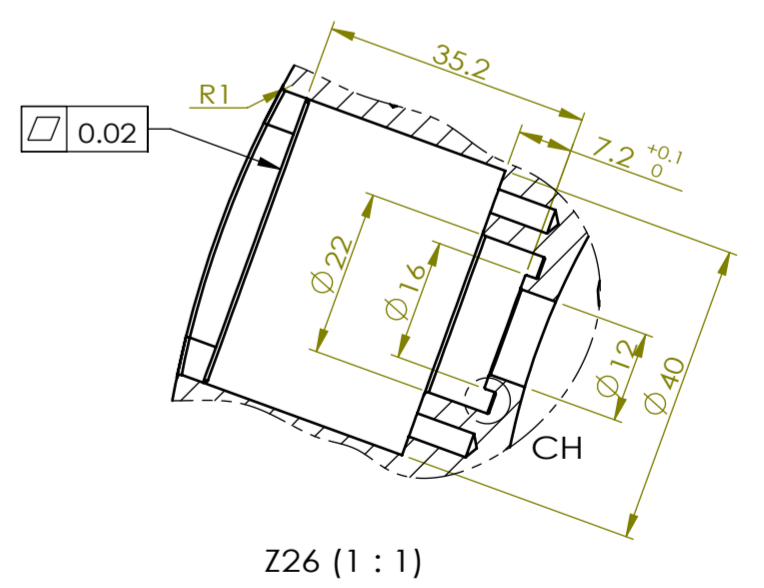
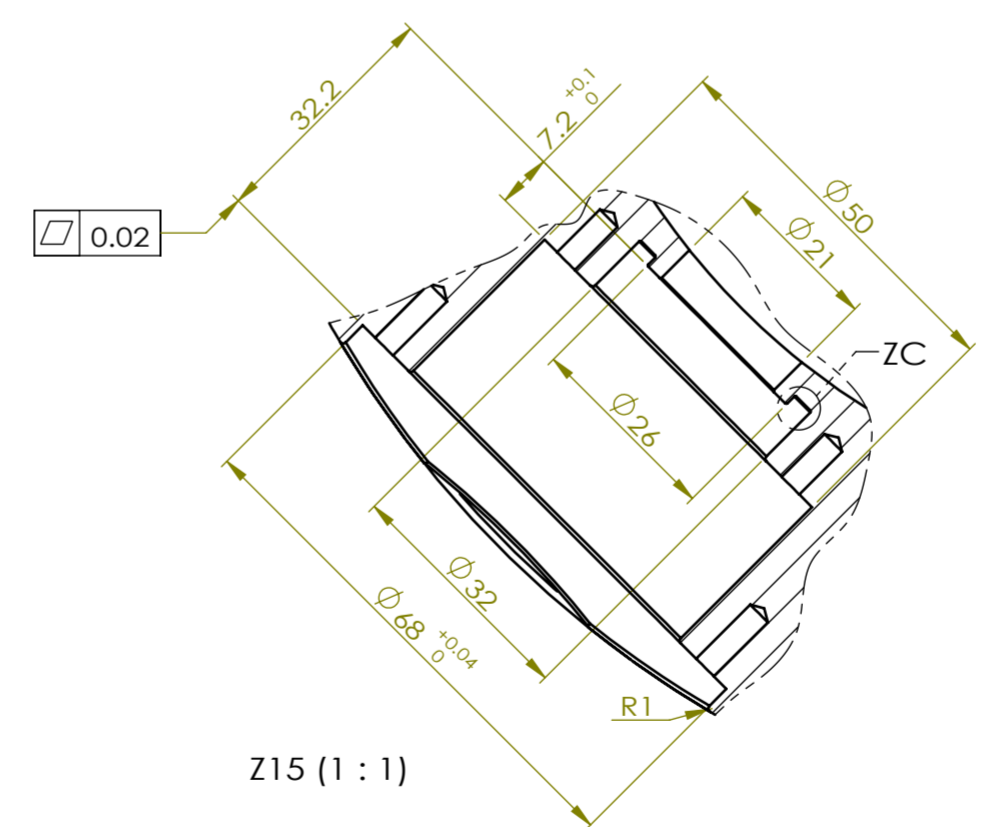
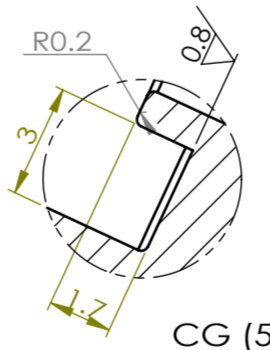
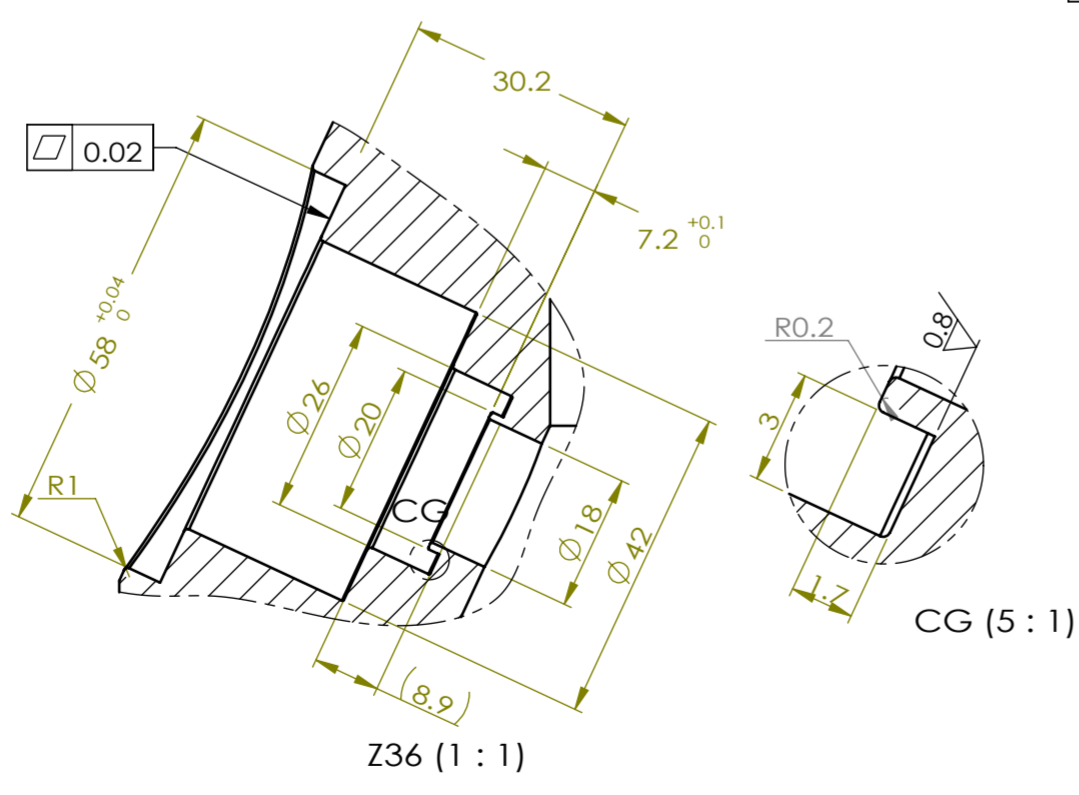
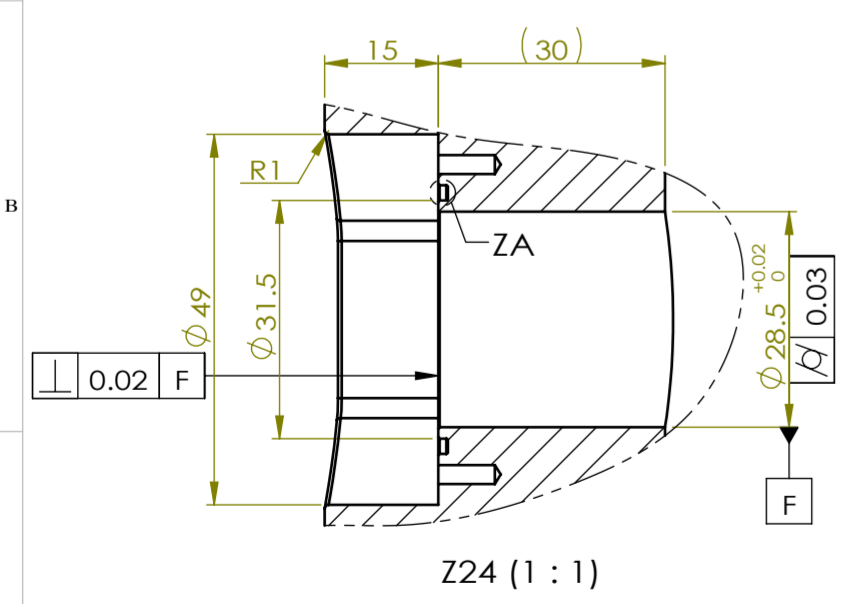
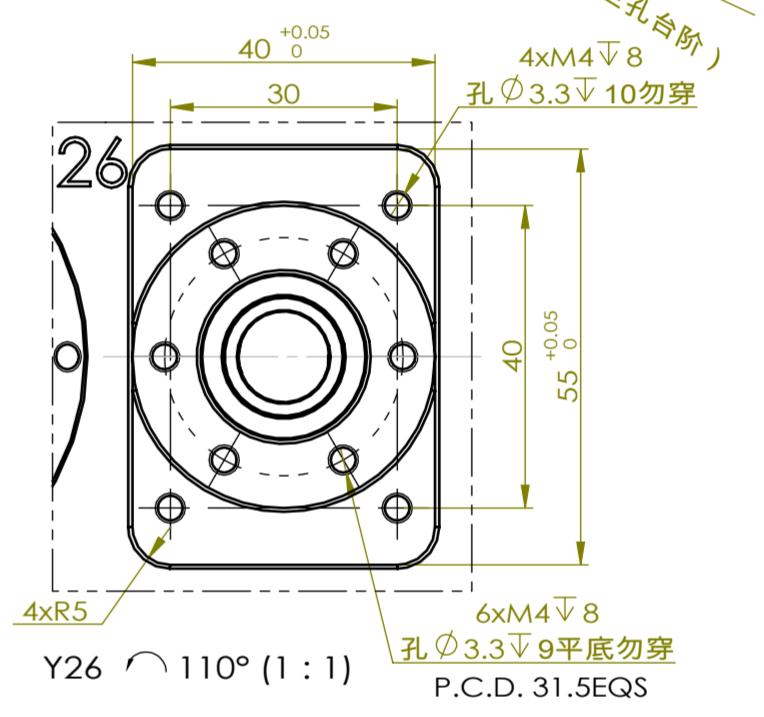
