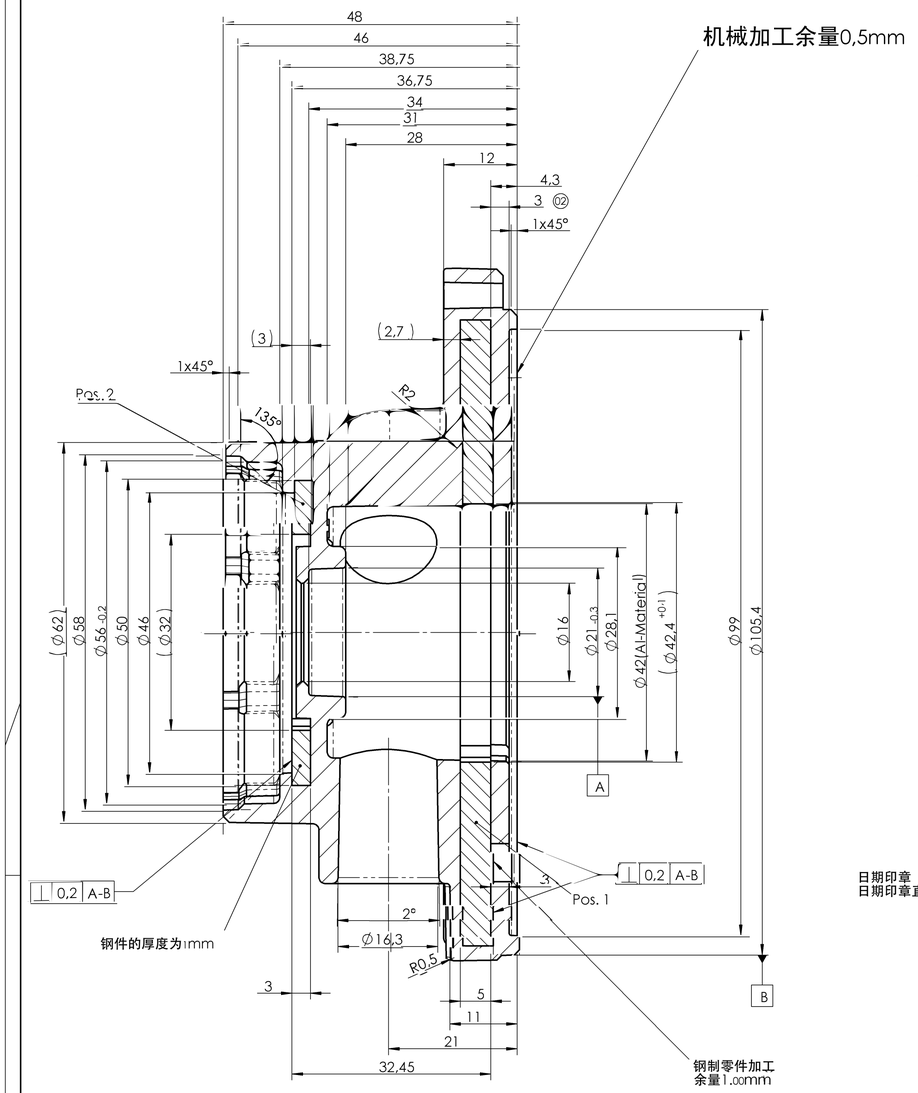
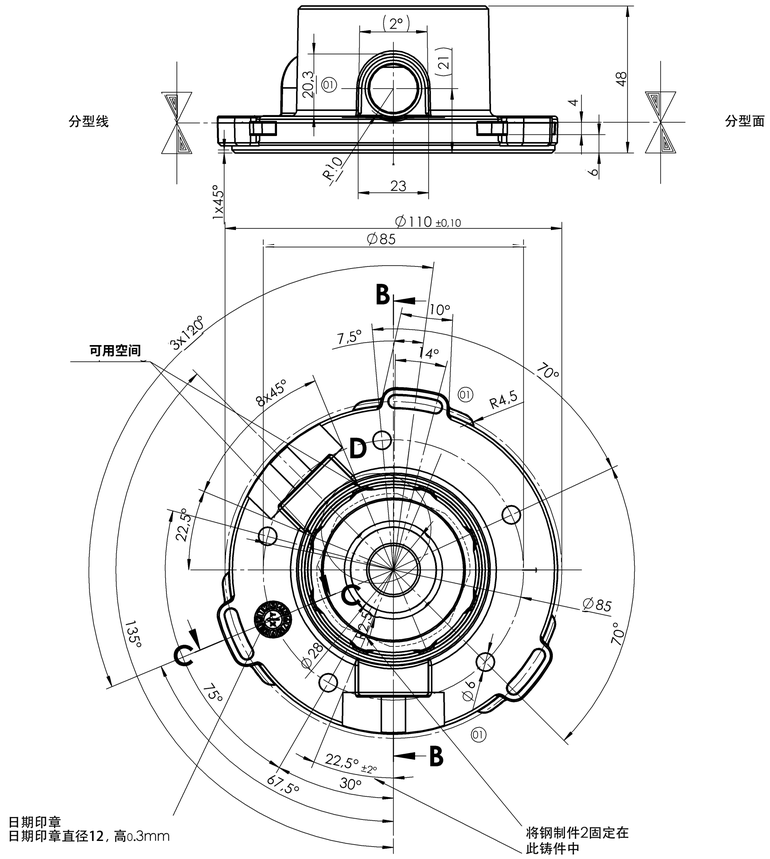
