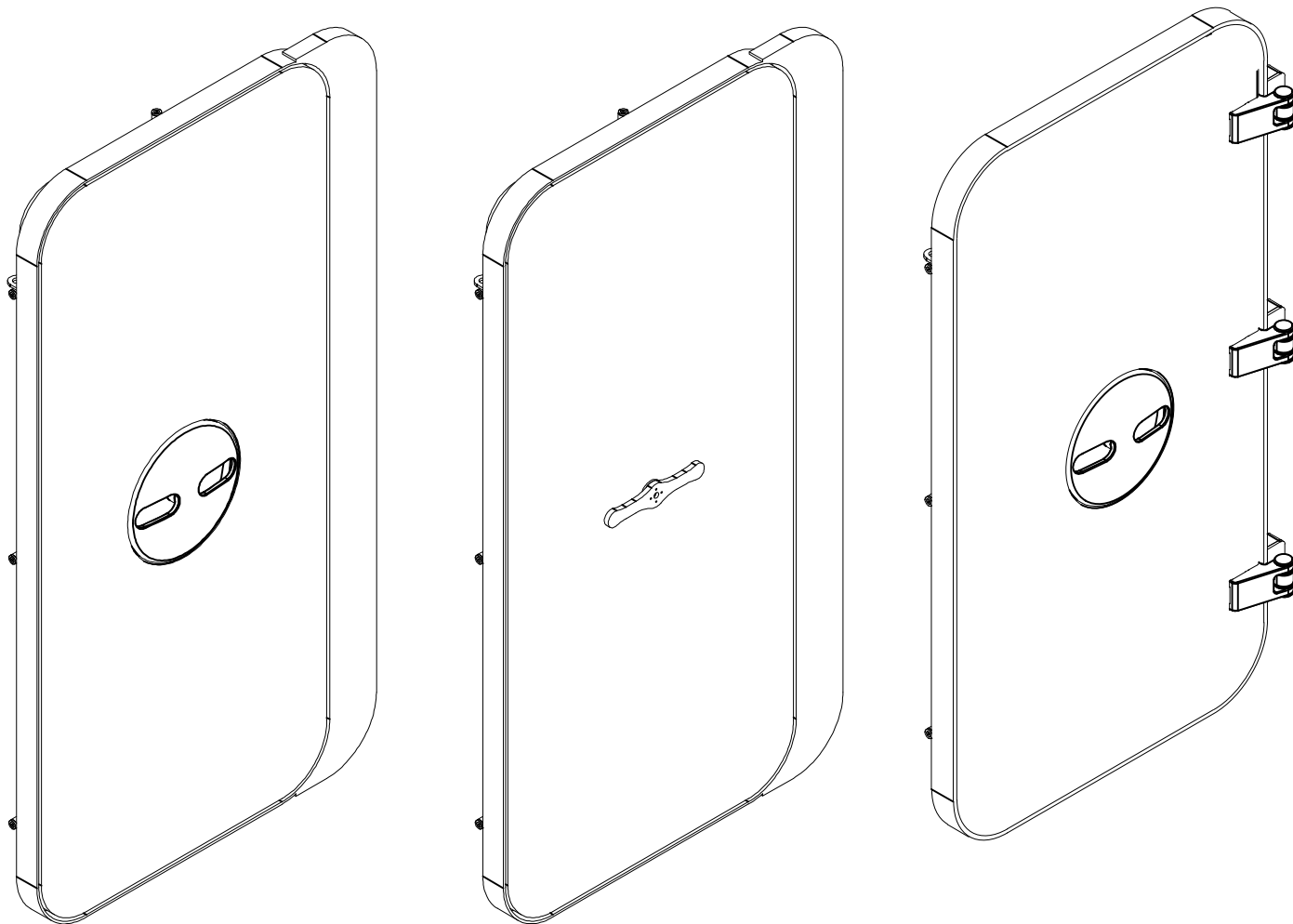


Flush door, welding insertion procedure

De Vor Metaalbewerking B.V.



 DE VOR DOORS AND HATCHES	De Vor Metaalbewerking B.V. Handelsweg 5 3481MJ Harmelen	Document name: Flush deur inlasprocedure
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Watertight Flush Door

Welding Insertion Procedure

Introduction

This user manual has been prepared with the purpose to have the various doors inserted into the ship's structure in the correct way.

In this manual we describe the various steps of the procedure, the sequence of these steps to be taken and what tolerances are acceptable.

This manual is intended for technical operational or preparatory staff. It is expected that these employees have a basic knowledge of how to read technical drawings.

In order to reach a good end result, the area (plate field) in which the doors will be placed needs to be free of tension. This implicates that no horizontal or vertical strips are welded along the plate cut in order to stretch the area.

Various types of doors

This manual can be used for all kinds of flush doors of De Vor Metaalbewerking. The doors can be opened in a vertical way and can be made of aluminium, steel or stainless steel. Please check the front page for the different types.

