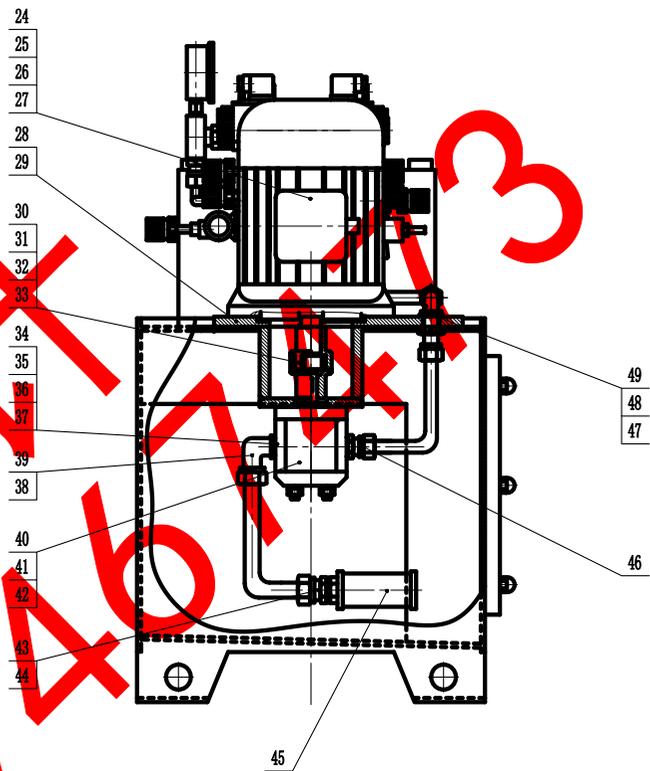
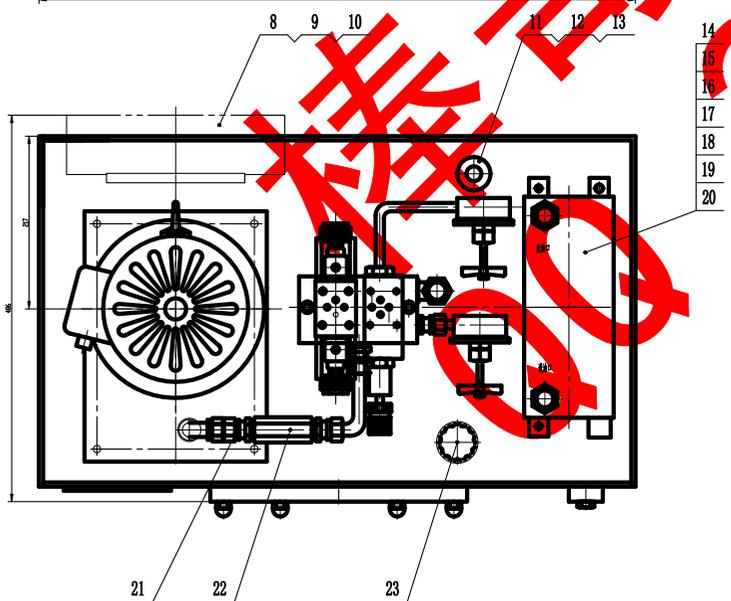
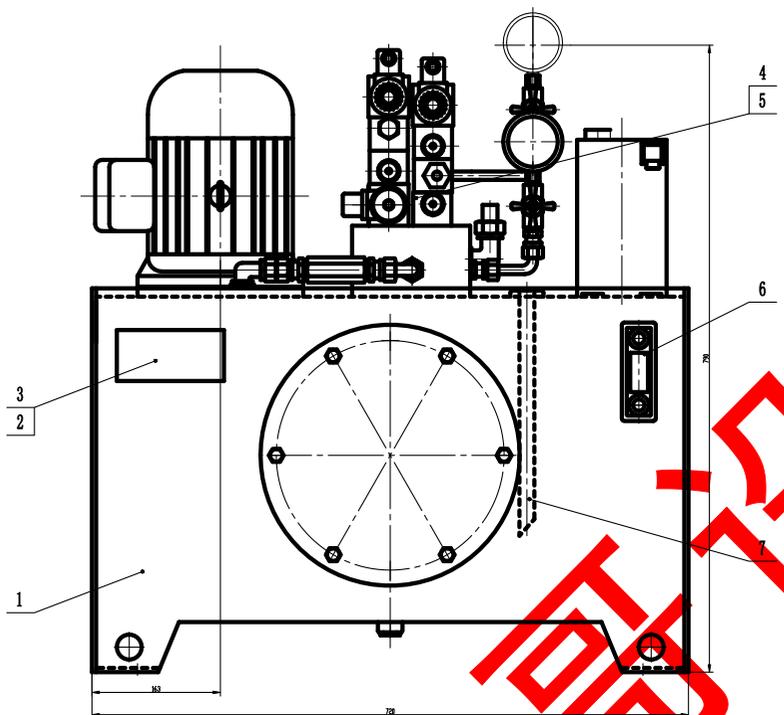


