ABSTRACT

LEVELLING SOLUTION FOR DECREASE DEFORMATION ON PATROL BOAT 36 METRES ENGINE FOUNDATION IN SUB ASSEMBLY PROCESS

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Build a new ship always started from fabrication process until erection process. Each process building ship often happening many problems from minor problem until mayor problem. The minor error on building ship can influence a quality of product which produced by shipyards. Majority shipyards in Indonesia, tendency for making error technical and error untechnical in production process enough heavy. One of them was caused by still not yet fulfill work standart processed. Technical errors often happening on production process like a dimension change (deformation), this thing can affect quality product. In this Field Project, we analyze about deformation on patrol boat 36 metres engine foundation still in sub assembly process in PT. Dumas Tanjung Perak Shipyard, where engine foundation represent main engine place put down. Deformation that happened in the form of arching of plate, effect of inappropriate plate joining of procedure. Besides, warm-up centrally when welding can become cause of deformation. It’s that needed a accuracy (control accuracy), where accuracy a product measured. Some activity of control accuracy used among others is scantling and levelling. By giving treatment of levelling at engine foundation at sub assembly, deformation earn minimize till moment step on next process of deformation which emerge don’t too big because there are deformation tolerance range < 2mm and quality of a product earn well guarantedly.