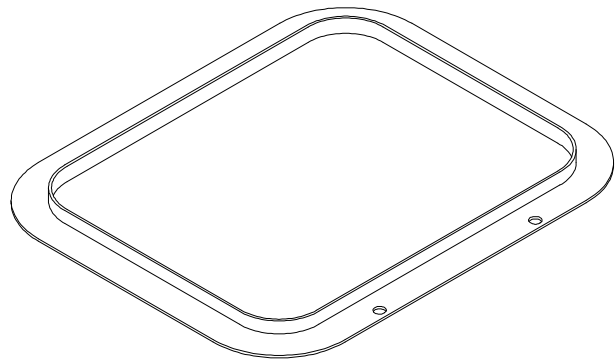
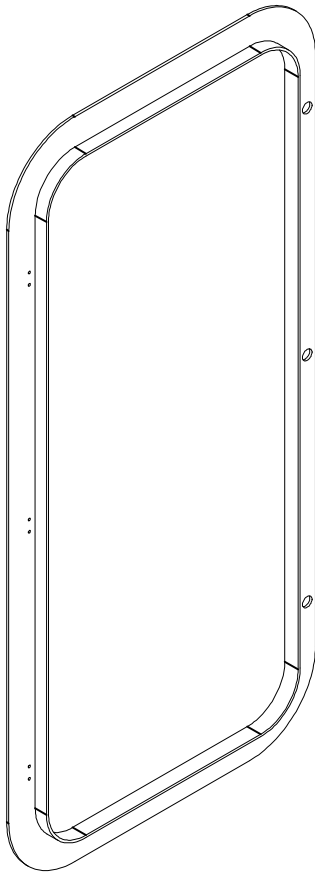


Rebated door, welding insertion procedure

De Vor Metaalbewerking B.V.



 DE VOR DOORS AND HATCHES	De Vor Metaalbewerking B.V. Handelsweg 5 3481MJ Harmelen	Document name: Opdek inlasprocedure
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Watertight Rebated 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 door 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 rebated doors of De Vor Metaalbewerking. The doors can be opened in a horizontal way (hatch) or a vertical way (door) 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.

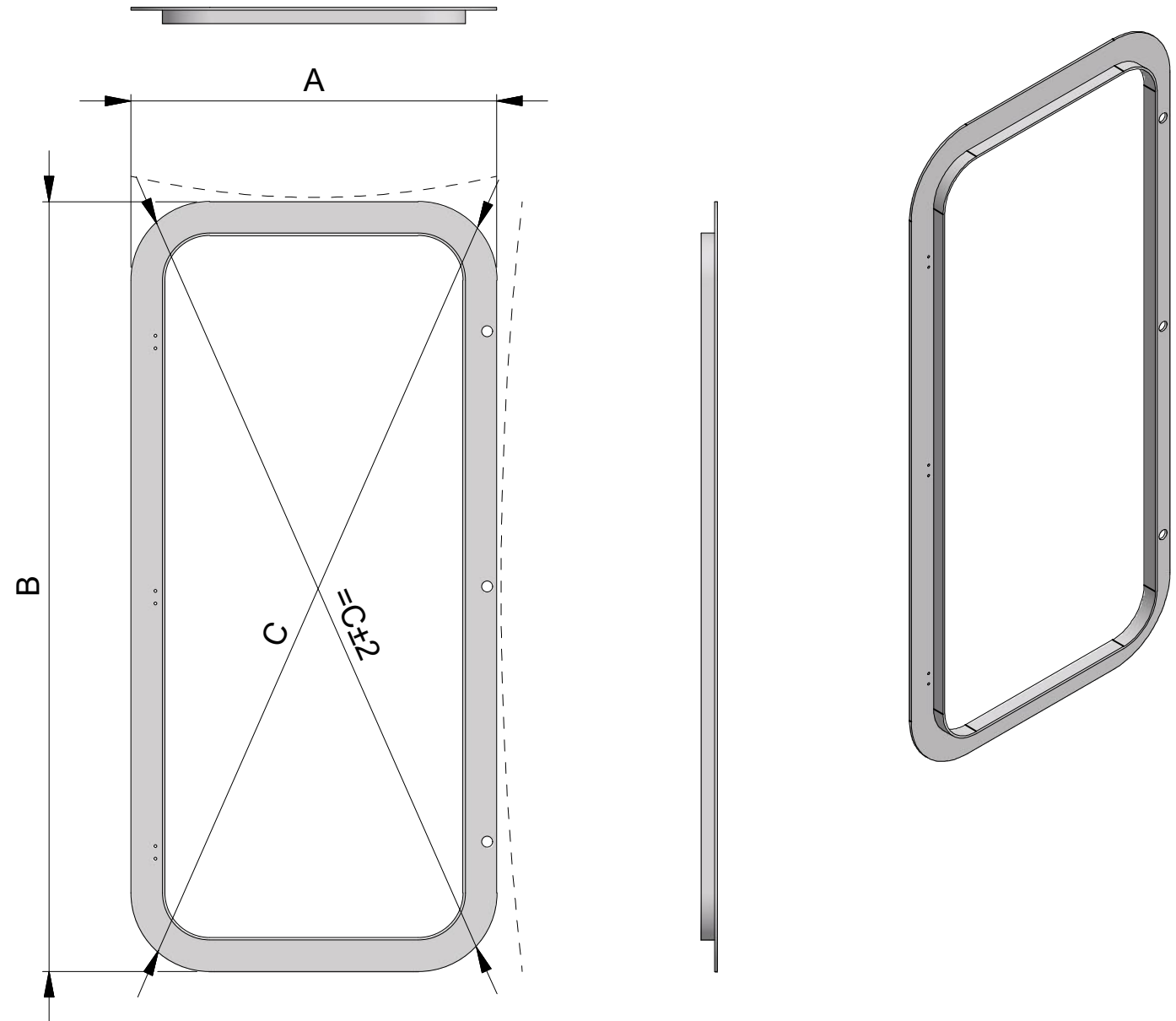
Excluded from the scope of this manual:

