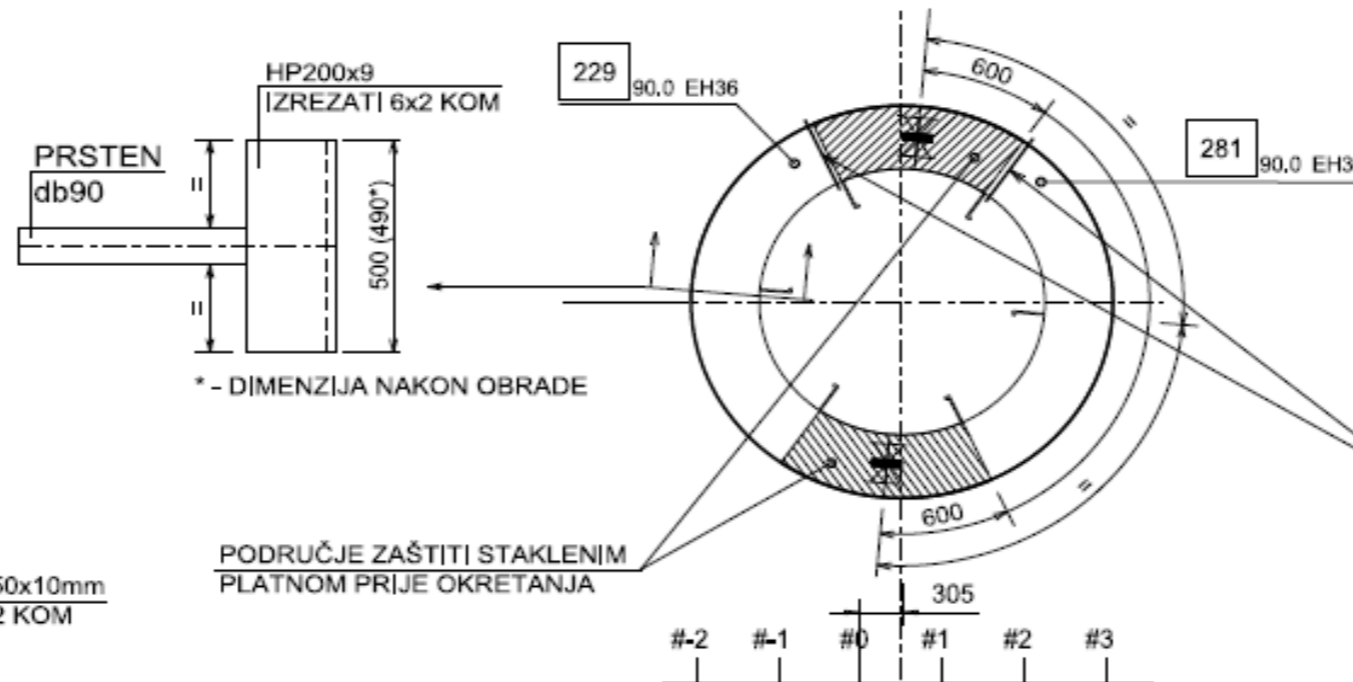
NAPOMENA: DET.3,4,5 PREMA NACRTU br.2210101001



SKICA br.1
DETALJ ZA "X" PRIPREMU



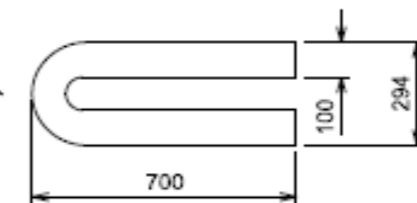
SKICA br.2
UKRUĆENJA ZA ZAVARIVANJE PRSTENA



* - DIMENZIJA NAKON OBRADJE

PODRUČJE ZAŠTITI STAKLENIM
PLATNOM PRIJE OKRETANJA

MEHANIČKA ZAŠTITA GRIJAČA
2 KOM.

