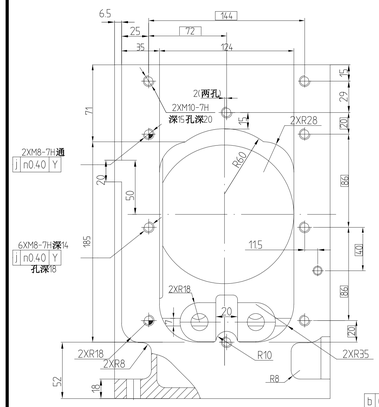
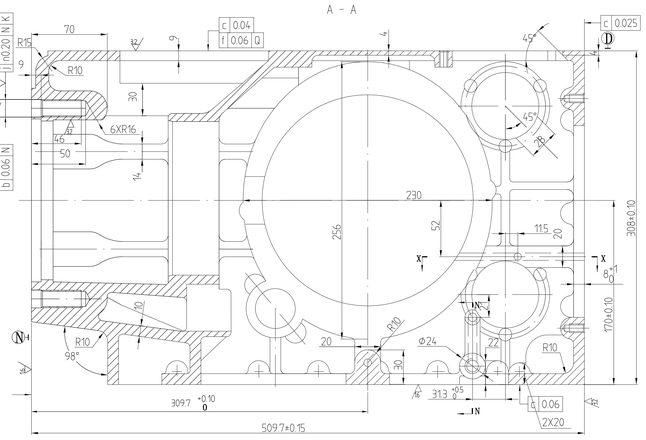
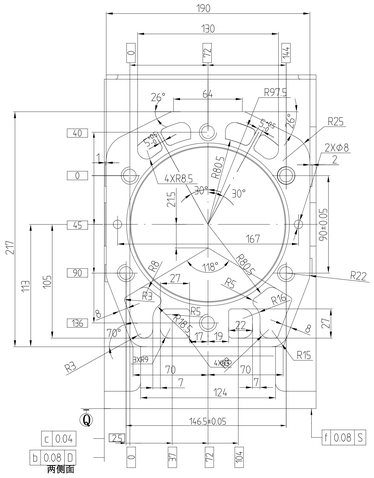
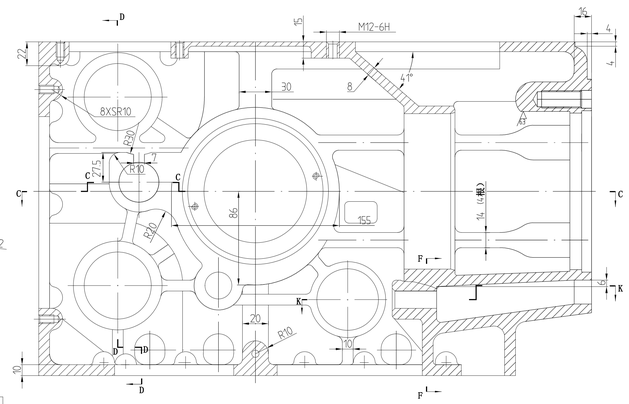
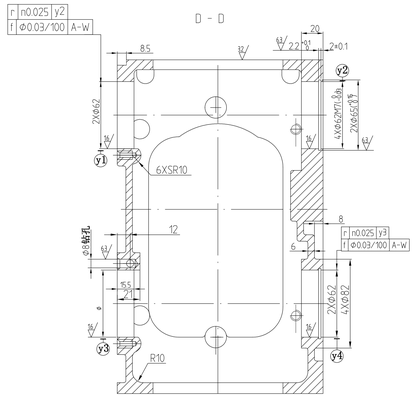
JD33.1-5

