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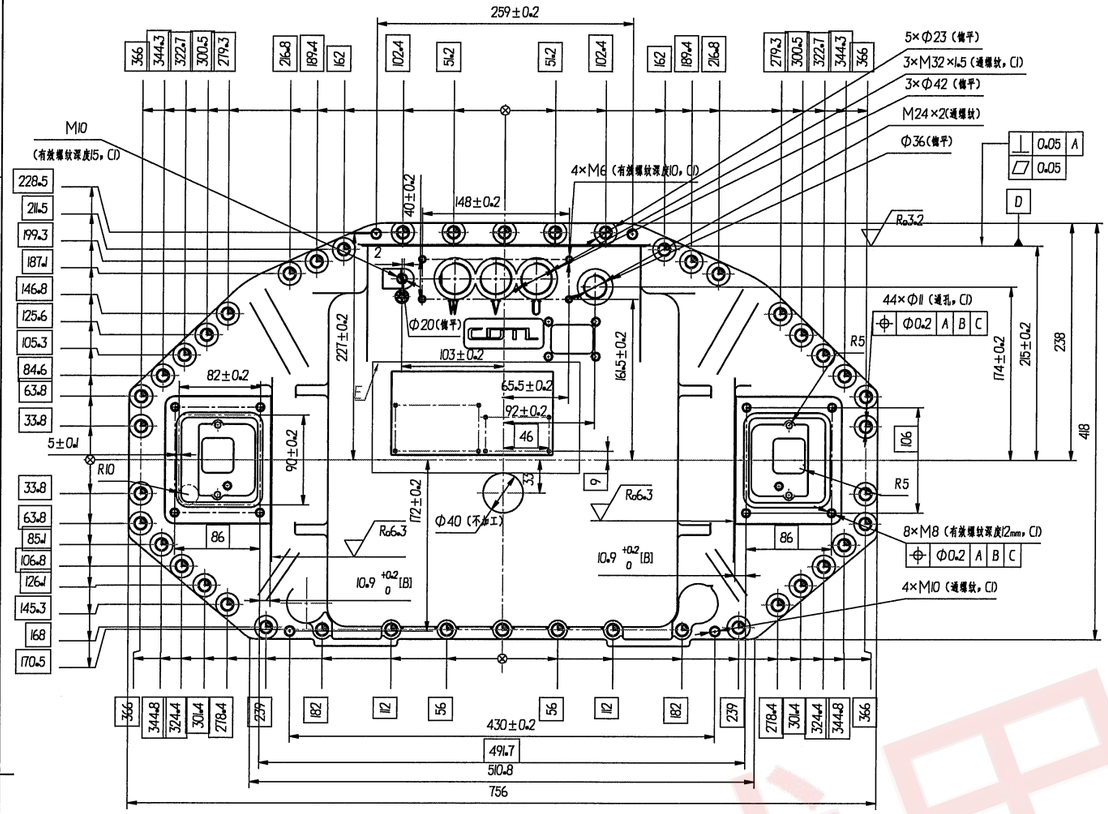
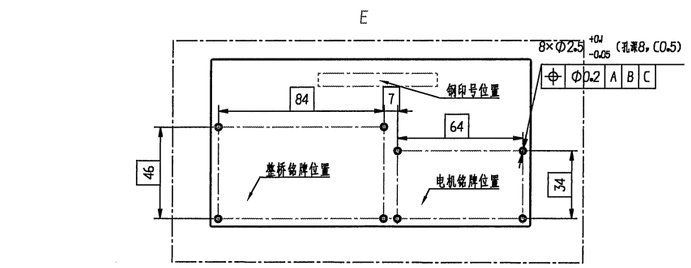
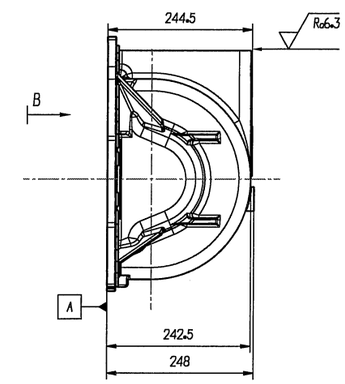
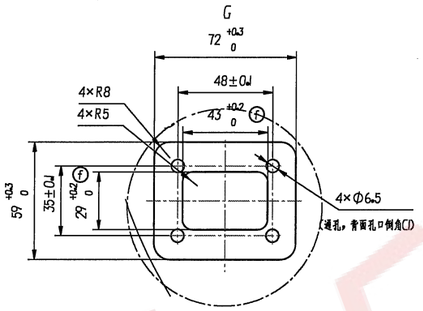
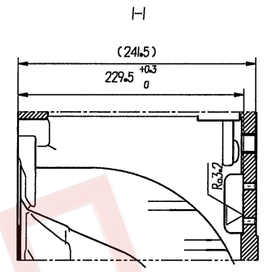
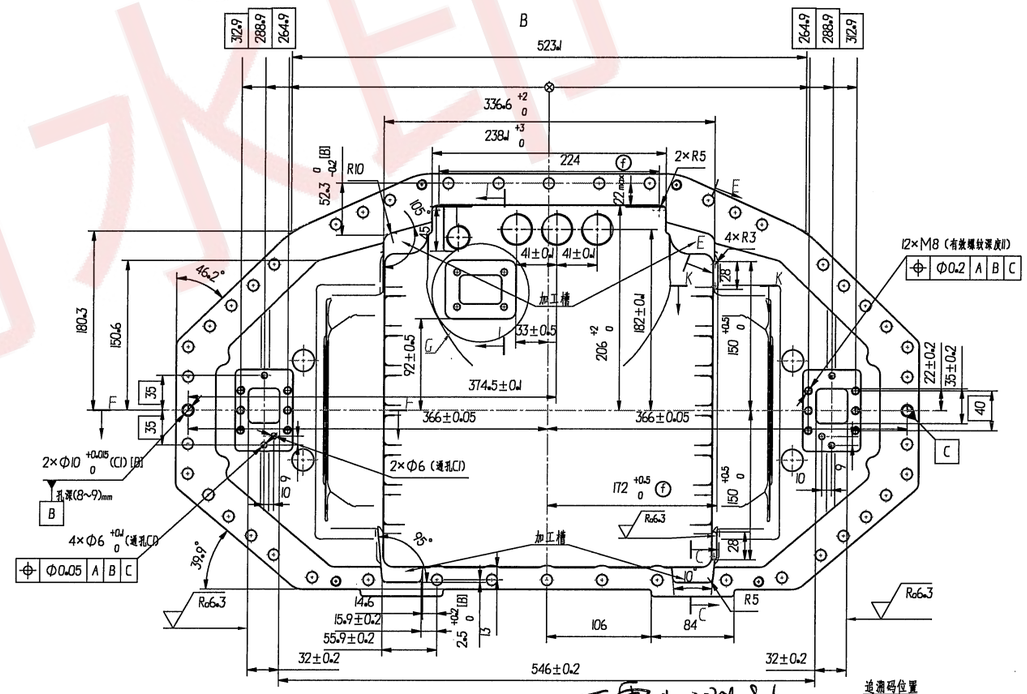