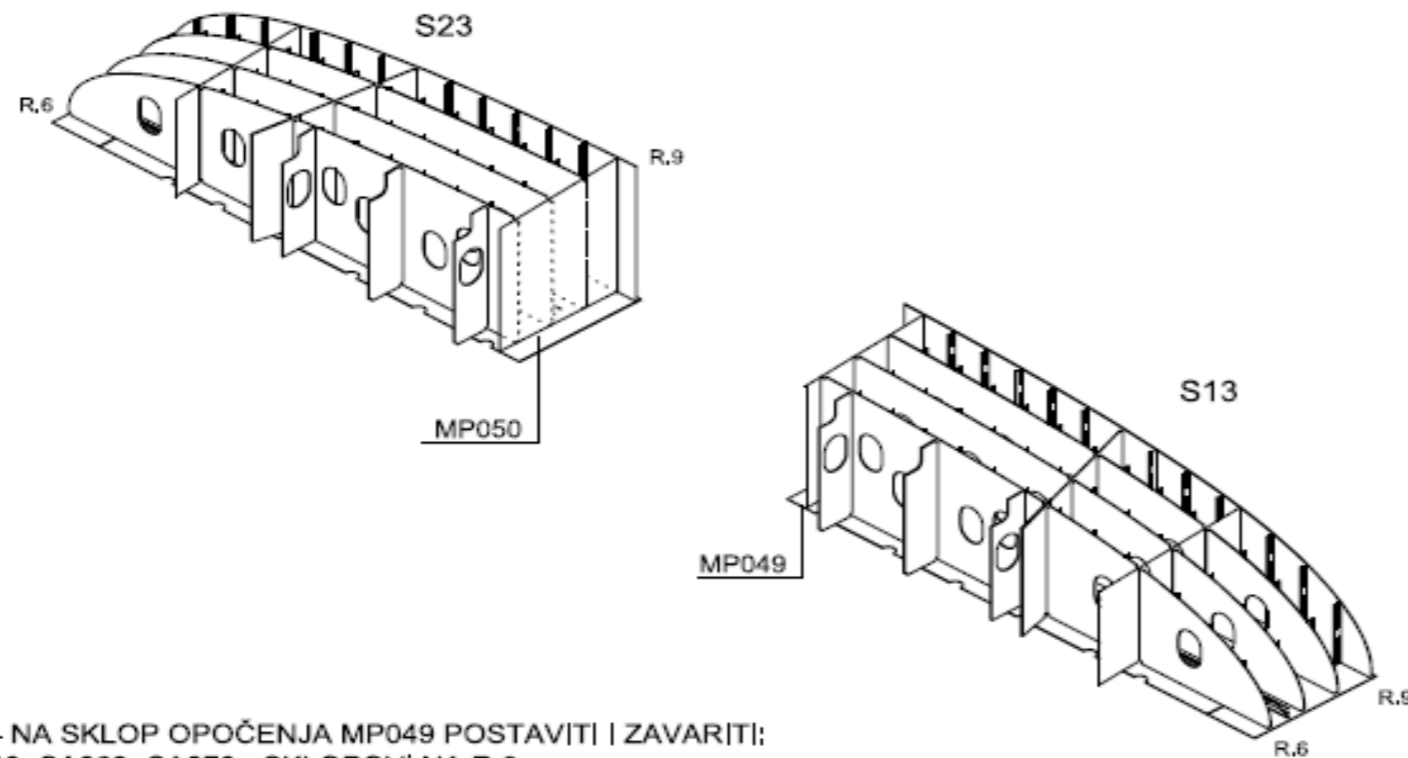


PLOČICA, 2 KOM.
200x100x50

FAZA III

IZRADA SEKCIJE S13, S23

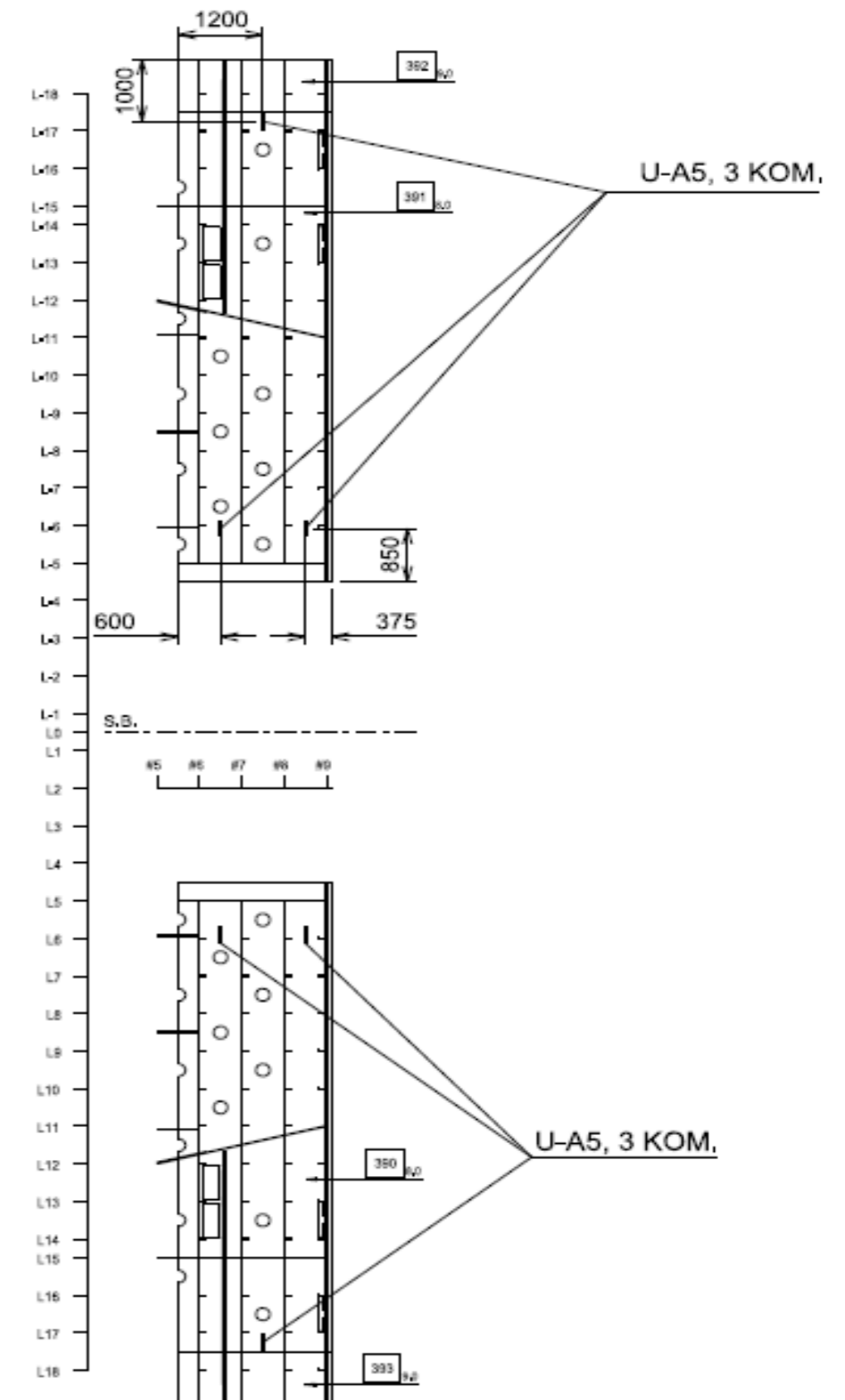
masa sekcije, S13 - 7,5t
masa sekcije, S23 - 7,5t



ZA S13 - NA SKLOP OPOČENJA MP049 POSTAVITI I ZAVARITI:
 MP040, CA069, CA070 - SKLOPOVI NA R.6
 CA071, CA072, CA073 - SKLOPOVI NA R.7
 CA074, CA075, CA076 - SKLOPOVI NA R.8
 CR013 - SKLOP NA R.9
 MP051 - SKLOP UZDUŽNE PREGRADE
 R.M.389, PRESJEK NA 2700mm OD S.B.
 R.M.387, PRESJEK NA 8400mm OD S.B.

ZA S23 - NA SKLOP OPLOČENJA MP050 POSTAVITI I ZAVARITI:
 MP040, CA069, CA070 - SKLOPOVI NA R.6
 CA071, CA072, CA073 - SKLOPOVI NA R.7
 CA074, CA075, CA076 - SKLOPOVI NA R.8
 CR014 - SKLOP NA R.9
 MP051 - SKLOP UZDUŽNE PREGRADE
 R.M.389, PRESJEK NA 2700mm OD S.B.
 R.M.387, PRESJEK NA 8400mm OD S.B.

