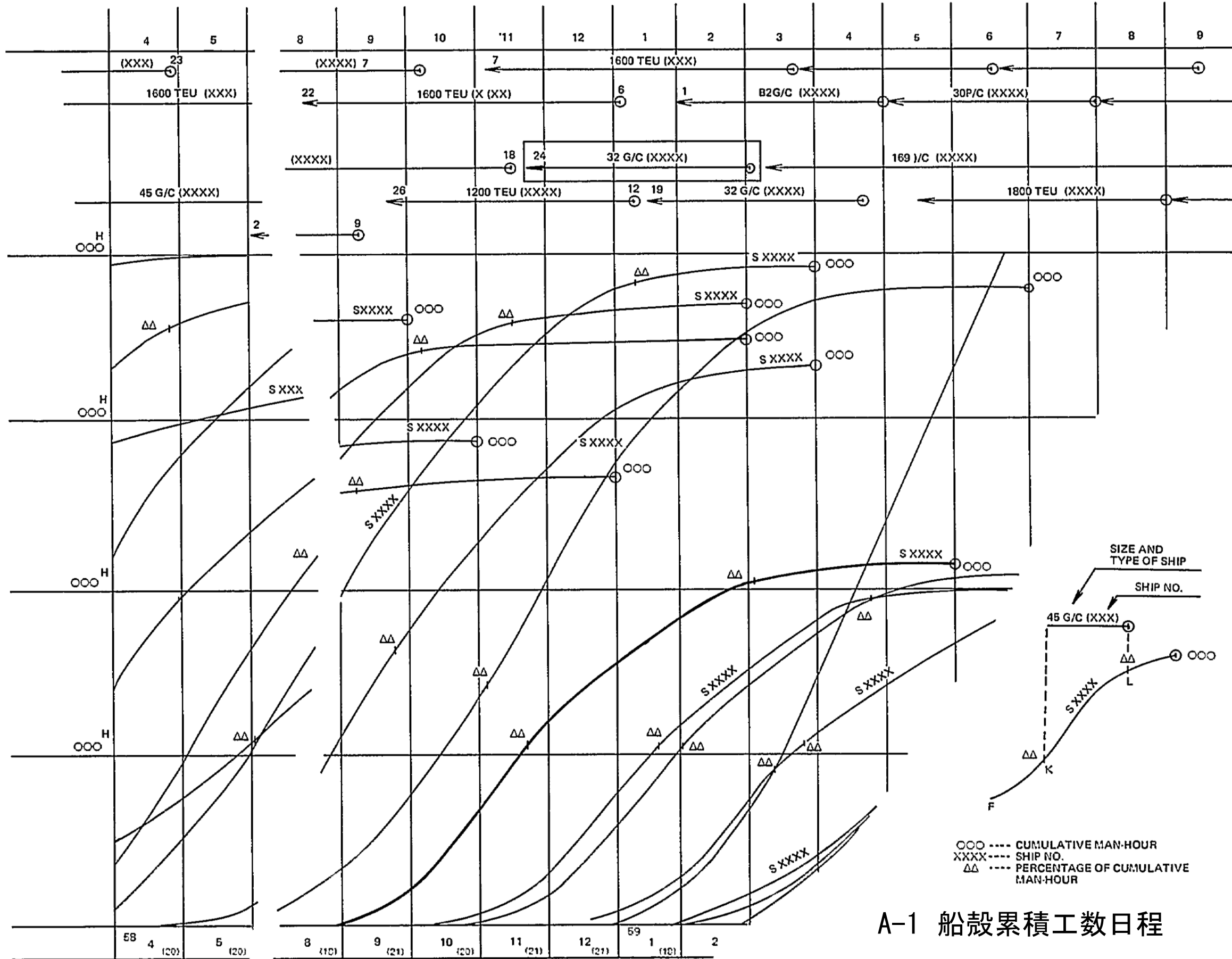


添付図 各種の日程の実例

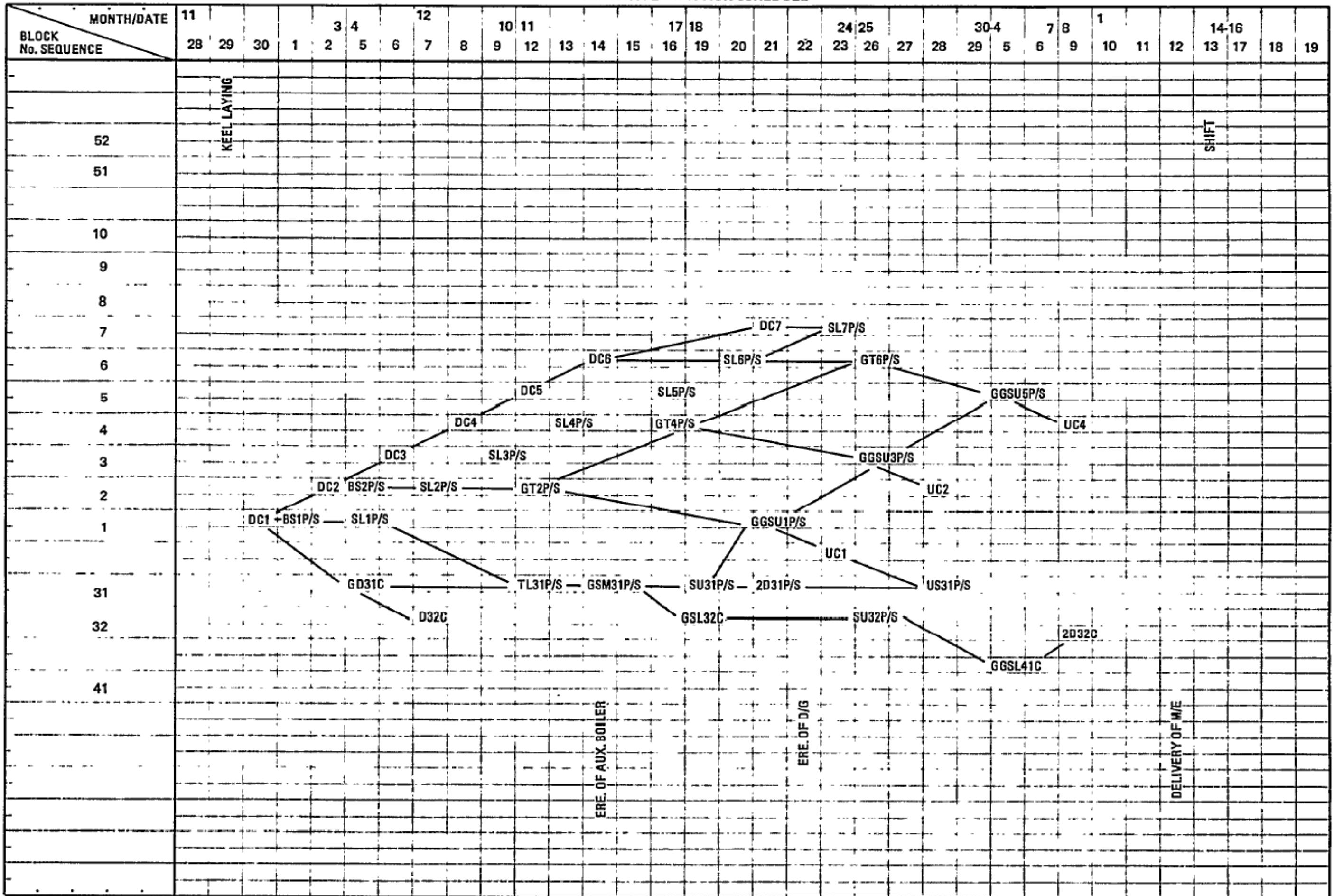
- A-1 船殻累積工数日程
 - A-2 XXXX 番船の仮の搭載日程
 - A-3 XXXX 番船の船殻作業タイミング日程
 - A-4 XXXX 番船の初期搭載日程
 - A-5 XXXX 番船の、取付者と溶接者向けの月別搭載日程
 - A-6 曲板ブロック組立ヤード用の組立課日程
 - A-7 曲板総組ブロック組立ヤード用の組立課日程
 - A-8 曲板総組ブロック組立ヤード月別日程
 - A-9 曲板総組ブロック組立ヤード週別日程
 - A-10 XXXX 番船の艤装作業タイミング日程
 - A-11 XXXX 番船の搭載後艤装作業タイミング日程
 - A-12 XXXX 番船の搭載後運転・試験タイミング日程
 - A-13 XXXX 番船の重要資材要求日程
 - A-14 XXXX 番船の重要資材要求表
 - A-15 XXXX 番船の機関課搭載後艤装日程
 - A-16 XXXX 番船の機関課ユニット艤装・ブロック艤装日程
 - A-17 XXXX 番船の運転・試験日程
 - A-18 グループ 00 週別日程（ブロック艤装）
 - A-19 XXXX 番船の週別日程（搭載後艤装）
 - A-20 XXXX 番船の週別日程（運転・試験）
 - A-21 XXXX 番船のブロック塗装日程
 - A-22 XXXX 番船の搭載後塗装日程
 - A-23 XXXX 番船の初期 IHOP 日程
 - A-24 XXXX 番船の最終 IHOP 日程
 - A-25 XXXX 番船のブロック塗装週別日程
 - A-26 XXXX 番船の搭載後塗装週別日程
- 以下の 4 図は、本編内に添付
- A-27 パイプ部品ファミリー製造での週別作業負荷
 - A-28 パイプ部品ファミリー別の平準化
 - A-29 ライン毎の作業負荷
 - A-30 パイプ部品ファミリー毎の作業負荷
- A-31 小径パイプ部品製造日程
 - A-32 中径パイプ部品製造日程
 - A-33 大径パイプ部品製造日程