# A0-装配图

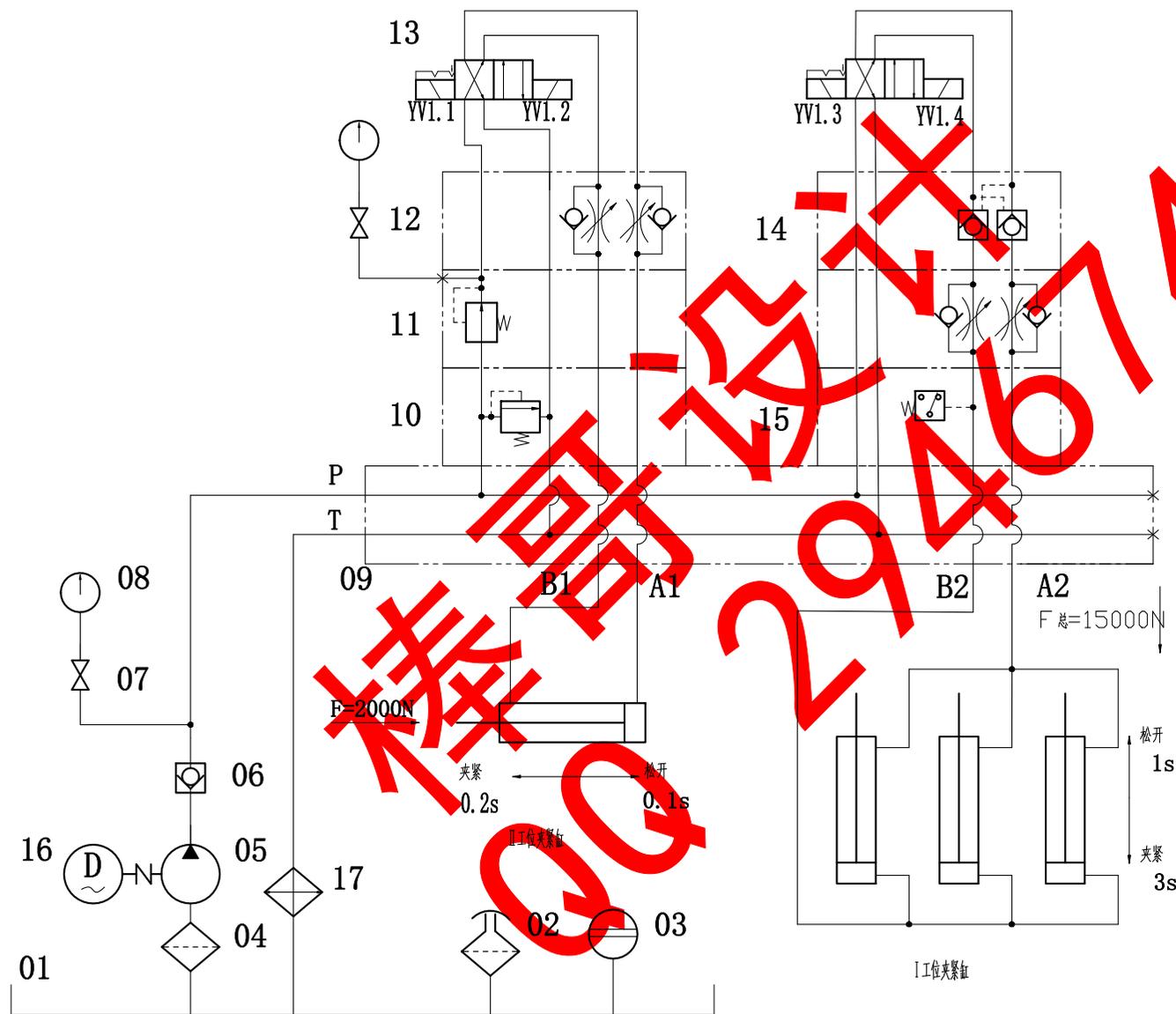


**技术要求:**

1. 管子的长度, 弯曲半径和实际位置由装配时确定, 管子和接头焊接后必须经酸洗处理;
2. 液压站装配完后, 试车前打开全部联接部分进行清洗, 清除一切残留杂质。

序号	代号	名称	规格	数量	比例	备注
1	YD10-25/31-05	油缸	100x100x100	1		
2	YD10-25/31-05	油缸	100x100x100	1		
3	YD10-25/31-05	油缸	100x100x100	1		
4	YD10-25/31-05	油缸	100x100x100	1		
5	YD10-25/31-05	油缸	100x100x100	1		
6	YD10-25/31-05	油缸	100x100x100	1		
7	YD10-25/31-05	油缸	100x100x100	1		
8	YD10-25/31-05	油缸	100x100x100	1		
9	YD10-25/31-05	油缸	100x100x100	1		
10	YD10-25/31-05	油缸	100x100x100	1		
11	YD10-25/31-05	油缸	100x100x100	1		
12	YD10-25/31-05	油缸	100x100x100	1		
13	YD10-25/31-05	油缸	100x100x100	1		
14	YD10-25/31-05	油缸	100x100x100	1		
15	YD10-25/31-05	油缸	100x100x100	1		
16	YD10-25/31-05	油缸	100x100x100	1		
17	YD10-25/31-05	油缸	100x100x100	1		
18	YD10-25/31-05	油缸	100x100x100	1		
19	YD10-25/31-05	油缸	100x100x100	1		
20	YD10-25/31-05	油缸	100x100x100	1		
21	YD10-25/31-05	油缸	100x100x100	1		
22	YD10-25/31-05	油缸	100x100x100	1		
