

# Izrada i strojna obrada sekcije 101

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**Supplement / Prilog**

*Publication year / Godina izdavanja:* **2024**

*Permanent link / Trajna poveznica:* <https://urn.nsk.hr/urn:nbn:hr:190:539936>

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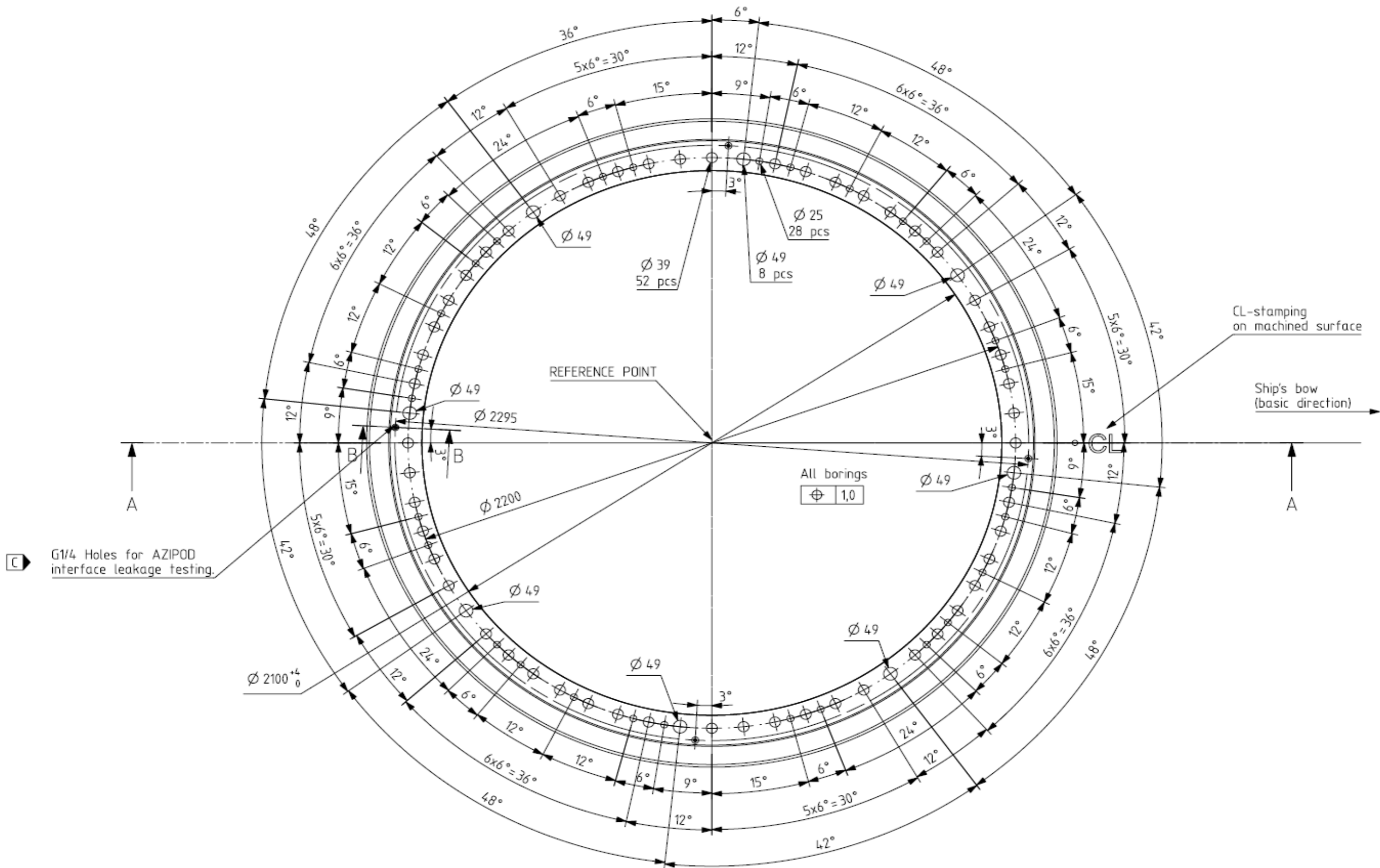
*Download date / Datum preuzimanja:* **2024-09-06**



*Repository / Repozitorij:*

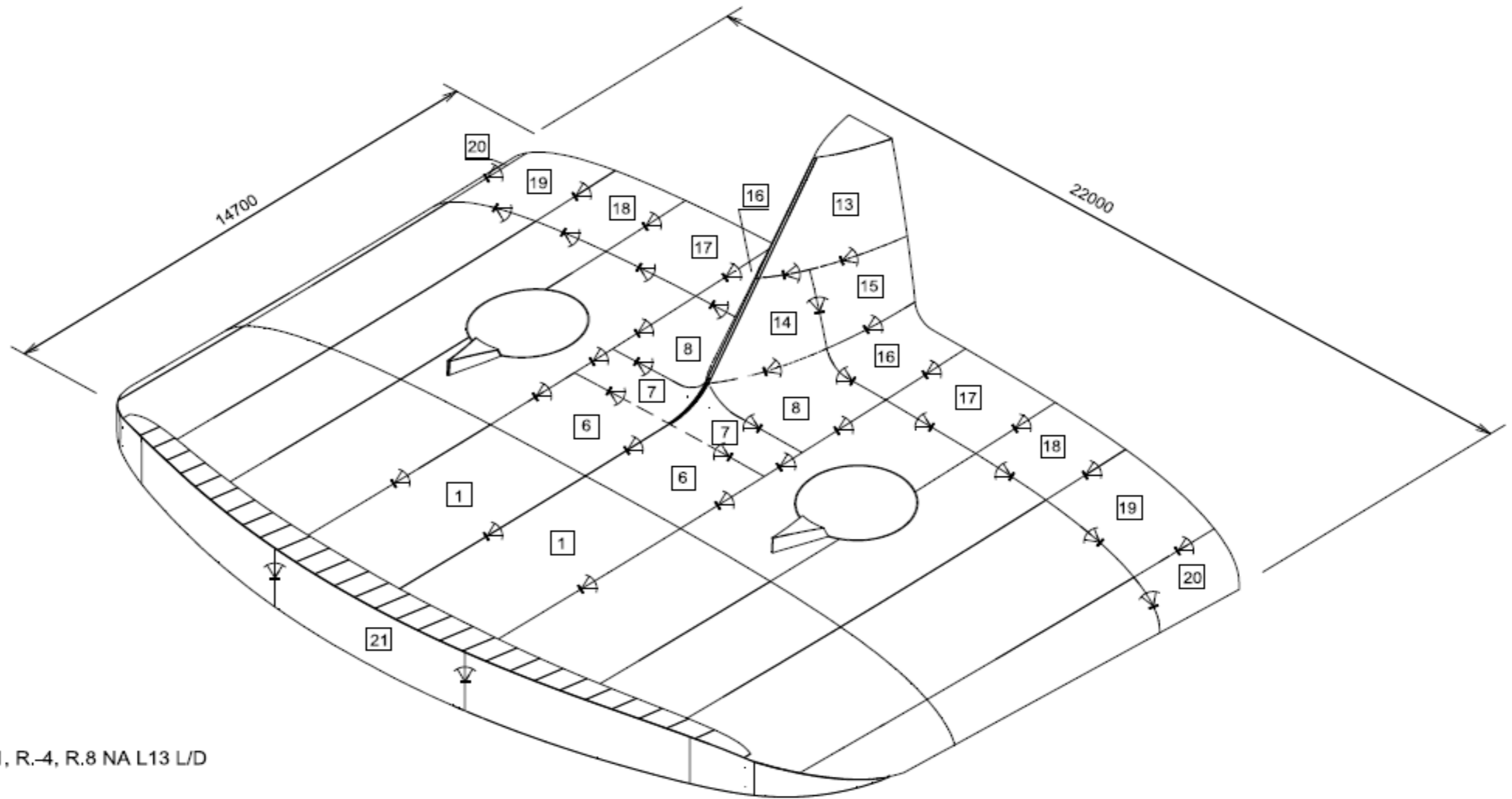
[Repository of the University of Rijeka, Faculty of Engineering](#)