HULL CONSTRUCTION MAN-HOUR CUMULATIVE SCHEDULE



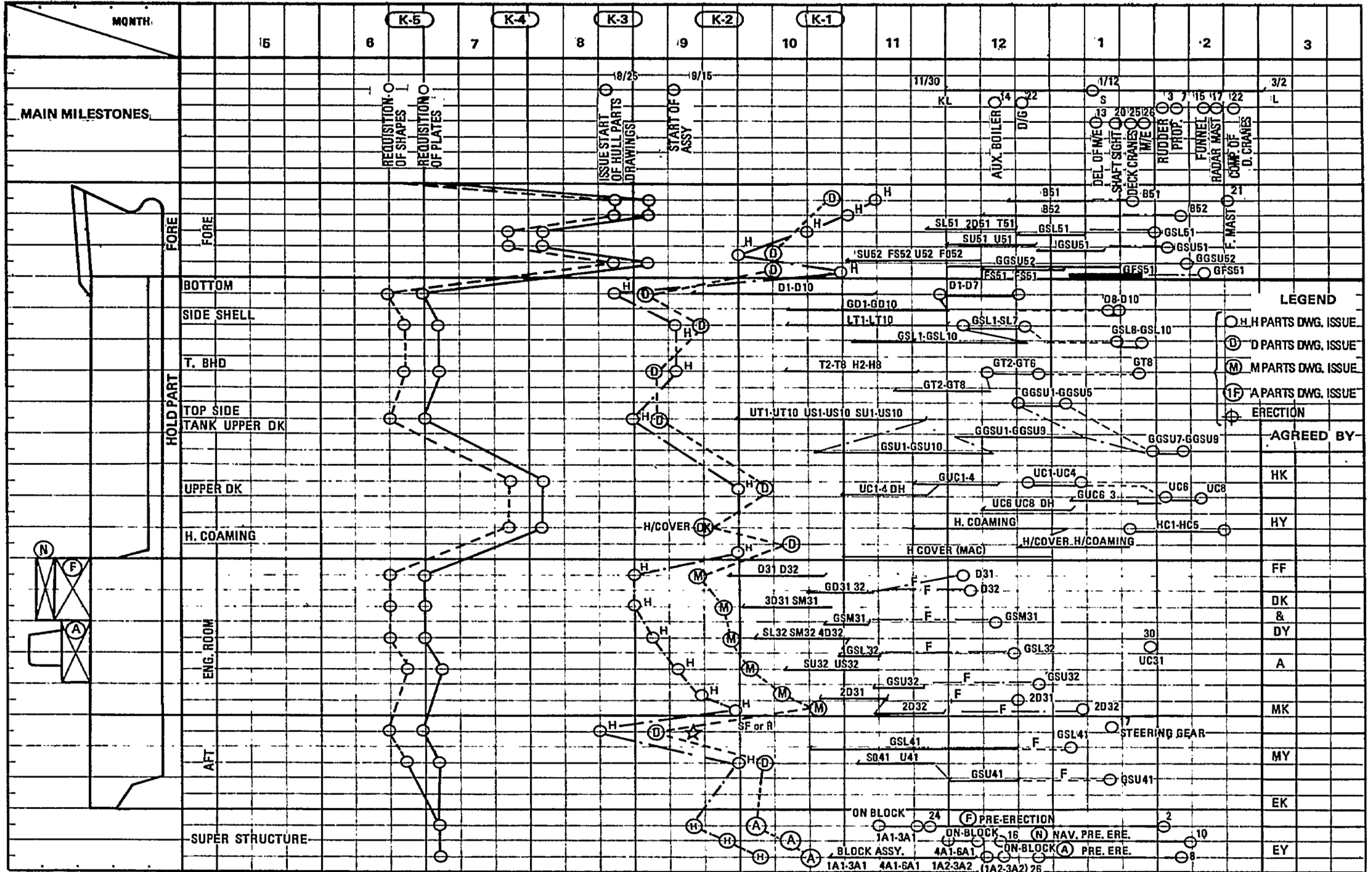
A-1 船殼累積工数日程

S No. XXXX TENTATIVE ERECTION SCHEDULE



PL. NO.

S No. XXXX HULL CONSTRUCTION ACTIVITIES TIMING SCHEDULE



(9756011) A3 トレス 46. 3. 100x50 K 当田

A-3 XXXX 番船の船殻作業タイミング日程

PL. NO.