- 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

More information about these products are available on our website: www.devordoorsandhatches.nl

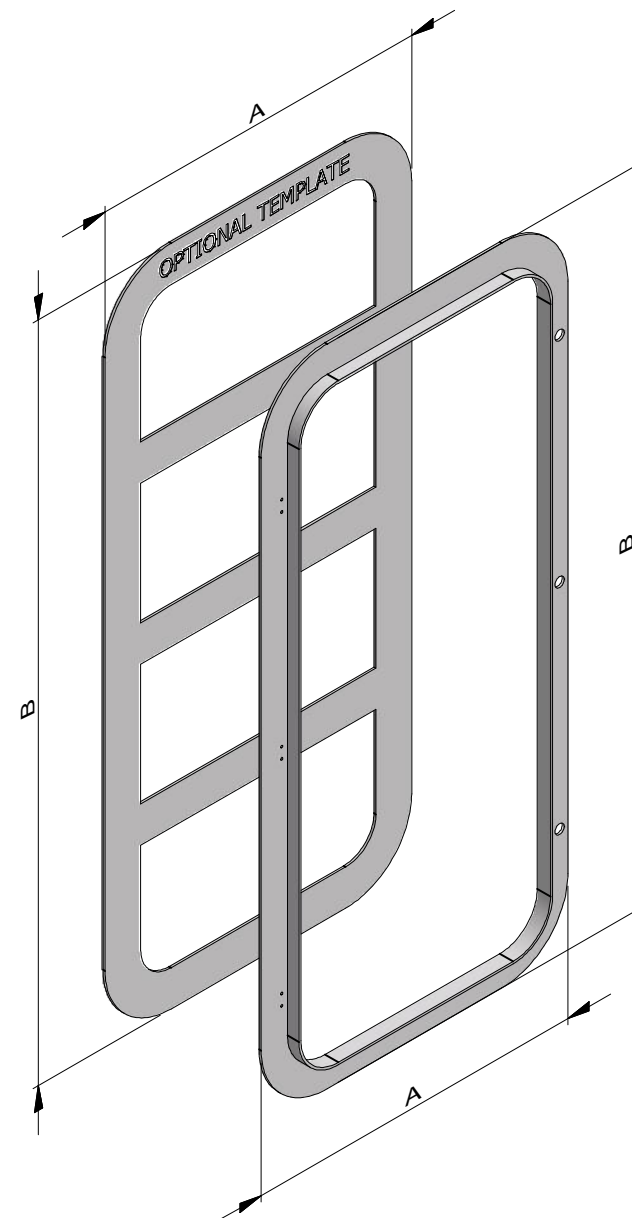
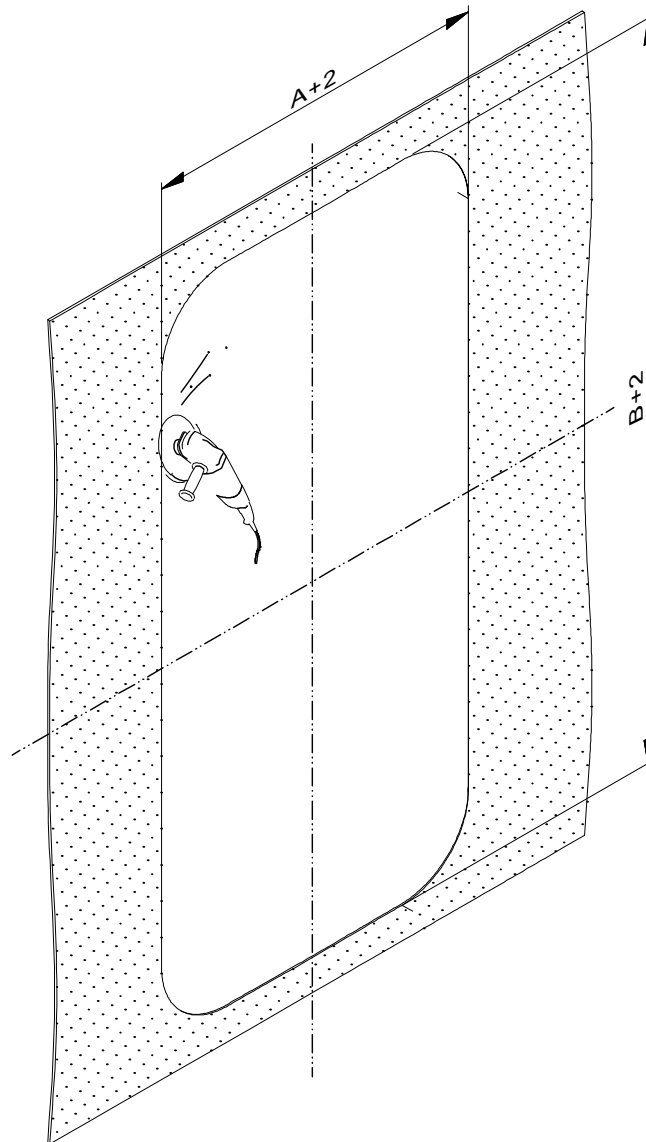
CHECKLIST

