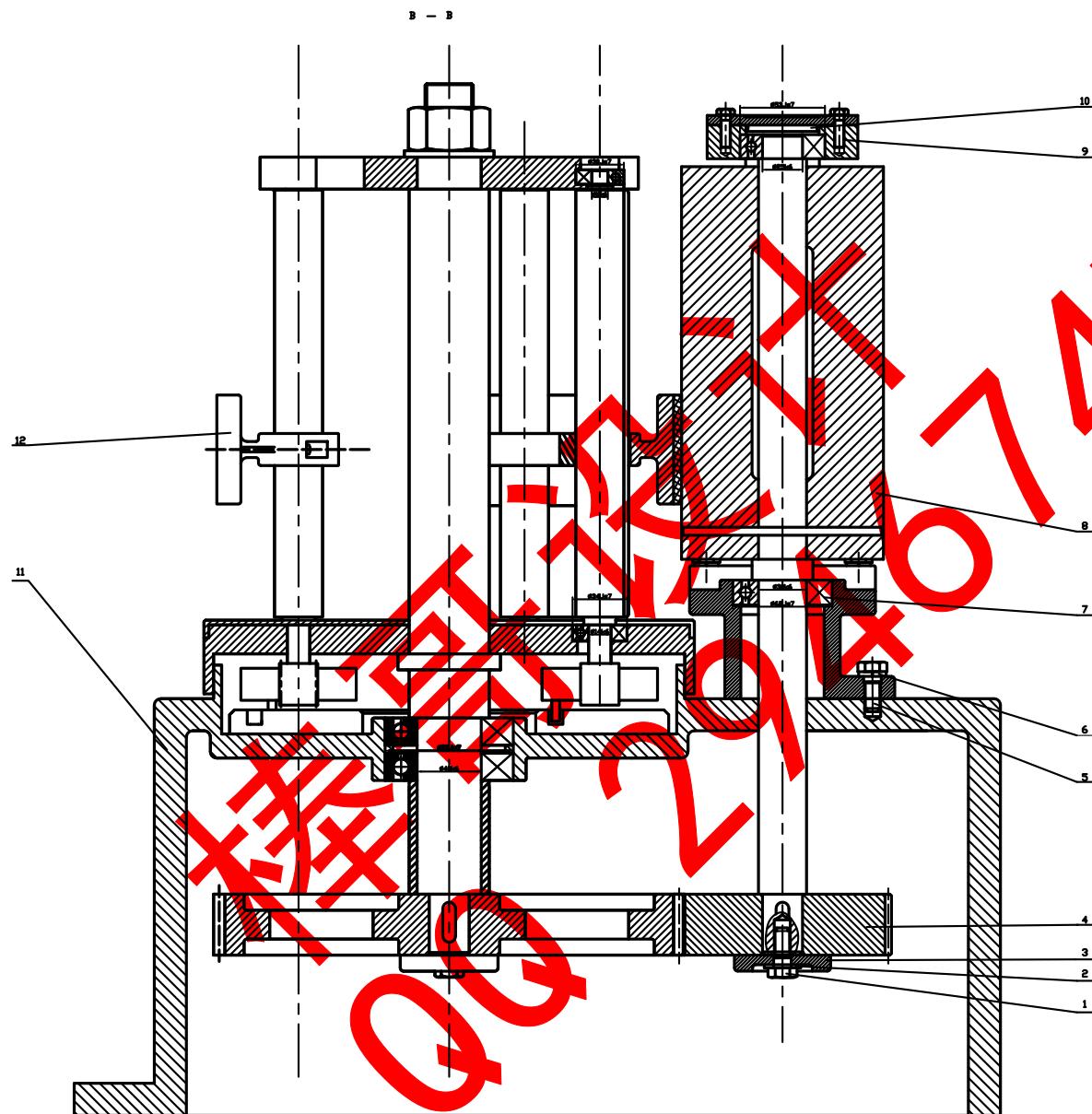


## A0-涂胶

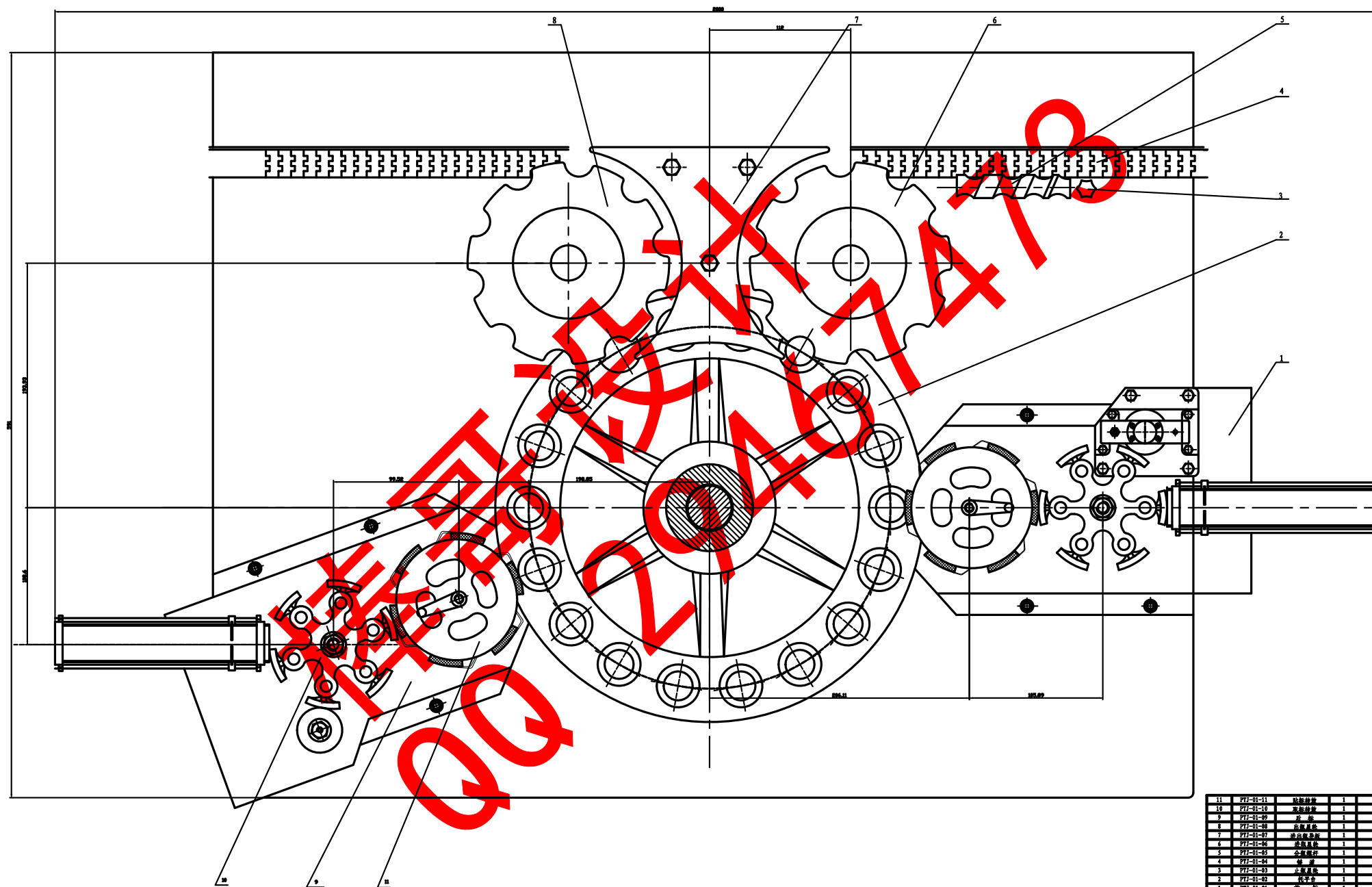


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| 10  | 2 | 1 | 0375-06  |
| 10  | 2 | 1 | 0375-07  |
| 10  | 2 | 1 | 0375-08  |
| 10  | 2 | 1 | 0375-09  |
| 10  | 2 | 1 | 0375-10  |
| 10  | 2 | 1 | 0375-11  |
| 10  | 2 | 1 | 0375-12  |
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| 10  | 2 | 1 | 0375-66  |
| 10  | 2 | 1 | 0375-67  |
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| 10  | 2 | 1 | 0375-82  |
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| 10  | 2 | 1 | 0375-93  |
| 10  | 2 | 1 | 0375-94  |
| 10  | 2 | 1 | 0375-95  |
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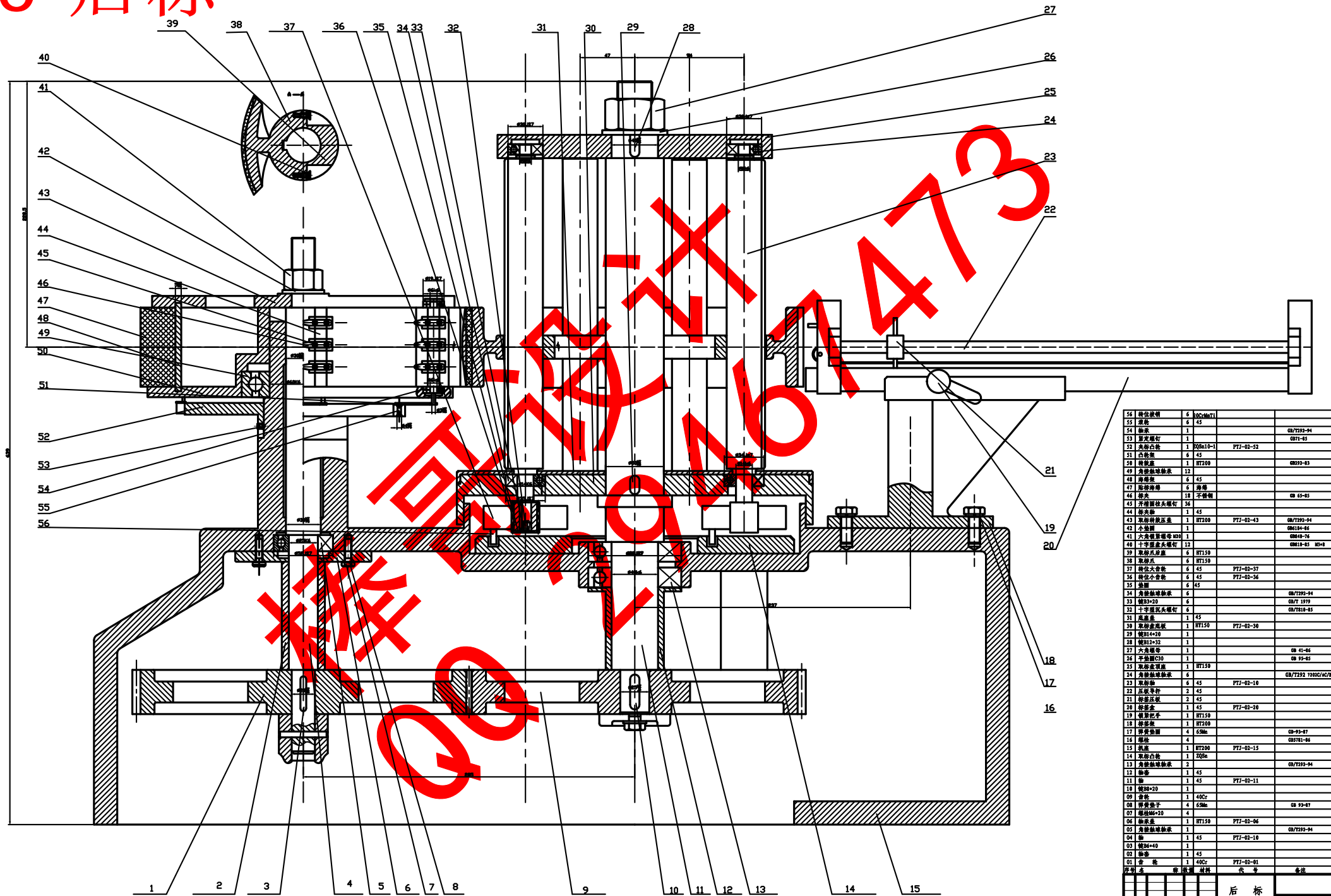
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PTJ-02-01

## A0-俯视

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# A0-后标



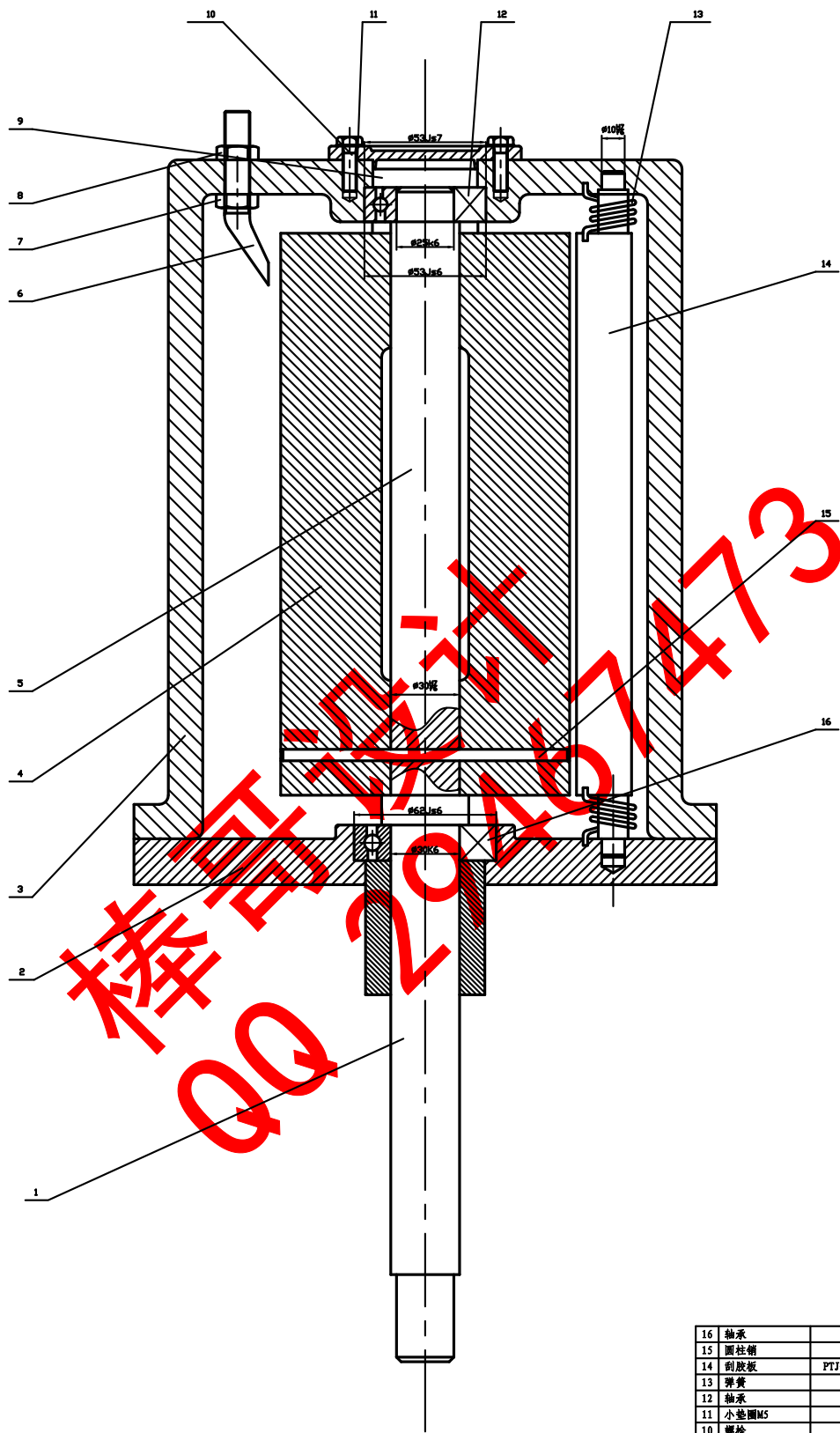
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| 56 | 螺栓     | 6  | 10C40M11 |           |            |            |
| 55 | 螺母     | 1  | 45       |           |            |            |
| 54 | 垫圈     | 1  |          |           | GB/T192-94 |            |