ASSEMBLY SECTION SCHEDULE FOR X X ASSEMBLY YARD

MONTH/DATE	22	23	⑧	25	27	28	29	30	31	1	2	3	4	⑨	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23-25	26	27	28	29	30	31	3	4	③	6	7	8
S No. XXXX	GFS8x8U8P/S (E) 8/23 (END)																																										
S No. XXXX	2D41 P/S		546																																								
S No. XXXX	GD32		GD33																																								
S No. XXXX	SU33 P/S		1A 9/6																																								
S No. XXXX	BS14 x (-L) P		D 9/6																																								
S No. XXXX	BG13 P/S		(E) 9/16																																								
S No. XXXX	SM51A P/S		1A 9/8																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA		DC32-SA P/S																																								
S No. XXXX	SL13 P		D 9/26																																								
S No. XXXX	SL14 P		D 9/21																																								
S No. XXXX	SU13 x (-D) x P		D10/5																																								
S No. XXXX	SU14x(-D)P		D10/3																																								
S No. XXXX	DC31 ONLY		DC31-S																																								
S No. XXXX	DC31-D		DC32 ONLY																																								
S No. XXXX	DC32 x -SA																																										

PL. NO.

XX ASSEMBLY YARD WEEKLY SCHEDULE

STATION	BUDGETARY MAN-HOUR	MONTH/ DATE BLOCK No.	17	18	19	20	21	22	23	24	25	26	27	28
							(H)	HF		W	W	W	W	W
A	HF XX W XX	S XX GBS3P			X		XX	XX	XX	XX	XX	XX	X	
	HF XX W XX	S XX GBS3S			HF	HF	W	W	W	W	W	W	W Δ	
			MAN-HOUR			INSPECTION					SXX	GBS4P	(H)	HF
B	W XX HF XX W XX	S XX GD1C	W XX	W XX	W XX	W X	W XX	W XX	W XX	W XX	W Δ	GBS4S	(H)	XX
	HF XX W XX	S XX GD2C	HF XX	HF XX	W XX	W XX	W XX	W XX	W XX	W XX	W Δ		(H)	HF XX
C	W XX HF XX W XX	S XX GD3C	W XX	W Δ XX								SXX	GD3C	HF XX
	HF XX W XX	S XX GD4C			(H)		HF XX	W XX	W XX	W XX	W Δ			W XX
D	HF XX W XX	S XX GD6C	HF XX	W XX	W XX	W XX	W X	W X	W Δ X	W X	W X	Δ		
	HF XX	S XX GGB7C							(H)	HF XX	HF XX	HF XX	HF XX	HF XX
F	W XX	S XX GGSM31P	W XX	W Δ X		SXX GGSH31P/S HF		HF XX	HF XX	HF XX	HF XX	W XX	W XX	W XX
	W XX	S XX GGSM31S	W XX	W Δ X		SXX GGSU31P/S HF		HF XX	HF XX	HF XX	HF XX	HF XX	HF XX	HF XX
	W XX	S XX GD33C	HF X	W XX	W XX	W XX	W XX	W Δ XX						
	HF XX W XX	S XX GD31C	(H)	HF XX	HF XX	HF XX	W X	W XX	W XX	W XX	W XX	W XX	W Δ XX	
		S XX GD32C	W Δ X				SXX GD32C	HF XX	HF XX	HF XX	HF XX	W XX	W XX	W XX
	HF XX W XX	S XX P/S GGSL31					(H)	HF XX		W XX	W XX	W XX	W XX	W XX
			MAN-DAY											
	TOTAL	HF	0	0	0	0	0	0	0	0	0	0	0	0
		W	00	00	00	00	00	00	00	00	00	00	00	00

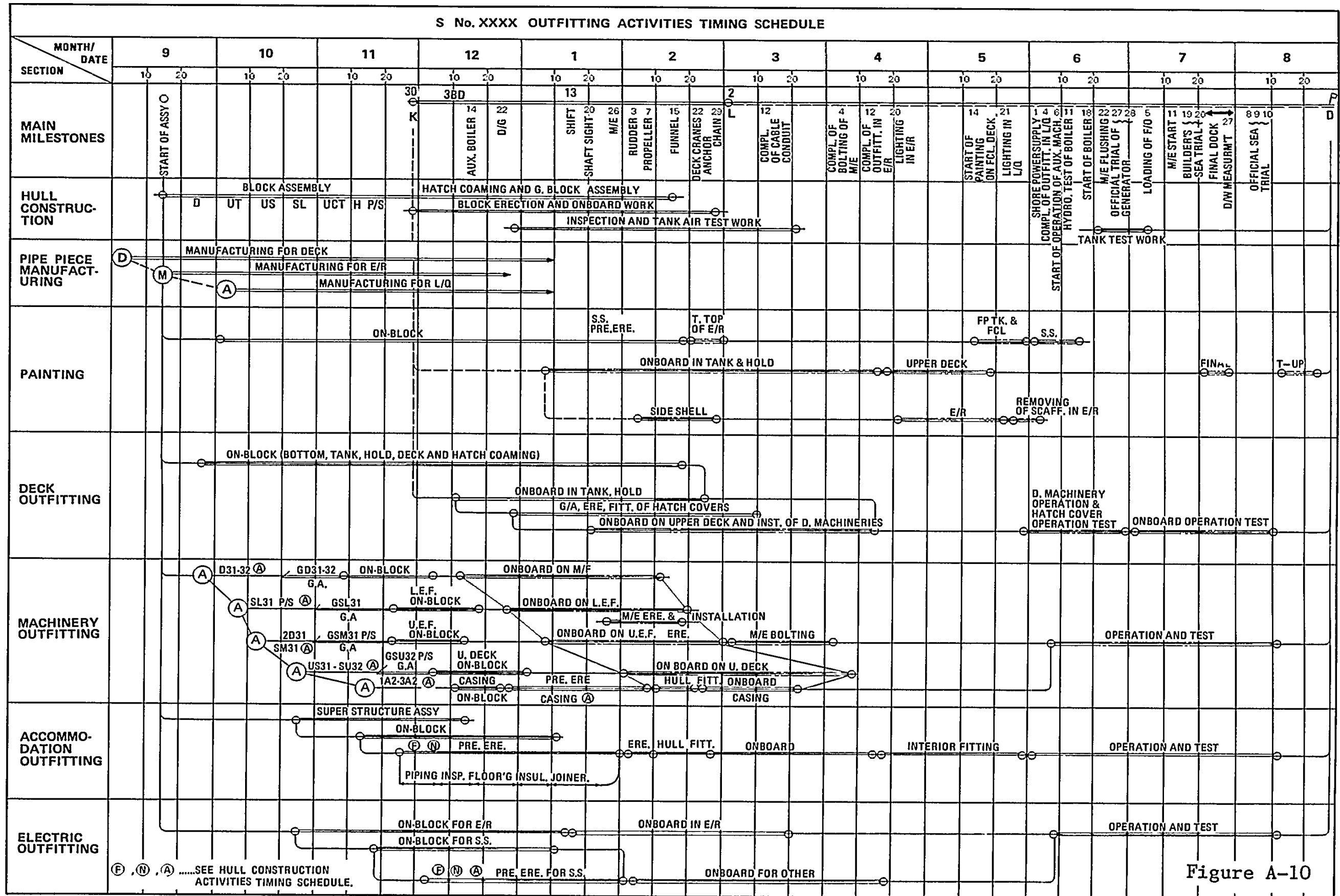
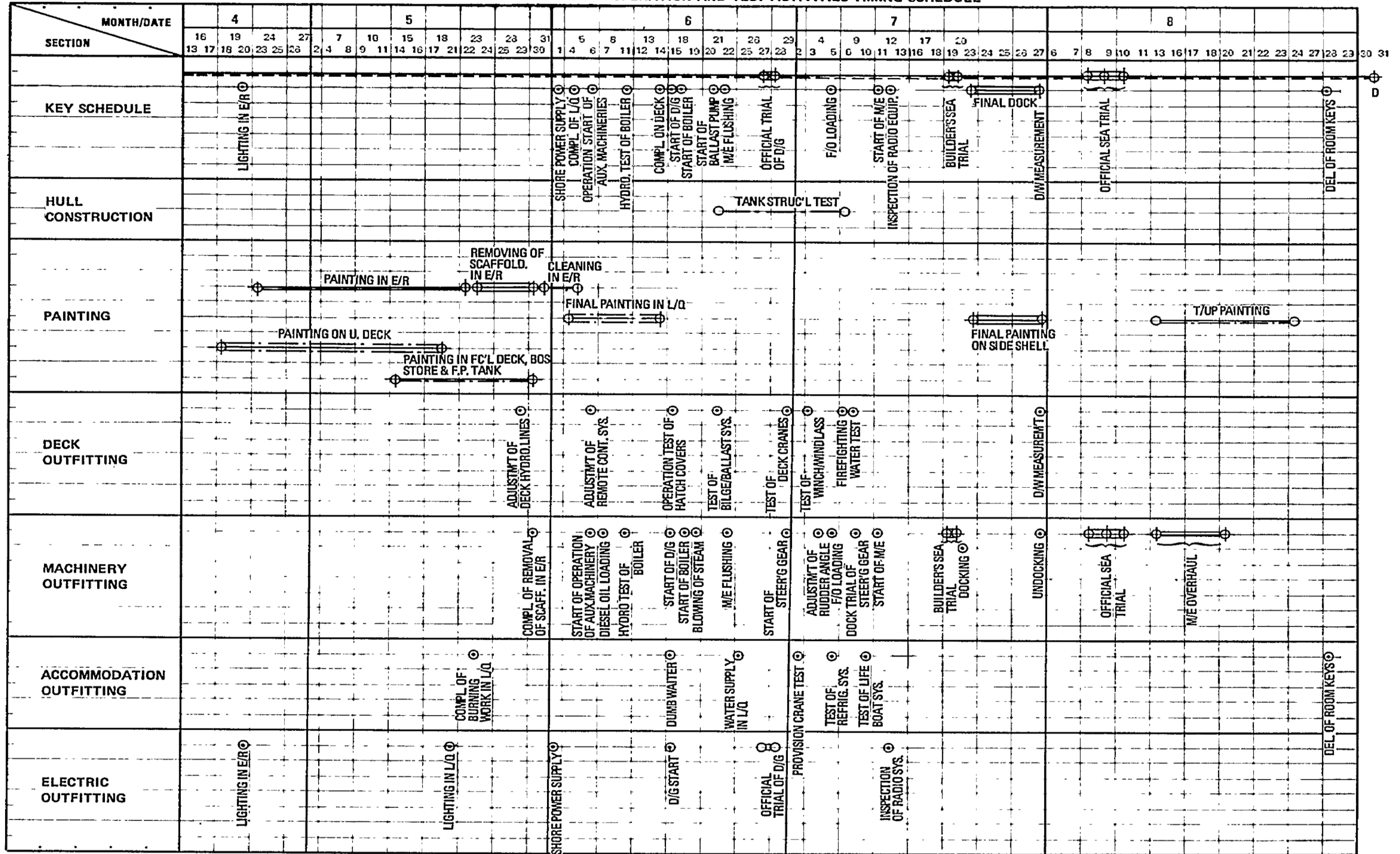