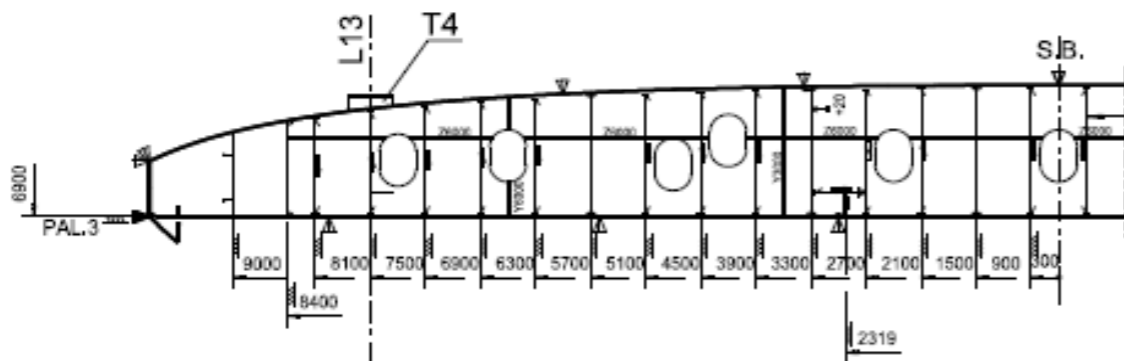


**FAZA VI**  
**IZRADA SEKCIJE VT01**

masa sekcije VT01 - 173,6t



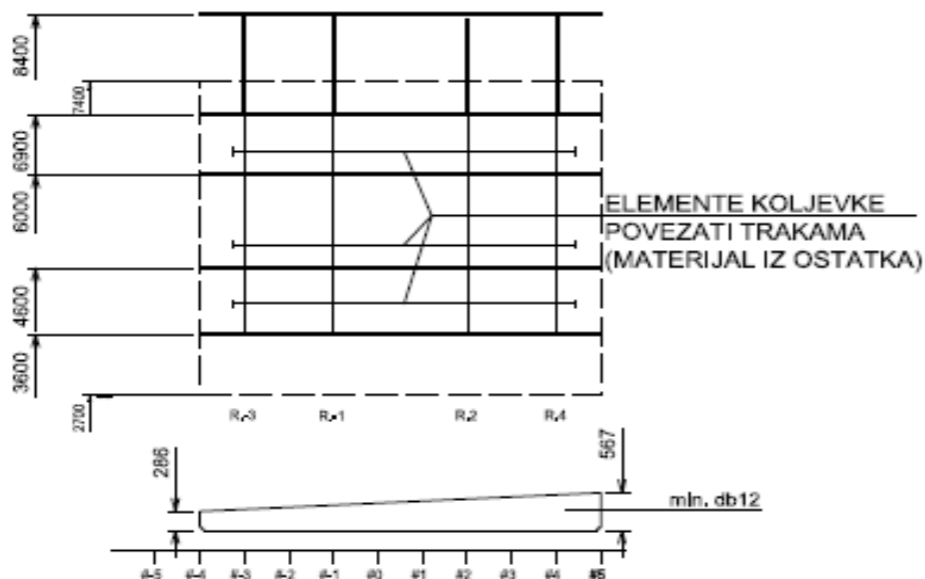
TEMELJ T4, POZICIJE: R.-11, R.-4, R.8 NA L13 L/D



**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



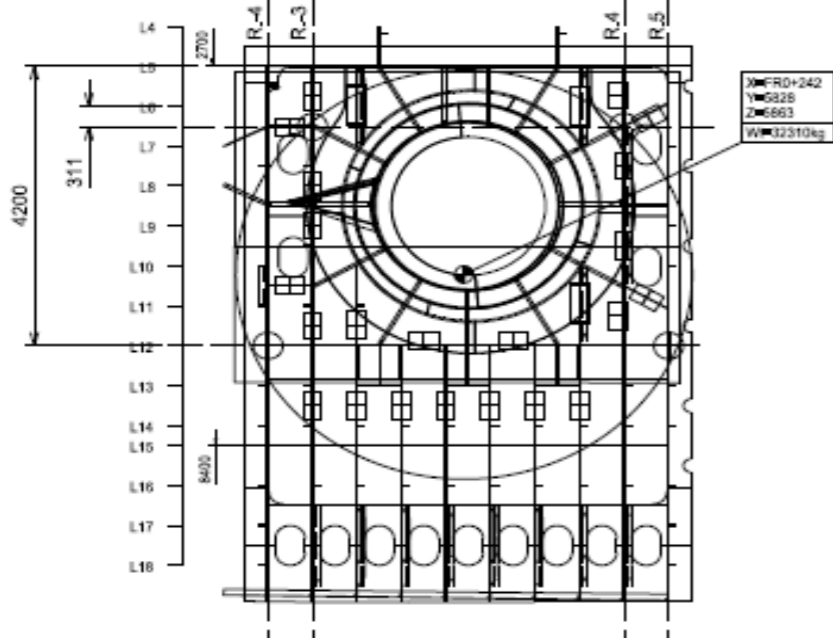
ELEMENTE KOLJEVKE  
POVEZATI TRAKAMA  
(MATERIJAL IZ OSTATKA)