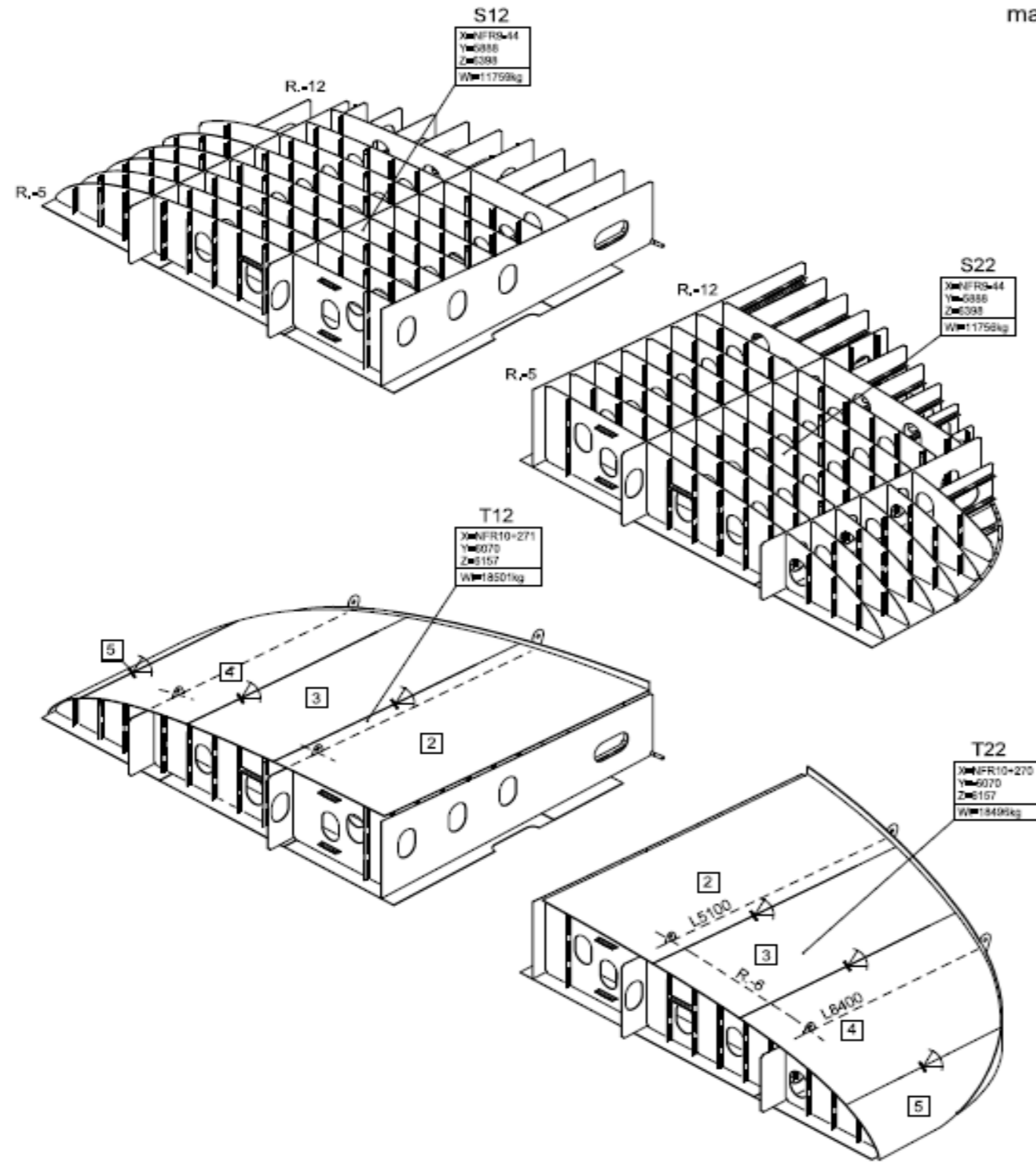
UŠKE ZA TRANSPORT I MONTAŽU U VT01



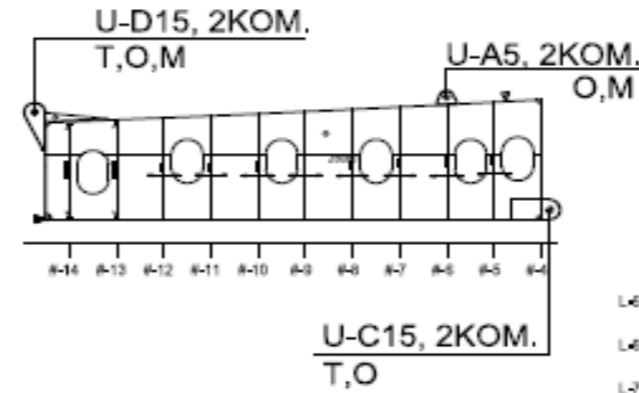