| 53 | 固定螺钉   | 1  |          |           | GB71-85    |            |
| 52 | 夹板凸块   | 1  | 200x10-1 | PTJ-02-52 |            |            |
| 51 | 凸块     | 6  | 45       |           |            |            |
| 50 | 螺母     | 1  | HT200    |           | GB933-83   |            |
| 49 | 角轴轴端密封 | 12 |          |           |            |            |
| 48 | 螺母     | 6  | 45       |           |            |            |
| 47 | 轴端密封   | 6  | 轴端       |           |            |            |
| 46 | 轴端     | 18 | 不锈钢      |           | GB 45-85   |            |
| 45 | 十字槽螺钉  | 36 |          |           |            |            |
| 44 | 轴端     | 1  | 45       |           |            |            |
| 43 | 固定螺钉   | 1  | HT200    | PTJ-02-43 |            | GB/T192-94 |
| 42 | 小轴     | 1  |          |           | GB4130-84  |            |
| 41 | 六角螺母   | 6  | M10      |           | GB44-74    |            |
| 40 | 十字槽螺钉  | 12 |          |           | GB115-85   | M10        |
| 39 | 轴端     | 6  | HT150    |           |            |            |
| 38 | 轴端     | 6  | HT150    |           |            |            |
| 37 | 轴端     | 6  | 45       |           |            |            |