- ☐ Undamaged frame
- ☐ Parallelity A (< 2mm)
- ☐ Parallelity B (< 2mm)
- ☐ Perpendicularity C ($\pm 2\text{mm}$)



CHECKLIST

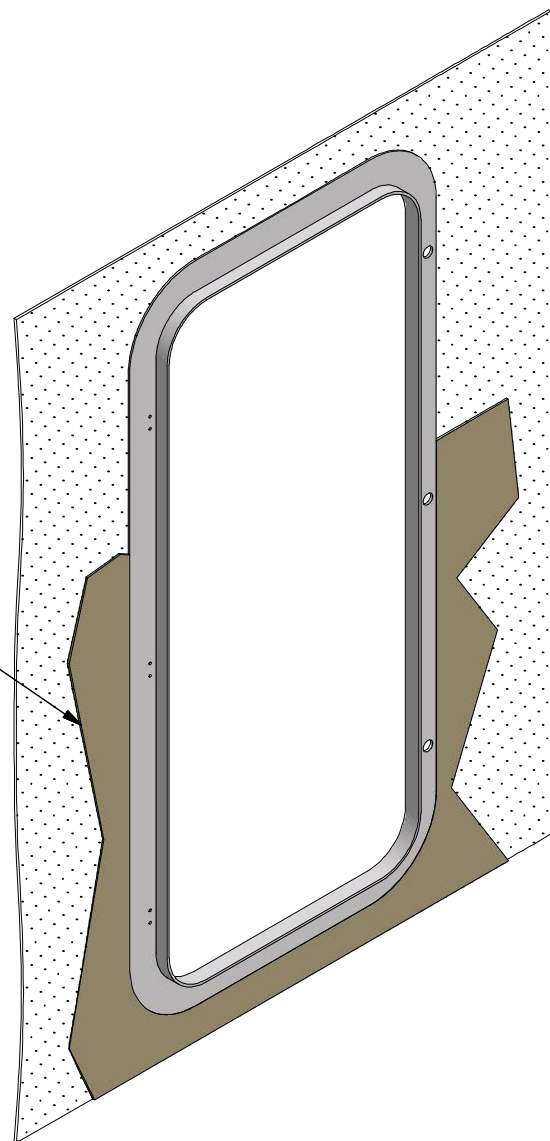
- ☐ Determine plate cut position
- ☐ Mark contour (using optional template)
- ☐ Make plate cut



