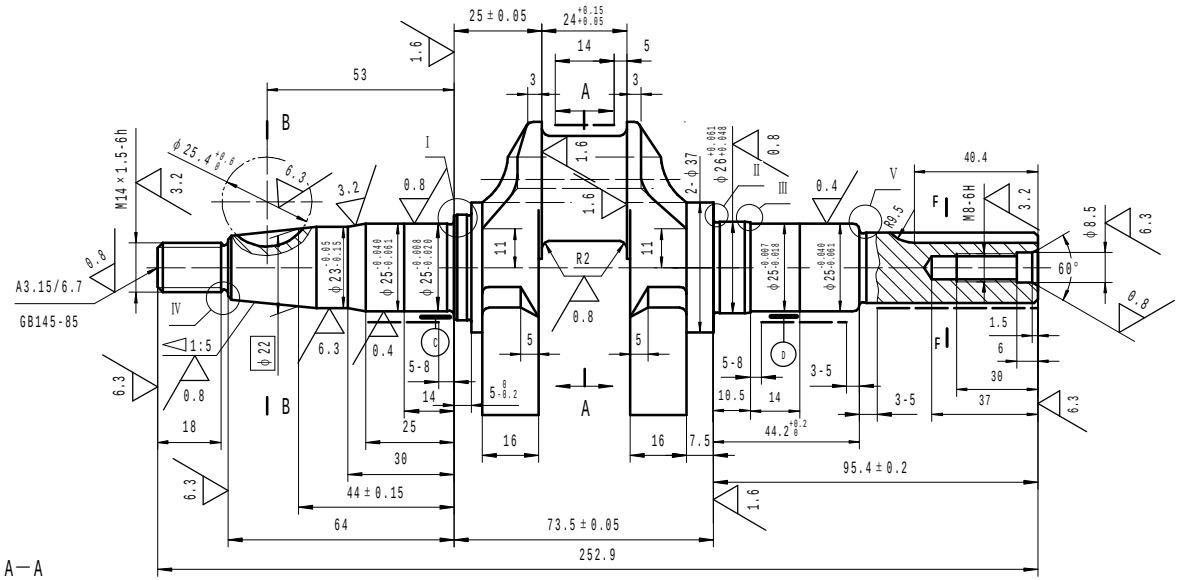
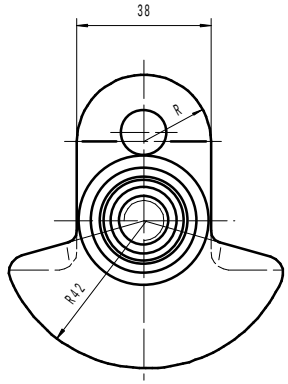
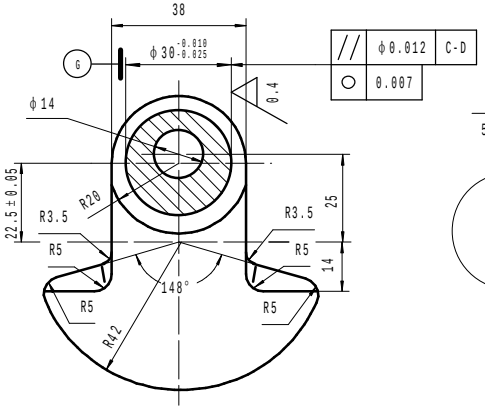
其余

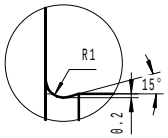




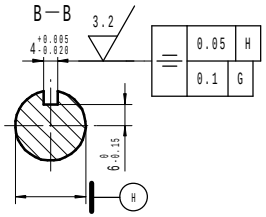
A—A



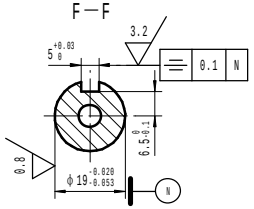
II
5 : 1



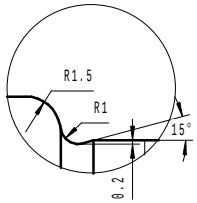
B—B



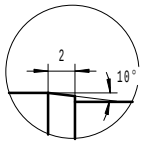
F—F



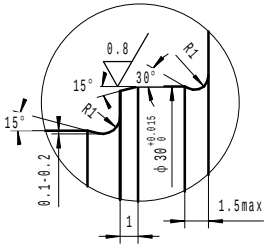
V
5 : 1



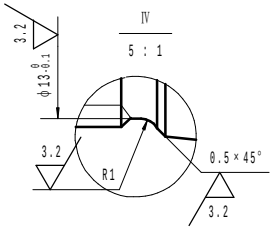
III
5 : 1



I
2 : 1



IV
5 : 1



技 术 要 求

1. 锻件不得有裂纹.结疤.缺料.氧化皮及未充满等缺陷;
2. 非加工表面的残留飞边.凹坑必须打磨平整;锻件的错模量不大于0.5;
3. 未注锻造圆角R2，未注拔模斜度5°；
4. 毛坯调质HB240-277,调质后抛丸处理;
5. 加工面的毛刺必须打磨干净,未注倒角均为1×45°；
6. 曲轴精加工后按NJ317-84《柴油机锻钢曲轴凸轮轴磁粉探伤技术条件》进行磁粉探伤，并达到Ⅰ类曲轴的要求，探伤后严格退磁;
7. 1:5锥面与锥度环规的结合面积应大于75%;
8. 各▽0.8外圆及端面相对于基准C-D的跳动不大于0.015;
9. 热处理: 粗点划线处高频淬火，硬化层深度1.2-2.5，硬度HRC48～58 ,键槽部位淬硬层深0.8-1.8
10. 标记处用5号凸字打“MX”.锻造厂标记及模具号,字高0.5-1;
11. 加工面未注尺寸公差按GB1804-79 IT14级执行,未注形位公差按GB1184-80 9级执行;

标记	处数	更改文件号	签	字	日	期
设	计					
审	核					
标	准					
审	定					
批	准					

曲 轴

40Cr GB/T3077-99

AT168FA

图样标记	重量	比例
		1:1
共 1 张		第 1 张

常州阿尔泰动力机械有限公司

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