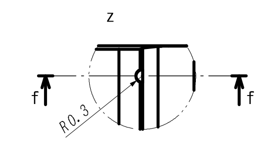
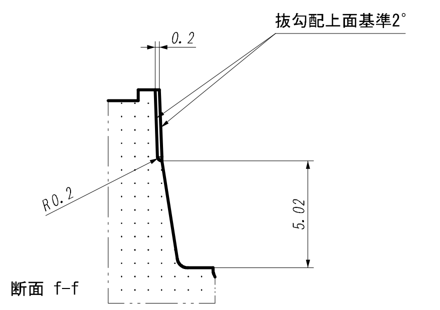
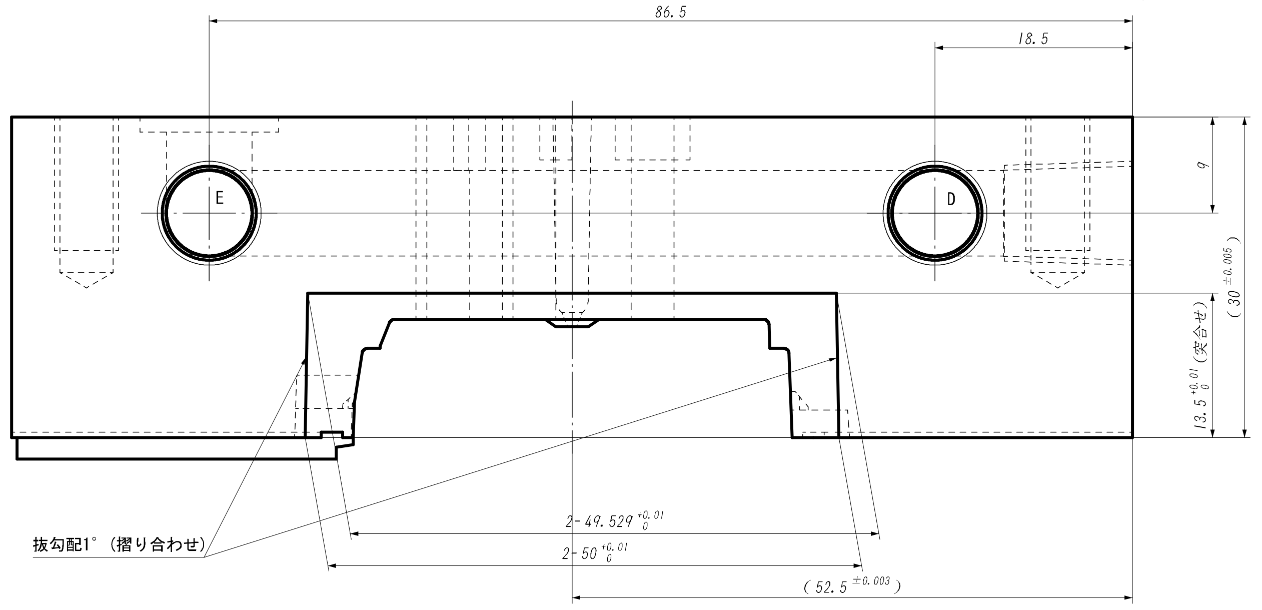
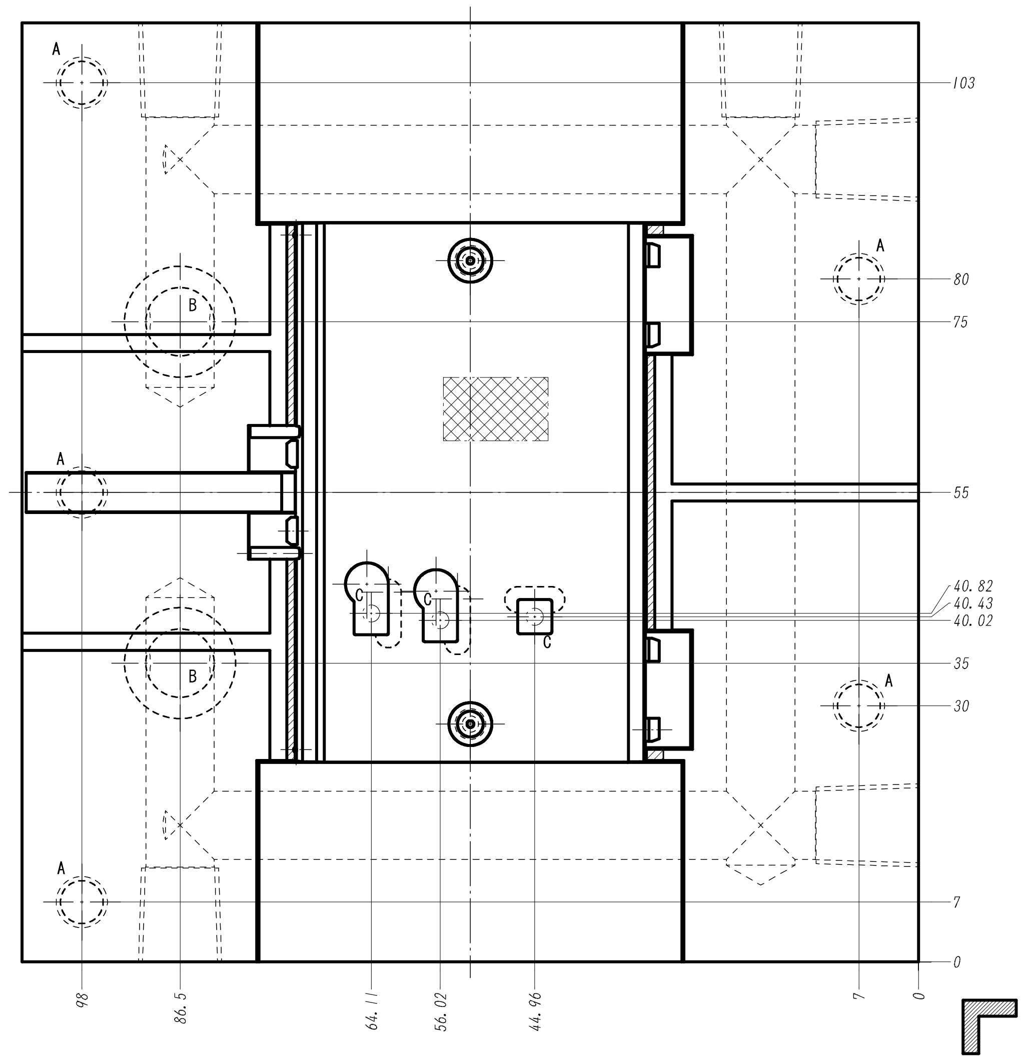