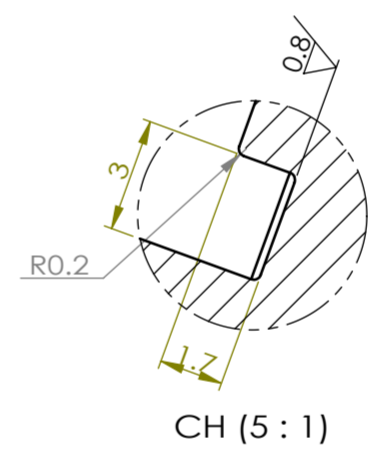
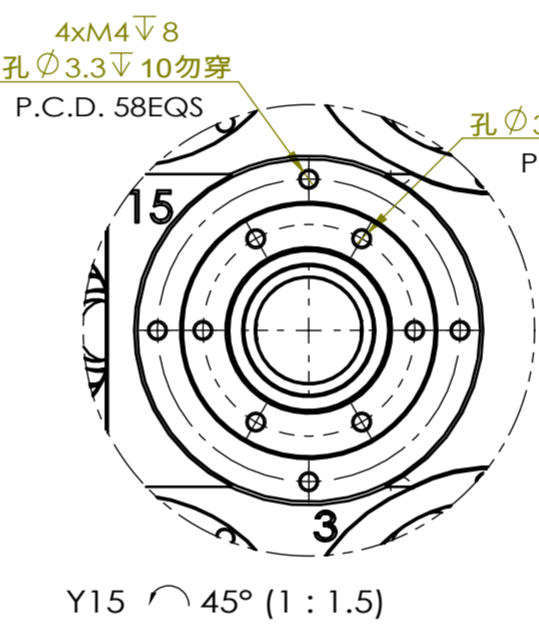
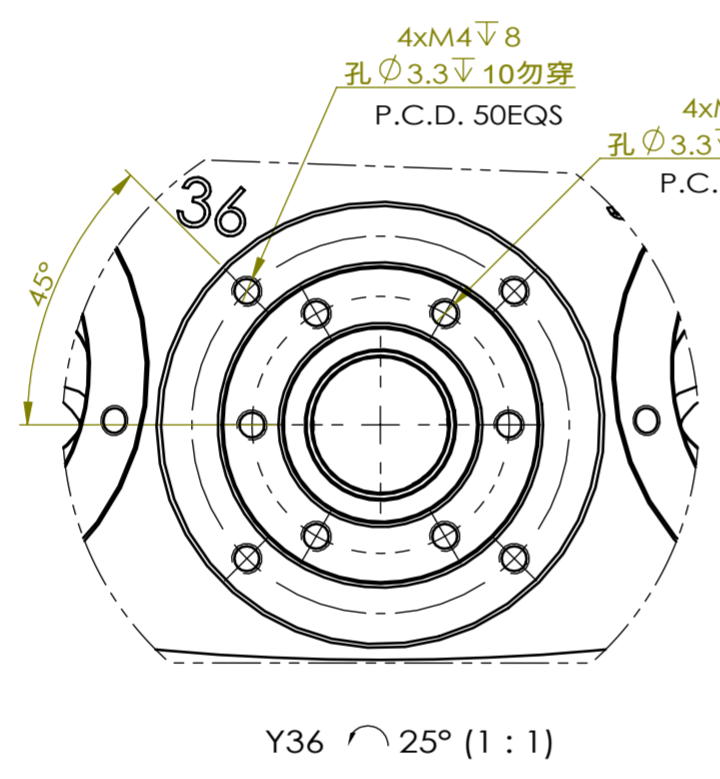
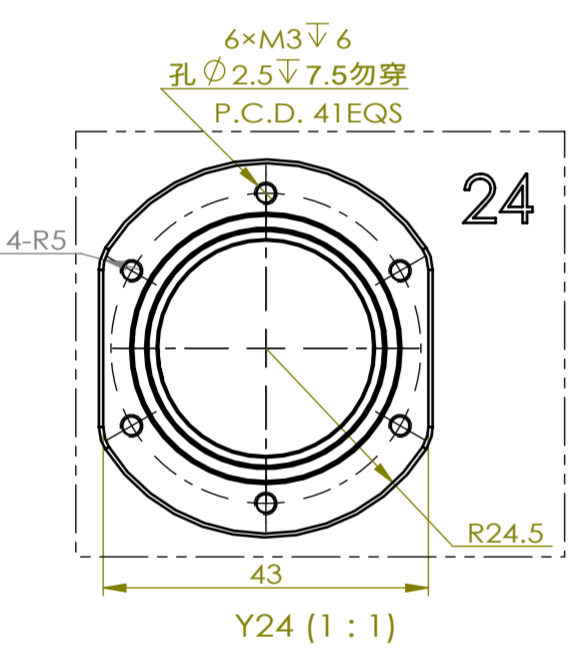
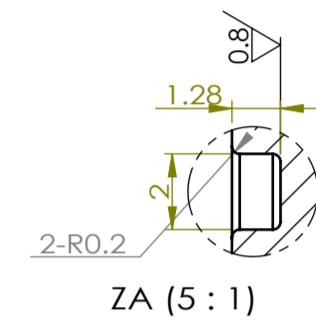