UŠKE ZA TRANSPORT SEKCIJE T11, T21



**NAPOMENA:**

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

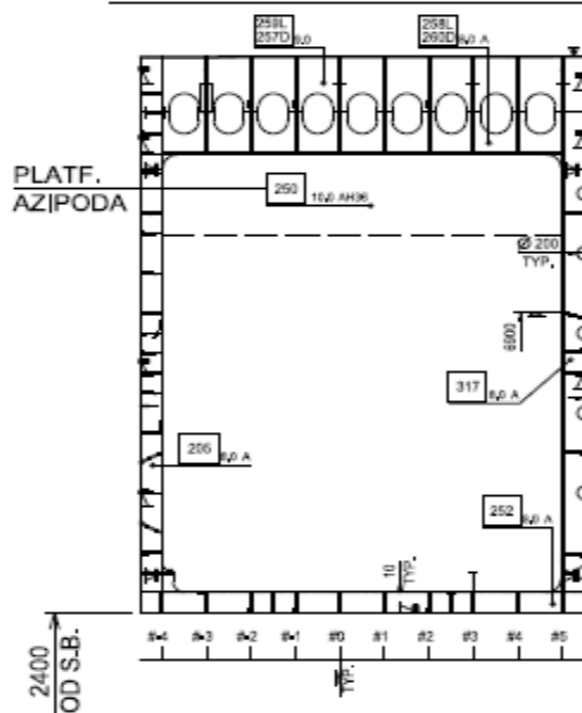


**FAZA V**

**IZRADA SEKCIJE T11, T21**

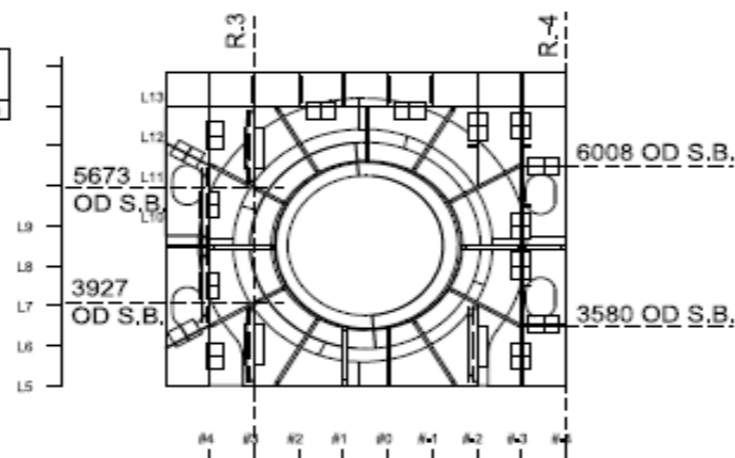
masa sekcije, T11 (T21) - 32,3t

PALUBA 6900mm IZNAD OSNOVICE



POLOŽAJ ČAHURA ZA MONTAŽU AZIPODA

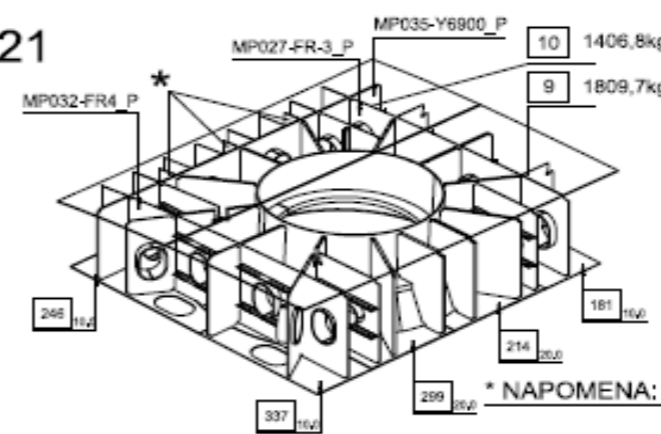
VIDI NACRT br. 1452608



**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

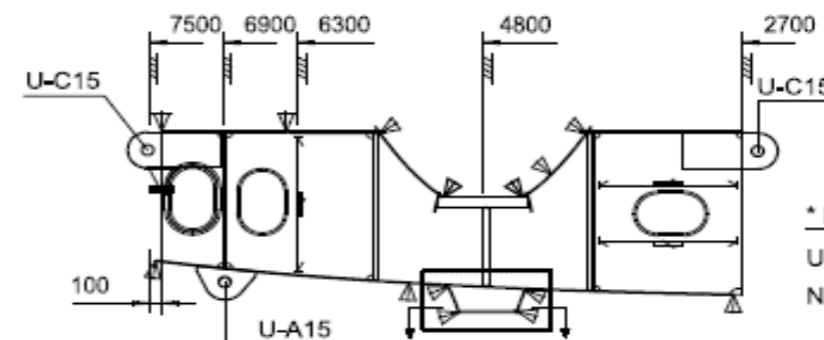
uključuje:

- 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:**

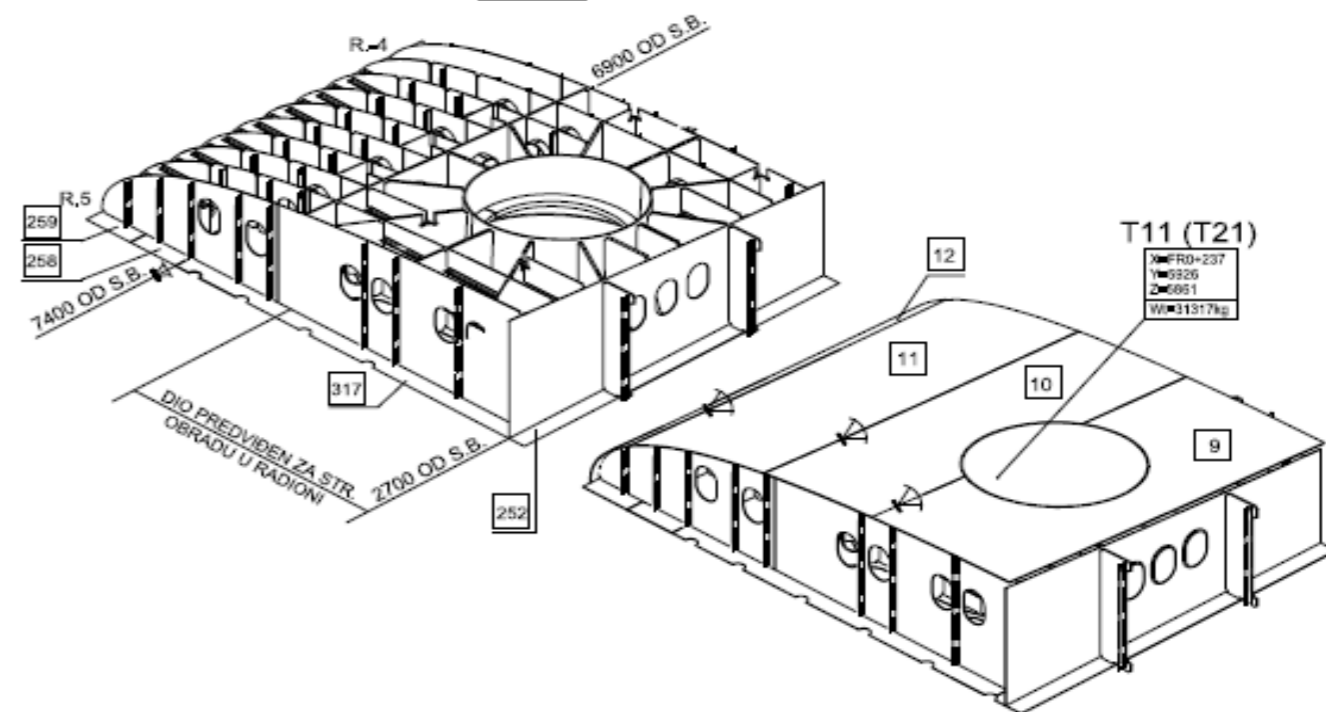
- NE MONTIRATI U MP035-Y6900 ZA S11 (S21):  
R.M.302 (PRESJEK A-A)  
R.M.209 (PRESJEK D-D)  
R.M.255 (R,0+300)
- MONTIRATI NAKON IZVRŠENE STROJNE OBRADU