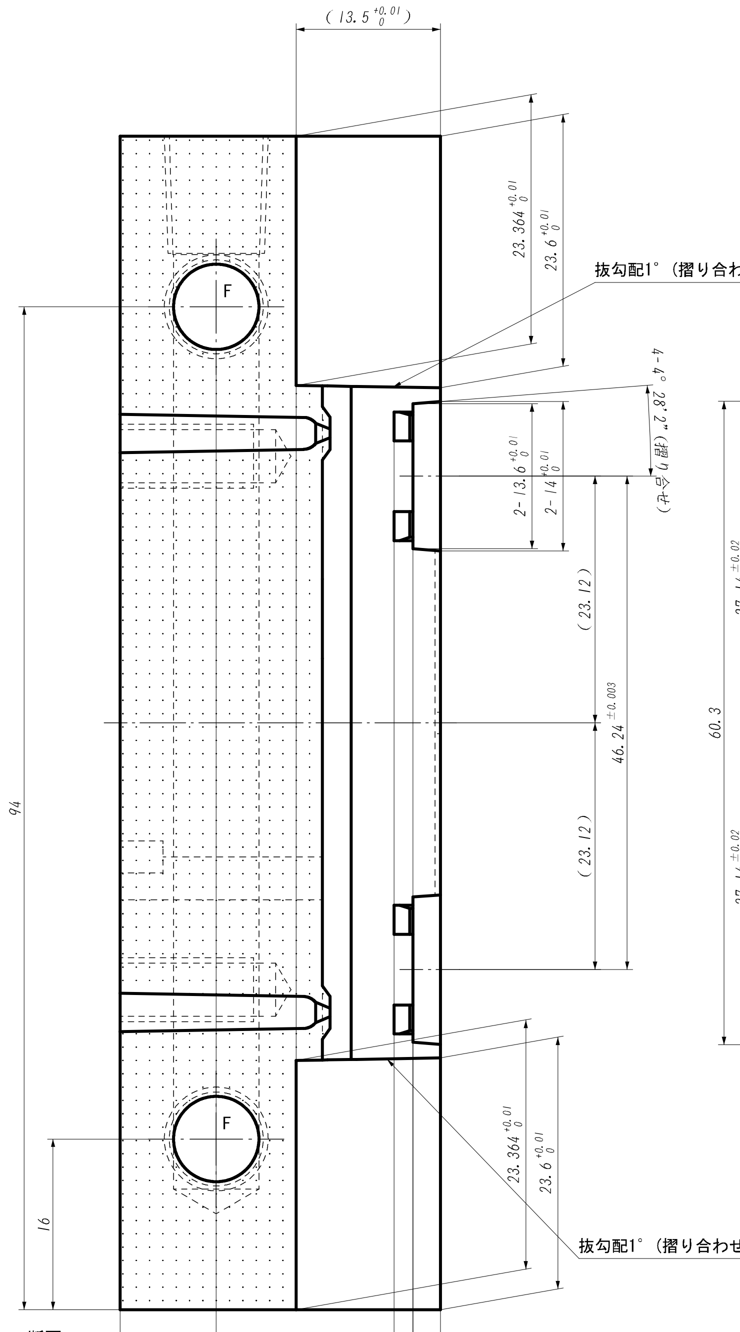

0.2
抜勾配上面基準2°
R0.2
5.02

断面 f-f

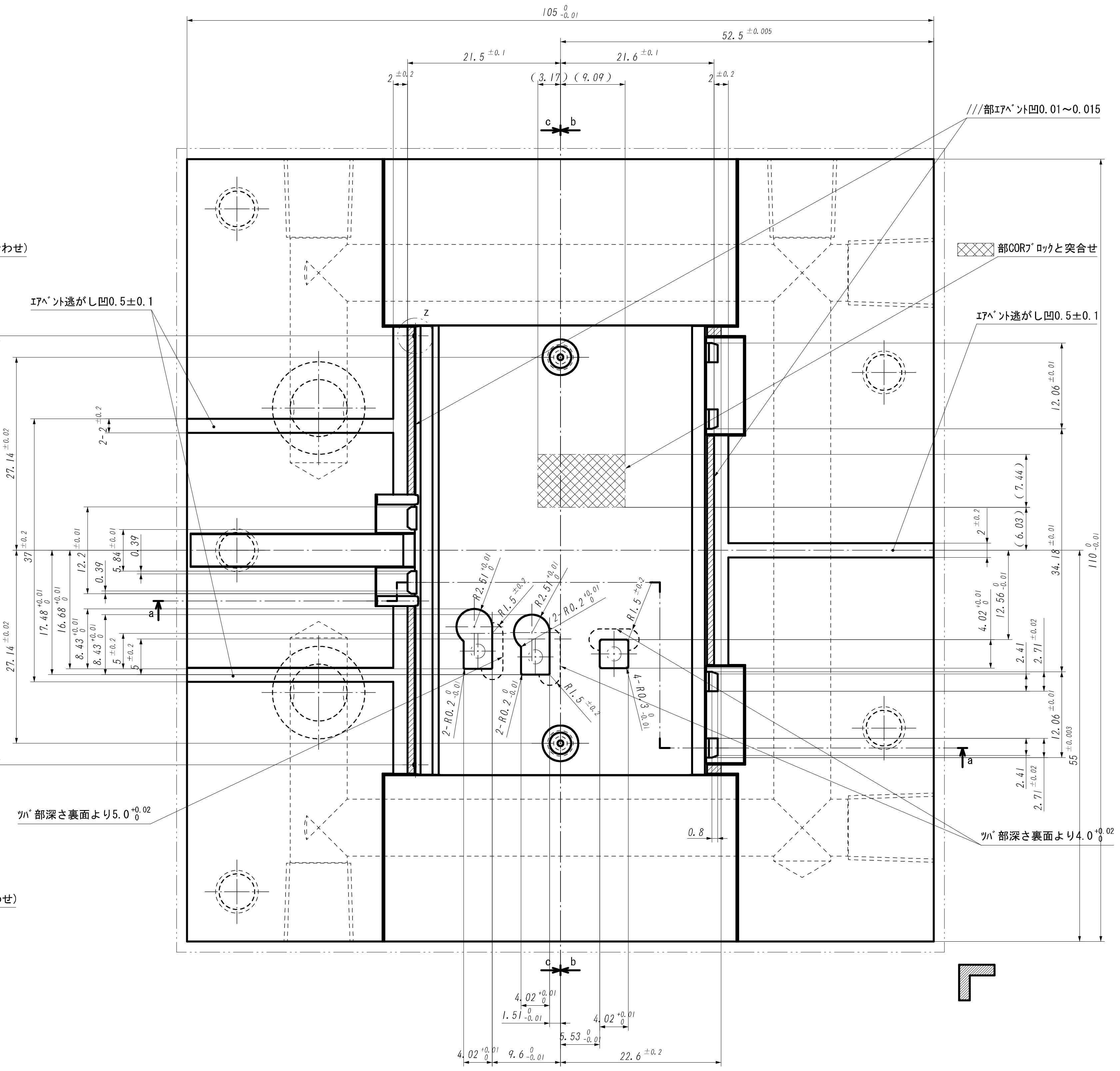

86.5
18.5
E
D
9
(30 ±0.005)
13.5 +0.01 0 (突合せ)
抜勾配1°(摺り合わせ)
2-49.529 +0.01 0
2-50 +0.01 0
(52.5 ±0.003)