| 36 | 轴端     | 6  | 45       |           |            |            |
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| 4  | 轴端     | 6  | 45       |           |            |            |
| 3  | 轴端     | 6  | 45       |           |            |            |
| 2  | 轴端     | 6  | 45       |           |            |            |
| 1  | 轴端     | 6  | 45       |           |            |            |

|    |        |    |          |           |            |            |
|----|--------|----|----------|-----------|------------|------------|
| 56 | 螺栓     | 6  | 10C40M11 |           |            |            |
| 55 | 螺母     | 1  | 45       |           |            |            |
| 54 | 垫圈     | 1  |          |           | GB/T192-94 |            |
| 53 | 固定螺钉   | 1  |          |           | GB71-85    |            |
| 52 | 夹板凸块   | 1  | 200x10-1 | PTJ-02-52 |            |            |
| 51 | 凸块     | 6  | 45       |           |            |            |
| 50 | 螺母     | 1  | HT200    |           | GB933-83   |            |
| 49 | 角轴轴端密封 | 12 |          |           |            |            |
| 48 | 螺母     | 6  | 45       |           |            |            |
| 47 | 轴端密封   | 6  | 轴端       |           |            |            |
| 46 | 轴端     | 18 | 不锈钢      |           | GB 45-85   |            |
| 45 | 十字槽螺钉  | 36 |          |           |            |            |
| 44 | 轴端     | 1  | 45       |           |            |            |
| 43 | 固定螺钉   | 1  | HT200    | PTJ-02-43 |            | GB/T192-94 |
| 42 | 小轴     | 1  |          |           | GB4130-84  |            |
| 41 | 六角螺母   | 6  | M10      |           | GB44-74    |            |
| 40 | 十字槽螺钉  | 12 |          |           | GB115-85   | M10        |
| 39 | 轴端     | 6  | HT150    |           |            |            |
| 38 | 轴端     | 6  | HT150    |           |            |            |
| 37 | 轴端     | 6  | 45       |           |            |            |
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| 2  | 轴端     | 6  | 45       |           |            |            |
| 1  | 轴端     | 6  | 45       |           |            |            |

|    |        |    |          |           |            |            |
|----|--------|----|----------|-----------|------------|------------|
| 56 | 螺栓     | 6  | 10C40M11 |           |            |            |
| 55 | 螺母     | 1  | 45       |           |            |            |