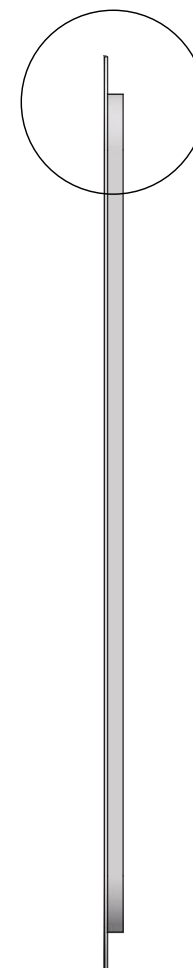
CHECKLIST

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

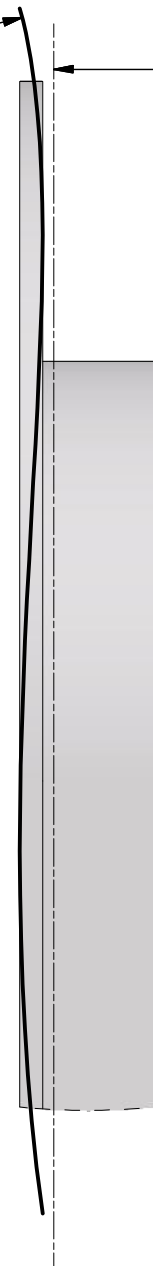