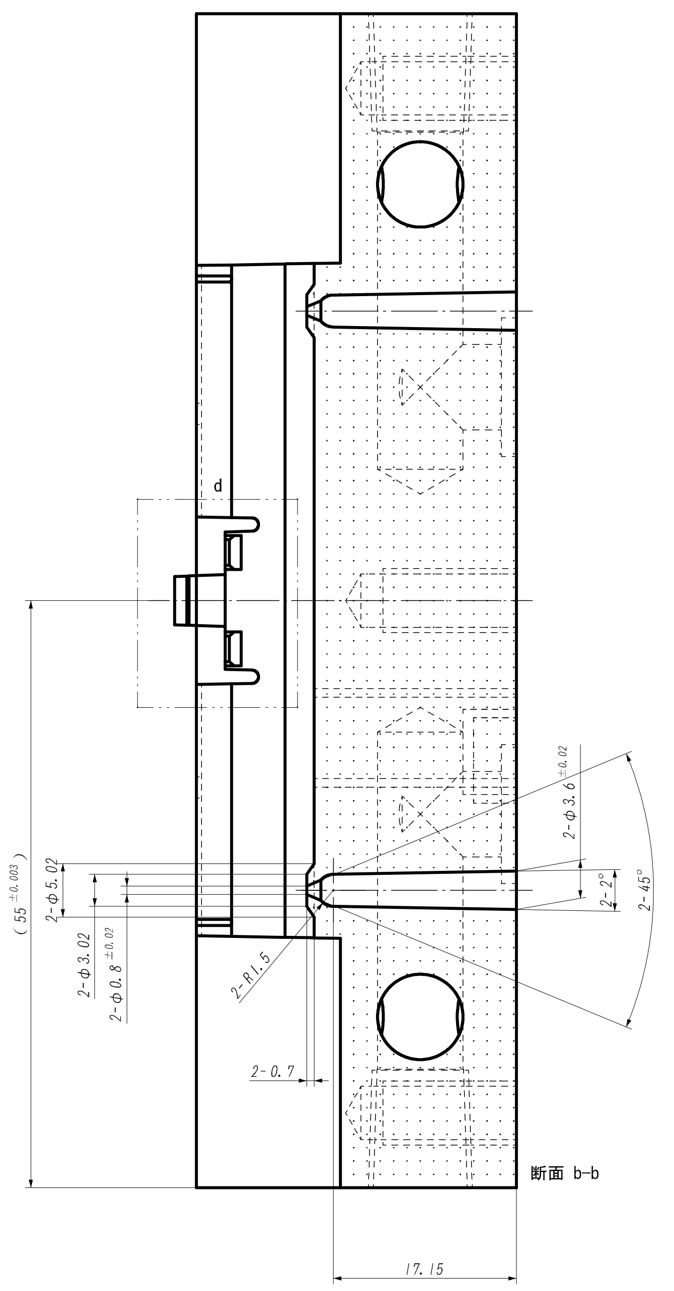
A:5-TAP6X12(B)
B:2-8X13, ZA13X1.4 $^{\pm0.05}$(B)
C:3-2(WE原点)
D:1-8X101, TAPRC1/8X12(T)
E:2-8X45(T,B), TAPRC1/8X11(T,B)
F:2-8X90.5, TAPRC1/8X12(B)


A
B
C
103
80
75
55
40.82
40.43
40.02
35
30
7
0
98
86.5
64.11
56.02
44.96
7
0

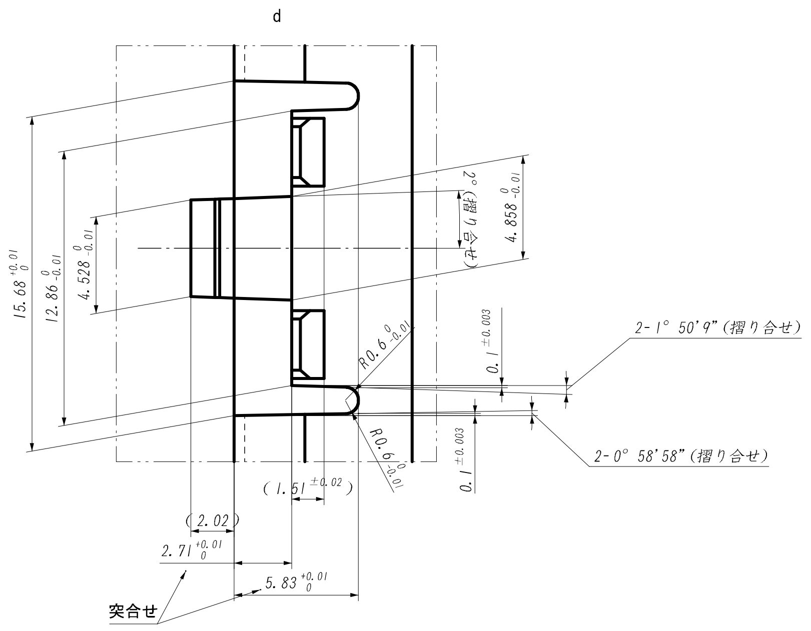

(13.5 +0.01 0)
23.364 +0.01 0
23.6 +0.01 0
抜勾配1°(摺り合わせ)
F
2-(3.6 +0.01 0)
2-14 +0.01 0
(23.12)
46.24 ±0.005
(23.12)
94
16
23.364 +0.01 0
23.6 +0.01 0
抜勾配1°(摺り合わせ)
9
1.76 ±0.01
2.56 +0.01 0 (突合せ)