FAZA II

IZRADA SEKCIJE T12, T22

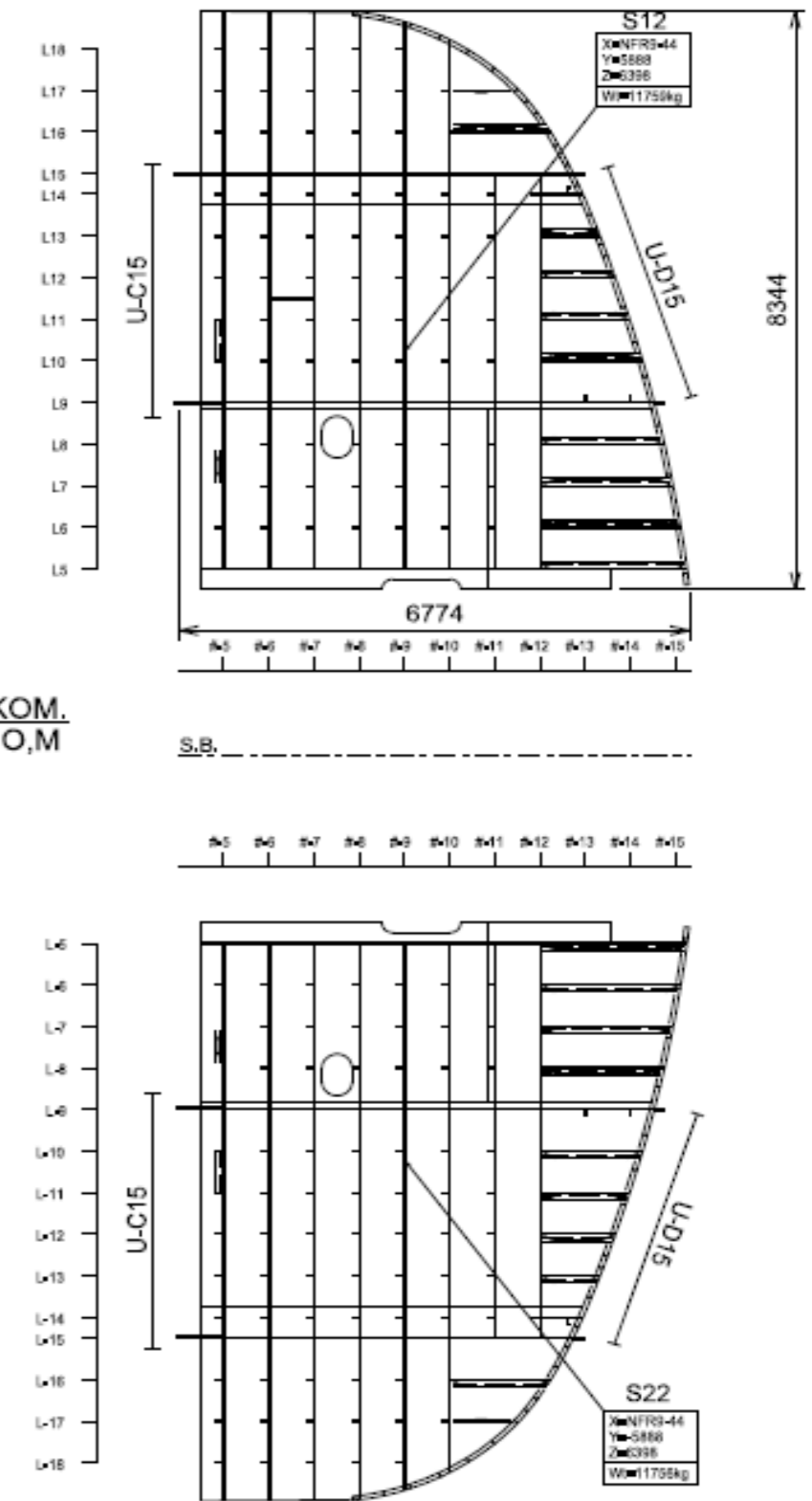
masa sekcije, T12=18,5t
masa sekcije, T22=18,5t



