

ANALISIS TEKNIS PEMASANGAN V-BRACKET PADA PEMBANGUNAN KAPAL PERINTIS 750 DWT DI PT. DKB SHIPYARD JAKARTA I

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Abstrak

Penggunaan Shaft Bracket pada kapal Perintis 750 DWT di PT. Dok & Perkapalan Kodja Bahari (Persero) Shipyards Jakarta – I yang menggunakan tipe V-Bracket sebagai penguat Sterntube pada sistem propulsinya, membutuhkan perhitungan teknis dan tahapan pemasangan yang khusus. Hal ini dikarenakan pada pemasangan V-Bracket akan mempengaruhi alignment terhadap Sterntube yang berpengaruh langsung ke Main Engine. Penelitian ini dilakukan untuk mengetahui tahapan pemasangan V-bracket terhadap sterntube pada kapal perintis 750 DWT serta mengetahui hasil alignment sterntube setelah proses pemasangan V-Bracket. Tahapan – tahapan yang dilakukan diantaranya : Fabrikasi, Fit-Up, Welding Prosedure Spesification, NDT, Annealing, dan Inspeksi oleh Class. Hasil akhir dari pemasangan V-Bracket terhadap Sterntube Kapal Perintis 750 DWT di PT. DKB Shipyards Jakarta I didapati perubahan dimensi inside diameter sterntube akibat tarikan pengelasan. Pada sterntube sebelah kiri perubahan Inside diameter terbesar yaitu 0,7 mm pada pengukuran diameter secara horisontal, sedangkan pada sterntube sebelah kanan mengalami perubahan Inside diameter terbesar yaitu 1,0 mm pada pengukuran diameter secara horisontal.

Kata Kunci : *V-Bracket, Allignment, Pengelasan, Propulsi, Sterntube*

**TECHNICAL ANALYSIS OF V-BRACKET INSTALLATION
ON NEW BUILDING OF PERINTIS 750 DWT SHIP
AT PT. DKB SHIPYARD JAKARTA I**

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Abstract

Application of Shaft Bracket on Perintis 750 DWT ship at PT. Dok & Perkapalan Kodja Bahari Shipyard Jakarta I which uses the V-Bracket type as a Sterntube amplifier in its propulsion system requires technical calculations and special installation steps. This is because in the installation of V-Bracket will affect allignment to Sterntube that directly affect the Main Engine. This research was conducted to know the step of mounting V-bracket to sterntube on Perintis 750 DWT Ship and to know result of allignment of sterntube after V-Bracket installation process. The stages include: Fabrication, Fit-Up, Welding Procedure Specification, NDT, Annealing, and Inspection by Class. The final result of V-Bracket installation on Sterntube Perintis 750 DWT Ship at PT. DKB Shipyard Jakarta I found the dimensional changes inside diameter of the sterntube due to the pull of welding. On the left sterntube changes Inside the largest diameter of 0.7 mm in diameter measurement horizontally, while on the right sterntube changes Inside the largest diameter of 1.0 mm in diameter measurement horizontally.

Keywords : *V-Bracket, Allignment, Welding, Propulsion, Sterntube*