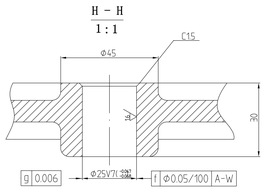


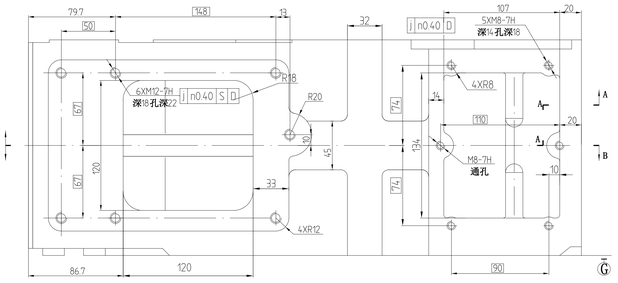


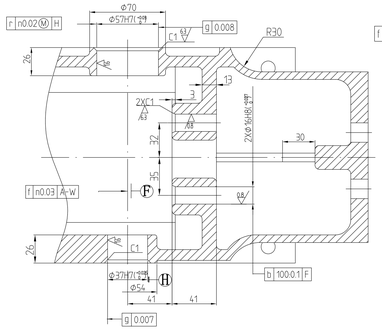


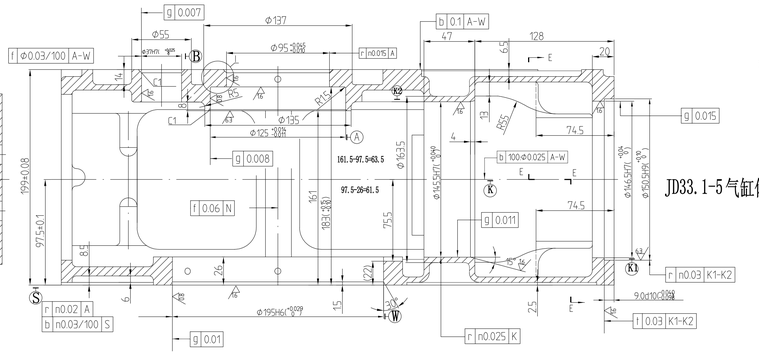


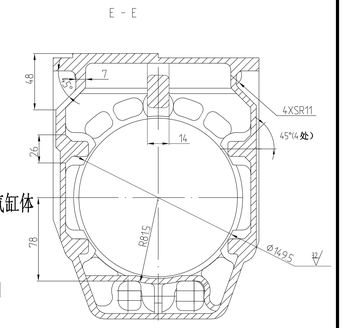








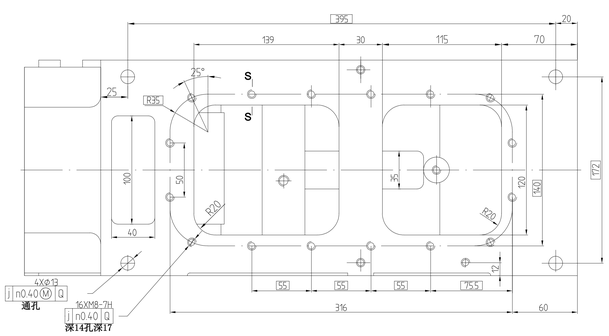


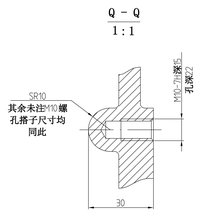


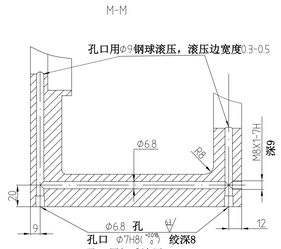
JD33.1-5气缸体

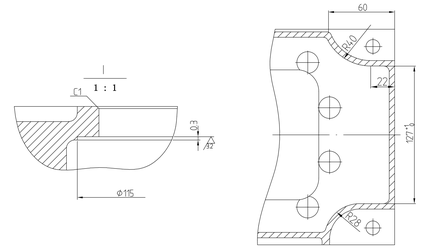
技术要求

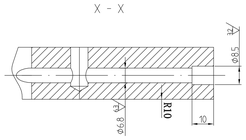
1、未注明铸造圆角半径为R8-10
2、铸造斜度不大于2°
3、未注明铸件壁厚5.5$^{+1}_{0}$ ，未注明筋宽10
4、浇口、冒口、泥沙芯、飞边、毛刺、包砂必须彻底清除干净
5、铸件应经退火处理，消除内应力
6、硬度190-240HBS，硬度在图上注有N面测量
7、显微组织应为细片状或中等片状珠光体，允许有少量（不大于5%）的铁素体和孤立分布的的磷共晶存在，石墨呈较均匀分布的细小或中等片状或菊花状
8、铸件不允许存在的铸造缺陷
(1) 铸件不允许有裂纹、浇不足、严重粘砂以及其它降低铸件结构强度或影响切削加工和铸件定位夹紧的铸造缺陷
(2) 机体与气缸套结合的表面主轴承孔和螺纹孔不允许有任何加工不掉的铸造缺陷
(3) 铸件的所有通水道不允许有严重影响水流状态的披缝及其它杂物存在
9、铸件允许存在的铸造缺陷