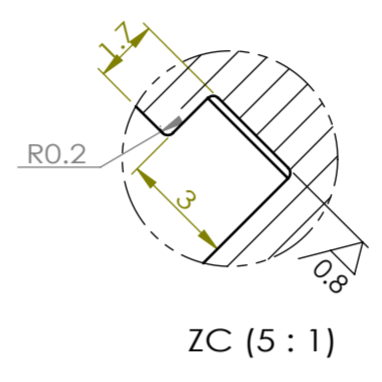
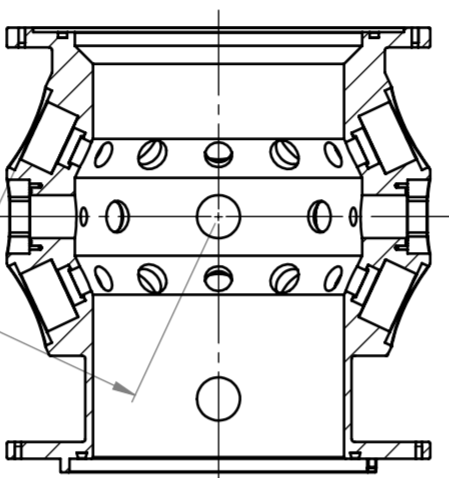
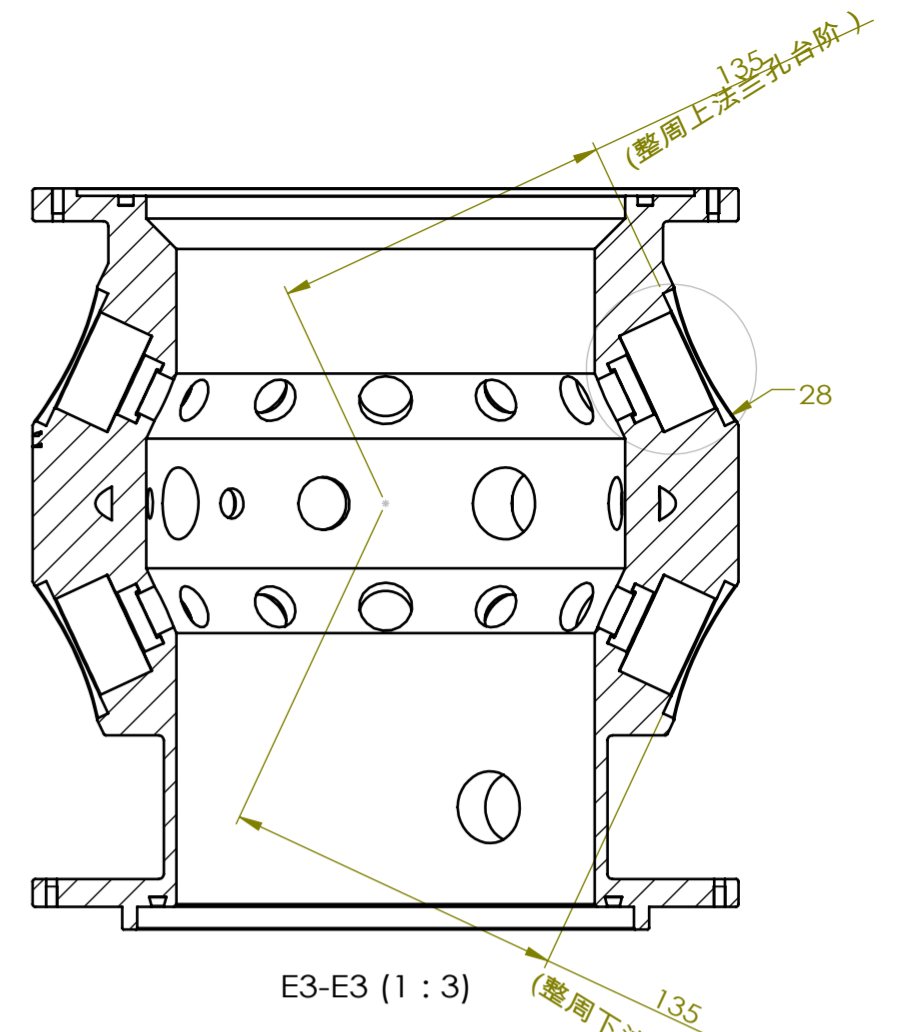
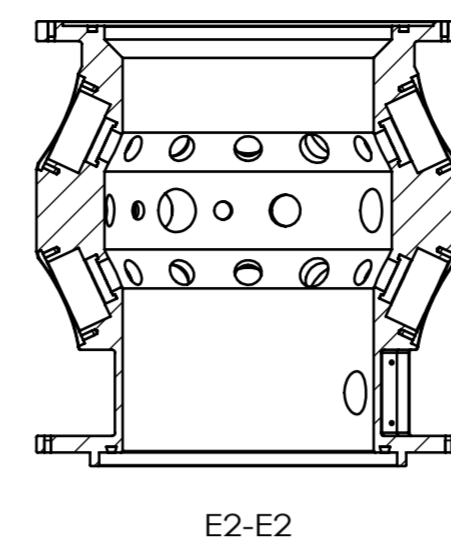
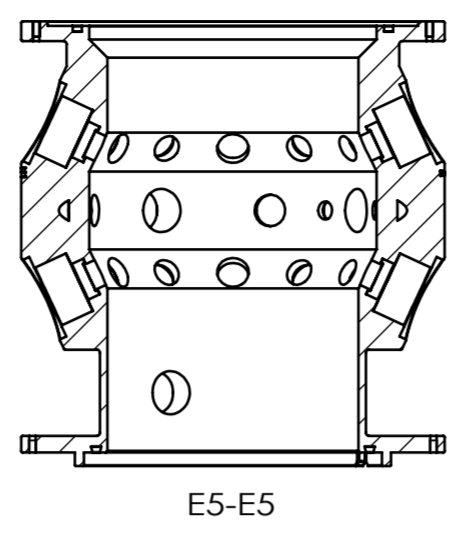
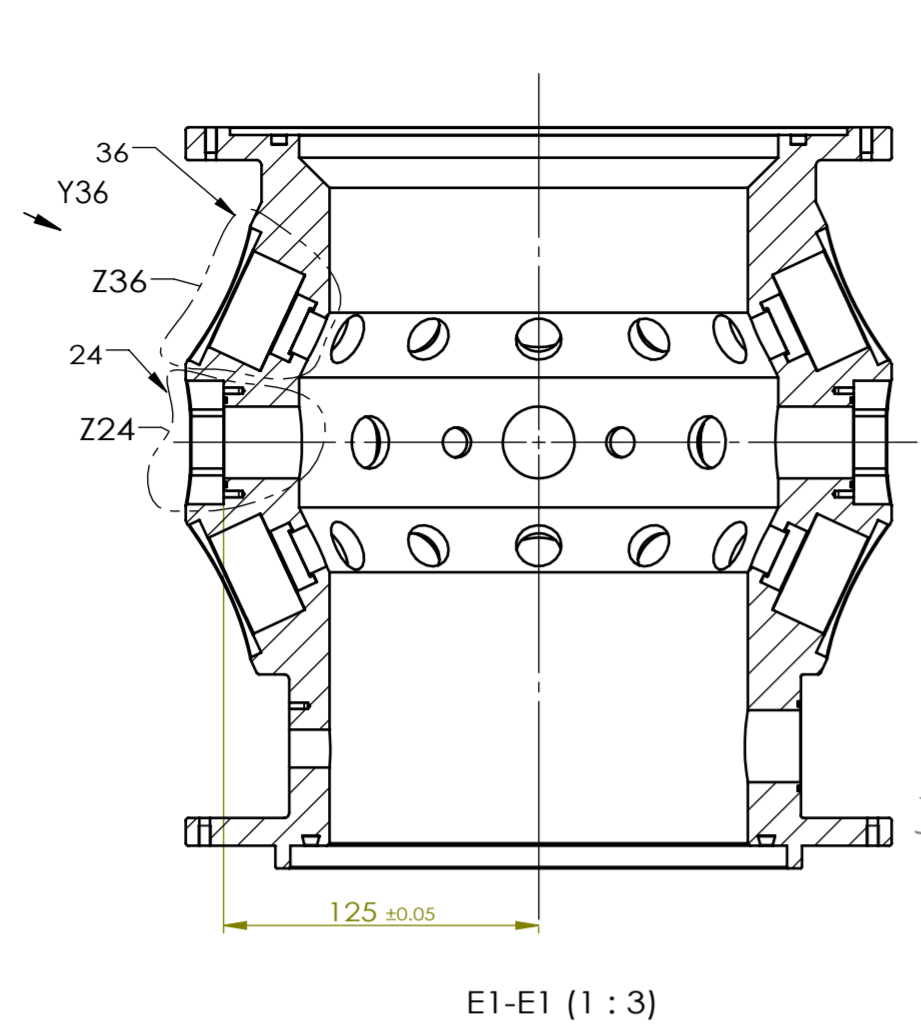