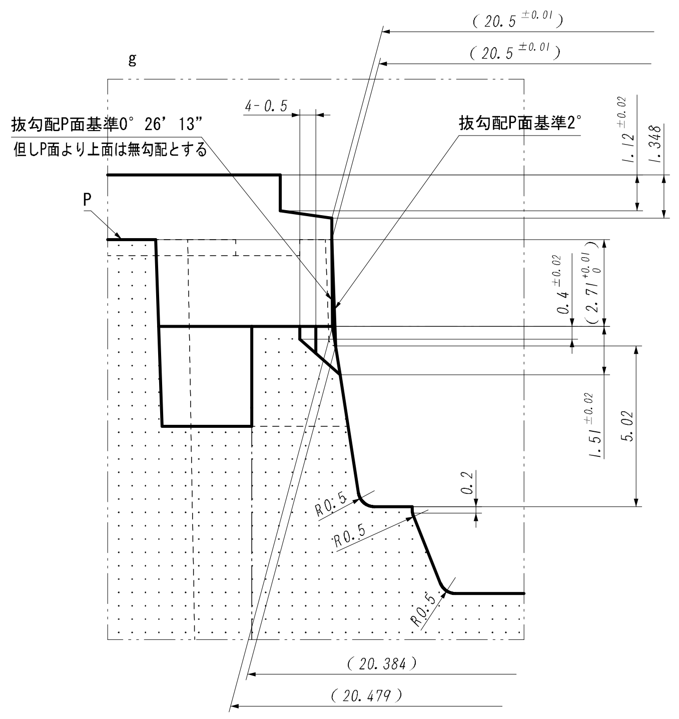
断面 c-c

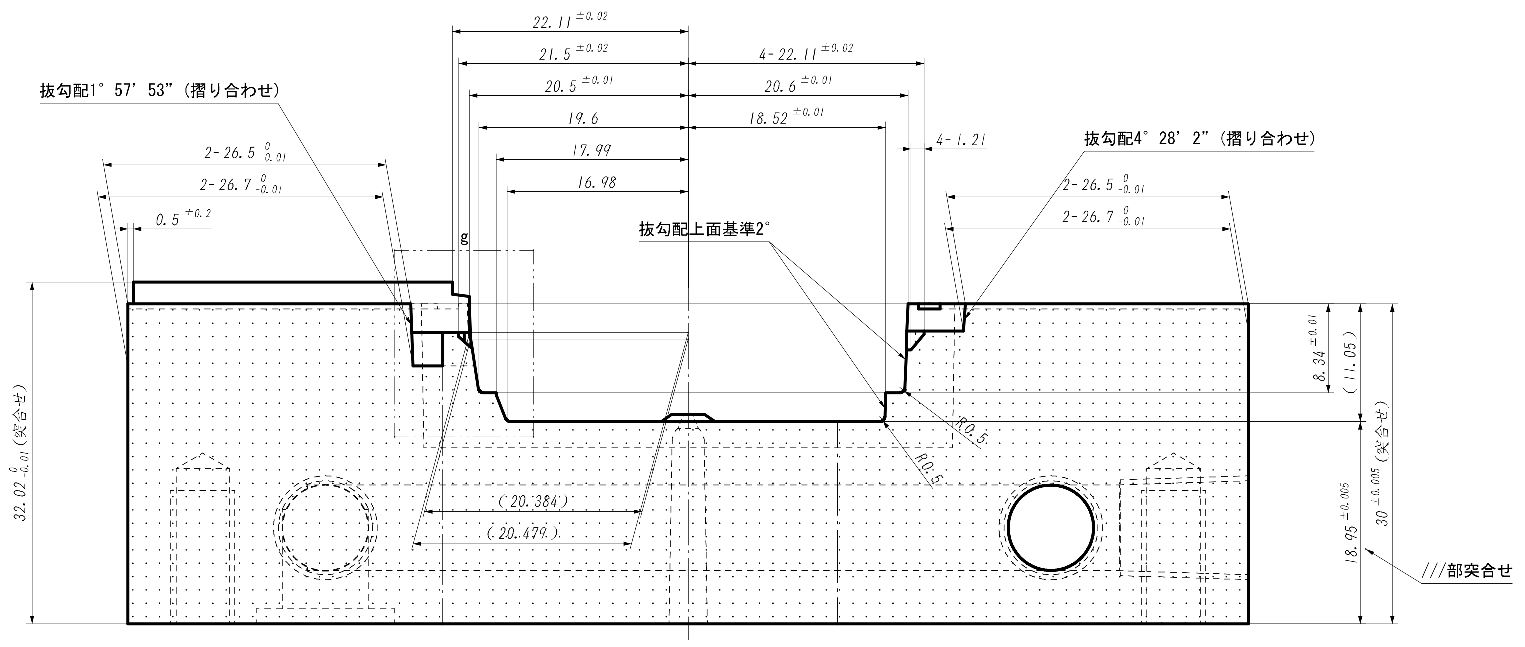

105 0 -0.01
52.5 ±0.005
21.5 ±0.1
21.6 ±0.1
(3.17)
(9.09)
c
b
///部エアベント凹0.01~0.015
部COREブロックと突合せ
エアベント逃がし凹0.5±0.1
エアベント逃がし凹0.5±0.1
z
E
D
60.3
27.14
37
12.7
16.68
17.48
8.43
5
0.39
5.84
(7.44)
(6.03)
34.18
110
12.06
12.56
4.02
2.41
2.71
12.06
55
a
a
ツバ部深さ裏面より5.0 +0.02 0
ツバ部深さ裏面より4.0 +0.02 0
0.8
4.02
1.51
5.53
4.02
9.6
22.6
c
b