(1) 非加工表面在离边缘20处允许有单个气孔，总数不多5个，直径小于5，深度小于1/4壁厚
(2) 加工表面上不应在边缘及螺孔周围10的范围内均有气孔存在，其余部分允许有单个气孔总数不多于5个，直径小于10
10 与气缸套配合的表面螺孔内表面及装配轴瓦的表面不应有任何缺陷
11. 有加工表面允许因石墨破裂而形成的点状针孔
12. 螺纹光洁无凹陷裂纹、所有未注钻孔及倒角均为
13. 螺孔口90° 倒角至螺纹外径（六个气缸盖螺栓除外）
14. 去尖角毛刺
15. 气缸套压入机体后，经392kpa的水压试验，历时15s不应有渗漏现象
16. 应消除型砂，粘砂，毛刺及金属屑，不加工表面应涂以铁红环氧底漆
17. 油道应彻底清除金属屑，并在490kpa的油压下进行试验、历时1min，不应有渗漏现象
18. 此机体为蒸循两用型，用作循环水机型时，水泵安装孔才需加工
19. 厂标ID为统一标准，突出2
20. 因铸造原因缸盖螺栓搭子影响缸套安装，要求精加工时 147.5镗孔从缸盖安装面向内镗深不小于80

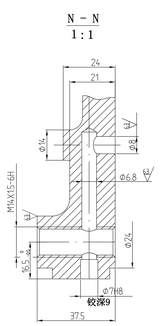


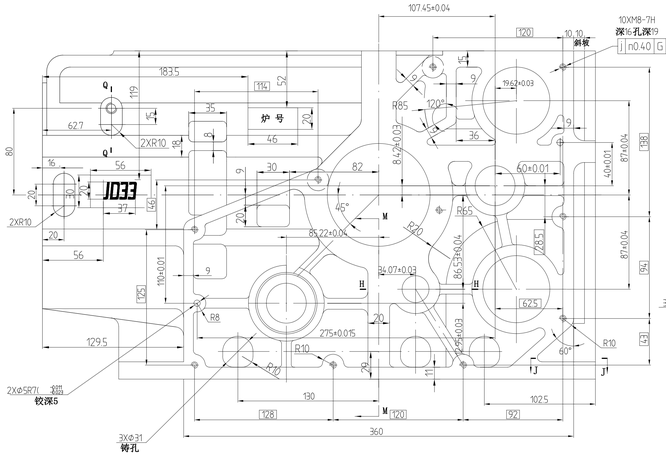


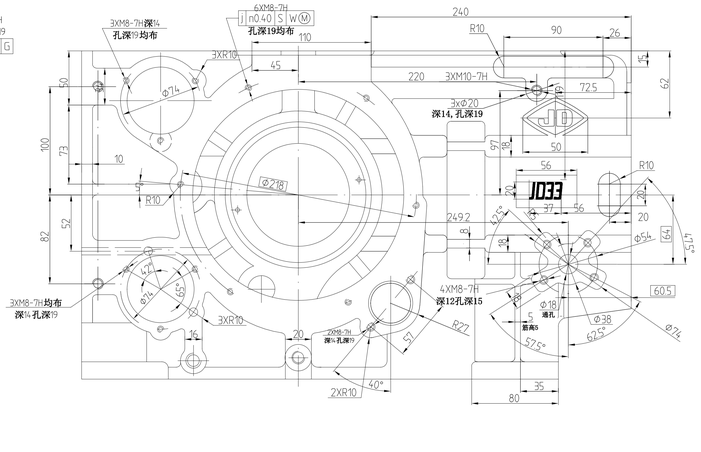


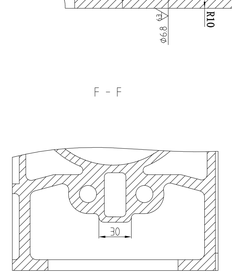












标记	处数	分区	更改文件号	签名	年月日
设计			标准化		
校对					
审核					
工艺			审定		

气缸体	JD33.1-5
图样标记	数量 / 重量 / 比例
S A	496kg 1:2
HT250 GB/T9439-1988	共 1 张 第 1 张
编码 02.01.01.006.068	江苏江淮动力股份有限公司

描图
CAD
描校
旧底图总号
底图总号
签字
日期