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TOLERANCE		
UNLESS OTHERWISE STATED		
RANGE	DIAMETER	LENGTH
1-20	±0.10	±0.10
21-63	±0.10	±0.20
64-300	±0.15	±0.30
301-500	±0.20	±0.50
500~	±0.20	±0.60

ROUGHNESS SYMBOL	
3.2	(1.6/0.8)

HEAT TREATMENT (HRc)	
UNLESS OTHERWISE STATED	0.3 ^C



重量约: 12.67kg

UNIT: mm	SIZE: A2	SCALE:	MATERIAL: 2a12	Q'ty: 1
SURFACE TREATMENT: 阳极氧化 (黑色)			ASSEMBLY TITLE: 外腔体加工	
DRAWN: 徐文良	DESIGNED: 徐文良	CHECKED:	APPROVED:	
2019/1/12	2019/1/12			
DRAWING NO.: ELF-01-00-00-01-外腔体(2/4)			MODEL NO.: ELF-01-00-00-01-外腔体	

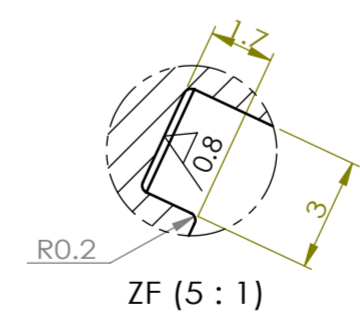
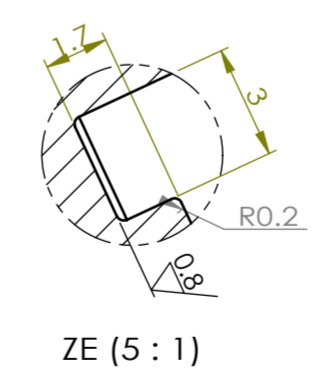
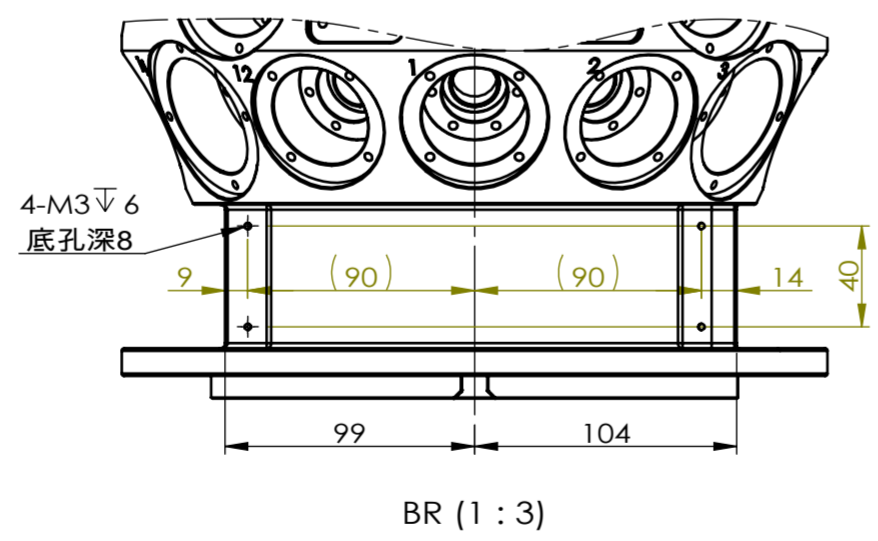
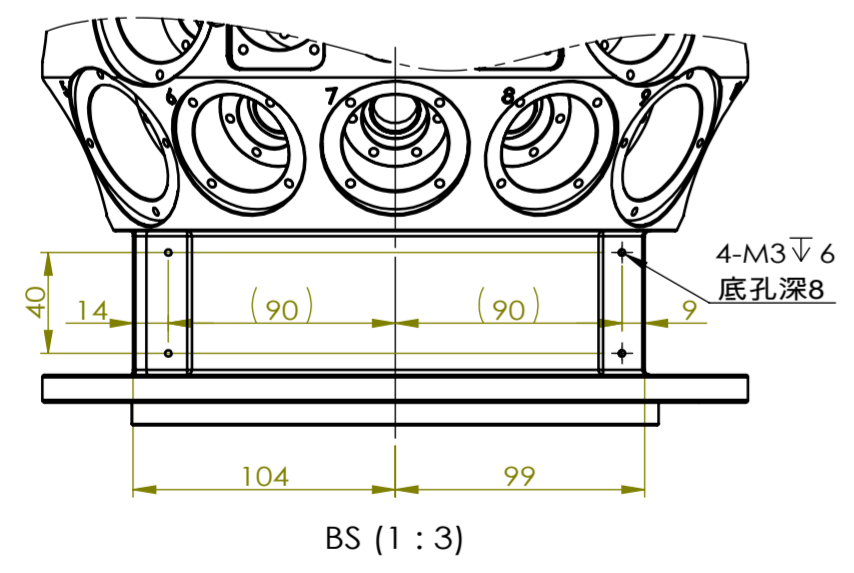
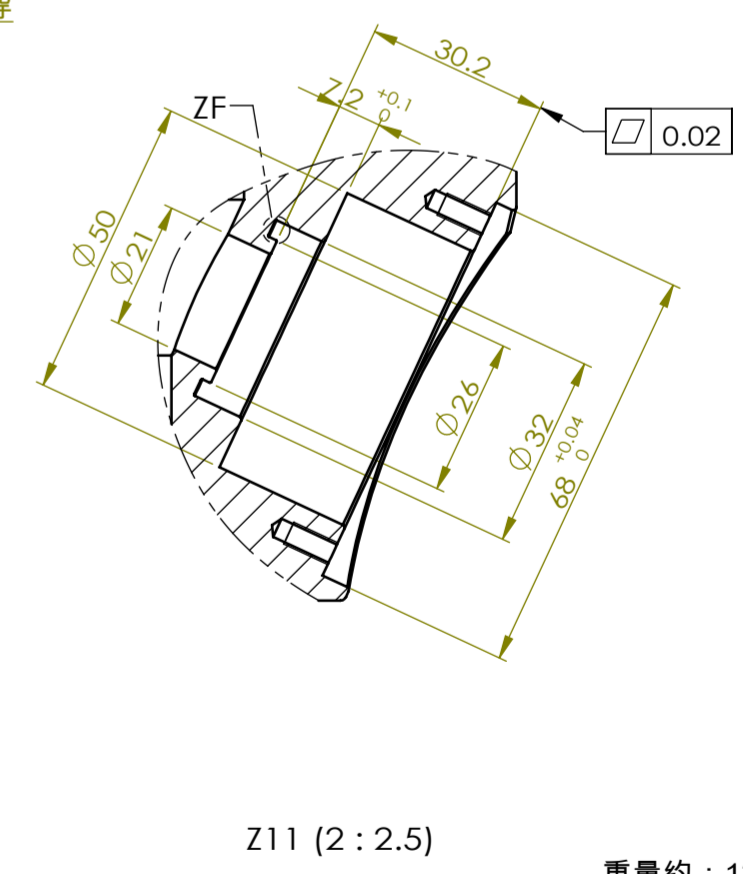