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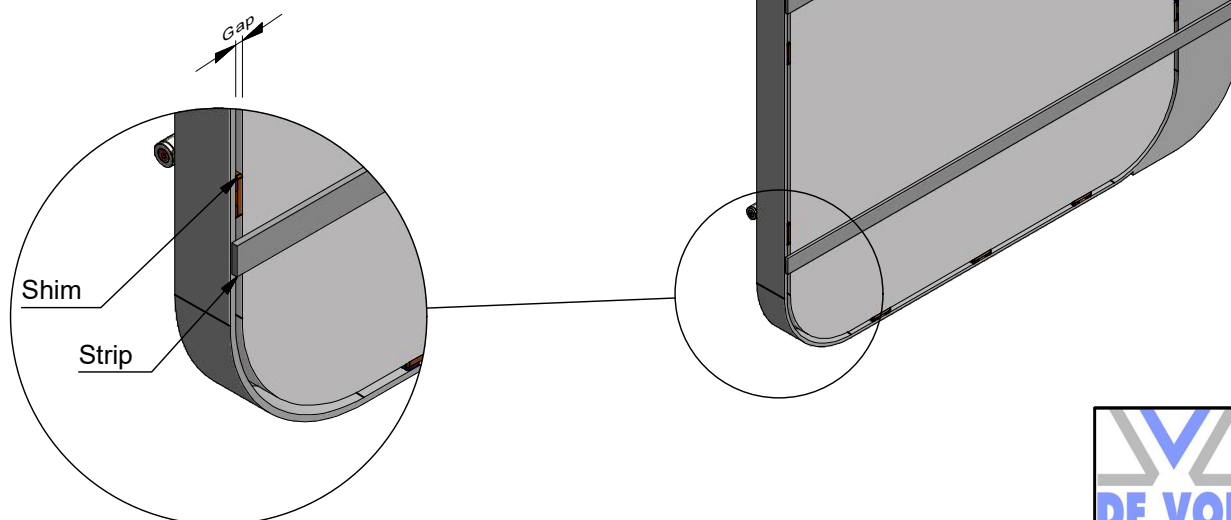
In the case of any conflict between the content of this manual and the regulations of the classification provider, the latter shall prevail.

Excluded from the scope of this manual:

- The extent to which the area in which the door is placed is straight /aligned
- The welding procedure specifications, the quality and the finishing of the welds.
- Safety instructions
- Required (measuring) tools

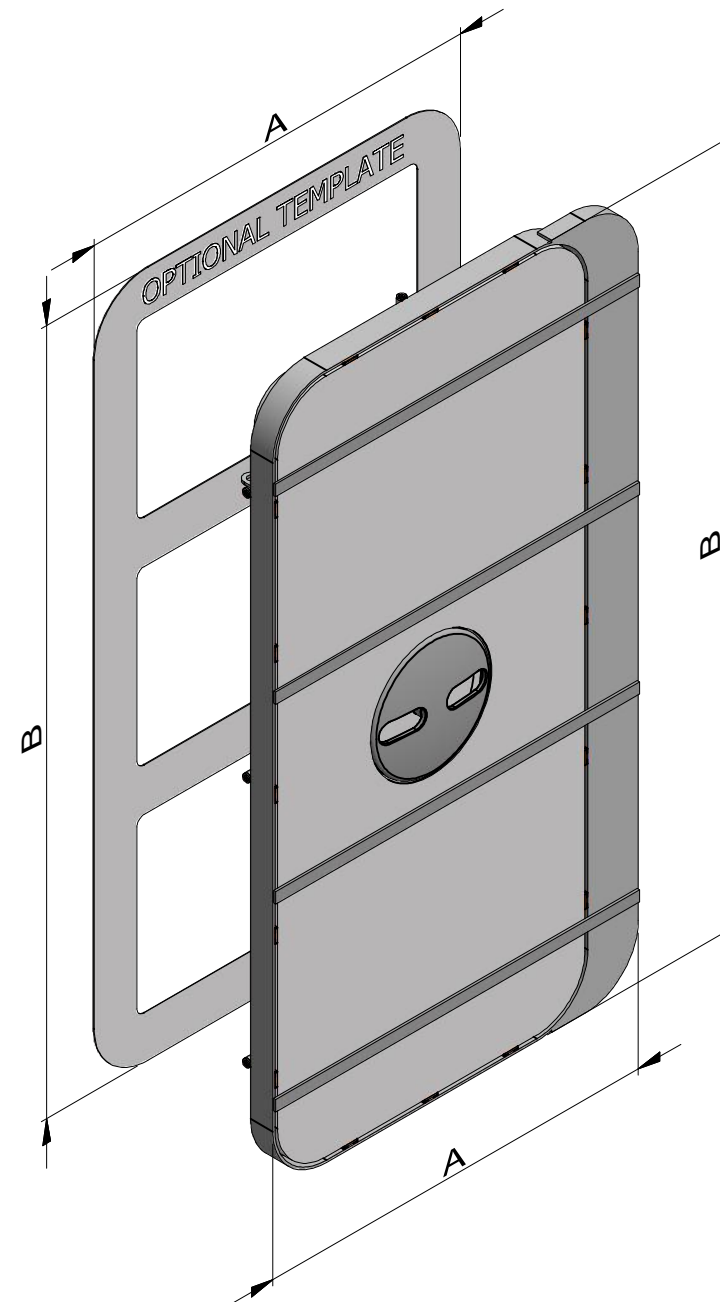
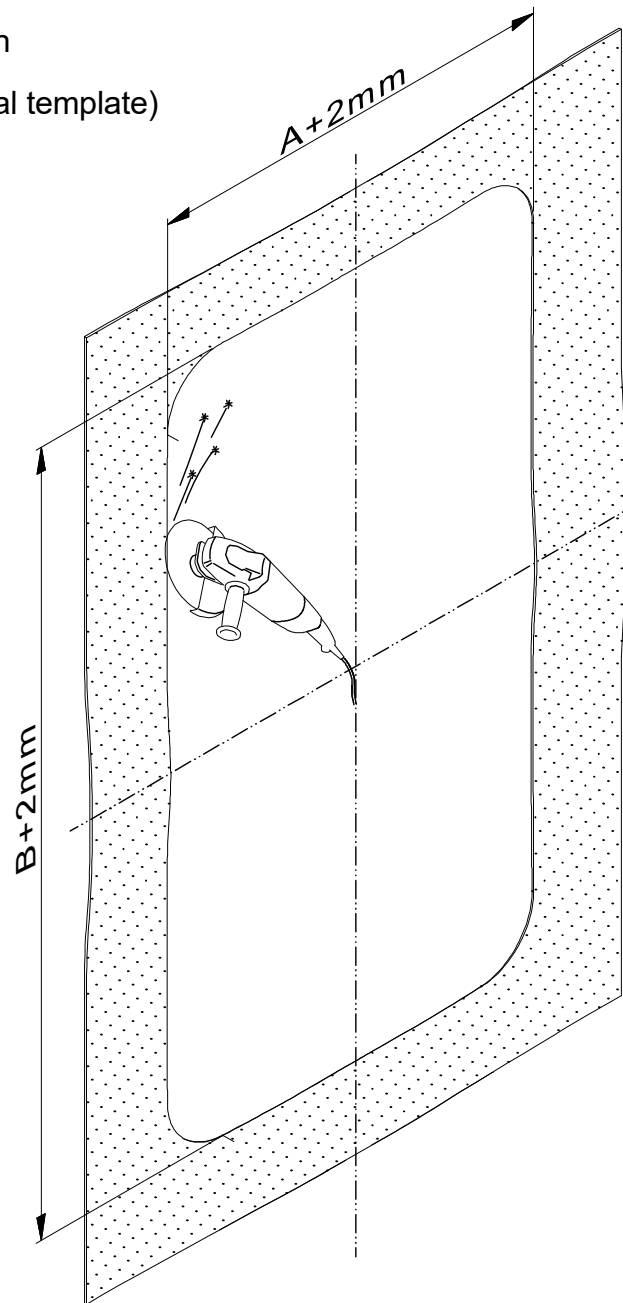
CHECKLIST