Filler



Deck construction tolerance yard

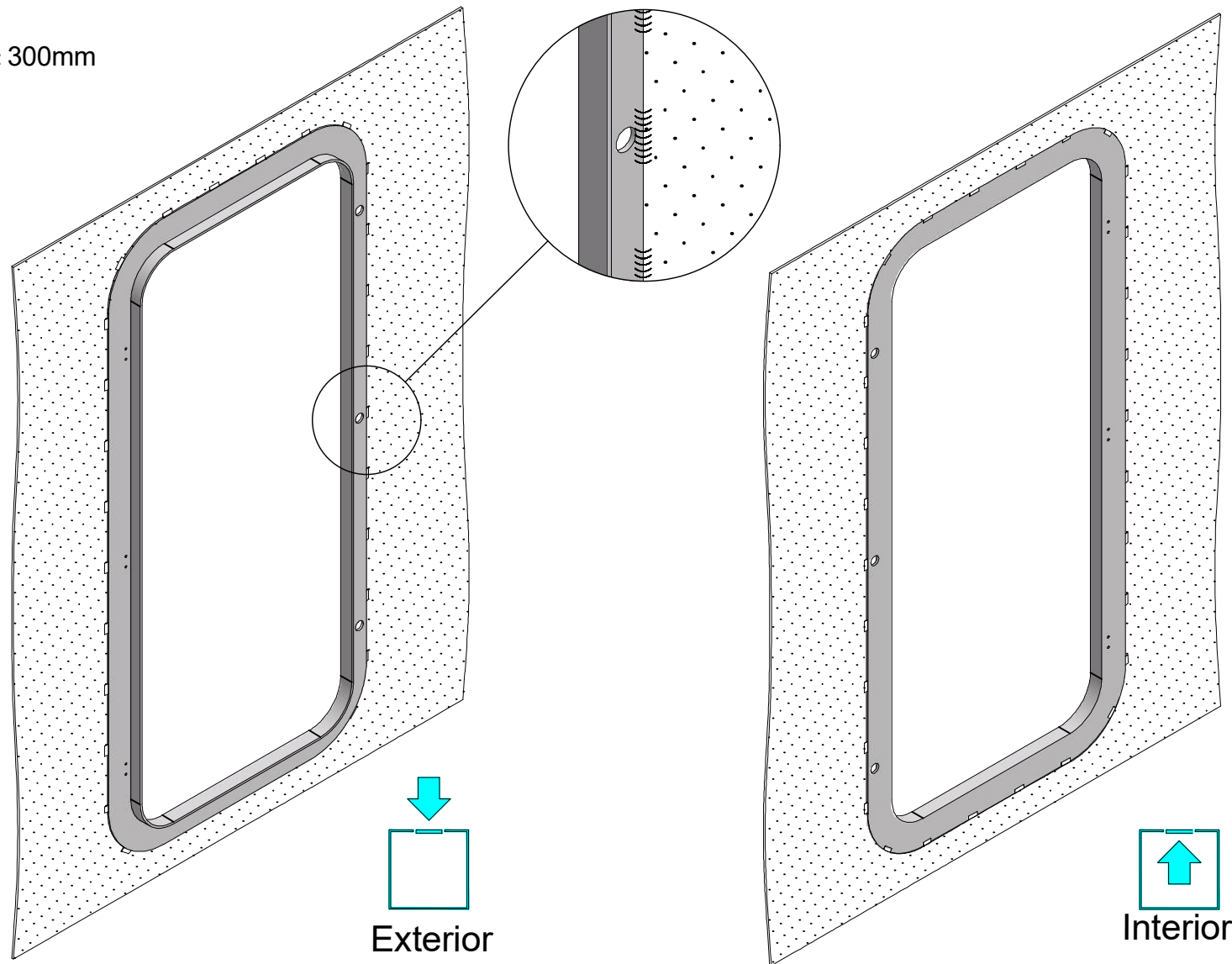
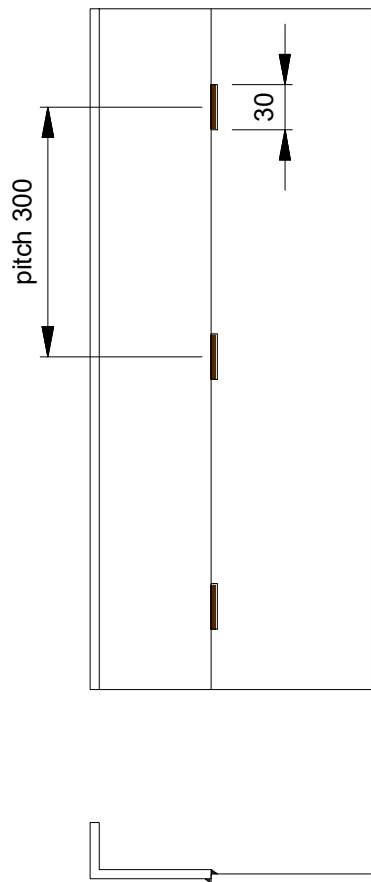