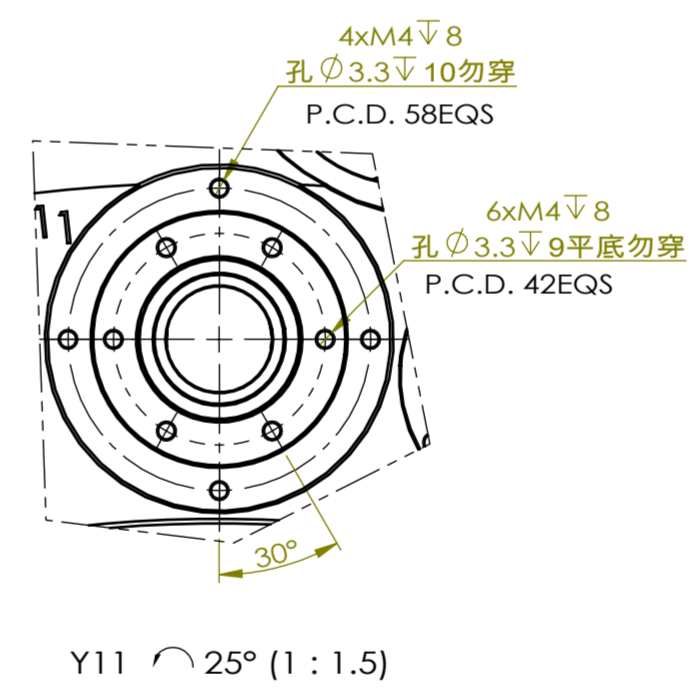
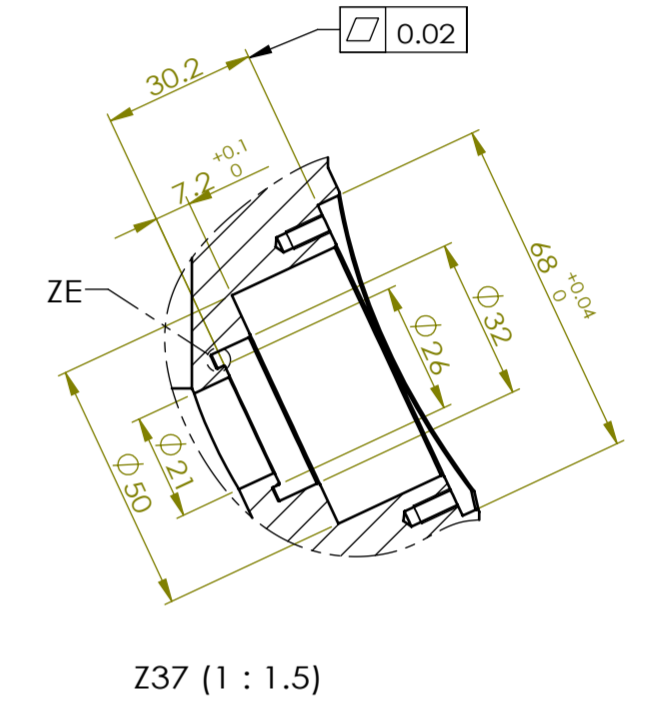
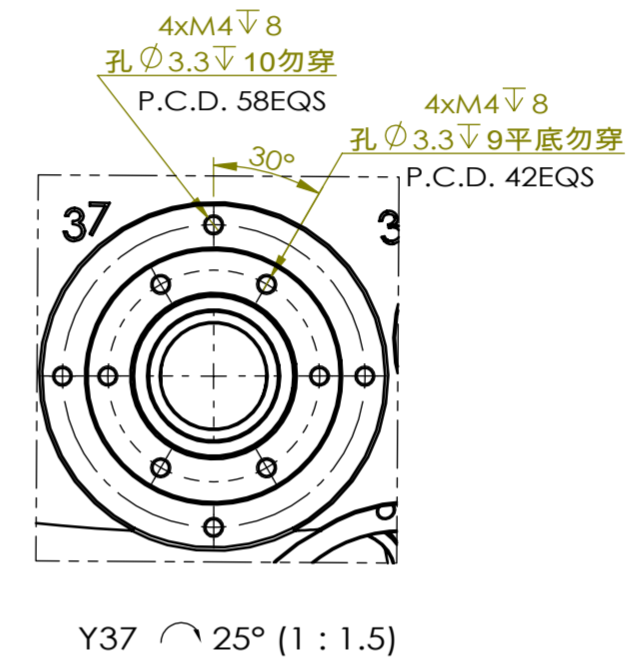
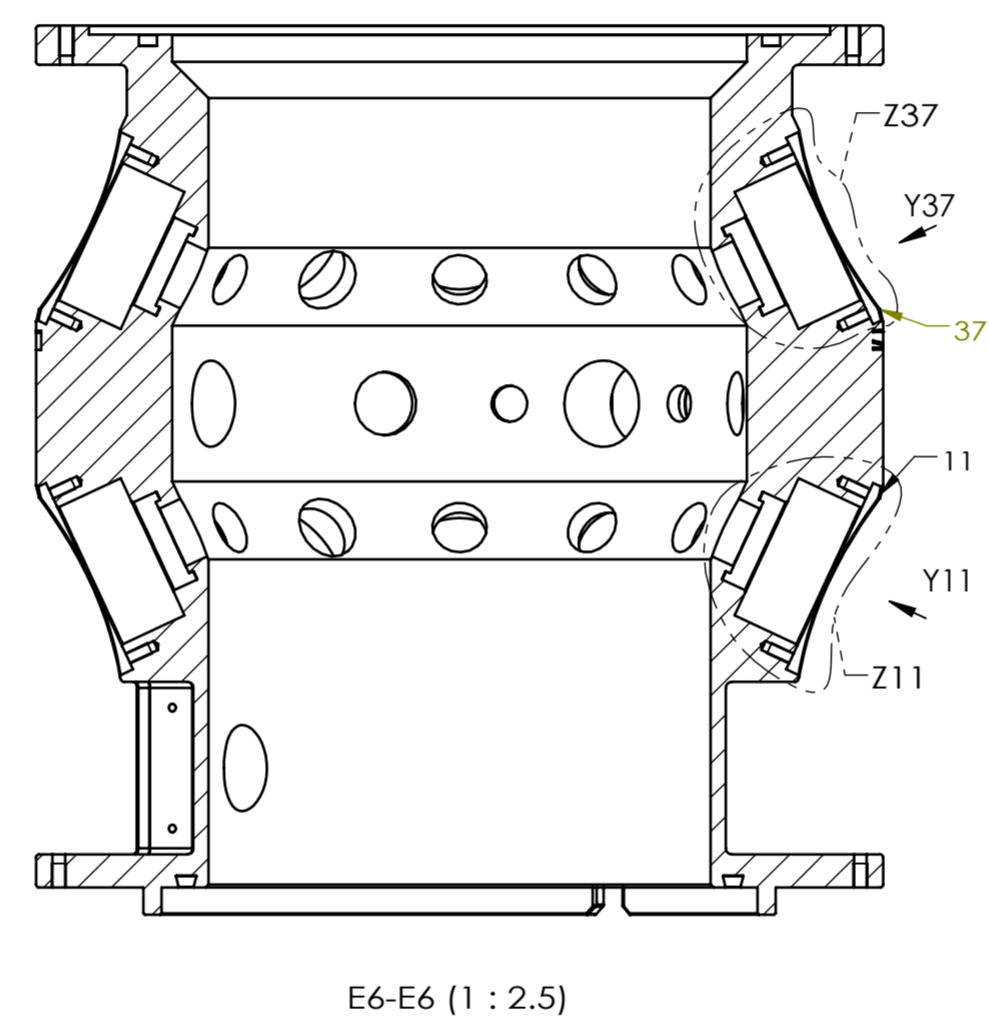
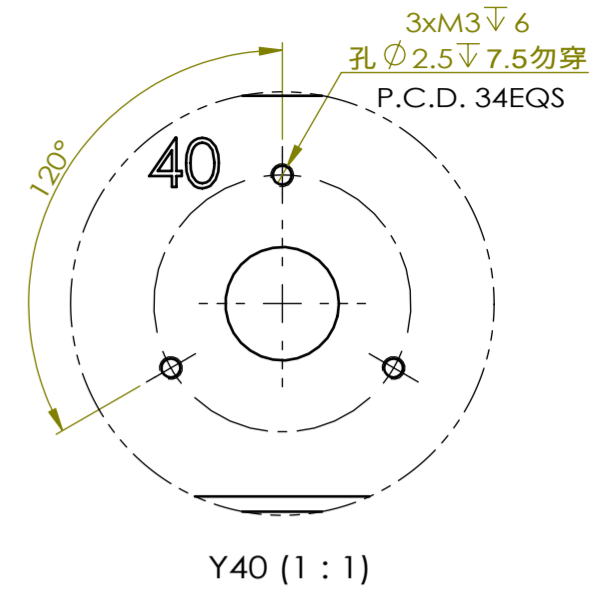
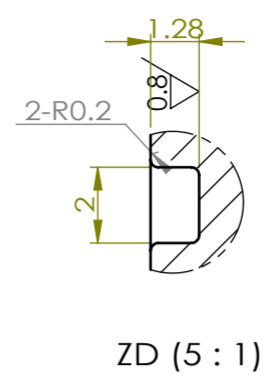
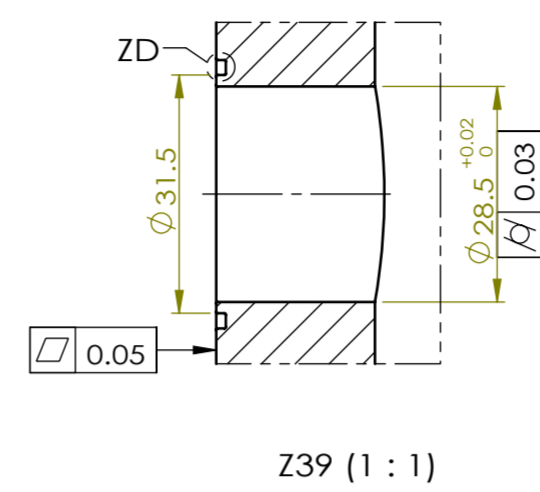
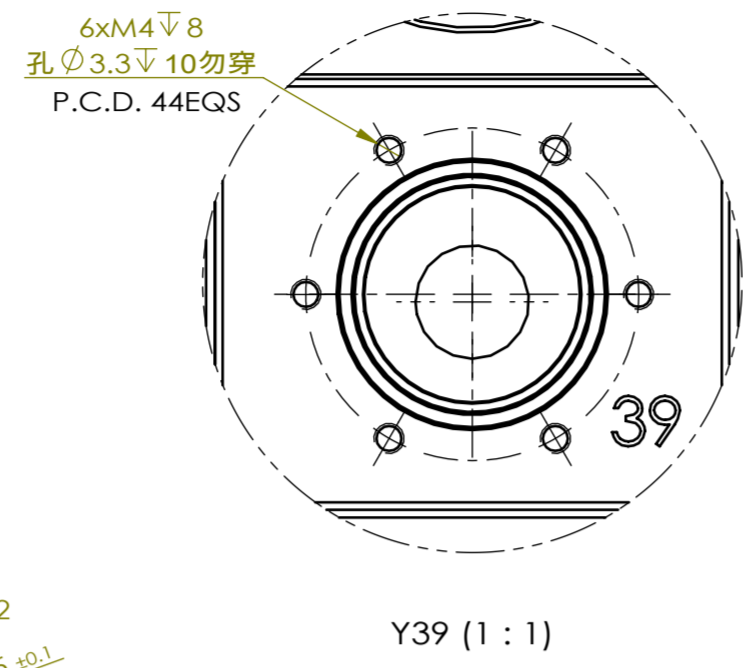
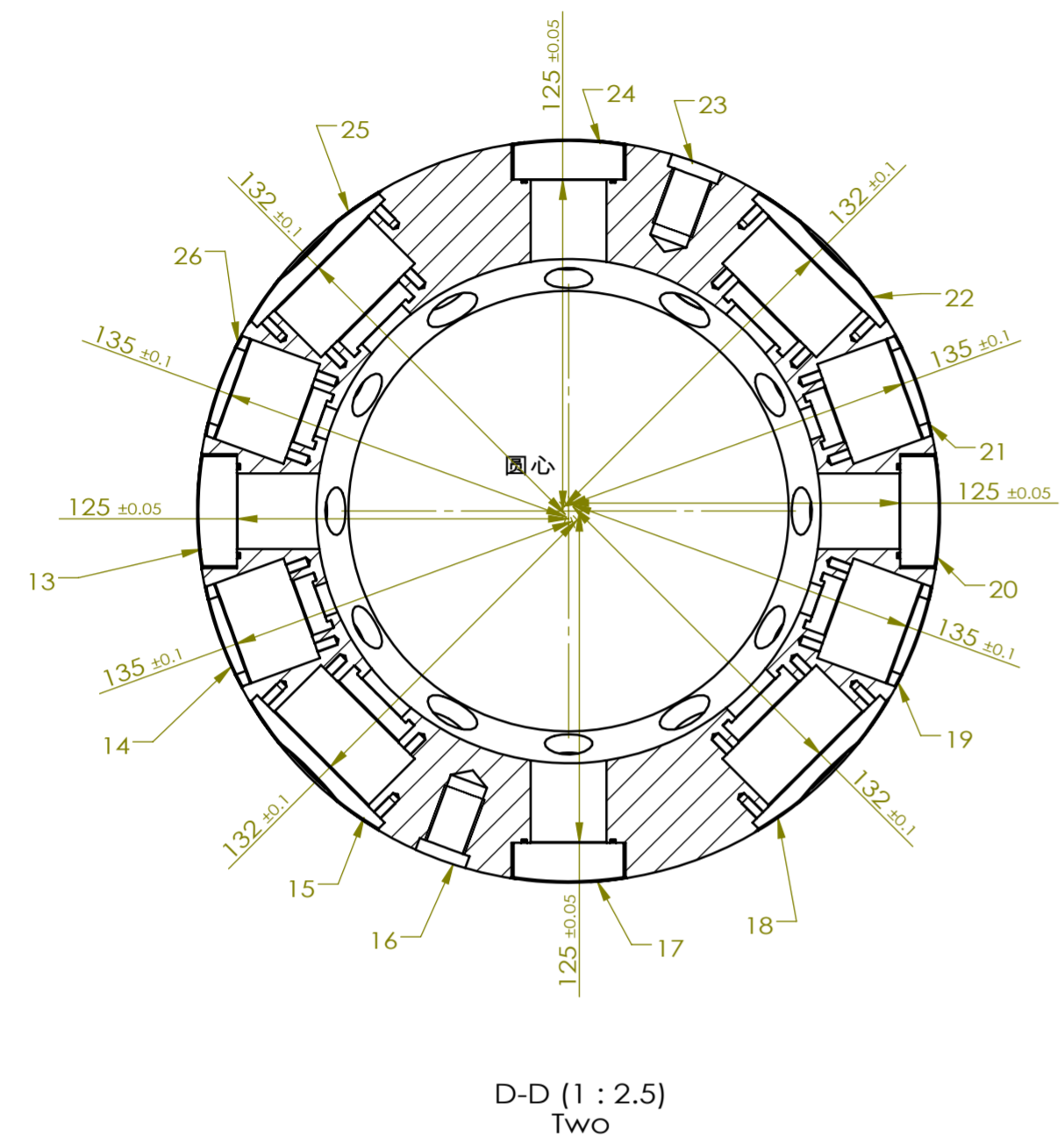
REV	DATE	DESCRIPTION	APPD