- ☐ Undamaged package (frame and door assembly)
- ☐ Strips are present
- ☐ Shims are present



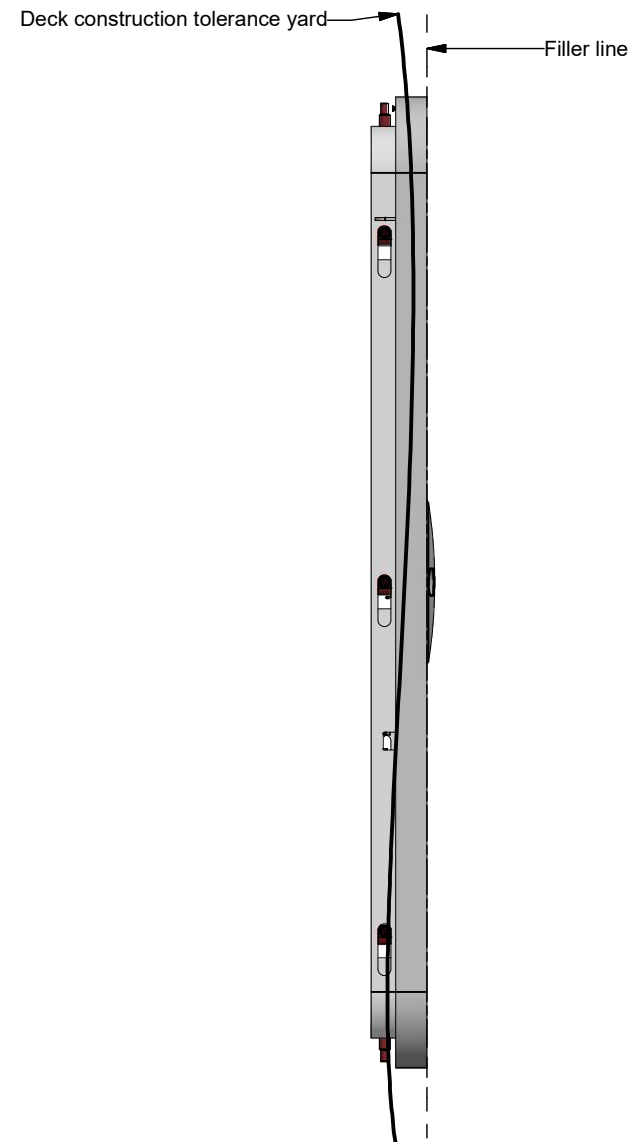
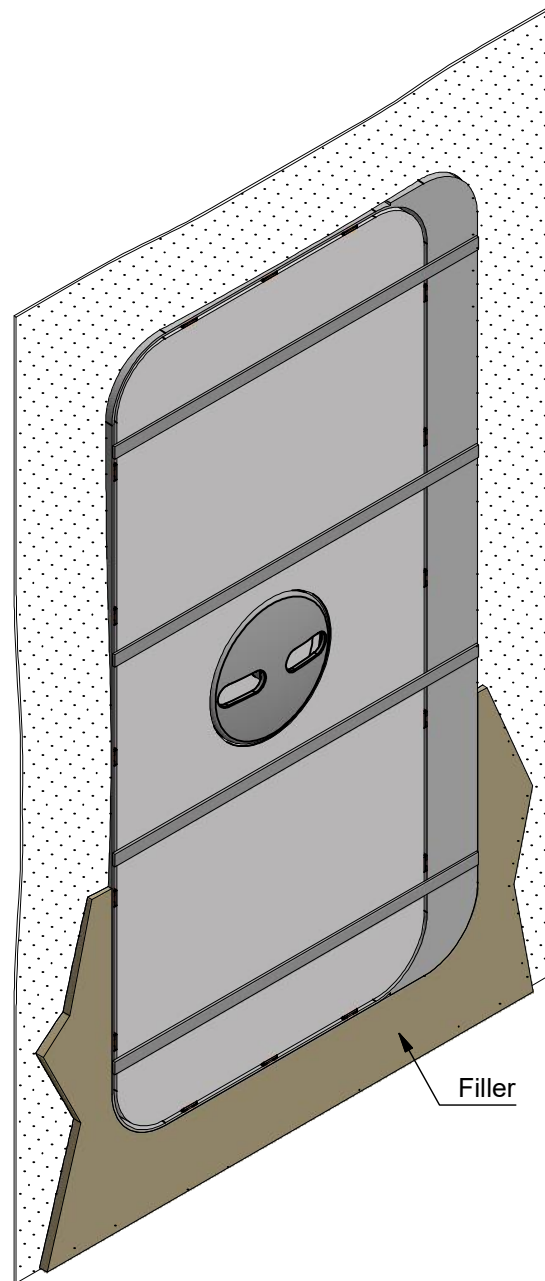
CHECKLIST