23	YD10-25/31-05	油缸	100x100x100	1		
24	YD10-25/31-05	油缸	100x100x100	1		
25	YD10-25/31-05	油缸	100x100x100	1		
26	YD10-25/31-05	油缸	100x100x100	1		
27	YD10-25/31-05	油缸	100x100x100	1		
28	YD10-25/31-05	油缸	100x100x100	1		
29	YD10-25/31-05	油缸	100x100x100	1		
30	YD10-25/31-05	油缸	100x100x100	1		
31	YD10-25/31-05	油缸	100x100x100	1		
32	YD10-25/31-05	油缸	100x100x100	1		
33	YD10-25/31-05	油缸	100x100x100	1		
34	YD10-25/31-05	油缸	100x100x100	1		
35	YD10-25/31-05	油缸	100x100x100	1		
36	YD10-25/31-05	油缸	100x100x100	1		
37	YD10-25/31-05	油缸	100x100x100	1		
38	YD10-25/31-05	油缸	100x100x100	1		
39	YD10-25/31-05	油缸	100x100x100	1		
40	YD10-25/31-05	油缸	100x100x100	1		
41	YD10-25/31-05	油缸	100x100x100	1		
42	YD10-25/31-05	油缸	100x100x100	1		
43	YD10-25/31-05	油缸	100x100x100	1		
44	YD10-25/31-05	油缸	100x100x100	1		
45	YD10-25/31-05	油缸	100x100x100	1		
46	YD10-25/31-05	油缸	100x100x100	1		
47	YD10-25/31-05	油缸	100x100x100	1		
48	YD10-25/31-05	油缸	100x100x100	1		
49	YD10-25/31-05	油缸	100x100x100	1		