Filler line



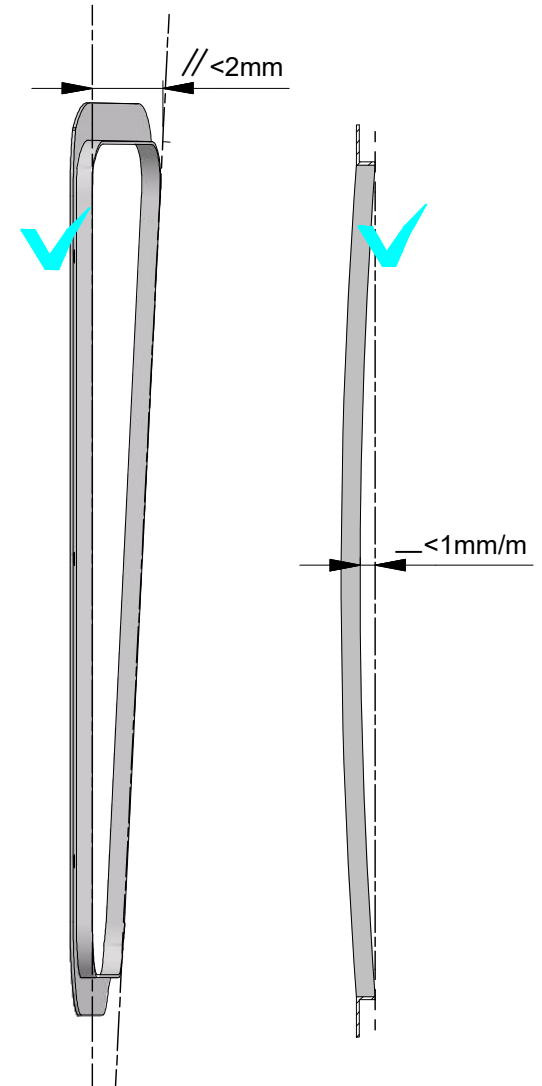
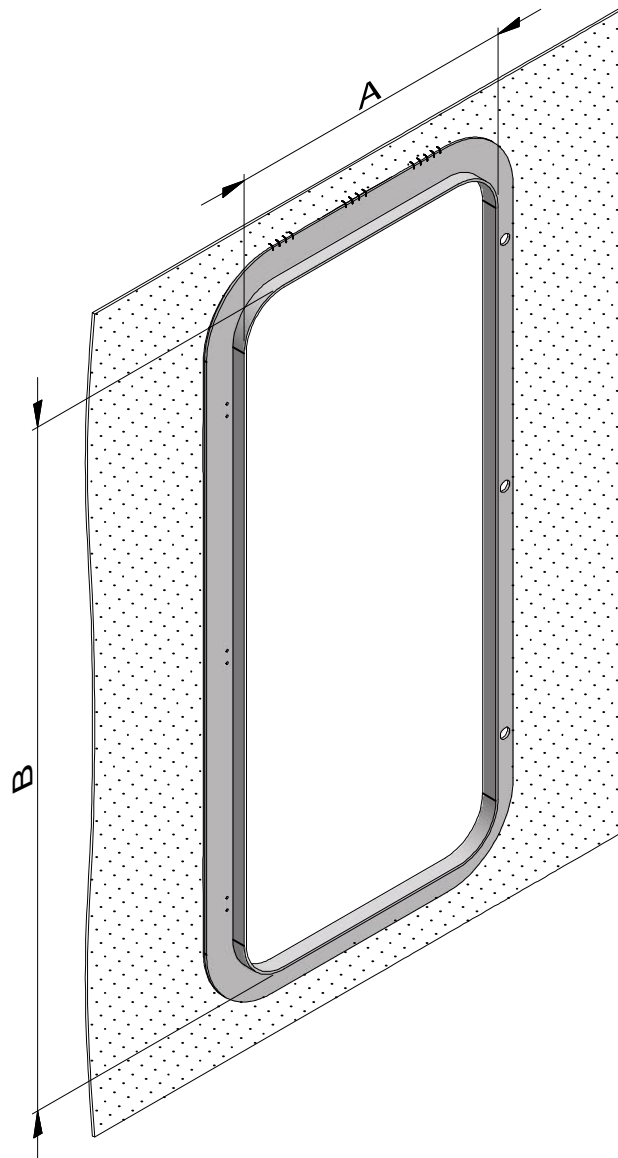
CHECKLIST

