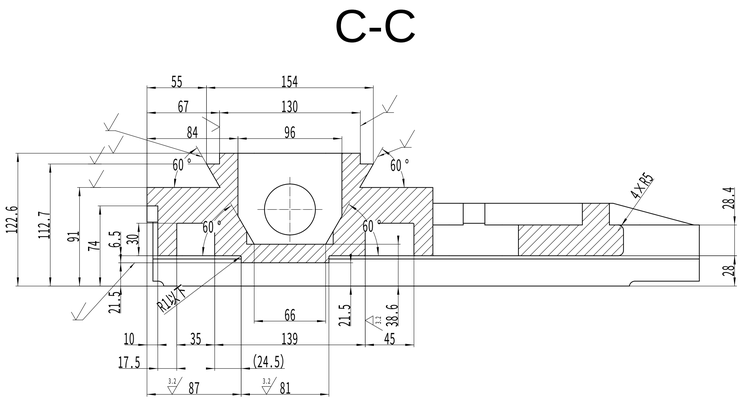
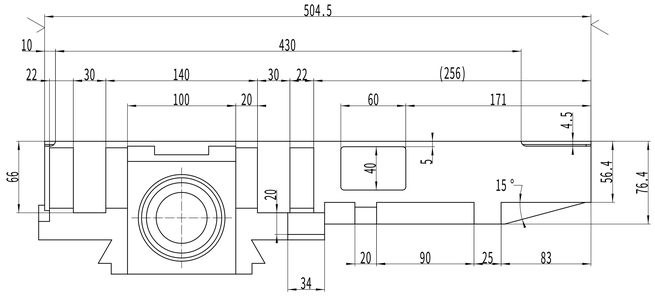
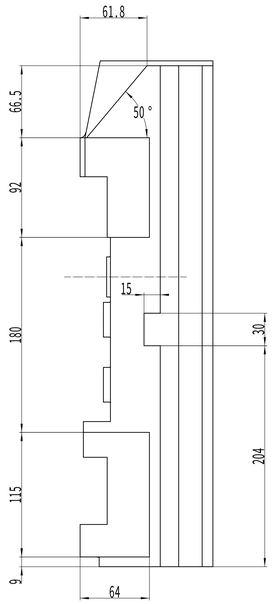
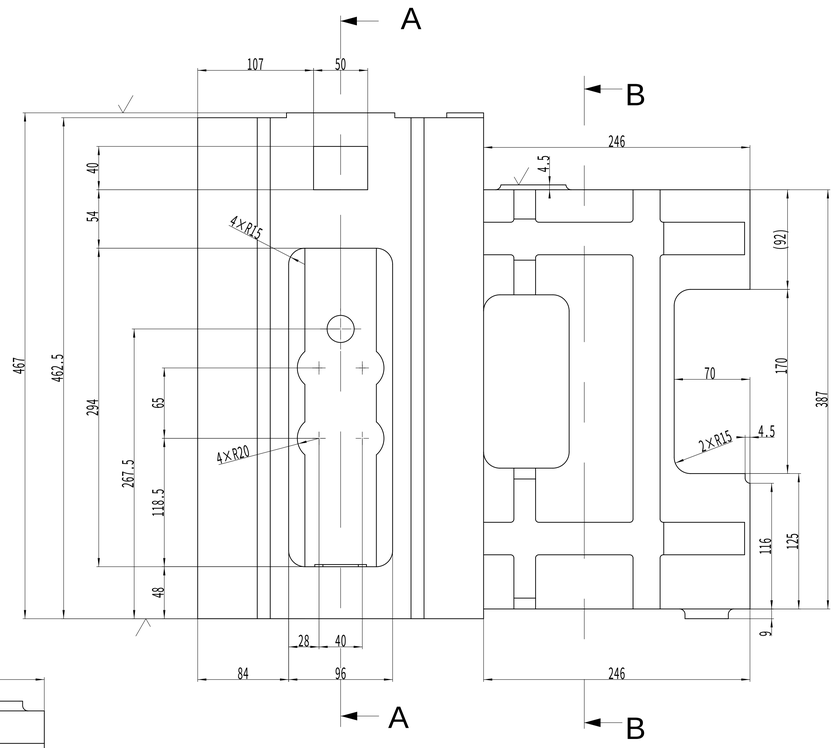