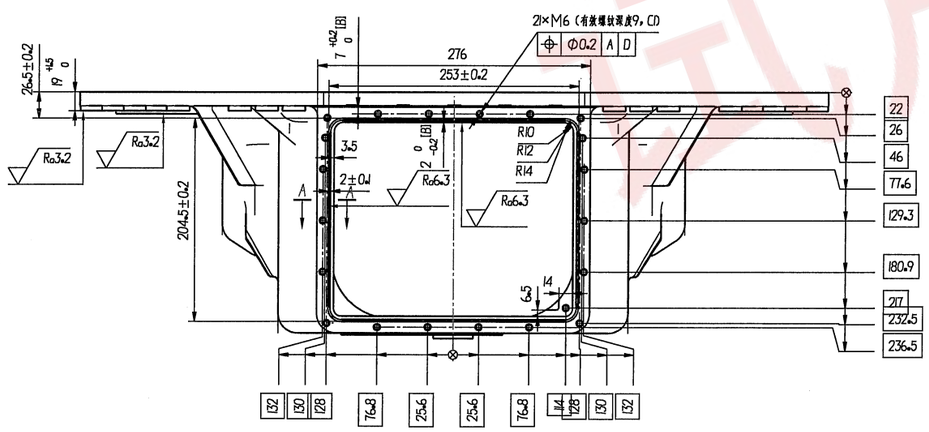


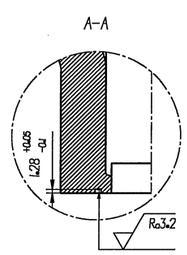


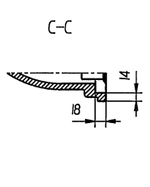


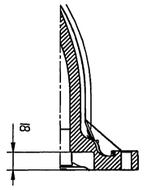


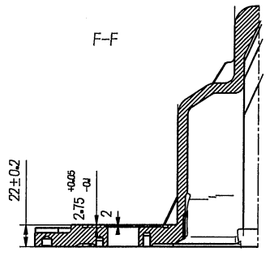


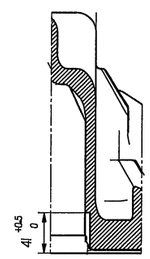










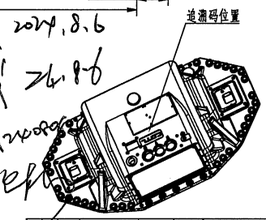


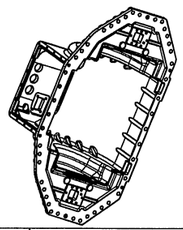
技术要求

1、去除铸造飞边、毛刺；
2、不允许有缺料、冷隔、缩孔、组织疏松、变形、裂纹等铸造缺陷；[A]
3、未注铸造内圆角R6-R8；
4、未注铸造外圆角R2-R4；
5、外侧面拔模斜度：1°30′、内侧面拔模斜度：2°-3°；
6、非加工面环氧树脂底漆加面漆处理，中性盐雾试验240h无基体腐蚀；
7、材料本体取样力学性能：屈服强度大于310MPa，抗拉强度大于450MPa，延伸率大于10%；[A]
8、未注铸造尺寸公差按QC/T 269、未注加工尺寸按QC/T267，未注形位公差按GB/T 1184-L；
9、金相组织要求：珠光体(15%，铁素体)85%，球化率)85%，整体硬度160-200HB；
10、探伤检测，详见技术协议；
11、前盖大安装平面为波纹面，加强与桥壳的密封性；[B]
12、零件整体清洁度要求：零件加工完后清洗机清洗，目测无铁屑等杂物颗粒、无油污；
13、加工面涂防锈油，库房存放3个月不得生锈，要求补漆处参考C5000N-JSLX-2023H-009；
14、在指定位置打零部件追溯码，追溯码包含：零件号+版本号+供应商代码+年月日+流水号；
例：P550R240001I AGA XXXX 240716 001，允许分行打刻；
15、[A]：关键特性，[B]：重要特性。

万震夫 2024.8.6
[illegible] 24.8.6

追溯码位置





4		C5000N-SJBG-202406-001	万震夫	2024.06.26	前盖	P550R240001IAGA	
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审核		批准					
工艺		日期	2024.07.16				

会签
旧底图号
底图总号
签字
日期

试用水印