

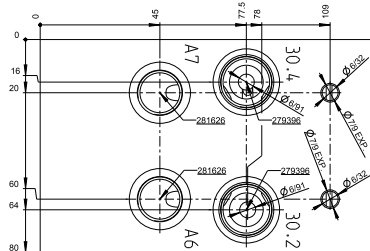
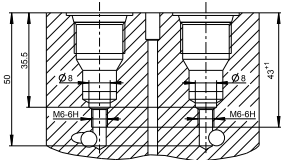
上海塑料
询价图纸

保密
Confidential

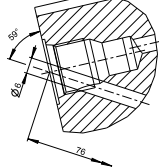
Index	Description of change	Date	Editor
2	ZMENENIE SÁZICE PORTY A KOMORY	04.08.2019	rs.bonin
3	Control of design. No technical control. All changes without effect on dimensions	04.10.2019	g.pich
4	Avoid of the prototype workshop	29.11.2019	g.pich
1	ZR 41181 EXPANDERS BKC TECHNICAL CLEANLINESS EXPANDERY BKC TECH CROTONA 30.01	13.07.2021	g.pich/mart1
6	41181 EXP. C.D. 30.1, 30.2, P.F. 11821 C.D. 30.1, 30.2, P.F.	09.10.2021	g.pich/mart1

6,3 (✓)

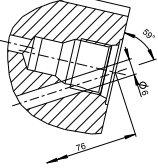
B-B



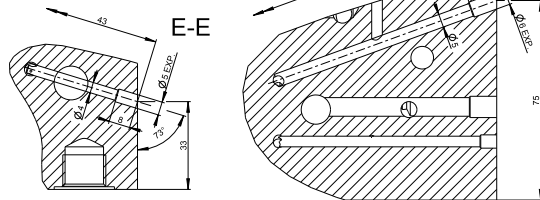
G-G



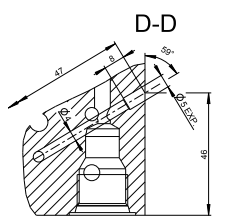
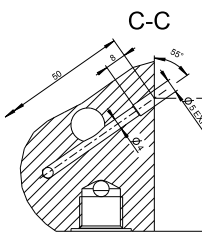
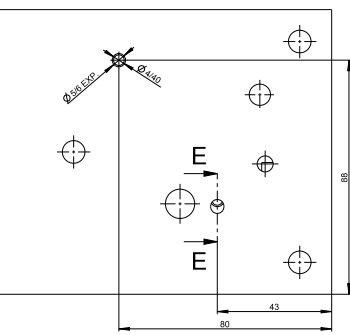
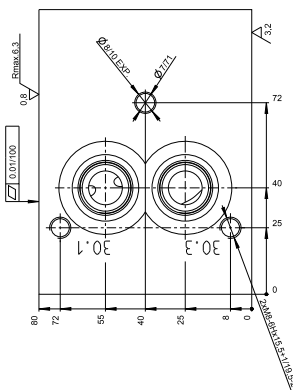
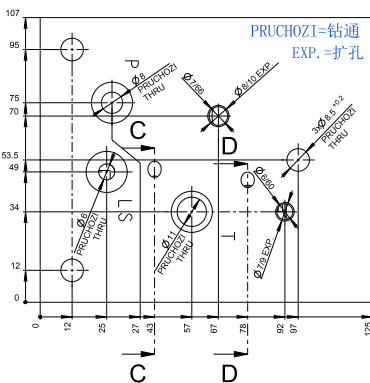
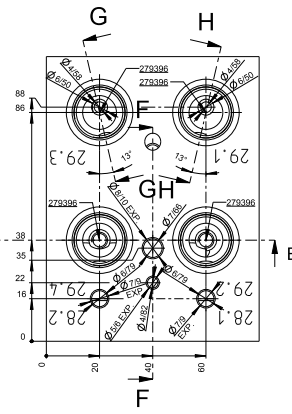
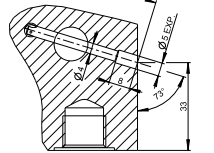
H-H