PRESJEK R.-2  
VRIJEDI I ZA R.3



**\* NAPOMENA:**

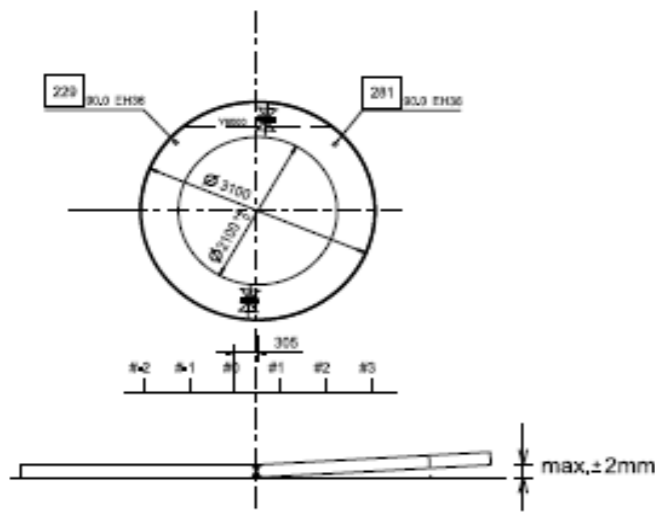
UŠKE C15 ODREZATI NAKON OKRETANJA



# FAZA IV IZRADA SKLOPOVA ZA AZIPOD

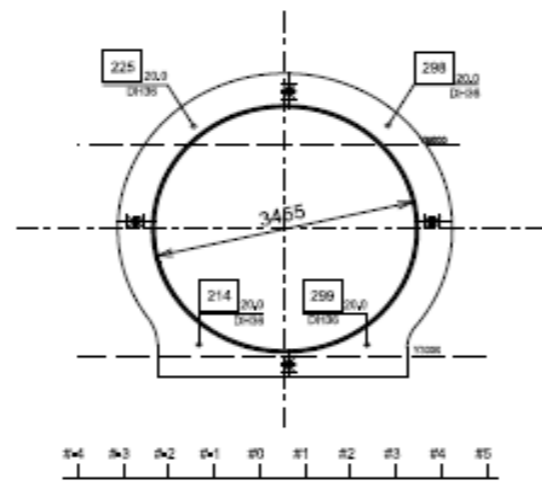
## PRSTEN TEMELJA

masa - 3t



## "Ω" PRSTEN PLATFORME

masa - 1t



R.M.42.43  
44,45  
SKLOP A

FAZA IV.2

SKLOP B

KOLJENO

SKLOP C

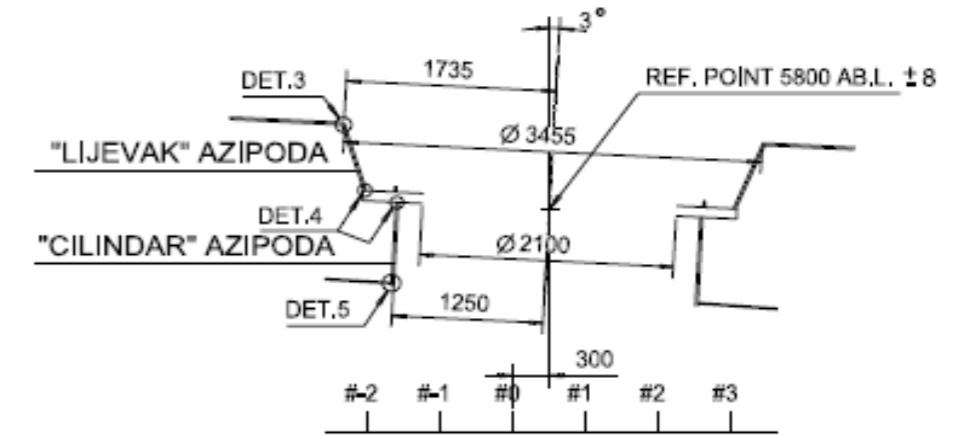
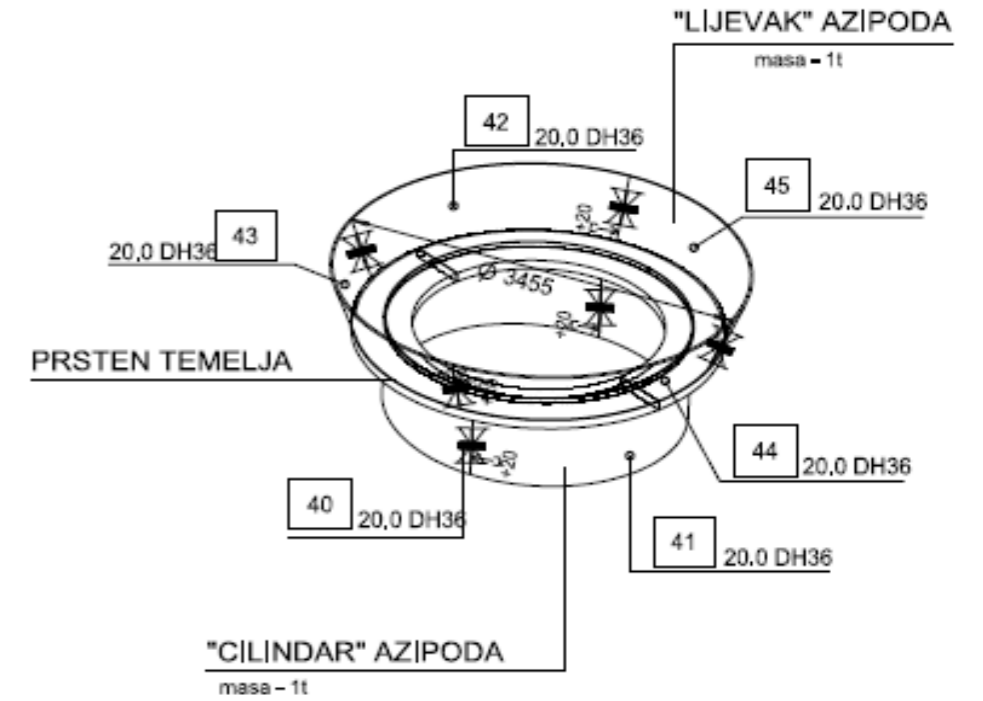
FAZA IV.5