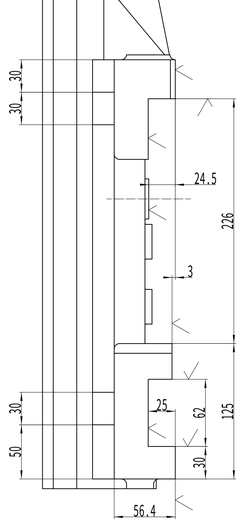


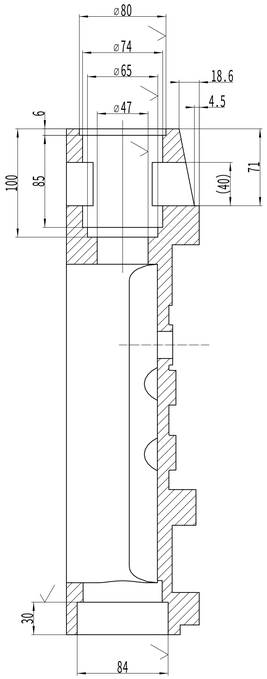
技术条件

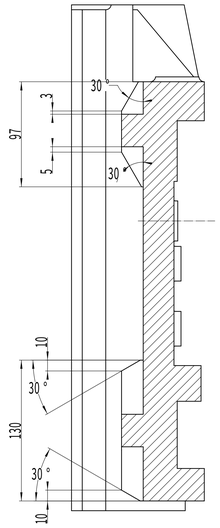
1，√代表需要加工；
2，未注铸造圆角R5~10；
3，铸件尺寸精度按GB/T6414—2017铸件尺寸公差几何形状公差与加工余量标准CT11级要求执行；
4，铸件硬度范围HB180~220；
5，正负起模斜度1度。铸件收缩率1%；
6，铸件应进行去应力时效处理；
7，铸件不允许存在气孔、缩孔、疏松、夹杂、裂纹、冷隔等影响使用的铸造缺陷；
8，铸件所有披缝、毛刺、浇冒口残余等必须清理和打磨平整；
9，重量公差按GB/T11351—2017铸件重量公差MT11级要求执行；
10，铸件表面去除氧化皮后喷环氧铁红油漆。

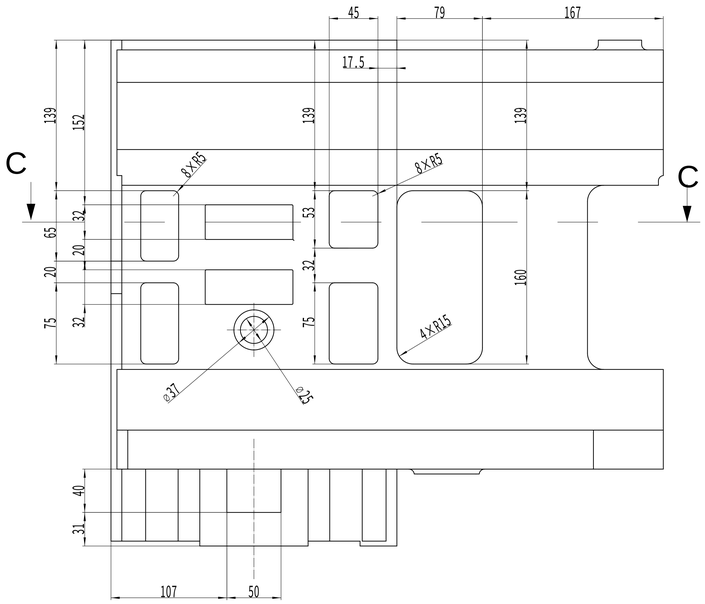


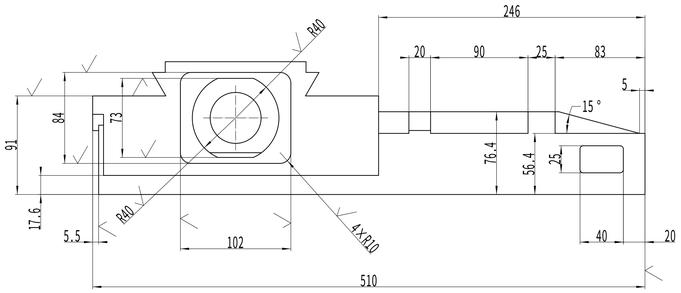


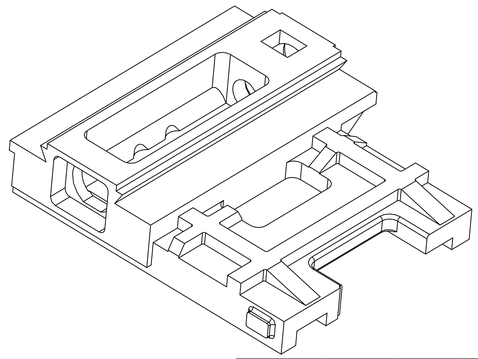


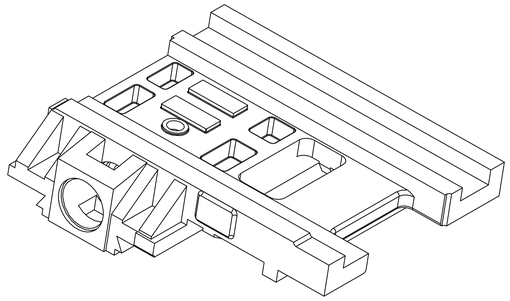












标记	处数	分区	更改文件号	签名	年、月、日	材质 HT250		机床拖板
设计			标准化			阶段标记	重量	比例 1:2
审核								
工艺			批准			共 张	第 张	