- ☐ Determine plate cut position
- ☐ Mark contour (using optional template)
- ☐ Make plate cut



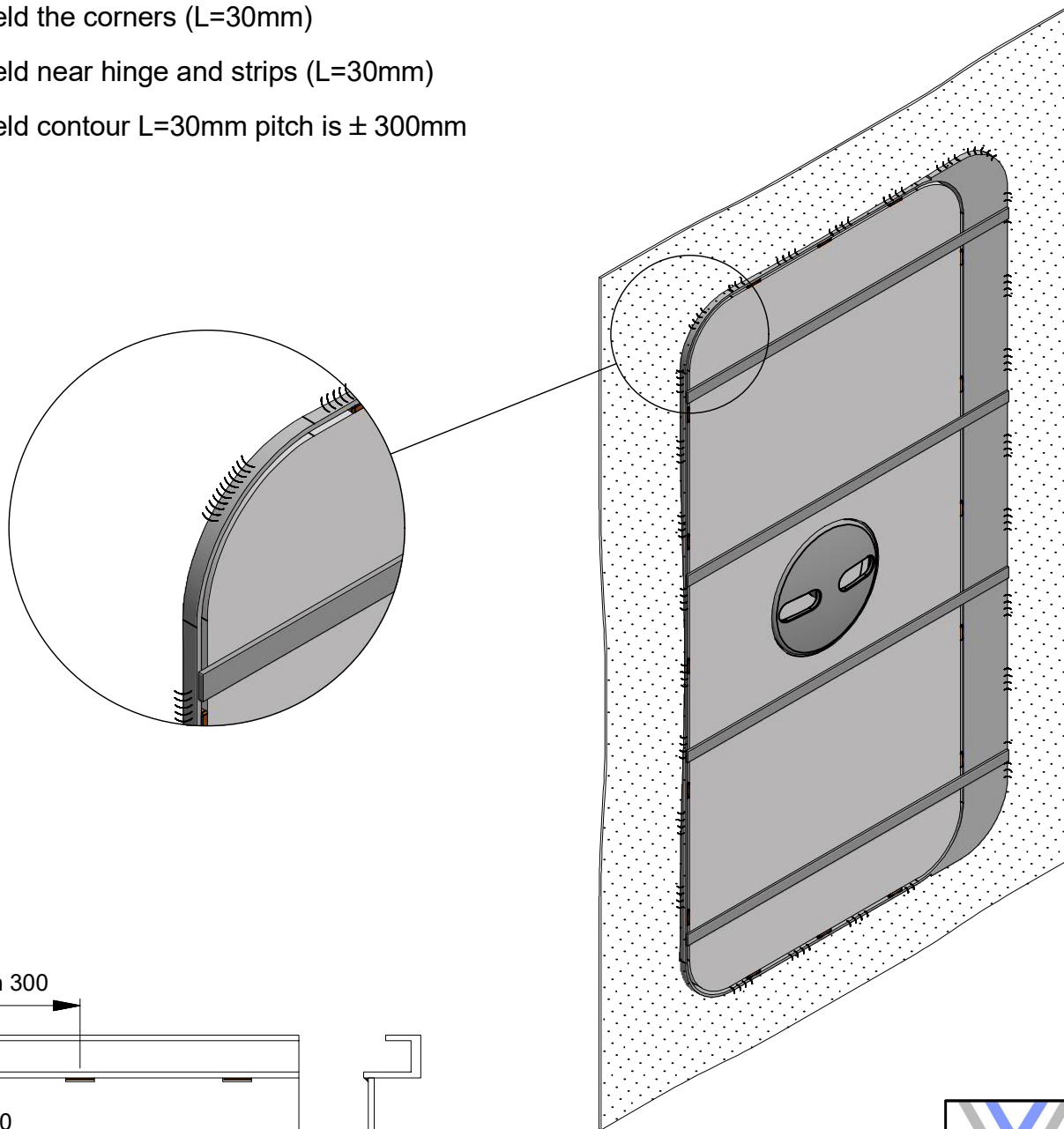
CHECKLIST

- ☐ Place package in plate cut
- ☐ Door is flush with filler line



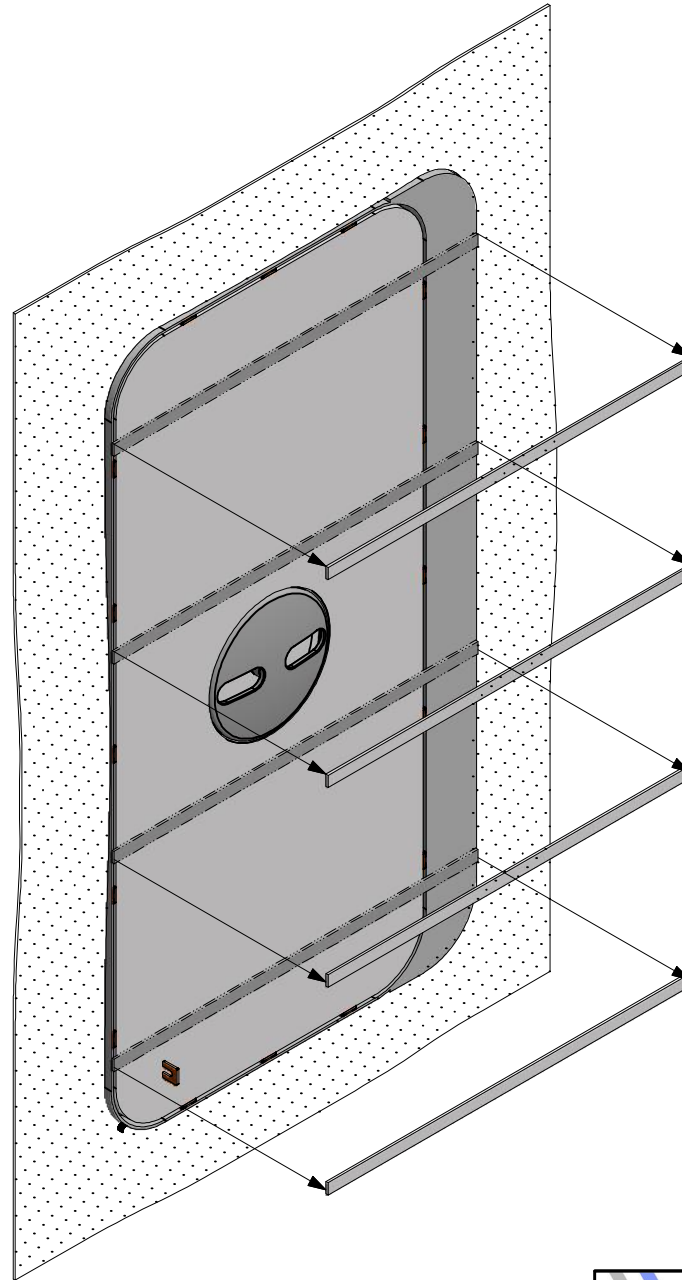
CHECKLIST

- ☐ 1. Tack weld the corners (L=30mm)
- ☐ 2. Tack weld near hinge and strips (L=30mm)
- ☐ 3. Tack weld contour L=30mm pitch is ± 300 mm