d
(55 ±0.003)
2-φ5.02
2-φ3.02
2-φ0.8
2-R1.5
2-0.7
2-φ3.6
2-45°
17.15

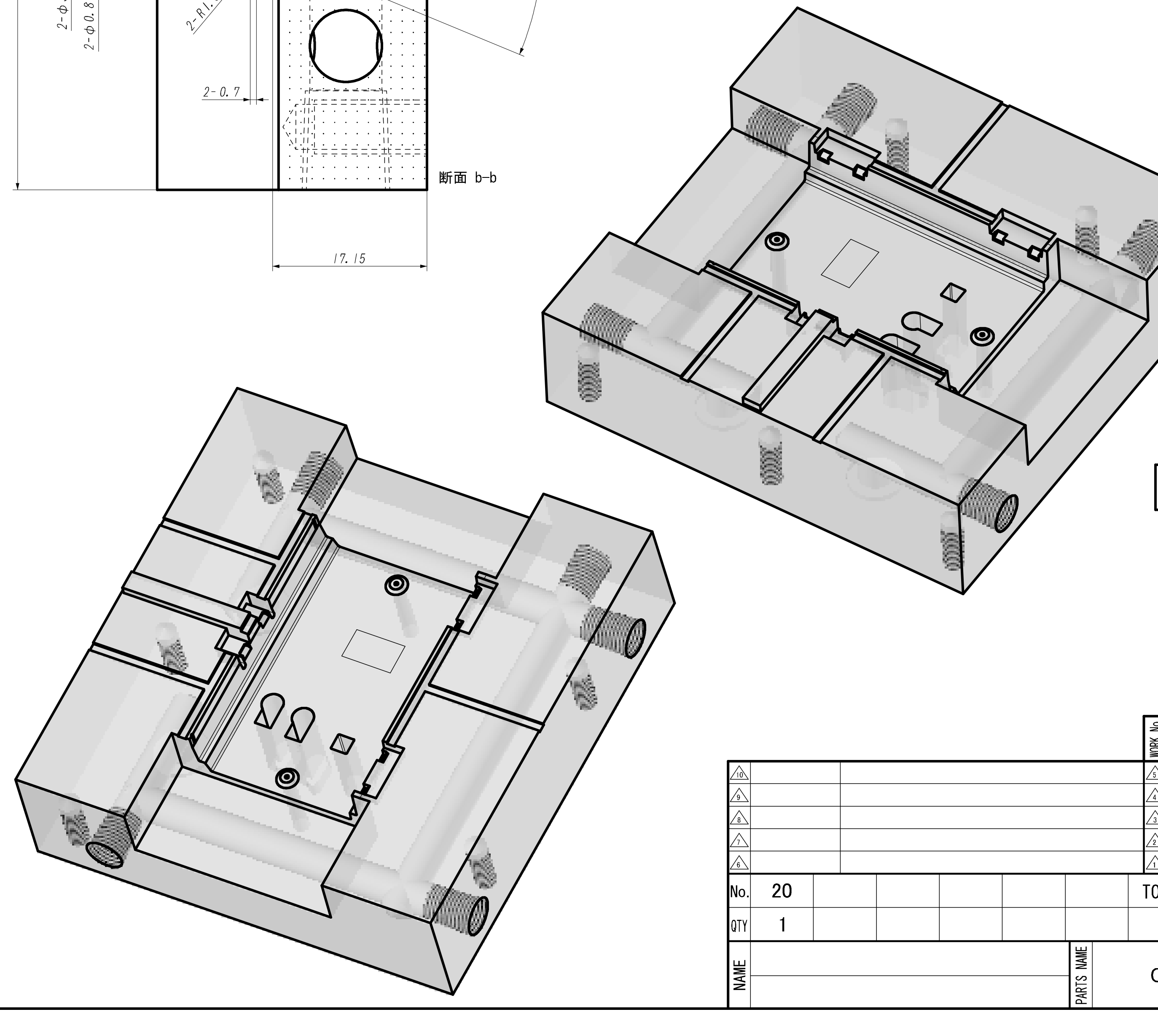
断面 b-b


d
15.68
12.86
4.528
4.858
2-1° 50'9"(摺り合せ)
2-0° 58'58"(摺り合せ)
(1.51)
(2.02)
2.71
5.83
突合せ


g
(20.5 ±0.01)
(20.5 ±0.01)
4-0.5
抜勾配P面基準0° 26' 13"
但しP面より上面は無勾配とする
抜勾配P面基準2°
P
1.348
1.12
0.4
2.71
1.51
5.02
0.2
R0.5
R0.5
R0.5
(20.384)
(20.479)


22.11 ±0.02
21.5 ±0.02
4-22.11 ±0.02
20.5 ±0.01
20.6 ±0.01
19.6
18.52
17.99
16.98
抜勾配1° 57' 53"(摺り合わせ)
抜勾配4° 28' 2"(摺り合せ)
2-26.5
2-26.7
0.5
4-1.21
2-26.5
2-26.7
抜勾配上面基準2°
8.34
(11.05)
32.02 (突合せ)
30 ±0.005
18.95
(20.384)
(20.479)
R0.5
///部突合せ

断面 a-a



型 No.	管理 No.
1	

General Tolerance ±0.2

Process	Estimate Time	Delivery	Actual Time

型部一般公差±0.03

MC加工

WE加工

放電加工

No.	20	
QTY	1	
TOTAL	1	
MATERIAL	STAVAX	
HEAT TREATMENT	T → G HRC52~54	
SCALE	2:1	
WORK No.		
NAME		
PARTS NAME	CAV本体	
APPROVED		
CHECKED		
DESIGNED	2011/05/19	