FAZA IV.6

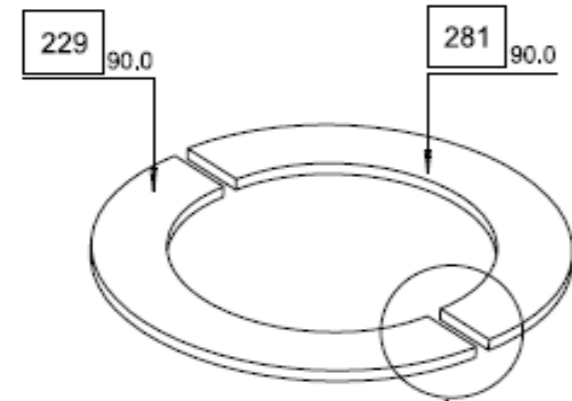
PRSTEN TEMELJA

"CILINDAR" AZIPODA

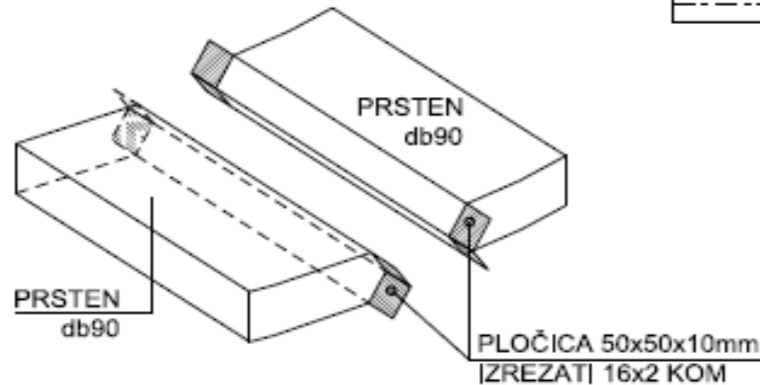
masa - 1t



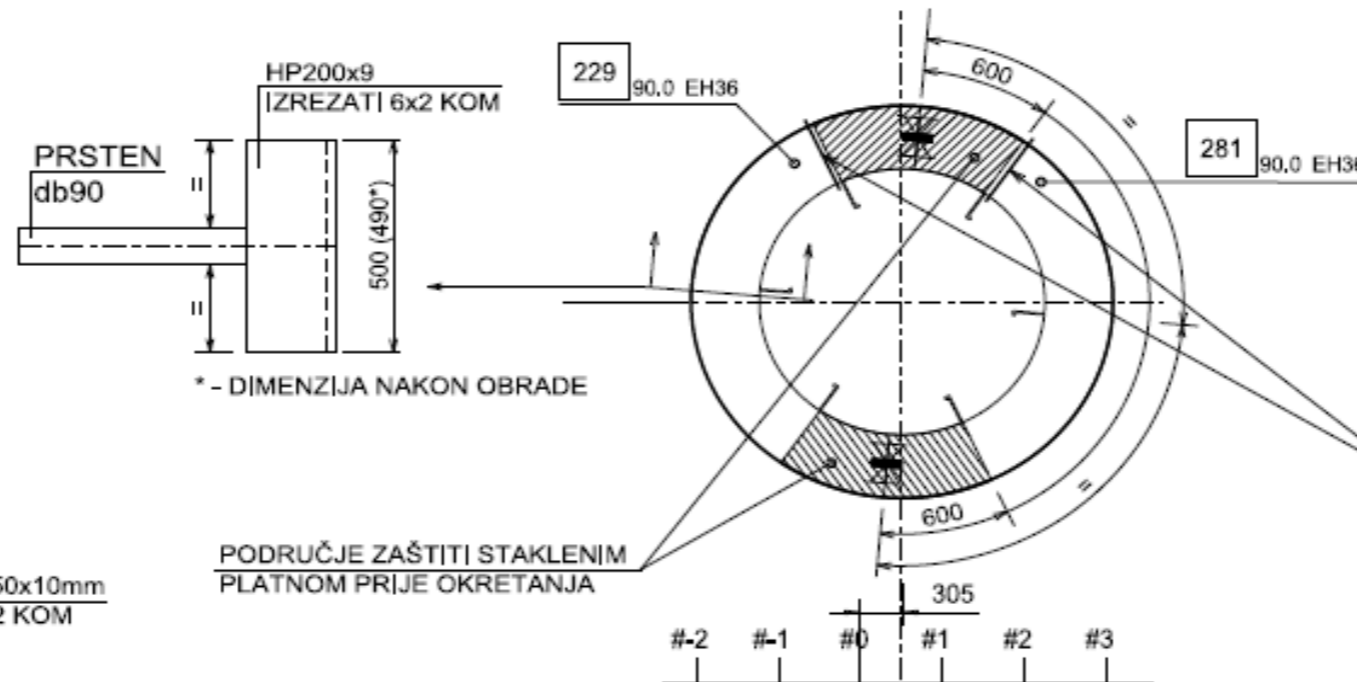
NAPOMENA: DET.3,4,5 PREMA NACRTU br.2210101001



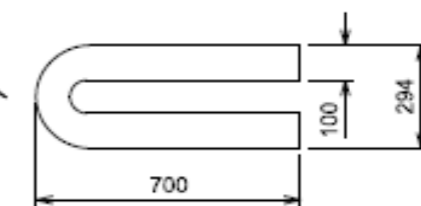
SKICA br.1  
DETALJ ZA "X" PRIPREMU



SKICA br.2  
UKRUĆENJA ZA ZAVARIVANJE PRSTENA



MEHANIČKA ZAŠTITA GRIJAČA  
2 KOM.