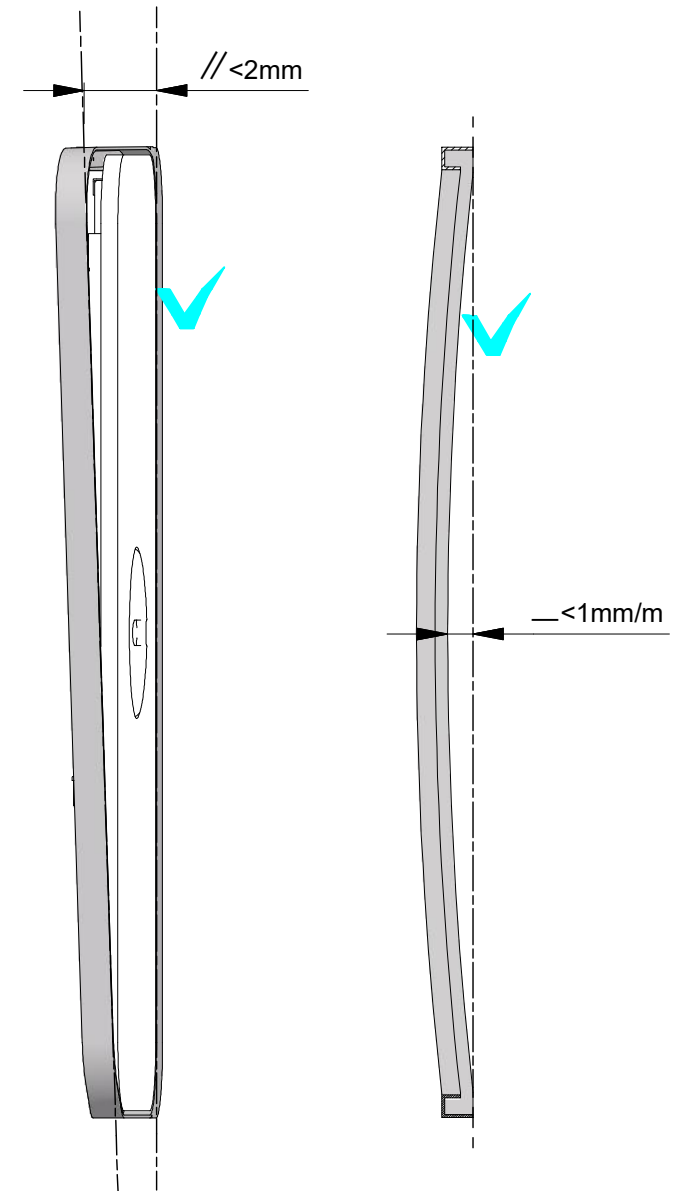
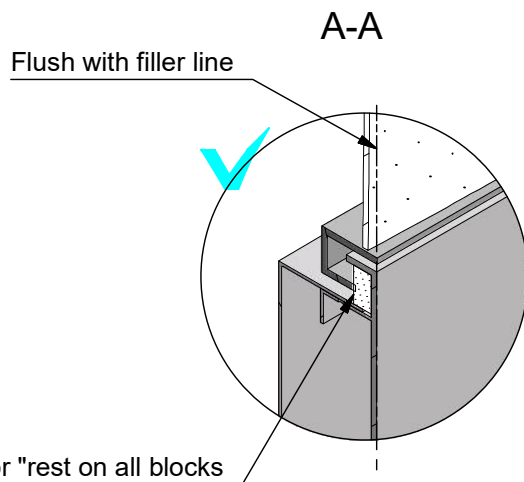
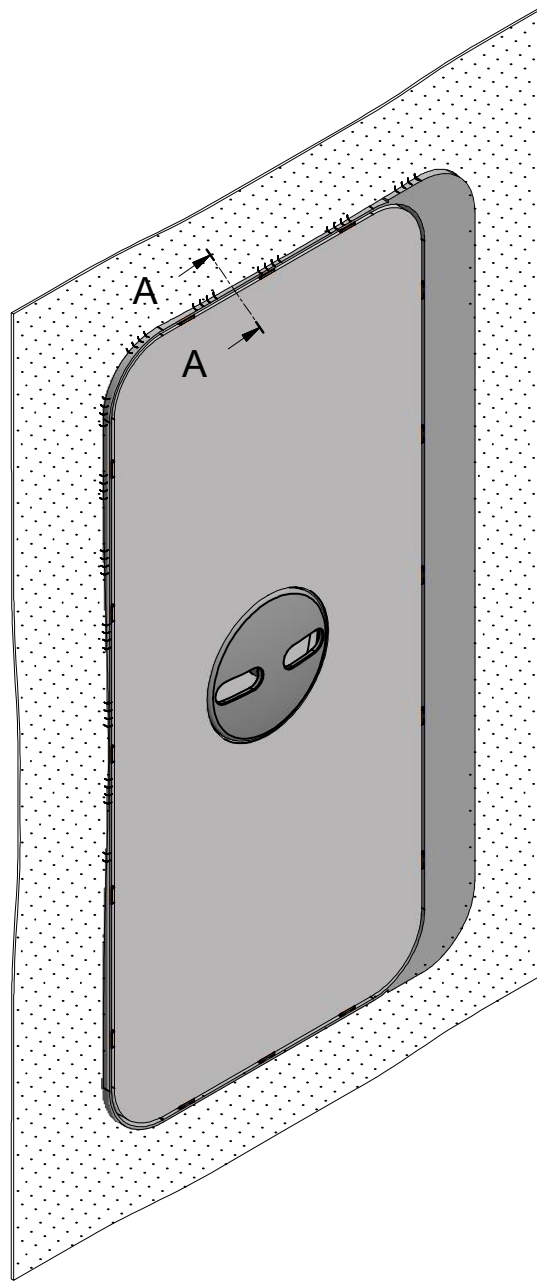
CHECKLIST

