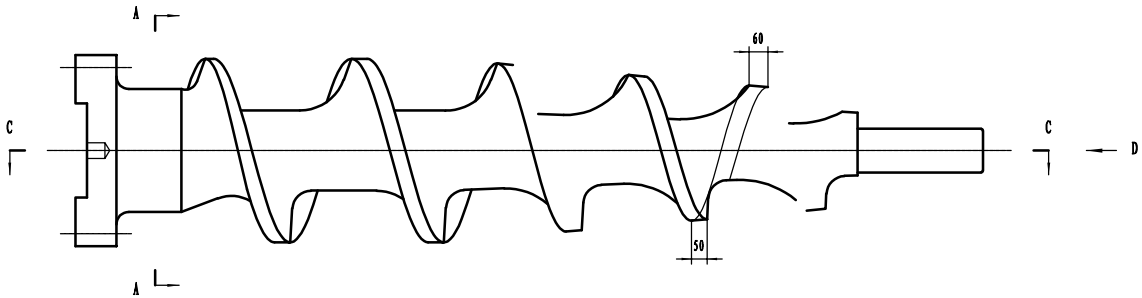
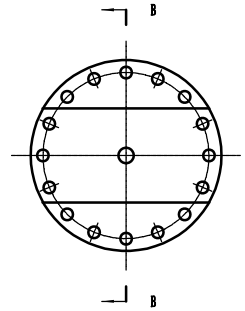
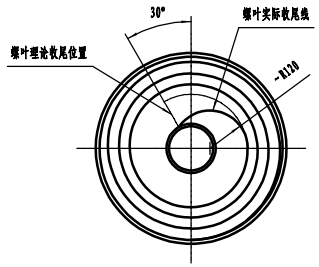
其余 6.3

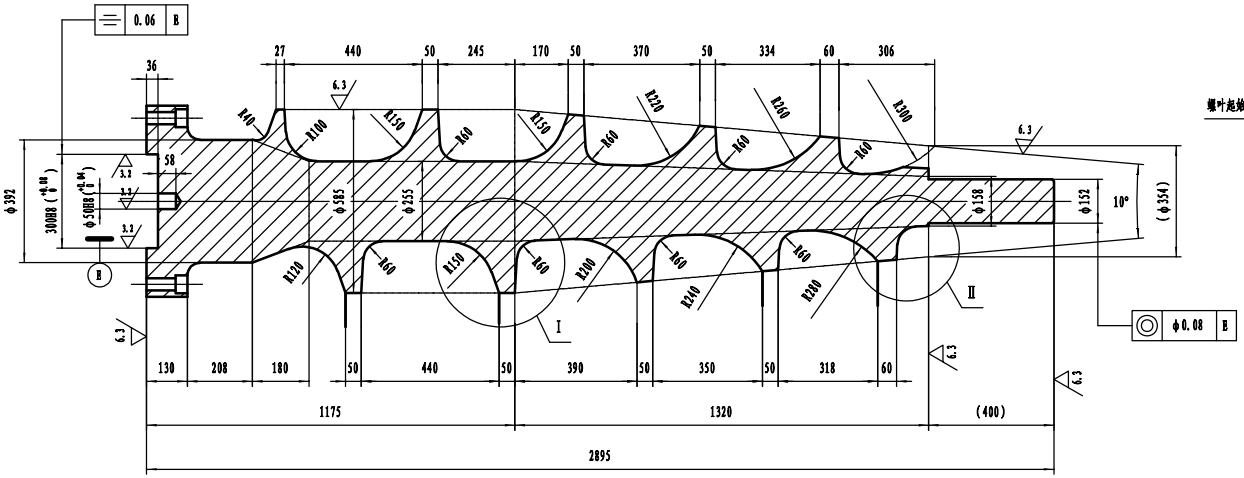




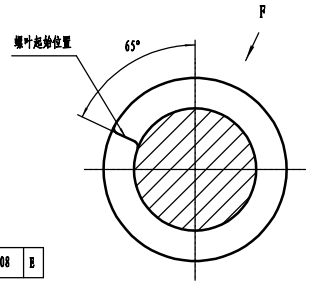
D 向



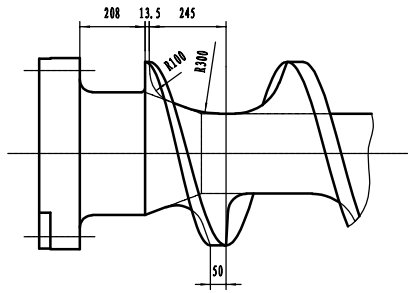
B－B



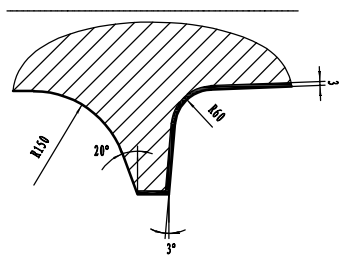
A－A



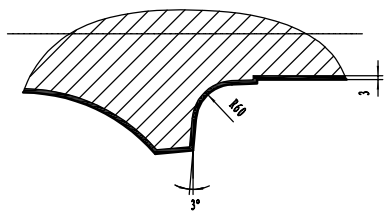
F 向



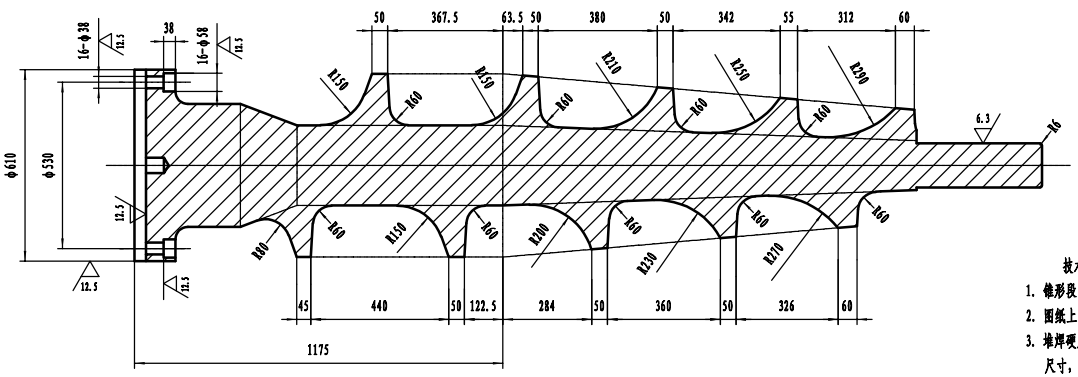
I
1：4



II
1：4



C－C



技术要求

1. 锥形段的螺旋面堆焊3mm厚的钨铬钴硬质合金，堆焊硬度不低于HRC55。
2. 图纸上的尺寸为加工后的净尺寸，零件铸造时应留出3mm厚的堆焊余量。
3. 堆焊硬质合金后应进行精加工，螺旋外径、锥度及芯轴直径等磨削至要求尺寸，其它无法进行机械加工的表面用手砂轮打磨抛光，表面粗糙度 6.3 。
4. 未注铸造圆角R5—15mm。

								ZG1Cr18Ni9Ti			23"螺旋喂料器
标记	处数	分区	更改文件号	签名	年、月、日						进料螺旋
设计			标准化			阶段标记		重量	比例		
								1520	1:8		
审核						共 张 第 张					LZW23A-0-14
工艺			批准								