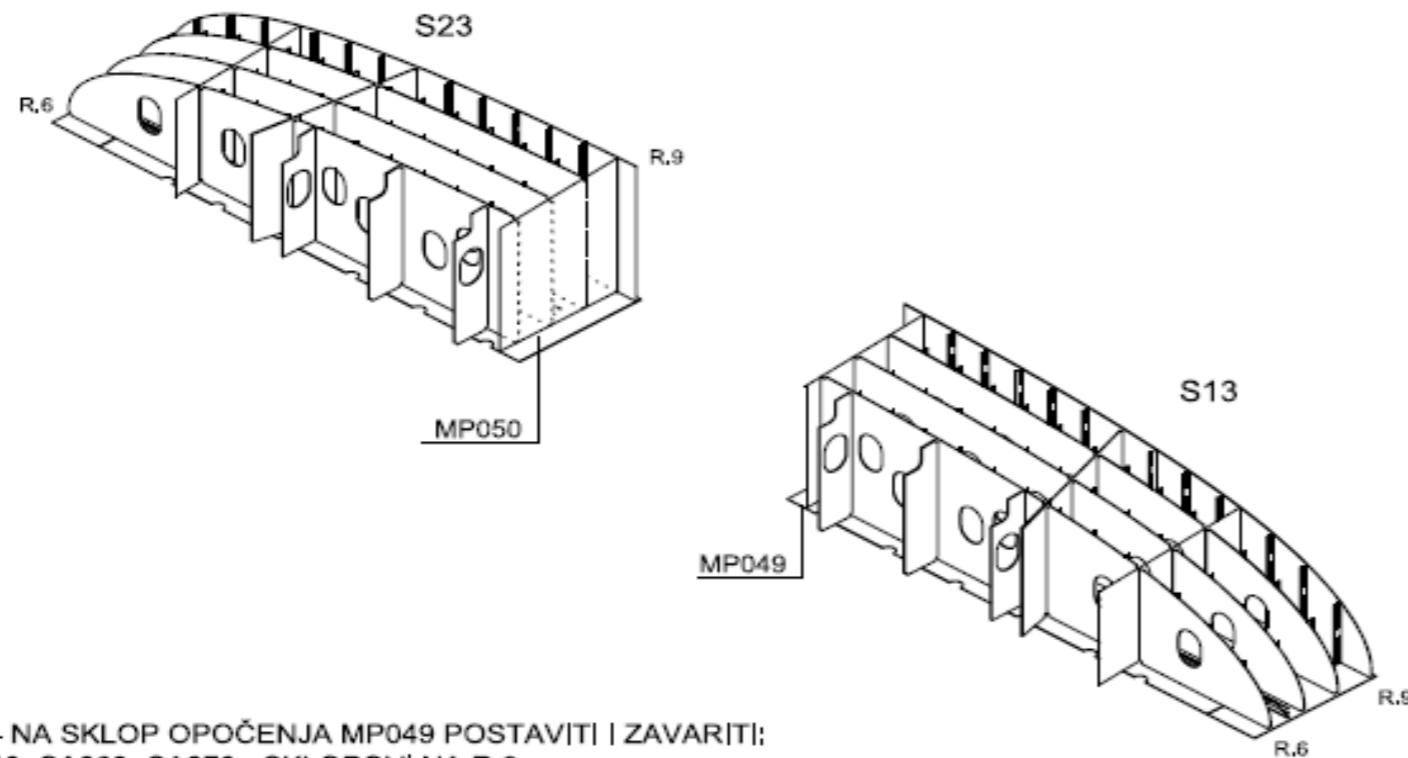
PLOČICA, 2 KOM.  
200x100x50

## 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

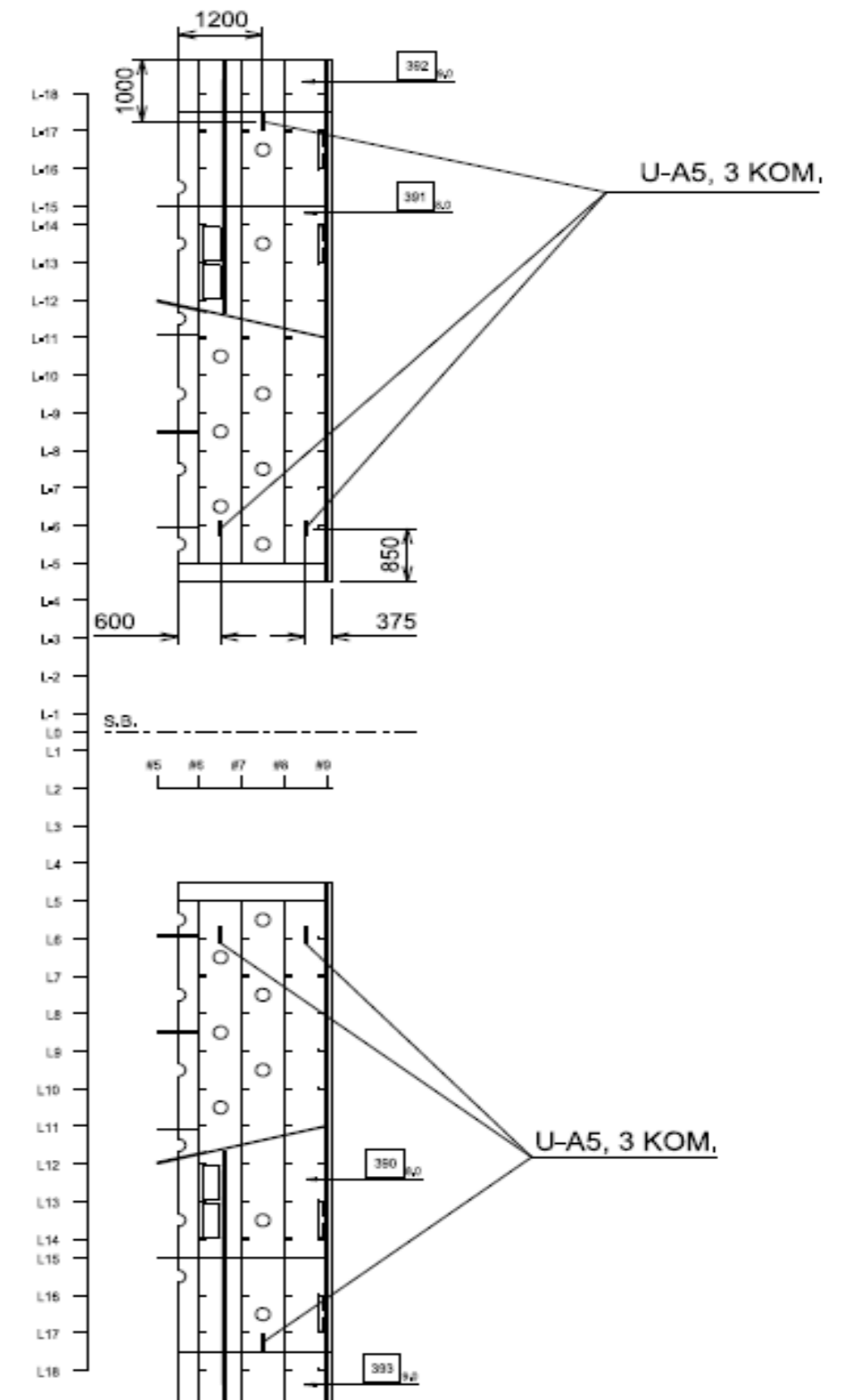
CR014 - SKLOP NA R.9

MP051 - SKLOP UZDUŽNE PREGRADE

R.M.389, PRESJEK NA 2700mm OD S.B.

R.M.387, PRESJEK NA 8400mm OD S.B.