PRESJEK 5100L/D (L9)
(vrljedl | za 8400L/D, L15)



UŠKE ZA TRANSPORT, OKRETANJE I MONTAŽU SEKCIJE T12, T22

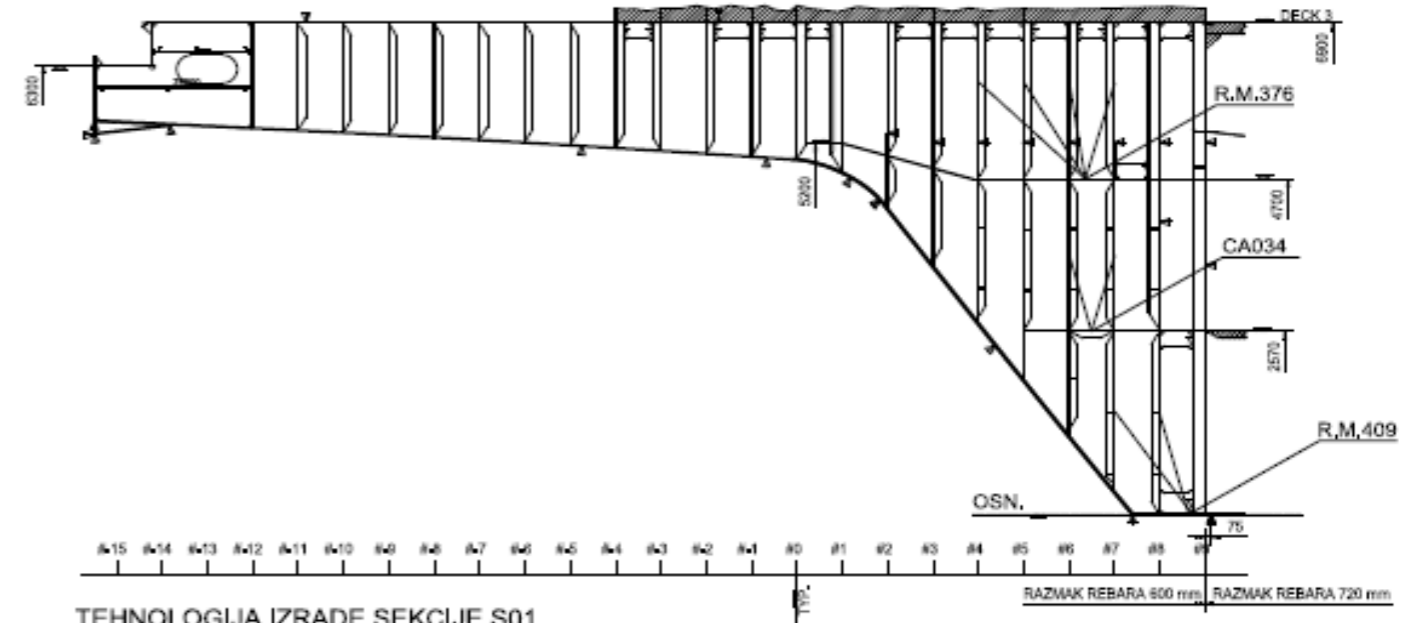
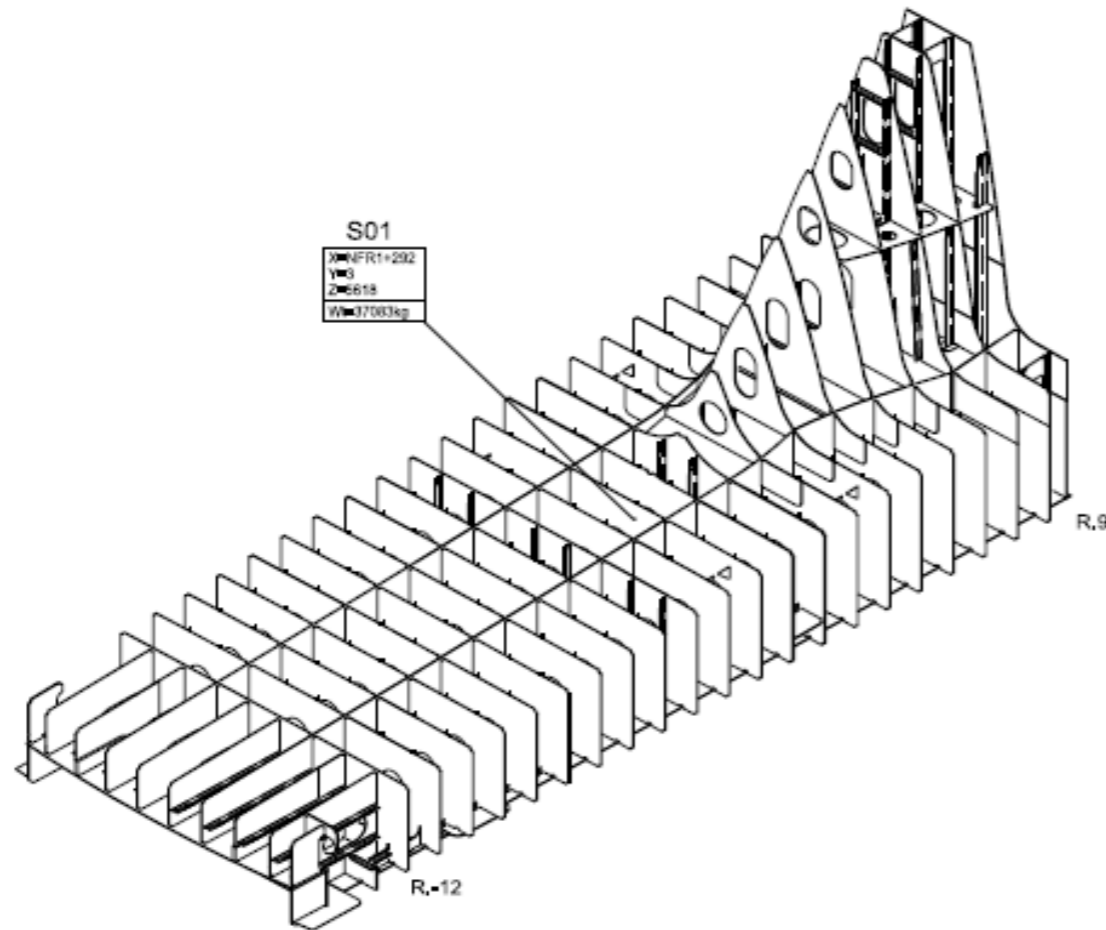


FAZA I

IZRADA SEKCIJE S01

UZD.PRESJEK NA 300mm OD S.B.

masa sekcije, S01=38,0t



TEHNOLOGIJA IZRADA SEKCIJE S01
(NADOPUNA DOKUMENTA (2210101001))

- NA OPLOČENJE PALUBE 3 (R.M.94, 226 I 227) POSTAVITI SKLOPOVE/ELEMENTE U PODRUČJU R.-12 DO R.1 U RASPONU 2700 L/D
- NA OPLOČENJE PLATFORME NA 4700mm OD OSNOVICE (R.M.376) POSTAVITI I ZAVARITI SKLOPOVE: MP009-FR4, MP012-FR5, MP015-FR6, MP018-FR7
- NA OPLOČENJE PLATFORME NA 2570mm OD OSNOVICE (CA034-Z2570) POSTAVITI I ZAVARITI SKLOPOVE: CR007-FR6, CR008-FR7
- NA LIM R.M.409 (PLATFORMA U OSNOVICI BRODA) POSTAVITI I ZAVARITI SKLOPOVE: CR010-FR7 I CR011-FR8

UŠKE ZA TRANSPORT SEKCIJE S01