- ☐ Remove strips
- ☐ Remove shims



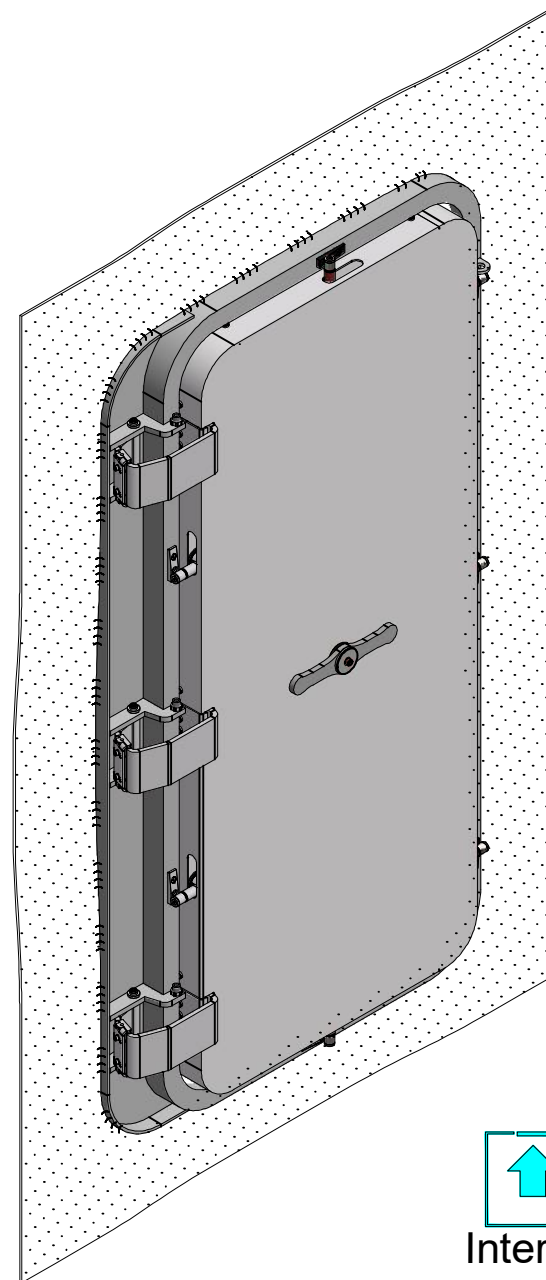
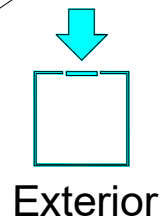
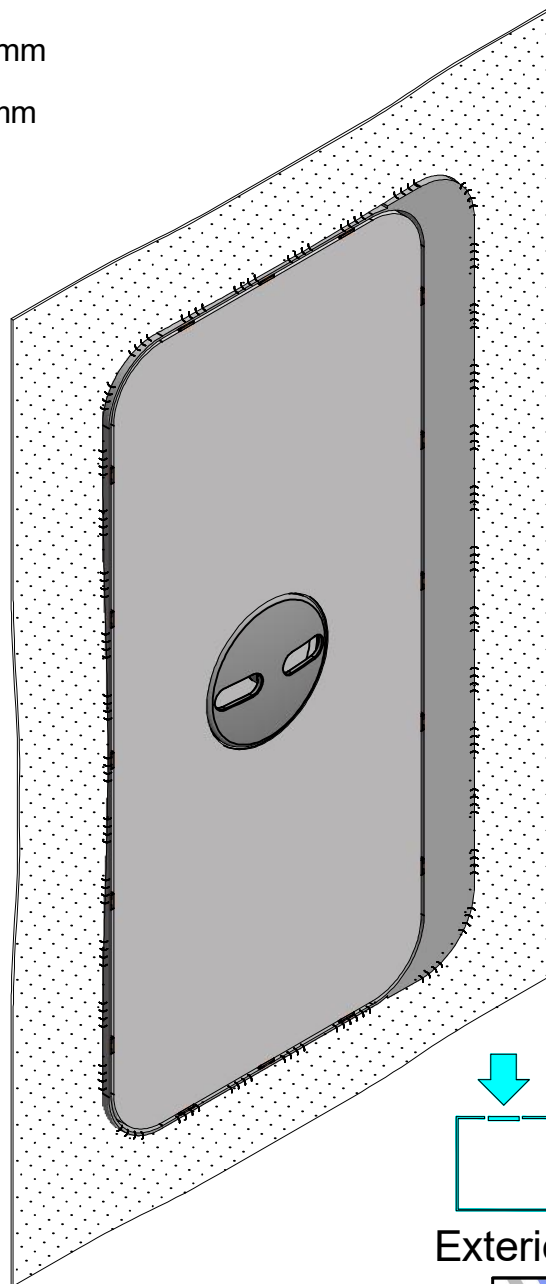
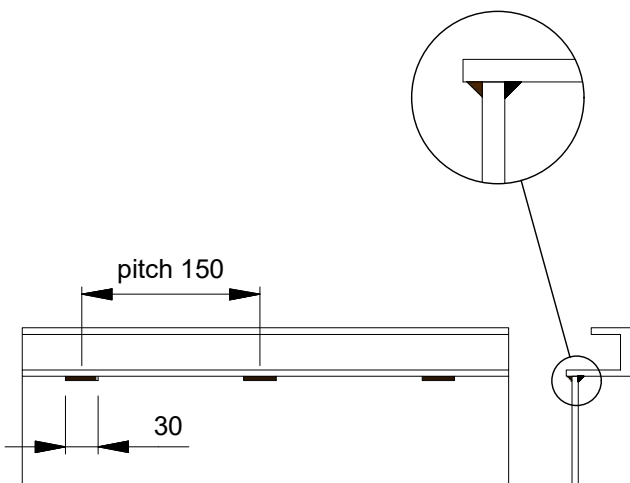
CHECKLIST

- ☐ Frame is placed parallel ($// \leq 2 \text{ mm}$)