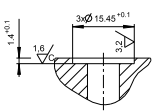
F-F



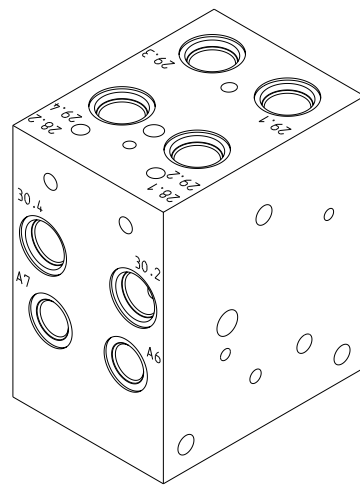
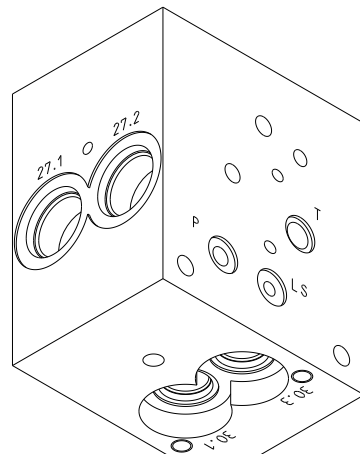
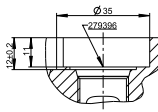
E-E



沉台
COUNTERBORE
(ZÁHLÓUBENÍ)
P.T,LS



型腔
CAVITIES
(KOMORY)
30.1,30.3



(除非另行注明) 以下规格适用于螺紋腔和接口:
1) 螺紋倒角 $\phi =$ 螺紋大徑 $\pm 0.4mm$
2) 倒角頂角 $= 90^\circ \pm 10^\circ$
按圖紙打標: 字高 5mm, 深度 0.5mm
孔位數公差: 尺寸值 ± 0.2
(除非另行注明) 鑽孔最大表面粗糙度 $Ra = 25$
外圓邊緣倒角 $0.5 \times 45^\circ$
擴孔 (EXP): 非孔工具 $\phi +0.1$; 粗糙度 $Ra = 3.2-6.3$
未標公差尺寸按 ISO 2768-mK

▽ Ra X%CSN EN ISO 1302

FOR THREADED CAVITIES AND PORTS IS VALID (UNLESS STATED OTHERWISE):
1) ϕ OF THREAD CHAMFER = BIG DIAMETER OF THREAD $\pm 0.4 mm$
2) THE TOP ANGLE OF CHAMFER = $90^\circ \pm 10^\circ$
POSITIONS OF MARKING ACCORDING TO DRAWING. LETTERS HIGH 5 mm, DEEP 0.5 mm
TOLERANCE OF THE HOLES POSITION: DIMENSION VALUE ± 0.2
MAX. SURFACE ROUGHNESS OF DRILLING HOLES (UNLESS STATED OTHERWISE) $Ra=25$
PERIPHERAL EDGES ARE CHAMFERED $0.5 \times 45^\circ$
THE HOLES FOR EXPANDERS (EXP): ϕ OF EXPANDER $+0.1$, SURFACE ROUGHNESS
DIMENSIONS WITHOUT TOLERANCES ACCORDING TO ISO 2768-mK

▽ Ra X%CSN EN ISO 1302

PRO ZAVITOVÉ KOMORY A PORTY PLATI (POKUD NENÍ UVEDENO JINAK):
1) ϕ SRAZENÍ PRO ZAVITÍ = VELIKÝ PRŮMĚR ZAVITÍ $\pm 0.4 mm$
2) VRCHOLOVÝ ÚHEL SRAZENÍ = $90^\circ \pm 10^\circ$
POVRCHOVÁ OCHRANA: BEZ POVRCHOVÉ OCHRANY
ODPOVĚDĚ POZADAVKŮM PROGRAMOVÁNÍ
ZNACIT PODLE VÝKRESU: VÝŠKA PÍSMŮ 5 mm, HL. 0.5 mm
TOLERANCE POLOHY OTVORŮ: HODNOTA KOTY ± 0.2
MAX. HODNOTA DRSNOSTI VRTANÝCH DER (POKUD NENÍ UVEDENO JINAK) $Ra=25$
OBVODOVÉ HRANY BLOKU SRAZIT $0.5 \times 45^\circ$
OTVORY PRO EXPANDERY (EXP): ϕ EXPANDERŮ $+0.1$, OPRACOVANÝ
NETOLEROVANÉ ROZMĚRY PODLE ISO 2768-mK

NETOLEROVANÉ ROZMĚRY PODLE ISO 2768-mK

材料: EN AW-Al
Cu4PbMgMn-T4
重量: 2.5kg

技术清洁度 组号 表面 测试方法 全部

Technical Cleanliness Code Surface [cm2] Test method A AHGS 3001

Technická čistota B 1170.7 A AHGS 3001

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In case of differences between the language versions, the ENGLISH version shall prevail

ISO 8015

ISO 8015

ISO 8015

ISO 8015

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