# A0-原理图



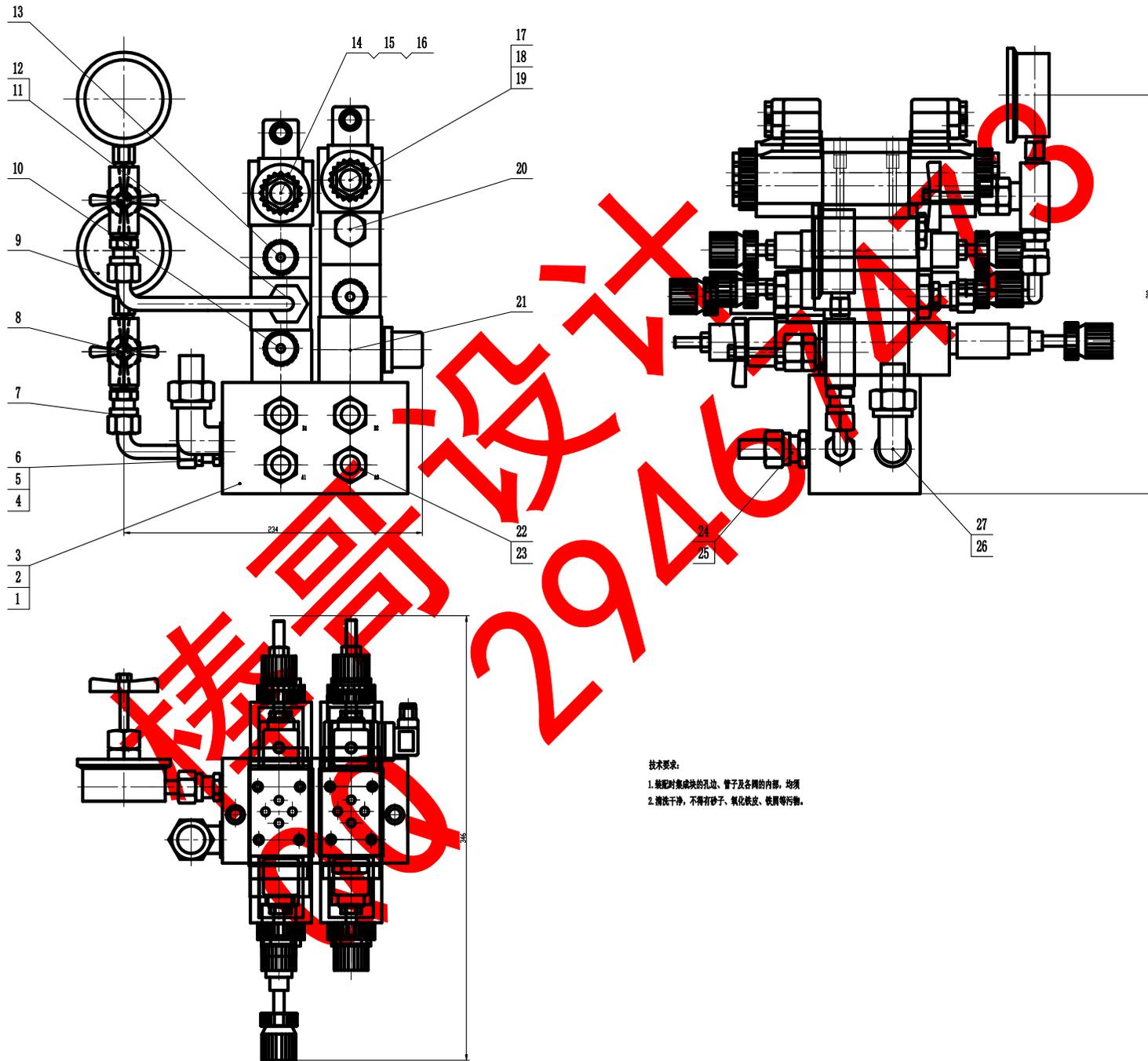
动作	电磁铁	YV1. 1	YV1. 2	YV1. 3	YV1. 4
II工位夹紧缸夹紧		+			
II工位夹紧缸松开			+		
I工位夹紧缸夹紧				+	
I工位夹紧缸松开					+
停止					