- ☐ Door is flush with filler line
- ☐ Frame is straight ($\text{—} \leq 1 \text{ mm/m}$)
- ☐ Door makes contact with all blocks



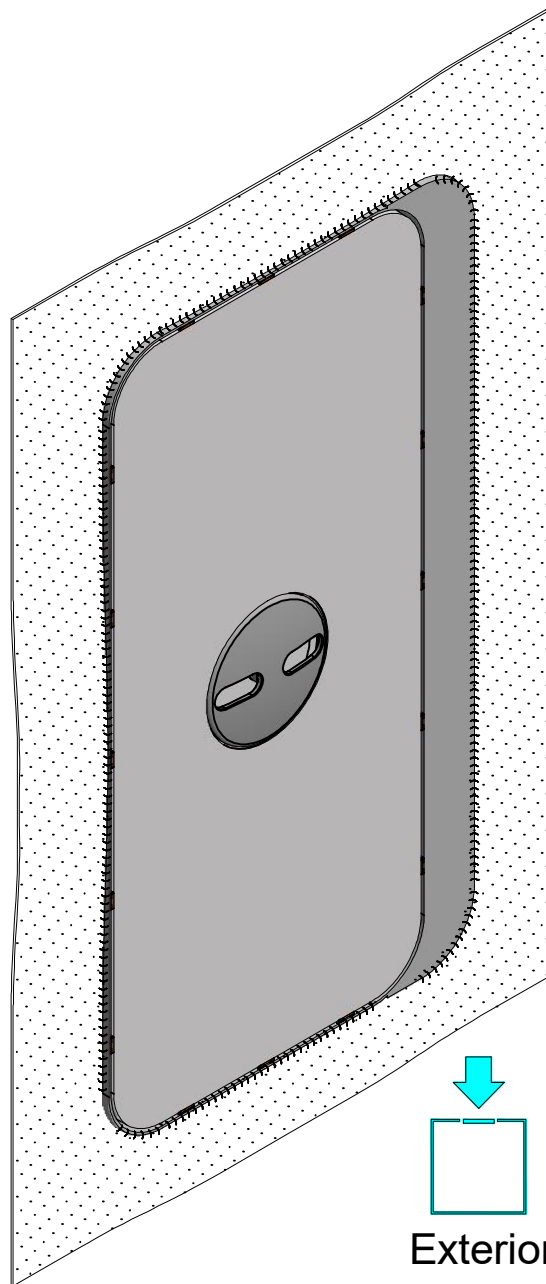
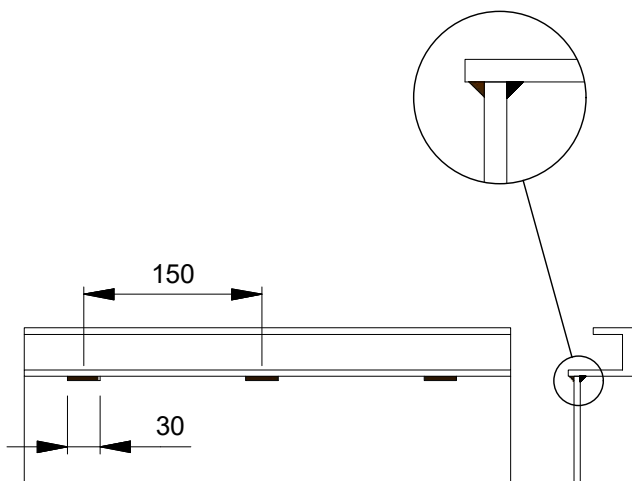
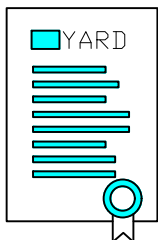
CHECKLIST