Figure A-10

A-10 XXXX 番船の艙装作業タイミング日程

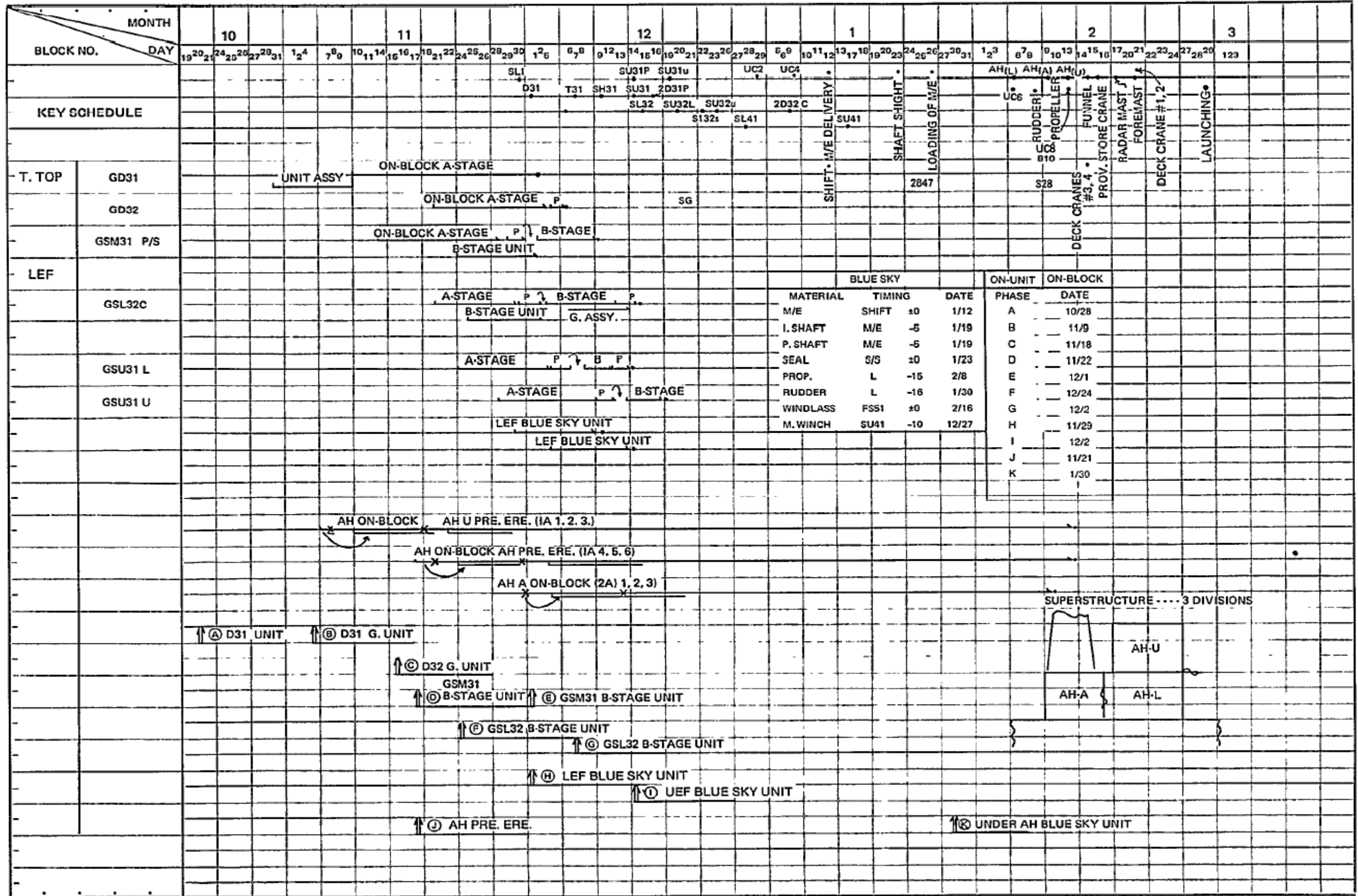
PL. NO.