序号	代号	名称	数量	材料	备注
17	溢流阀	溢流阀	1		溢流
16	电动机	电动机	1		电动机
15	换向阀	换向阀	1		换向
14	换向阀	换向阀	1		换向
13	换向阀	换向阀	2		换向
12	换向阀	换向阀	1		换向
11	换向阀	换向阀	1		换向
10	换向阀	换向阀	1		换向
9	换向阀	换向阀	1		换向
8	换向阀	换向阀	1		换向
7	换向阀	换向阀	2		换向
6	换向阀	换向阀	1		换向
5	换向阀	换向阀	1		换向
4	换向阀	换向阀	1		换向
3	换向阀	换向阀	1		换向
2	换向阀	换向阀	1		换向
1	换向阀	换向阀	1		换向

序号	代号	名称	数量	材料	备注
					太湖学院
					原理图
共	张				JYLGD-BYSJ-01

# A0-阀组



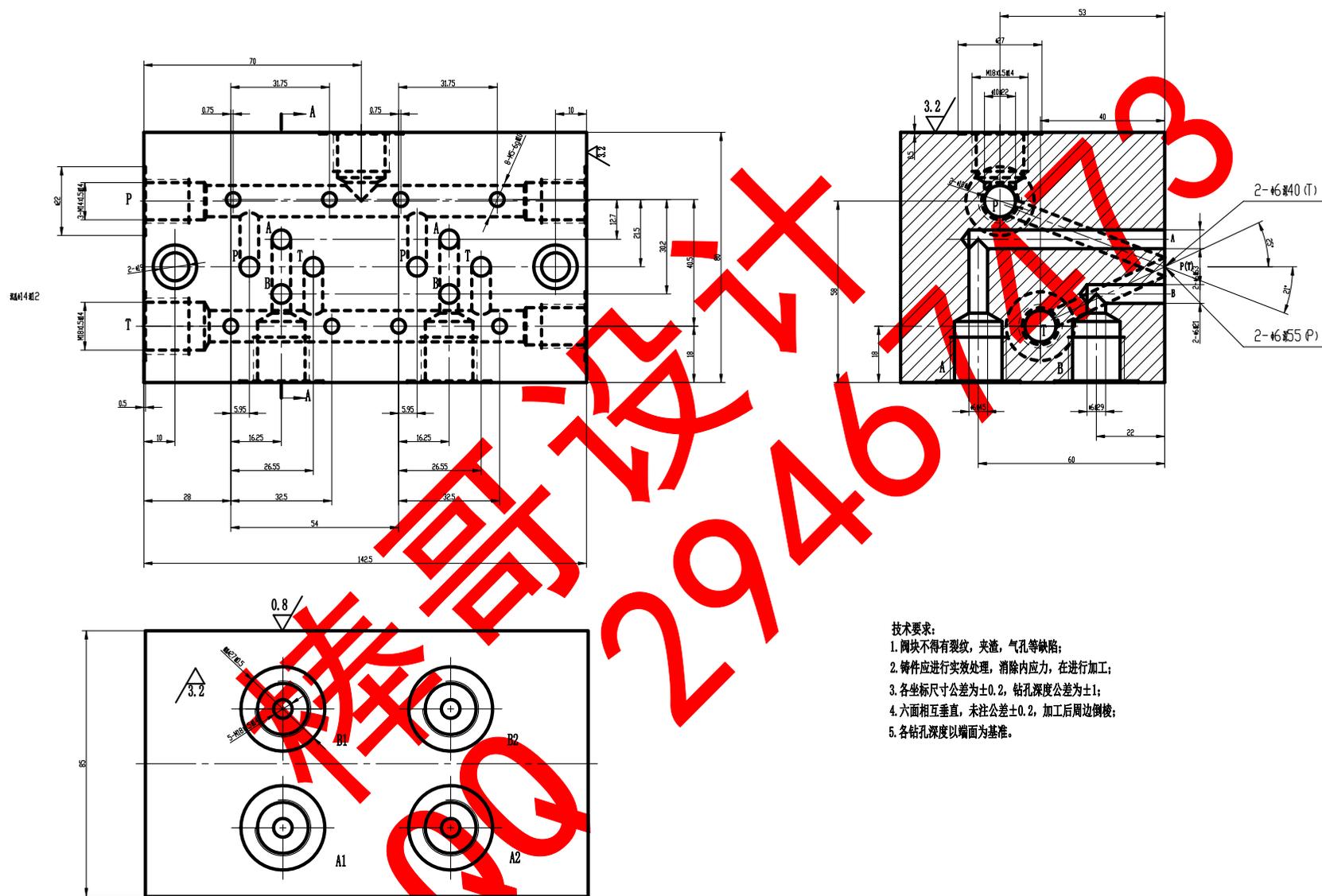
**技术要求:**

1. 装配时集装块的孔边、管子及各阀的内部，均须
2. 清洗干净，不得有砂子、氧化铁皮、铁屑等杂物。

27	J9802-77	阀 18	1						
26	CR37X 1-43	阀 18 G1/4	1						
25	J9802-77	阀 18	1						
24	CR37X 1-43	阀 G1/4	1						
23	J9802-77	阀 18	4						
22	CR37X 1-43	阀 G1/4	4						
21	WPC-202-20	电磁阀	1						1.000
20	WPC-202-40-20	电磁阀	1	45					1.000
19	TL807	阀 M5	4	45					
18	TL805	阀 M5x185	4	400					
17	DS-10-202-20	电磁阀	1						1.000
16	TL807	阀 M5	4	45					