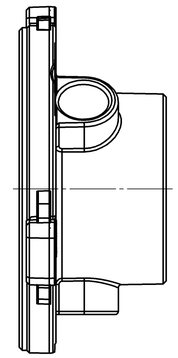
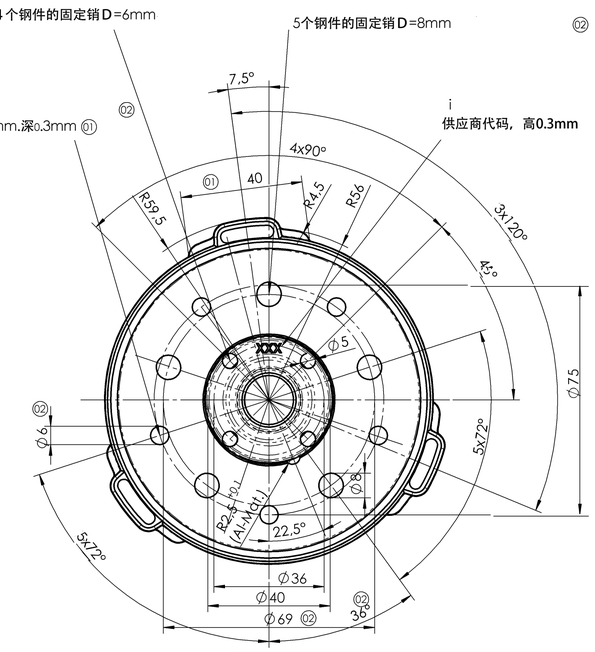