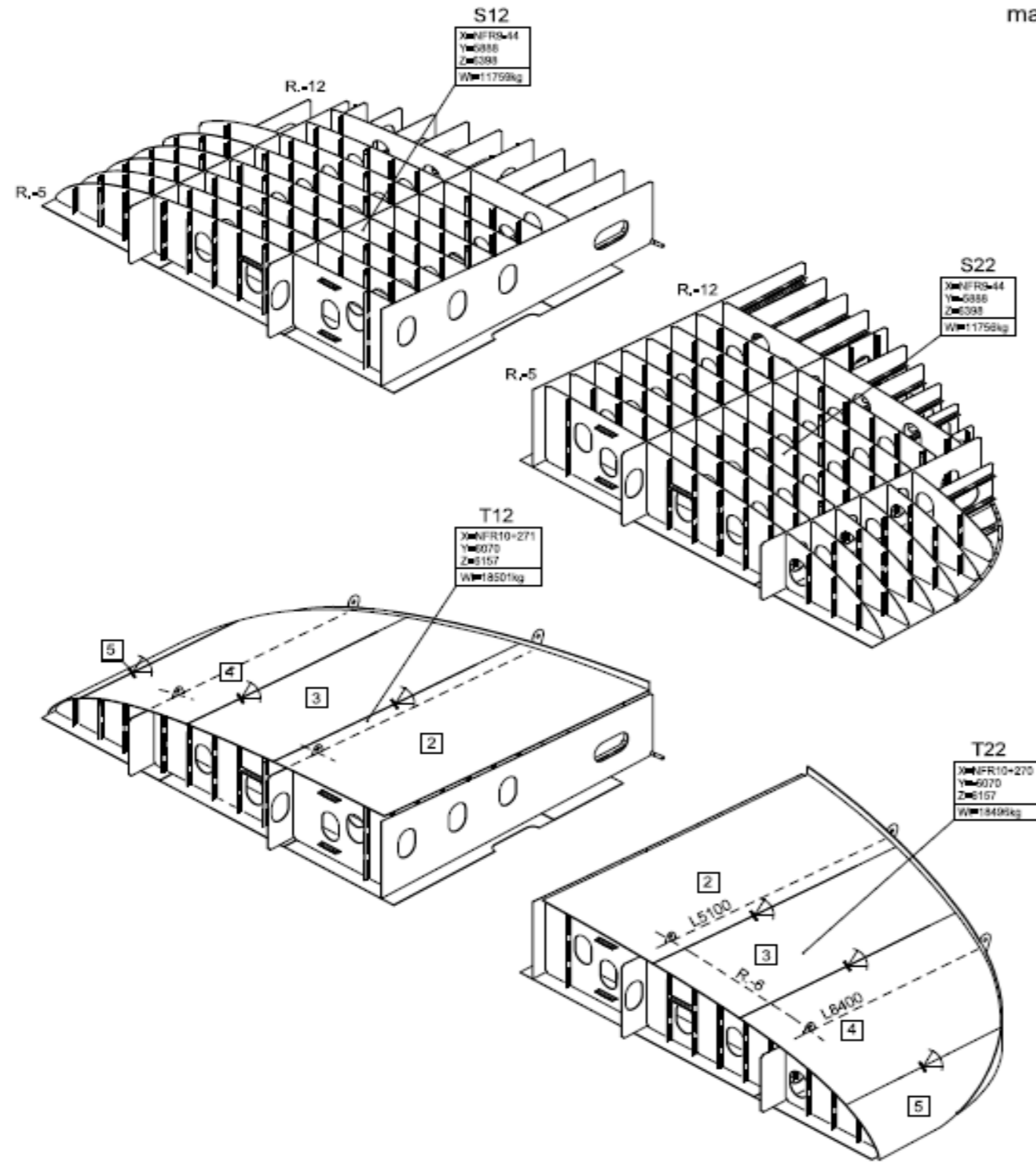
### UŠKE ZA TRANSPORT I MONTAŽU U VT01



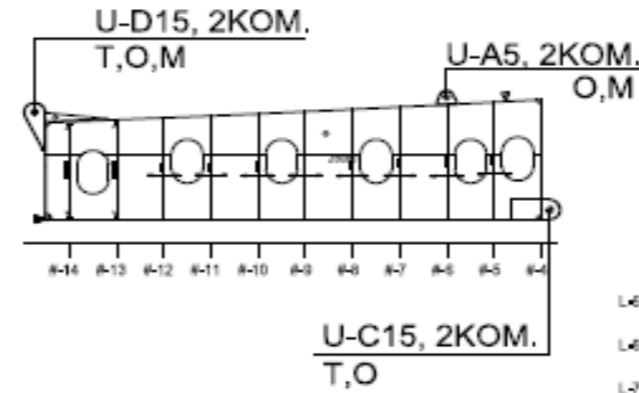
## FAZA II

### IZRADA SEKCIJE T12, T22

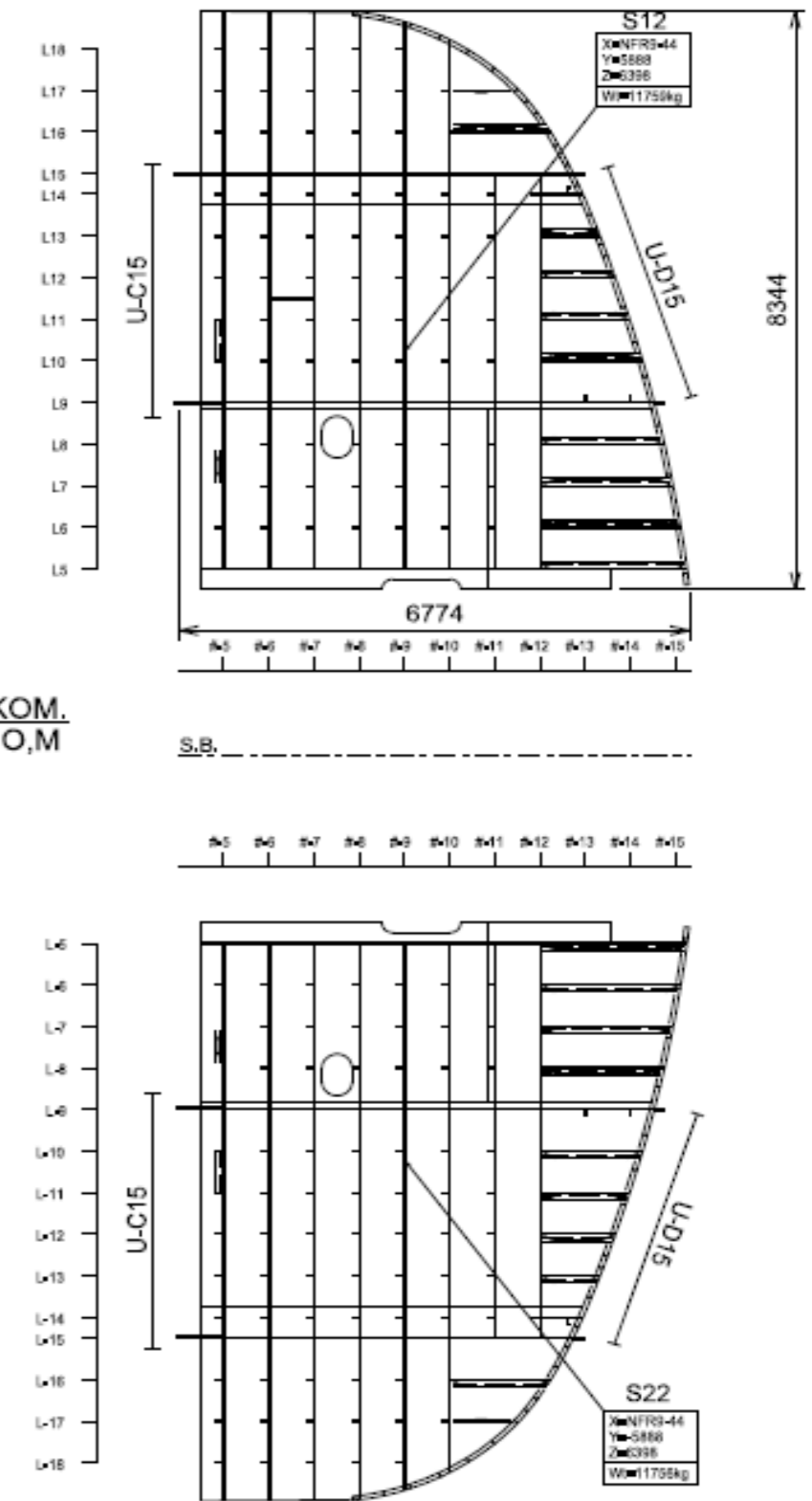
masa sekcije, T12=18,5t  
masa sekcije, T22=18,5t