15	TL805	阀 M5x180	4	400					
14	DS-10-202-20	电磁阀	1						1.000
13	WPC-202-40-1-20	电磁阀	2						1.000
12	CR37X 1-43	阀 E10/R 1/4	1						1.000
11	WPC-202-42-20	电磁阀	1						1.000
10	WPC-202-42-20	电磁阀	1						1.000
9	W-2-1/2-100-AL	阀 R 1/4	2						1.000
8	CG2-42	电磁阀 R 1/4	2						1.000
7	CR37X 1-43	阀 E10/R 1/4	2						1.000
6	CR37X 1-43	阀 G1/4x1.5	1						2.000
5	J9802-77	阀 G1/4	1						
4	CR37X 1-43	阀 G1/4	1						
3	J9802-77	阀 G1/4	2						
2	J970444-46	阀 G1/4x1.5	2						
1	J9704-2031-02	阀	1	20					
合	件	磅	磅	磅	磅	磅	磅	磅	磅
太湖学院									
阀组									
制	图	审	核	校	查	会	签	批	注
工	作	图	号	共	张	第	张		

# A1-阀块

其余 6.3



- 技术要求:
1. 阀块不得有裂纹, 夹渣, 气孔等缺陷;
  2. 铸件应进行时效处理, 消除内应力, 在进行加工;
  3. 各坐标尺寸公差为±0.2, 钻孔深度公差为±1;
  4. 六面相互垂直, 未注公差±0.2, 加工后周边倒棱;
  5. 各钻孔深度以端面为基准。

					太湖学院		
					阀块		
设计	张佳睿	审核	张佳睿	日期	2023.10.10	比例	1:1
共 5 张					第 5 张		