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



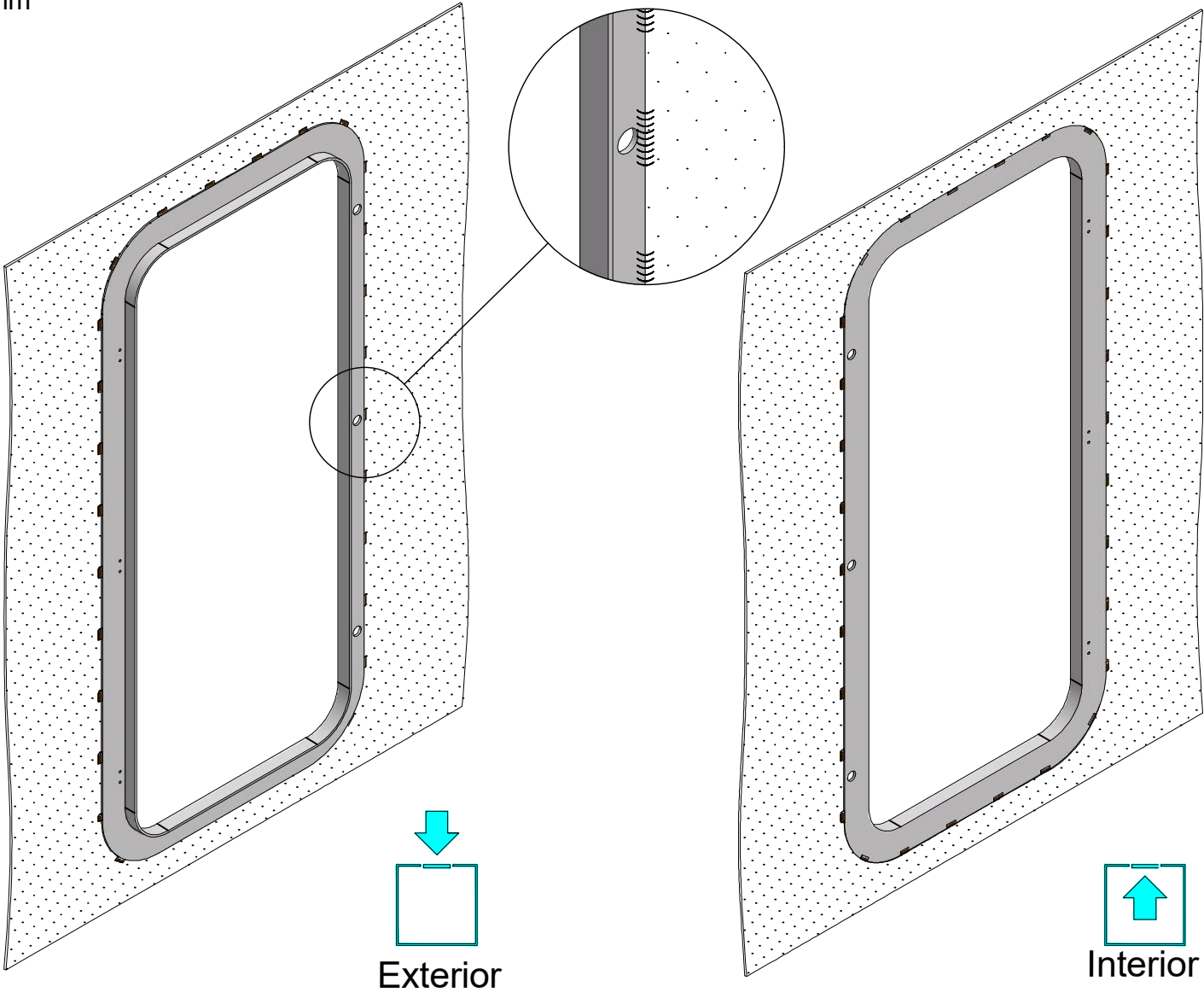
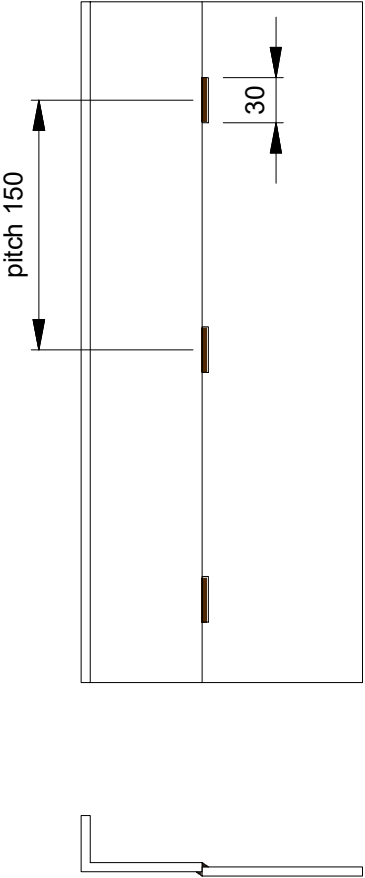
CHECKLIST

- ☐ Frame is parallel ($// < 2\text{mm}$)
- ☐ Frame is straight ($\text{—} < 1\text{mm/m}$)
- ☐ Parallelity A ($< 2\text{mm}$)
- ☐ Parallelity B ($< 2\text{mm}$)