S No. XXXX ONBOARD OPERATION AND TEST ACTIVITIES TIMING SCHEDULE



(9756011) A3 トレス 45.3. 100x50 K 当田

Ishikawajima-Harima Heavy Industries Co., Ltd.



S. No.

IMPORTANT MATERIAL NEED DATE TABLE

D.W.G. NO.	DESCRIPTIONS	Q'TY.	N. DATE	N. DATE COND. ALT. COND.	N. PACKAGE	XXXX									
						ORIG.	ALT 1	ALT 2							
XXXXXXXX	MAIN DIESEL ENGINE			SLIDE ± o		1/13	1/13	1/12							
XXXXXXXX	MAIN DIESEL GENERATOR		△	SU32 E-2 2D32c E-1		12/23	12/19	1/5							
XXXXXXXX	ELECT. BALLANCER			SU41 E-2			59 1/12	1/12							
XXXXXXXX	SHAFT GENERATOR			M/E E-2			39 1/24	1/24							
XXXXXXXX	AUX. BOILER		△	2D32c E-3		12/14	12/9	12/28							
XXXXXXXX	EXH. GAS ECONOMIZER			J + 10		12/18	12/1	12/5							
XXXXXXXX	INTERMEDIATE SHAFT			M/E E-5		1/6	1/19	1/19							
XXXXXXXX	PROPELLER SHAFT			M/E E-5											
XXXXXXXX	PROPELLER			L-15		2/8	2/10	2/8							
XXXXXXXX	STERN TUBE BEARING			S.S ± 10		1/12	1/20	1/23							
XXXXXXXX	STERN TUBE SEAL ASS'Y			S.S ± 10											

S.S. SHAFT CENTER SIGHTING

A-14

XXXX 番船の重要資材要求表

MONTH/DAY		(17)	(18)	(21)	(22)	(24)	(25)	(26)	(28)	(29)	(30)	12 / (1)	12 / (2)	
KEY SCHEDULE														
NEED DATE OF PALLETS AND PREPARATION OF TOOLS			S NO. XXXX	XZD31S-0 XZD31S-1	X098-1 X117-0 X117-1 X117-2	X098-0 X115-0 X117-3, 4, 5	Y096-0 X171-0 X173-0 YM3501-0, 1 X031-0		X136-0 X186-0 XUS31S-0, 1	YM3501-8	X176-0 X099-0 X099-1	BZXGSU41P-O 41S-O B4XZAZP-O		
BLOCK NO.	WORKERS NAMES													
D31	○○○ ○○○ ○○○	FLOOR PLATES, REACH RODS, HANDRAILS												
								TO ONBOARD						
D32	○○○ ○○○ ○○○		B4YM13GH	14GH	13K0~2	14K-0~2								
								TO ONBOARD						
D33	○○○ ○○○ ○○○		B4YM15P-0~9	YH15K-0~3	YM15GH-0									
							UNIT ○○		B4Y096-0		GT3ICA		B4X099-1	
D31	○○○ ○○○ ○○○ ○○○		B4Y 053-0	B4Y 037-0	B4Y 054-0	B4Y 081-0	B4YH11P-0~4		B4YM12P-C~4		11K-0 12K-0			
D32	○○○ ○○○ ○○○		B4Y 061-0	B4Y 116-0	B4YM 15P-1~4	B4YM15K-0								
SU(A)	○○○ ○○○			B4XZD31S-0		B4X098-0		SM(B) (P)	B4X 171-0		B4X 186-0		B4XZAZP-O	
				B4XZD31S-1		B4X115-0			B4X 173-0				CH	
SM(B) (S)	○○○ ○○○				B4X098-1	B4X 117-0	117-1		117-2	117-3	117-4	117-5	B4X099-0	
								SL32(B) C	B4YM 3501-0	3501-1	3501-8		SU41C(A)	
									B4X031-0	B4X136-0			BZXGSU41PO SO	
									SU31U (A)	B4XUS31 S-0 S-1		SU3ZS	B4X176-0	
MAN-DAY	B A	/												
MAN-HOUR	B A	/												
GROUP'S EVENTS														
PATROL AFTER WORK														
CRANE SCHEDULE														

S. No. XXXX WEEKLY SCHEDULE (ON-BOARD OUTFITTING)

SECTION XXX GROUP XXX

MONTH/DAY	2/6	2/7	2/8	2/9	2/10	2/13	
PALLET NEED DATE & EVENTS NAME	BM71P --0--4 --1--5 --2 --3	ZM42P ZM45P		3Z MEETING CH ERECTION			
XX	ZM 12P - 9) 18 PCS. (MOLDED) ZM 11P - 9) B4X186 1 pc. B4X171 4 pcs.			VALVE 2 PCS. T4ZM71P -- 0 2 pcs T4ZM71P -- 1 3 pcs	T4ZM71 -- 2 20 pcs. VALVE 1 PCS. B/FLANGE 1 PCS.		
XX	ZM41P (MOLDED)	ASSY T4BZD3ZC-D	PIPE 18 PCS. VALVES 7 PCS.	ASSY T4BZD32C-1 PIPE 12 pcs. VALVE 7 pcs.	ZM42P -- 0, ZM45P -- 0		
XX	ZM25KA -- 0 2 pcs ZM22FA -- 0 TROLLEY BEAM	FLOOR PLATE 2 pcs.	ZM7KA -- 1 INC. LADDAR TELBX	ASSY T4BZD32C	ZM45KA -- 0		C.C.
XX	ZM31P -- 9	45 PCS.	IN WAY OF COMPRESSOR		ASSY COMPRESSOR		
XX		ZM35P -- 0	94 PCS.				
XX		T2ZASRPA - 1	PIPE 40 PCS.	VALVES 18 pcs.	SIGHTGLASS 1 pcs.		
ALLOC.	XXXX	X	X	X	X	X	
	XXXX	X	X	X	X	X	

S. No. XXXX WEEKLY SCHEDULE (OPERATION AND TEST)

SECTION XXX GROUP XXX

MONTH/DAY	5/28	29	30	31	1	2	
KEY SCHEDULE			D/G OFFICIAL TRIAL				
NAME							
M/E XX	TAKING OUT OF AND LANDING OF OIL	PREPARATION OF FLUSHING No. 2		(INSP.) CLEANING	FILL. OF L/O FROM L/O SETT. TK TO SUMP TK.		
XX				FLUSHING			
			PREPARATION OF F/O FLUSHING				
AUX. XX		COMPRESSOR SAFETY DEVICE	(INSP.) BILGE SUCTION TEST	(INSP.) DUMPER OPER.	(INSP.) EMERG. SHUT-DOWN VALVE	(INSP.)	C.C.
BOILER XX			(INSP.) BOILER SAFETY DEVICE	INCINERATOR ADJUSTMENT (INSP.)			
	(INSP.) CLEANING OF EMER. D/G F/O TK	EMER. D/G START D/O 5 DRUMS L/O 40 lit.	6/4 OFF. SEA TRIAL				
ALLOC.	XX	X	X	X	X	X	
	XX	X	X	X	X	X	

PL. NO.