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



### UŠKE ZA TRANSPORT, OKRETANJE I MONTAŽU SEKCIJE T12, T22

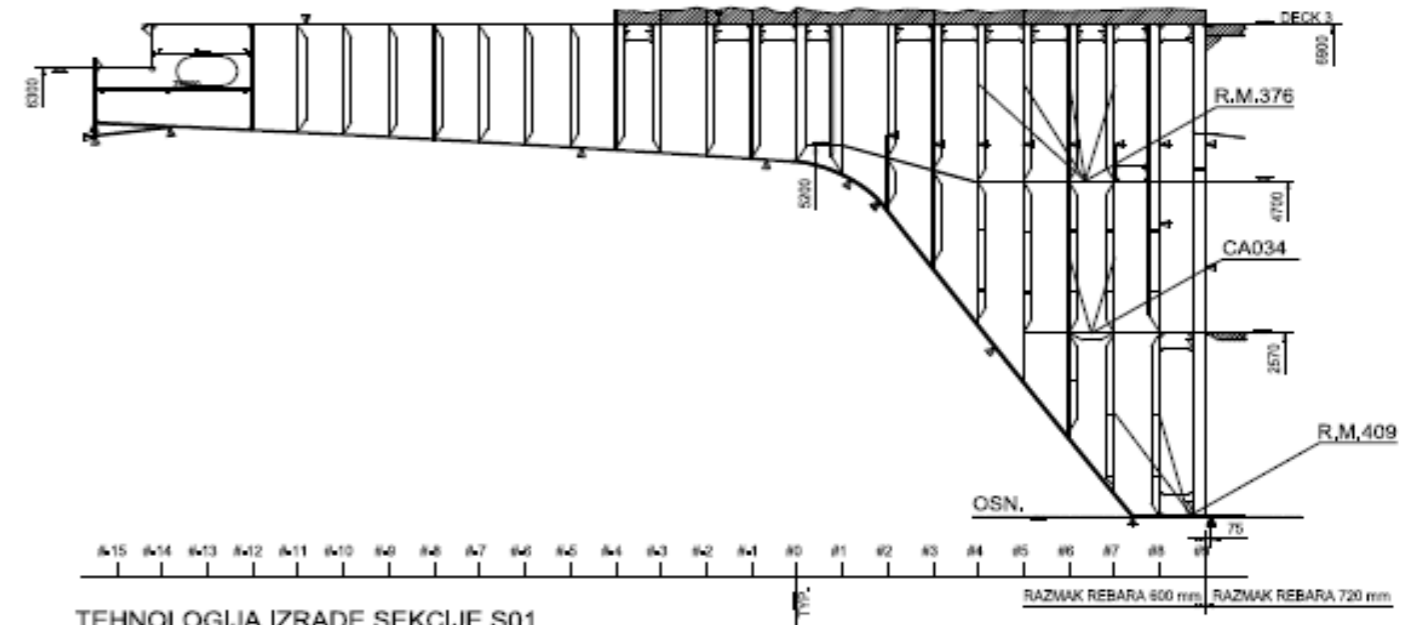
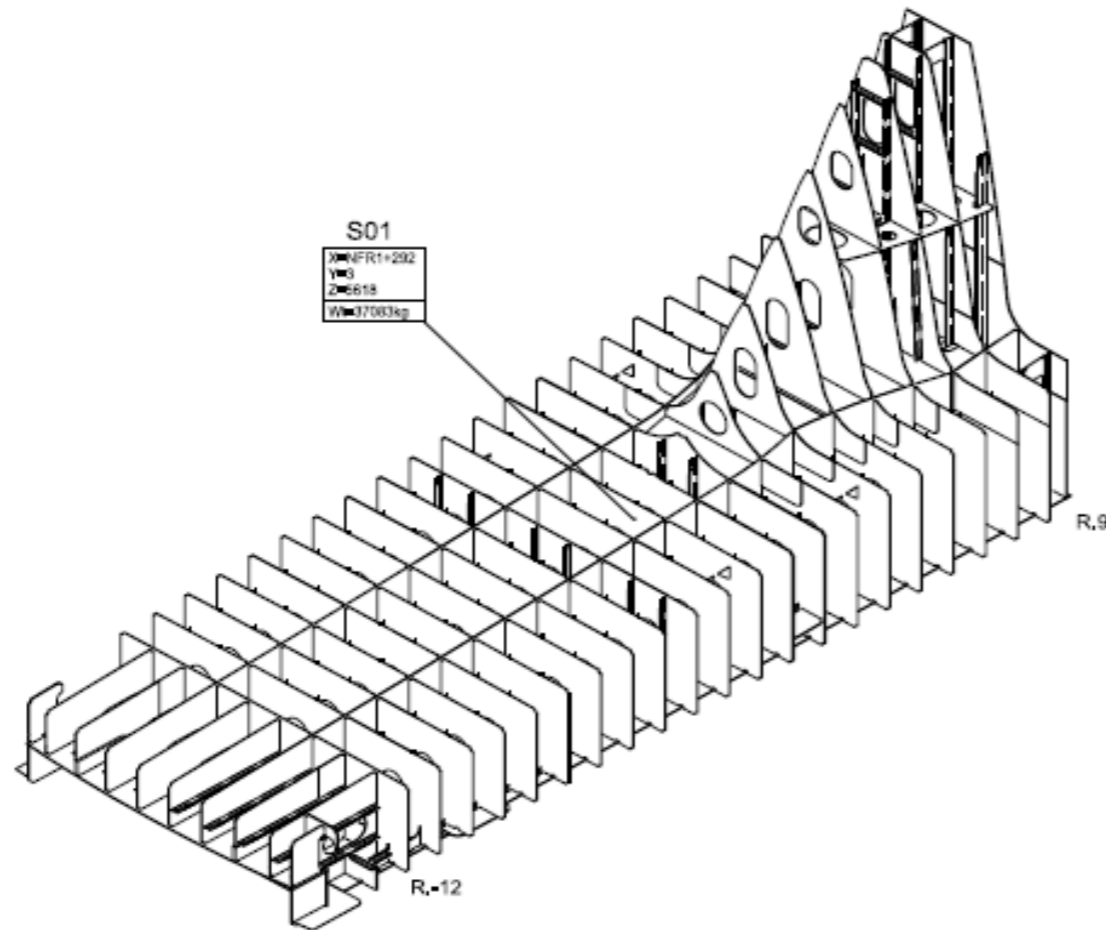


# FAZA I

## 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