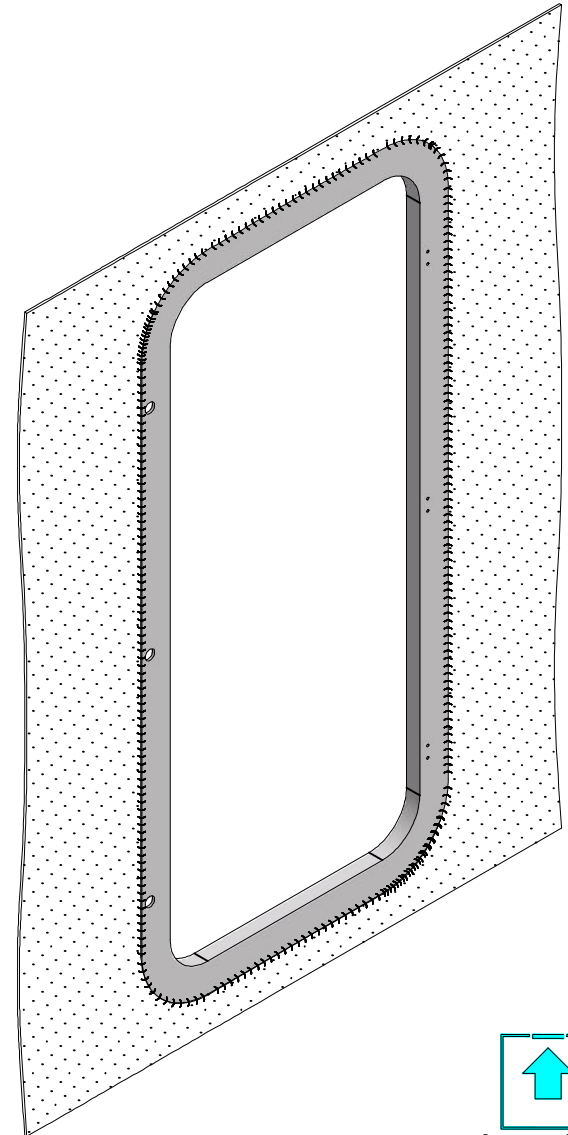
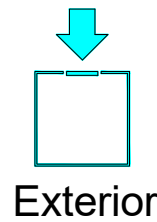
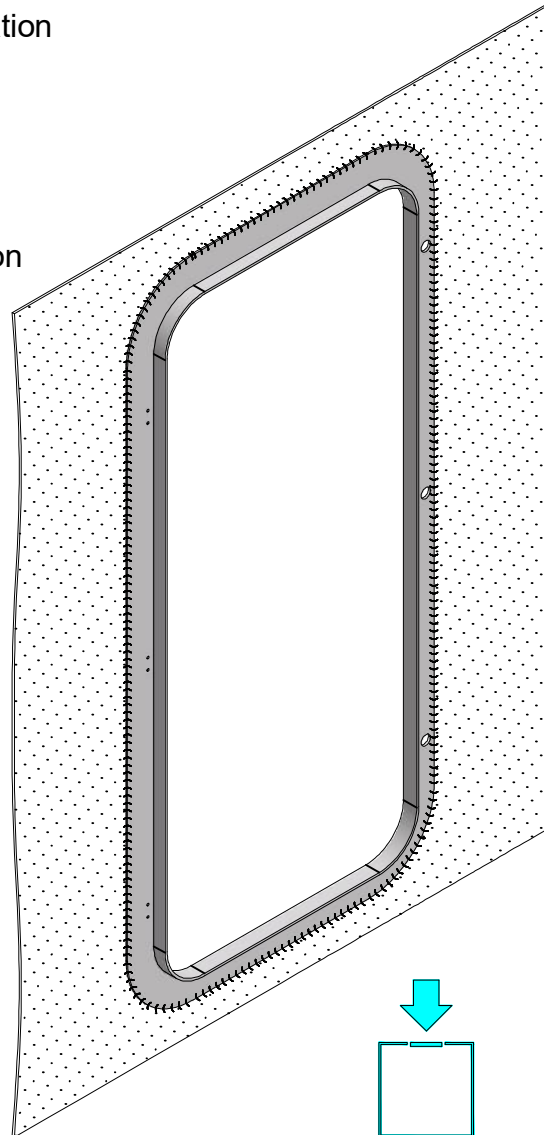
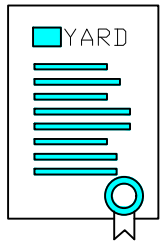
CHECKLIST

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



CHECKLIST

- ☐ 1. Weld parameters are according to yard specification
- ☐ 2. Fully weld interior corners
- ☐ 3. Fully weld exterior corners
- ☐ 4. Weld crosswise between tack welds
(alternate interior and exterior) to minimize deformation



CHECKLIST

- ☐ Frame is parallel ($// < 2\text{mm}$)
- ☐ Frame profile is perpendicular to hatch face ($\perp < 1\text{mm}$)
- ☐ Frame is straight ($\text{---} < 1\text{mm/m}$)
- ☐ Parallelity A ($< 2\text{mm}$)
- ☐ Parallelity B ($< 2\text{mm}$)
- ☐ (Weld) finish quality according to yard specifications