SNO. XXXX ON-BLOCK PAINTING SCHEDULE (1/2)

DATE: XX/XX/XX

ZONE	DAY																																															
	10			11			12			1			2			3			4			5																										
	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	1	2	3	4	5	6	7	8	9	10	11	12								
BOTTOM				DC 1 XX/XX			DC 2 XX/XX			BS 3 XX/XX			BS 4 XX/XX			DG 1C XX/XX			GBS 3 XX/XX			GBS 1 XX/XX									GBS 2 XX/XX						DS 9 XX/XX											
																BS 5 NO PAINT	BS 6 NO PAINT		BS 7 XX/XX			BS 4 XX/XX	BS 5 XX/XX	BS 6 XX/XX	BS 7 XX/XX			BS 8 XX/XX	BC 9 XX/XX								GBS 8 XX/XX	GBC 9 XX/XX					GBS 9 XX/XX					
T. BULKHEAD																H 2 XX/XX			H 4 XX/XX	GT 2 XX/XX	H 6 XX/XX	GT 2 (E) XX/XX	GT 6 (E) XX/XX	H 8 (T) XX/XX	GT 6 (E) XX/XX																					GT 8 XX/XX		
SIDE SHELL																LT 1 XX/XX	LT 2 XX/XX	LT 3 XX/XX	LT 4 XX/XX	LT 6 XX/XX	LT 8 XX/XX	GSL 1 XX/XX			GSL 3 XX/XX	GSL 5 XX/XX	GSL 7 XX/XX																			GSL 8 XX/XX	GSL 9 XX/XX	
																			LT 5 XX/XX	LT 7 XX/XX	LT 9 XX/XX	GSL 2 XX/XX			GSL 4 XX/XX	GSL 6 XX/XX																						
ENGINE ROOM																			SL 31 XX/XX	D 32-SB XX/XX	GD 31 XX/XX				GD 32 XX/XX	GSM 31 XX/XX	GSU 32S, GSM 31 (E) XX/XX	GSU 32S XX/XX																				
XXX																																																
UPPER DECK																																																
XXX																																																
SUPERSTRUCTURE																																																
HATCH COVER																																																
AREA (M ²)																																																
MAN-HOUR																																																
MAN-DAY																																																

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ZONE	DAY																																																
	13	17	18	19	20	23	24	25	26	27	30	31	1	2	3	6	7	8	9	10	13	14	15	16	17	20	21	22	23	24	27	28	29	3															
BOTTOM	GB10 XX/XX		B51C XX/XX		(E)	B52C XX/XX																																											
T. BULKHEAD																																																	
T. BULKHEAD	(T) GT8 XX/XX																																																
SIDE SHEEL	GSL10 XX/XX		GSL51C XX/XX		(T) GSL51C XX/XX		(E) GSU51 XX/XX		GSU52C XX/XX		(E)		GFS51C XX/XX		GFS51C XX/XX		(E)		HP XX/XX																														
SIDE SHEEL																																																	
ENGINE ROOM																																																	
ENGINE ROOM	GSU41 (E) XX/XX		UC31 XX/XX		UC6 XX/XX		UC8 XX/XX		UC10 XX/XX		GGUS9 XX/XX		GUC6 (E) XX/XX																																				
UPPER DECK	BW9 XX/XX		GSU10 XX/XX		GGUS7 XX/XX		(E) CL1 XX/XX																																										
UPPER DECK																																																	
UPPER DECK	BW10 XX/XX																																																
HATCH COVER																																																	
HATCH COVER	HC4 XX/XXX				HC3 XX/XXX				HC2 XX/XX				HC1 XX/XX																																				
AREA (M ²)	XX (XX)		XX (XX)		XX (XX)		XX (XX)		XX (XX)																																								
HOUR	X (X)		X (X)		X (X)		X (X)		X (X)																																								
MAN-DAY	O		O		O		O		O																																								