B-B
比例 **2 : 1**







零件必须进行抛丸处理　Rz 30-35

一般加工余量0.5mm

顶针最大深度+0,5/-0,2 mm

用真空系统铸造零件

机加工零件：112229

关于气孔，请注意AMT工作标准WN 023的定义

铸件结构和表面上均无气泡、气孔、空隙、裂缝和凹坑等，可以以极限样品的形式指定影响功能的铸造缺陷。

成型偏差最大0.2mm

最大允许毛刺0.2mm

表面和成品结构无缺陷。
需要为没有功能影响的铸造缺陷定义极限样品

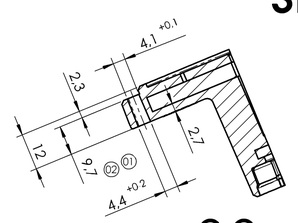
根据DIN 1688的一般公差

符合DIN 1725的材料标准

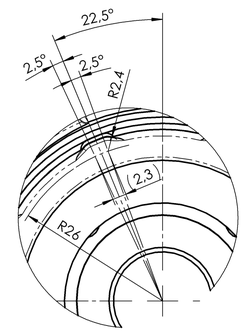
脱模角未定尺寸为1°
未标注半径R 1
无尺寸倒角lx 45°

铸件清洗,无干净抹灰，细节打磨

3D扫描评估的图形执行



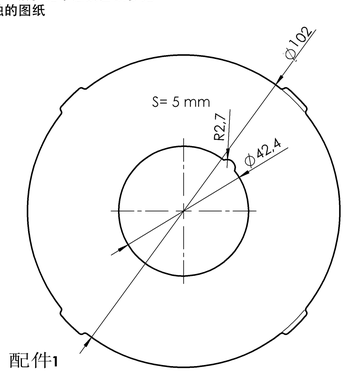
C-C



D (2 : 1)

仅钢垫圈112231

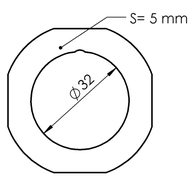
材质：钢参见单独的图纸参见
单独的图纸 (02)



配件1

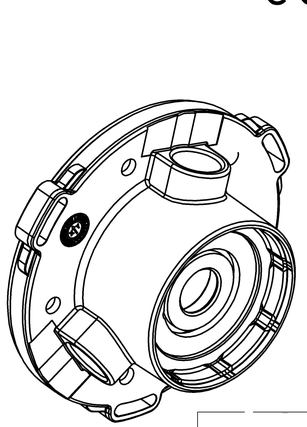
重量：0,27 kg

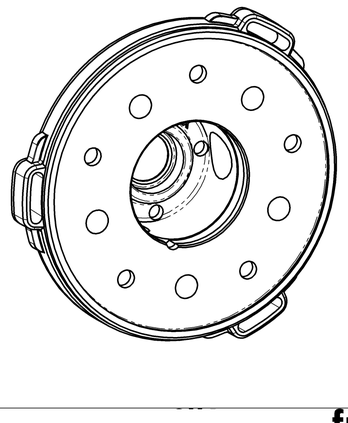
仅限钢板编号112232
材料：钢参见单独的图纸



零件2

重量:0.029 kg





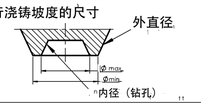
材料钢：C50/1.0540
或者: GD-AlSi9Cu3 (01)

重量：0,52 kg

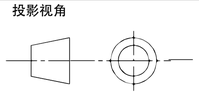
表面光洁度
铸造/模具滑块
Rz 40

从3D零件中获取缺失的尺寸

执行浇铸坡度的尺寸



投影视角



普通公差（尺寸无公差范围）DIN1688，用于浇铸系列GTA 13/5

Nennmaß/ nominal size	0- 18	>18- 30	>30- 50	>50- 80	>80 - 120	>120-180	>180 -250	>250-315	>315-400	>400-500
Toleranz / tolerance	±0.17	±0.20	±0.25	±0.30	±0.35	±0.40	±0.45	±0.53	±0.55	±0.60

3				6	
2				5	
1	01	siehe Stammblatt	10.02.20	MG	4
Aend.-Nr.	Index	Aenderung/Change	Datum	Name	Aend.-Nr. Index Aenderung/Change Datum Name

表面光洁度符合EN DIN ISO 1302

U roh/raw	V Rz 63	W Rz 16	X Rz 4	Y Rz 2,5	Z geschliffen/grinded Rz 1,6

Allgemeintoleranzen/General tolerances DIN ISO 2768 - mK　=Pruefmass / Test dimension

Nennmass/Nominal size	0,5...6	> 6...30	> 30...120	> 120...400	> 400...1000	> 1000...2000
Toleranz/Tolerance	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2

Rauhe Roughness DIN EN ISO 4287 工件边缘 DIN ISO 13715

材料 GD-AlSi9Cu3	Blanke no/dimension		名称		Maßstab Scale 1:1
Bearb. Gepr.	20.12.19	MG	图号 112229	Zeichn. index Drawing index 02	B-Lagerschild kpl.RT
Norm.			Ersatz f./Substitute f.: 106837		Blattformat Sheet size A1

Blatt/Sheet 1/1

für g