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TOLERANCE		
UNLESS OTHERWISE STATED		
RANGE	DIAMETER	LENGTH
1-20	±0.10	±0.10
21-63	±0.10	±0.20
64-300	±0.15	±0.30
301-500	±0.20	±0.50
500~	±0.20	±0.60

ROUGHNESS SYMBOL		
3.2	1.6	0.8

HEAT TREATMENT (HRc)	
UNLESS OTHERWISE STATED	0.3



重量約 : 12.67kg

UNIT: mm	SIZE: A2	SCALE: 1:2.5	MATERIAL: 2a12	Q'ty: 1
SURFACE TREATMENT: 阳极氧化 (黑色)			ASSEMBLY TITLE: 外腔体加工	
DRAWN: 徐文良	DESIGNED: 徐文良	CHECKED:	APPROVED:	
2019/1/12	2019/1/12			
DRAWING NO.: ELF-01-00-00-01-外腔体(3/4)			MODEL NO.: ELF-01-00-00-01-外腔体	

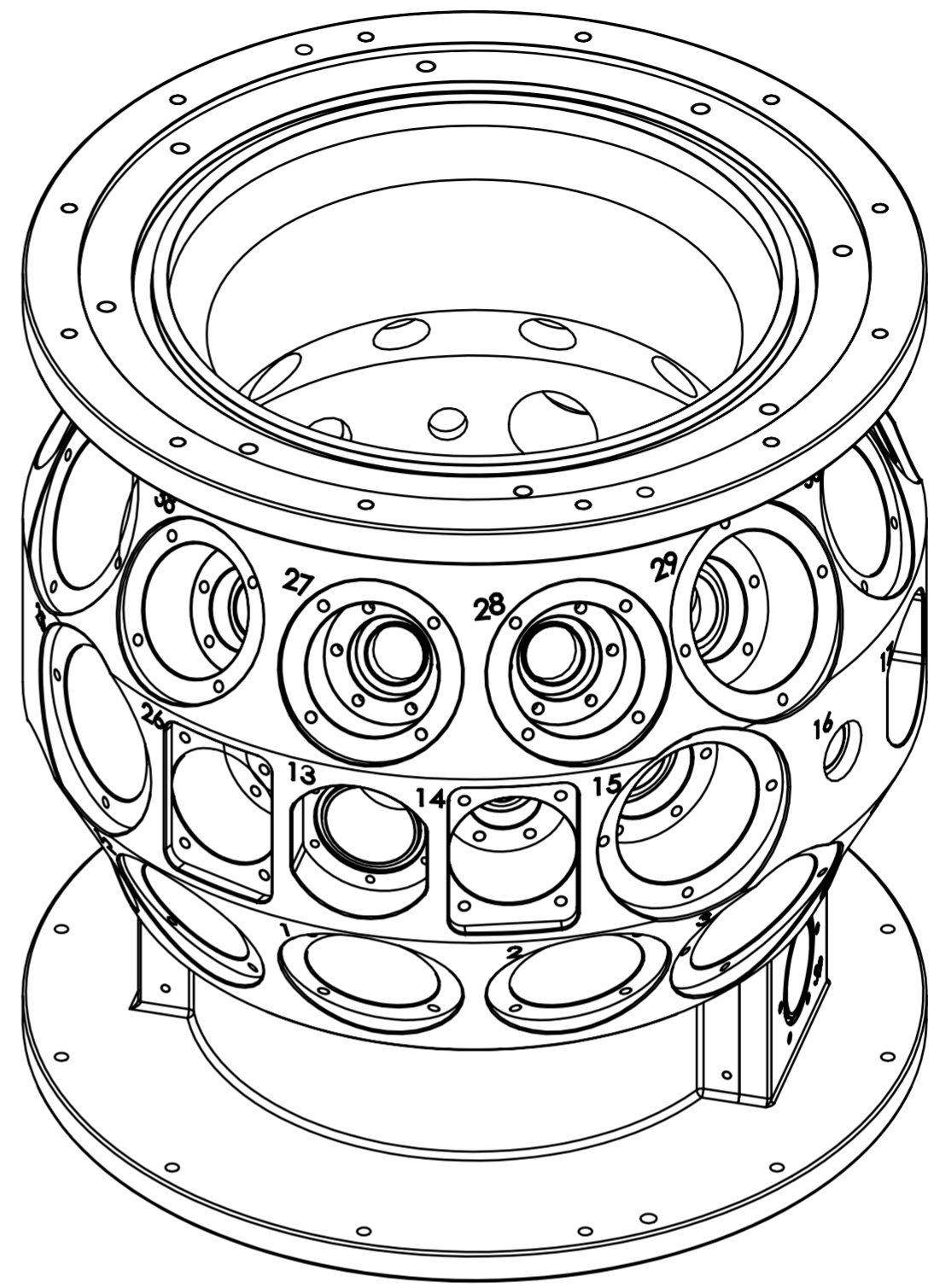
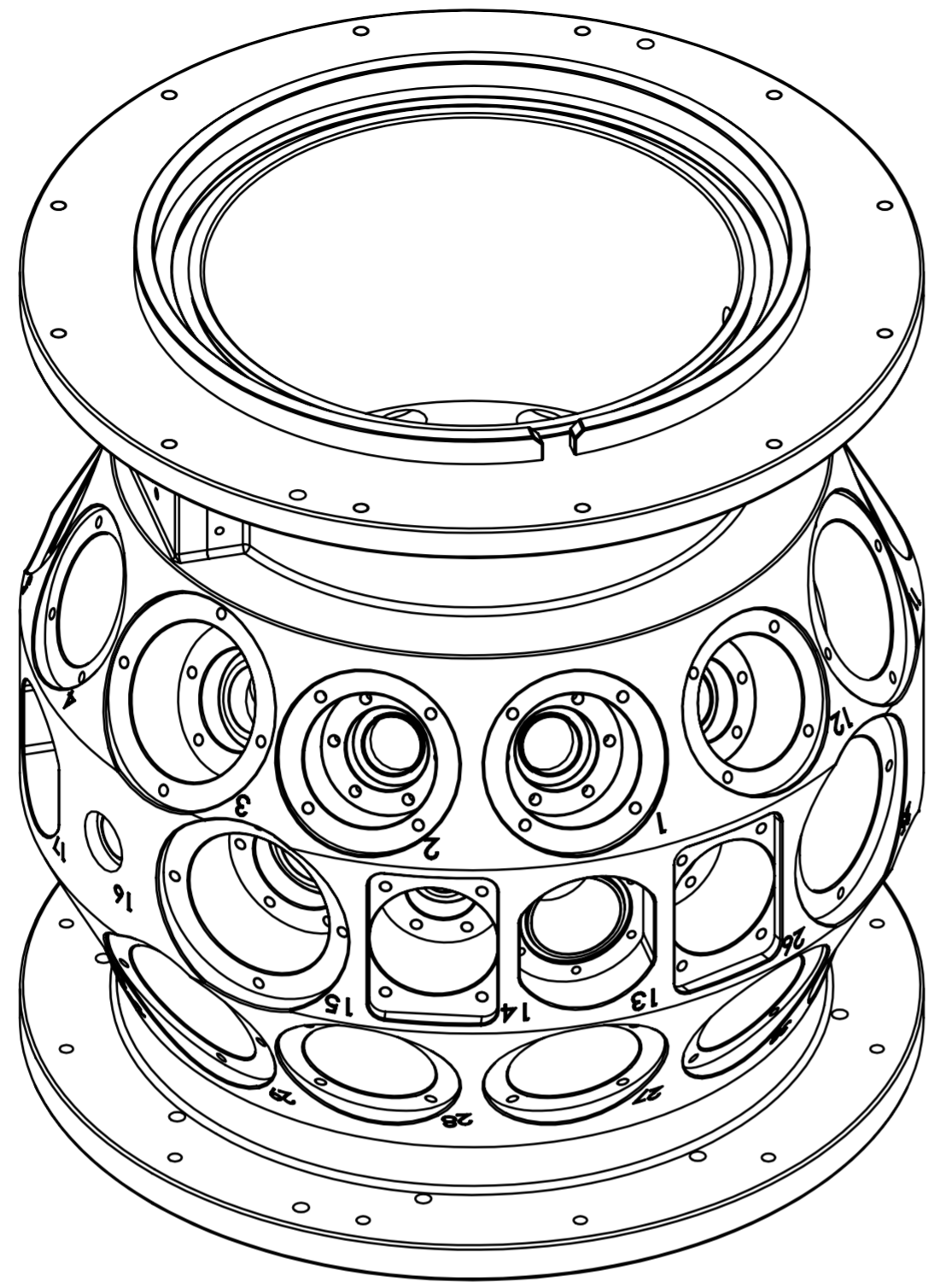
REV	DATE	DESCRIPTION	APPD

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TOLERANCE		
UNLESS OTHERWISE STATED		
RANGE	DIAMETER	LENGTH
1-20	±0.10	±0.10
21-63	±0.10	±0.20
64-300	±0.15	±0.30
301-500	±0.20	±0.50
500~	±0.20	±0.60

ROUGHNESS SYMBOL	
3.2	(1.6 / 0.8)

HEAT TREATMENT (HRc)	
UNLESS OTHERWISE STATED	0.3 ^C
SHARP CORNERS	R



技术要求:

- 1、外腔体精加工前要进行热处理去应力；
- 2、视图D-D有两个为D-D One（图纸第一页）与D-D Two（图纸第三页）；
- 3、所有螺纹孔下钢丝螺套,(牙套深度按为螺孔标注的有效深度)；
- 4、零件表面无擦伤,划痕；
- 5、所有上法兰面,中法兰面与下法兰面的法兰安装孔轴线的交点论在腔体中心,轴线相对腔体中心偏差SR0.1；
- 6、孔1,2,4,6,7,8,10,12,27,28,30,32,,33,34,36,38,法兰安装孔尺寸相同,包括所有形位公差及尺寸公差。(见Y36和Z36视图)；
- 7、孔3,5,9,11法兰安装孔尺寸相同,包括所有形位公差及尺寸公差。(见Y11和Z11视图)；
- 8、孔13,17,20,24法兰安装孔尺寸相同,包括所有形位公差及尺寸公差。(见Y24和Z24视图)；
- 9、孔14,19,21,26法兰安装孔尺寸相同,包括所有形位公差及尺寸公差。(见Y26和Z26视图)；
- 10、孔,29,31,35,37法兰安装孔尺寸相同,包括所有形位公差及尺寸公差。(见Y37和Z37视图)；
- 11、孔15,18,22,25法兰安装孔尺寸相同,包括所有形位公差及尺寸公差。(见Y15和Z15视图)；
- 12、孔16,23法兰安装孔尺寸相同,包括所有形位公差及尺寸公差；
- 13、孔39,40为不同尺寸孔,均有独立视图表示；
- 14、所有孔周围刻字,刻字深度为0.15mm,字高4.8mm,刻字位置按照模型的方式进行刻字,不得触碰圆弧R角,破坏法兰安装孔加工面；
- 15、窗口编号为4、10、27、33视窗孔的整周上法兰孔台阶尺寸要求参照视图E4-E4中视窗孔27尺寸标注。

重量约: 12.67kg

UNIT: mm	SIZE: A2	SCALE:	MATERIAL	2a12	Q'ty	1
SURFACE TREATMENT			阳极氧化(黑色)		ASSEMBLY TITLE	
DRAWN	DESIGNED	CHECKED	APPROVED	PARTS NAME		
徐文良	徐文良			外腔体加工		
DRAWING NO.				ELF-01-00-00-01-外腔体(4/4)		
MODEL NO.				ELF-01-00-00-01-外腔体		

REV	DATE	DESCRIPTION	APPD