PL. NO. _____

S NO. XXXX ONBOARD PAINTING SCHEDULE

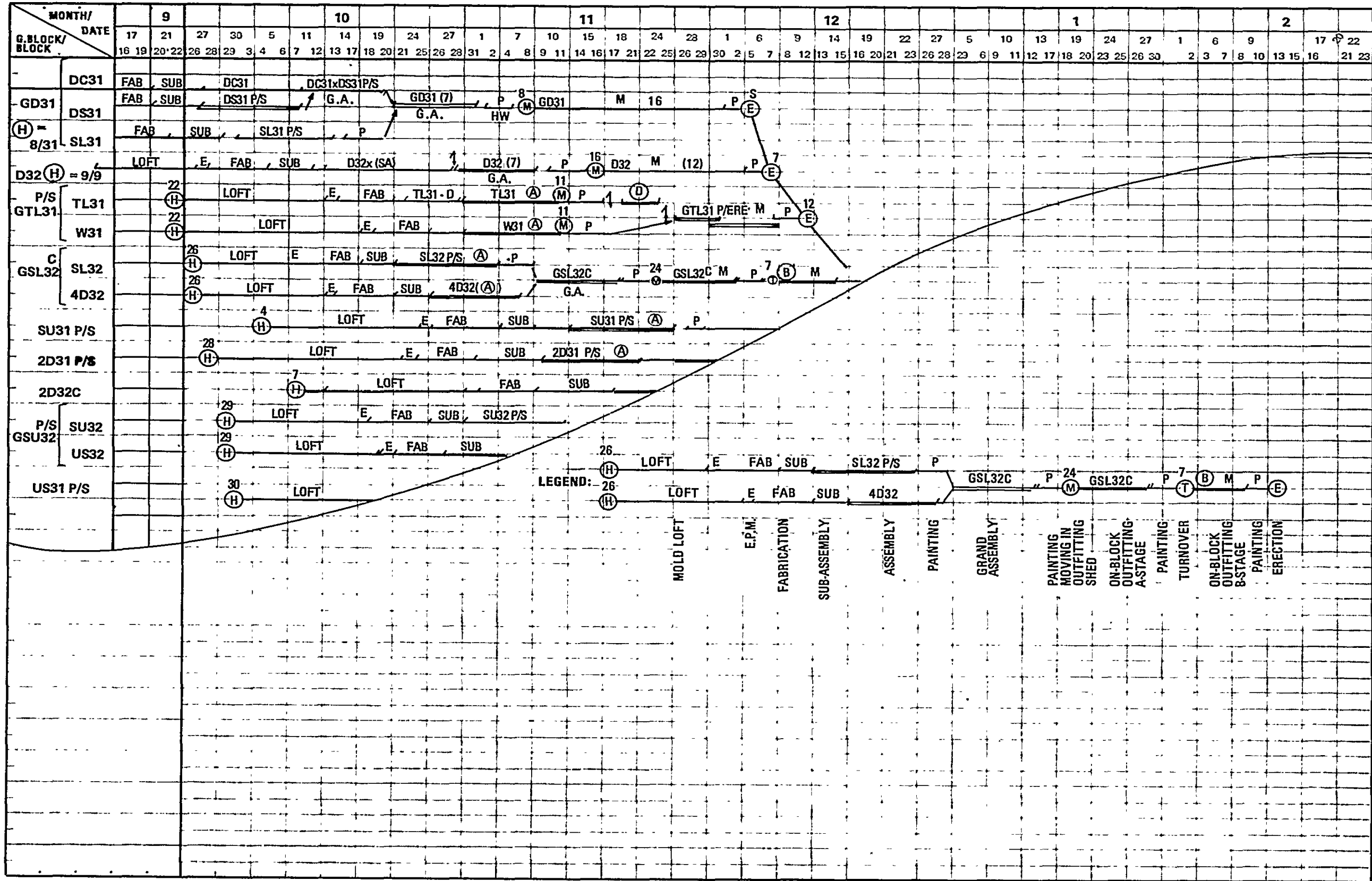
DATE: XX/XX/XX

ZONE	DAY																																				
	3 20 21	22	24 23	25 26	27	28	29	31 30	1 2	3	4	5	7 6	8 9	10	11	12	13	15 16	17	18	19	21 20	23	24	25	26	28~1 27	3 2	5 4	6 7	8					
MAIN EVENT	DEBALLASTING OF NO. 1 HOLD										PAINTING IN ENGINE ROOM										REMOVAL OF SCAFFOLDS																
NO 1 WBT P/S											C	P/R	TE	IP																							
NO 2 FOT P/S	T/U																																				
NO 3 WBT P/S	R	C		T/U	INS																																
NO 4 FOT P/S	INS																																				
NO 1 TST P/S																																					
NO 2 TST P/S																																					
NO 3 TST P/S																																					
NO 4 TST P/S																																					
NO 5 TST P/S																																					
PIPE DUCT																																					
F P T																																					
A P T																																					
NO 1 HOLD																																					
NO 2 HOLD																																					
NO 3 HOLD																																					
NO 4 HOLD																																					
NO 5 HOLD																																					
NO 1, 2 DRWT NO 1, 2 FRWT																																					
E/R, S.G/R, F.P/R																																					
BOSUN STORE DECK STORE																																					
SUPER STRUCTURE																																					
UPPER DECK																																					
MAN-DAY																																					

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PL. NO.

S No. XXXX PRELIMINARY IHOP SCHEDULE



(9756011) A3 トレス 46.3. 100x50 K 当田

Ishikawajima-Marine Heavy Industries Co., Ltd.

PL. NO.

S NO. XXXX ON-BLOCK PAINTING WEEKLY SCHEDULE

DATE: XX/XX/XX

BLOCK	DAY PROCESS YARD	10/27	28	29	30	31	11/1	2	3	4	5	6
KINDS OF PAINTING AND PAINTING												
GD1C	1A	P/R TEAC P/R DTE P/ROK P/R TB XX XX (X) XX XXX	VTAC 1P~2P 2XXX			TE T/U BTE T/U SPAF 1P~2P (X) 2XX	SPAF 3P XX (X)					
GD2C	1A					P/R TEAC P/R BTE P/R TE P/R RPO XX XX (X) XX XX	VTAC 1P~2P 2XX (X)	BTE TE T/U SPAF 1P~2P (X) 2XX		SPAF 3P XX (X)		
GBS3 P/S	1A											
GBS4 P/S	2W	TE T/U										
GBS7 P/S	2W											
LT 1 P/S	2W		P/R TE P/R BTE P/R LZ XX XX (X)			TE, ETE T/U WRP 1P (X) XX						
LT 2 P/S	2W						P/R TE P/R BTE XX XX (X)			TE, BTE T/U (X)		
LT 3 P/S	2W							P/R BTE, P/R TE XX (X) XX		TE, BTE T/U (X)		
LT 4 P/S	2W									P/R TE P/R BTE XX XX (X)		
LT 5 P/S	2W											
GD31	1A		INS.			P/R TEAC P/R TE P/R BTE P/R RPO XX XX (X) XX XX	VTAC 1P~2P 2XX (X)	TE ETE T/U SPAF 1P~2P (X)		INS. SPAF 3P XX (X)		
GD32	1A					(X)						
SM31 P/S	1A	P/R TEAC P/R EAC P/R TE P/R LZ TAC IP EAC2P WRP 1P XX XX (X) XX XX XX XX (X) XX										
3D31 P/S	SUBCON	P/R TE P/R LZ XX (X) XX										
SU31LS	1W									P/R EA P/R CAC P/R LZ XX XX (X)		
TK31A	2A											
SL32 P/S	1W					P/R TEAC P/R EAC P/R LZ XX (X) XX XX	VTAC 1P EAC 2P WRP 1P XX XX XX (X)	EBT 1P XX (X)				
US1-T P/S	SUBCON	P/R BTE P/R LZ XX (X) XX	WRP 1P, ETE T/U XX (X)									
P/R AREA		XXXX	XXXX			XXXX	XXX	XXX				
PAINTING AREA		XXXX	XXXX			XXX	XXXX	XXX		XXX		
AREA/DAY		XXX	XXX			XXX	XXX	XXX		XXX		
MAN-DAY		OO	OO			OO	OO	OO		OO		

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SNO. XXXX ONBOARD PAINTING WEEKLY SCHEDULE

ZONE \ DAY		DATE:														PREPARED BY:		
		3 ③ SAT	4 ④ SUN	5 MON	6 TUE	7 WED	8 THU	9 FRI	10 ⑩ SAT	11 ⑪ SUN	12 MON	13 TUE	14 WED	15 THU	16 FRI	17 SAT		
KEY SCHEDULE																		
						B GRADE INS. PAINT	T/U	INS. ON STAFF			REMOVAL OF SCAFF. CLEAN.	T/U			INS.			
NO. 4 WBT (P)		P/R = ISC-B P = TEISOμ		DE-RUST ○	○	○	○	○				○			○			○
AREA X R = HOURS (P/R) AREA X R = HOURS (P)								B GRADE INS. PAINT					REMOVAL OF SCAFF. CLEAN					
NO. 4 WBT(S)				CLEANING		DE-RUST ○	○	○			T/U ○	INS.						T/U
AREA X R = HOURS (P/R) AREA X R = HOURS (P)																		
						B GRADE INS. PAINT	T/U	INS.										
E/R W.B. TANK		P/R = ISC-B WBT P = TEISOμ		WBT ○	DE-RUST ○	○	○	○										
AREA X R = HOURS (P/R) AREA X R = HOURS (P)												B GRADE INS. PAINT	T/U	INS.				
AREA X R = HOURS (P/R) AREA X R = HOURS (P)		P/R = ISC-B P = TEISOμ						DE-RUST ○			DE-RUST ○	○	○	○	○			
												B GRADE INS. PAINT	T/U	INS.				
AREA X R = HOURS (P/R) AREA X R = HOURS (P)		P/R = ISC-B P = OIL COAT								LOT	DE-RUST ○	○	○	○	○			
INSIDE OF SUPERSTRUCTURE		P/R = ICC-B P = LZIP					2ND OK ~ NAV DK DE-RUST	PAINT			DE-RUST ○	○	○	○	○	○	○	○
AREA X R = HOURS (P/R) AREA X R = HOURS (P)																		
MAN-DAY				○	○	○○	○○	○○										