- ☐ Tack weld exterior contour L=30mm pitch is ± 150 mm
- ☐ Tack weld interior contour L=30mm pitch is ± 150 mm

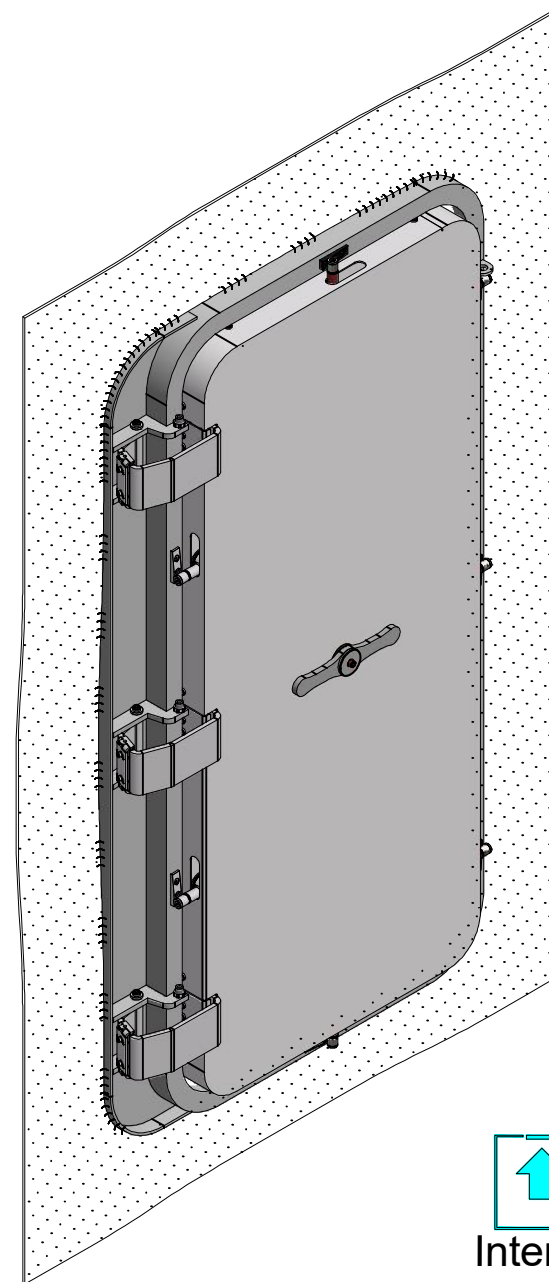


CHECKLIST

- ☐ 1. Weld parameters are according to yard specification
- ☐ 2. Fully weld corners
- ☐ 3. Weld crosswise between tack welds to minimize deformation
- ☐ 4. Interior side completely welded or tack welded according to yard specification



Exterior



Interior



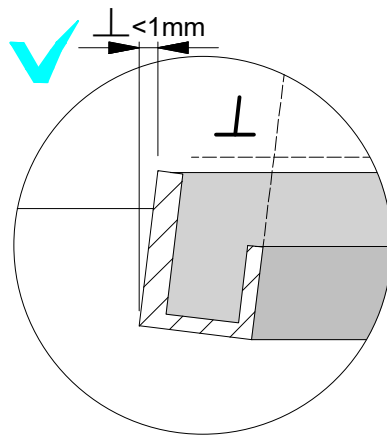
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Flush door, welding
insertion procedure

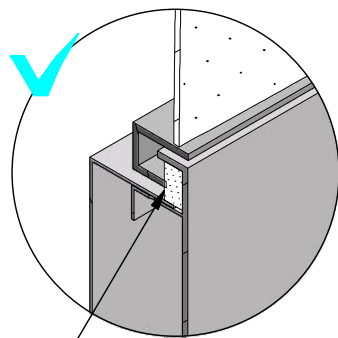
Sheet 9 of 10

CHECKLIST

- ☐ Frame is placed parallel ($// \leq 2 \text{ mm}$)
- ☐ Door is flush with filler line
- ☐ Frame is straight ($\text{—} \leq 1 \text{ mm/m}$)
- ☐ Door makes contact with all blocks
- ☐ (Weld) finish quality according to yard specifications



A-A



Door makes contact with all blocks