MONTH/WEEK:

SMALL BORE PIPE PIECE MANUFACTURING SCHEDULE

	(F)	(M)	(T)	(W)	(TH)	(F)	(M)
MARKING AND CUTTING	9/3 50 ^φ -157 157	40 ^φ -135 135	40 ^φ -134 134	32 ^φ -27 25 ^φ -40 20 ^φ -36 15 ^φ -27 130	9/4		
JOINING OF STRAIGHT PIPE PIECE	9/3 50 ^φ -90 90	40 ^φ -135 135	40 ^φ -26 26	32 ^φ -4 25 ^φ -29 20 ^φ -28 15 ^φ -18 79	9/4		
WELDING OF STRAIGHT PIPE PIECE	9/3 50 ^φ -90 90	40 ^φ -135 135	40 ^φ -26 26	32 ^φ -4 25 ^φ -29 20 ^φ -28 15 ^φ -18 79	9/4		
BENDING BY BENDER	9/3 50 ^φ -90 90	50 ^φ -29 40 ^φ -65 94	40 ^φ -92 92	32 ^φ -9 25 ^φ -36 20 ^φ -14 15 ^φ -21 80	9/4		
JOINING OF BENT PIPE PIECE	9/2 40 ^φ -90 20	40 ^φ -50 15 ^φ -29 32 ^φ -3 25 ^φ -22 20 ^φ -2 106	9/3 50 ^φ -67 67	40 ^φ -70 70	40 ^φ -38 32 ^φ -23 61	25 ^φ -11 20 ^φ -8 15 ^φ -9 9/4 28	TOTAL/DAY OF NO. OF PIPE PIECES
JOINING OF BRANCH PIPE PIECE	9/2 25-6 15 ^φ -1 9	9/3 50 ^φ -3 3	40 ^φ -23 23		32 ^φ -1 1	25 ^φ -1 15 ^φ -2 3	
WELDING OF HIGH GRADE PIPE PIECE	9/2 40 ^φ -114 25 ^φ -6 15 ^φ -1	40 ^φ -70 32 ^φ -3	25 ^φ -22 9/3 50 ^φ -10 20 ^φ -2 15 ^φ -29	50 ^φ -57	40 ^φ -60	40 ^φ -48 32 ^φ -10	32 ^φ -13 25 ^φ -11 20 ^φ -8 15 ^φ -9
MACHINING OF PIPE PIECE					50 ^φ -18 40 ^φ -14 32 ^φ -2 25 ^φ -3		

MONTH WEEK:

MIDDLE BORE PIPE PIECE MANUFACTURING SCHEDULE

	(F)	(M)	(T)	(W)	(TH)	(F)	(M)
MARKING AND CUTTING	9/2 65 ϕ -57 9/3 65 ϕ -20	9/2 Piller-10 9/3 65 ϕ -70	65 ϕ -75	80 ϕ -36 100 ϕ -40	125 ϕ -65 150 ϕ -10	150 ϕ -33 200 ϕ -16 9/4	
JOINING OF STRAIGHT PIPE PIECE	9/2 80 ϕ -7 65 ϕ -40	65 ϕ -33 9/3 65 ϕ -25	65 ϕ -68	80 ϕ -29 100 ϕ -35	100 ϕ -8 125 ϕ -39 150 ϕ -10	150 ϕ -9 200 ϕ -6 9/4	
WELDING OF STRAIGHT PIPE PIECE	9/2 80 ϕ -27 65 ϕ -25	65 ϕ -48	9/3 65 ϕ -50	65 ϕ -43 80 ϕ -10	80 ϕ -19 100 ϕ -35	100 ϕ -8 125 ϕ -39 150 ϕ -10	150 ϕ -9 200 ϕ -6 9/4
BENDING BY BENDER	9/2 150 ϕ -2 125 ϕ -25 80 ϕ -5	80 ϕ -7 65 ϕ -28	9/3 65 ϕ -41	65 ϕ -39	80 ϕ -32 100 ϕ -10	100 ϕ -35 125 ϕ -10	125 ϕ -19 150 ϕ -11 200 ϕ -3
JOINING OF BENT PIPE PIECE	9/1 54 ϕ -18 125 ϕ -7 150 ϕ -11 200 ϕ -11	(P) 20 ϕ -5 (P) 150 ϕ -10 65 ϕ -3 125 ϕ -8 50 ϕ -7 100 ϕ -5 40 ϕ -1 80 ϕ -7 9/2 200 ϕ -10	9/2 200 ϕ -12 150 ϕ -12 125 ϕ -30	100 ϕ -19 80 ϕ -14 65 ϕ -17 (P) 200 ϕ -4	(P) 150 ϕ -3 125 ϕ -5 100 ϕ -19 80 ϕ -9 65 ϕ -8	9/3 65 ϕ -15 65 ϕ -67	80 ϕ -21 (P) 200 ϕ -11 100 ϕ -46 200 ϕ -5 125 ϕ -29 150 ϕ -8 150 ϕ -28 125 ϕ -5 100 ϕ -18 80 ϕ -9 65 ϕ -7
WELDING OF BENT PIPE PIECE							

MONTH/WEEK:

LARGE BORE PIPE PIECE MANUFACTURING SCHEDULE

W. STATION \ DAY	(F)	(M)	(T)	(W)	(TH)	(F)	(M)
MARKING AND CUTTING	250 ^φ -3		9/3 850 ^φ -1 750 ^φ -1 450 ^φ -1 400 ^φ -4	400 ^φ -11 350 ^φ -2	300 ^φ -5 250 ^φ -14		
JOINING OF STRAIGHT PIPE PIECE	259 ^φ -3		9/3 750 ^φ -1	400 ^φ -4 350 ^φ -2	250 ^φ -7		
WELDING OF STRAIGHT PIPE PIECE	250 ^φ -3		9/3 750 ^φ -1	400 ^φ -4 350 ^φ -2	250 ^φ -7		
JOINING AND WELDING OF BRANCH PIPE PIECE	9/1 550 ^φ -1 9/2 300 ^φ -1 250 ^φ -5				350 ^φ -2		250 ^φ -1
JOINING OF BENT PIPE PIECE		9/2 600 ^φ -2 300 ^φ -1 250 ^φ -2	9/3 850 ^φ -1 450 ^φ -1 400 ^φ -3	400 ^φ -6	400 ^φ -2	300 ^φ -5	250 ^φ -7 P 350 ^φ -1 250 ^φ -9
WELDING OF BENT PIPE PIECE							
LONG LENGTH PIPE PIECE (> 5.5M)	9/1 650 ^φ -7	550 ^φ -2 300 ^φ -3 257 ^φ -2	250 ^φ -2 200 ^φ -2 9/2 650 ^φ -4	650 ^φ -2 550 ^φ -1 350 ^φ -2	300 ^φ -7 250 ^φ -2	250 ^φ -4 200 ^φ -6	150 ^φ -3 125 ^φ -3 750 ^φ -1 550 ^φ -2 300 ^φ -8 250 ^φ -2