| 54 | 垫圈     | 1  |          |           | GB/T192-94 |            |
| 53 | 固定螺钉   | 1  |          |           | GB71-85    |            |
| 52 | 夹板凸块   | 1  | 200x10-1 | PTJ-02-52 |            |            |
| 51 | 凸块     | 6  | 45       |           |            |            |
| 50 | 螺母     | 1  | HT200    |           | GB933-83   |            |
| 49 | 角轴轴端密封 | 12 |          |           |            |            |
| 48 | 螺母     | 6  | 45       |           |            |            |
| 47 | 轴端密封   | 6  | 轴端       |           |            |            |
| 46 | 轴端     | 18 | 不锈钢      |           | GB 45-85   |            |
| 45 | 十字槽螺钉  | 36 |          |           |            |            |
| 44 | 轴端     | 1  | 45       |           |            |            |
| 43 | 固定螺钉   | 1  | HT200    | PTJ-02-43 |            | GB/T192-94 |
| 42 | 小轴     | 1  |          |           | GB4130-84  |            |
| 41 | 六角螺母   | 6  | M10      |           | GB44-74    |            |
| 40 | 十字槽螺钉  | 12 |          |           | GB115-85   | M10        |
| 39 | 轴端     | 6  | HT150    |           |            |            |
| 38 | 轴端     | 6  | HT150    |           |            |            |
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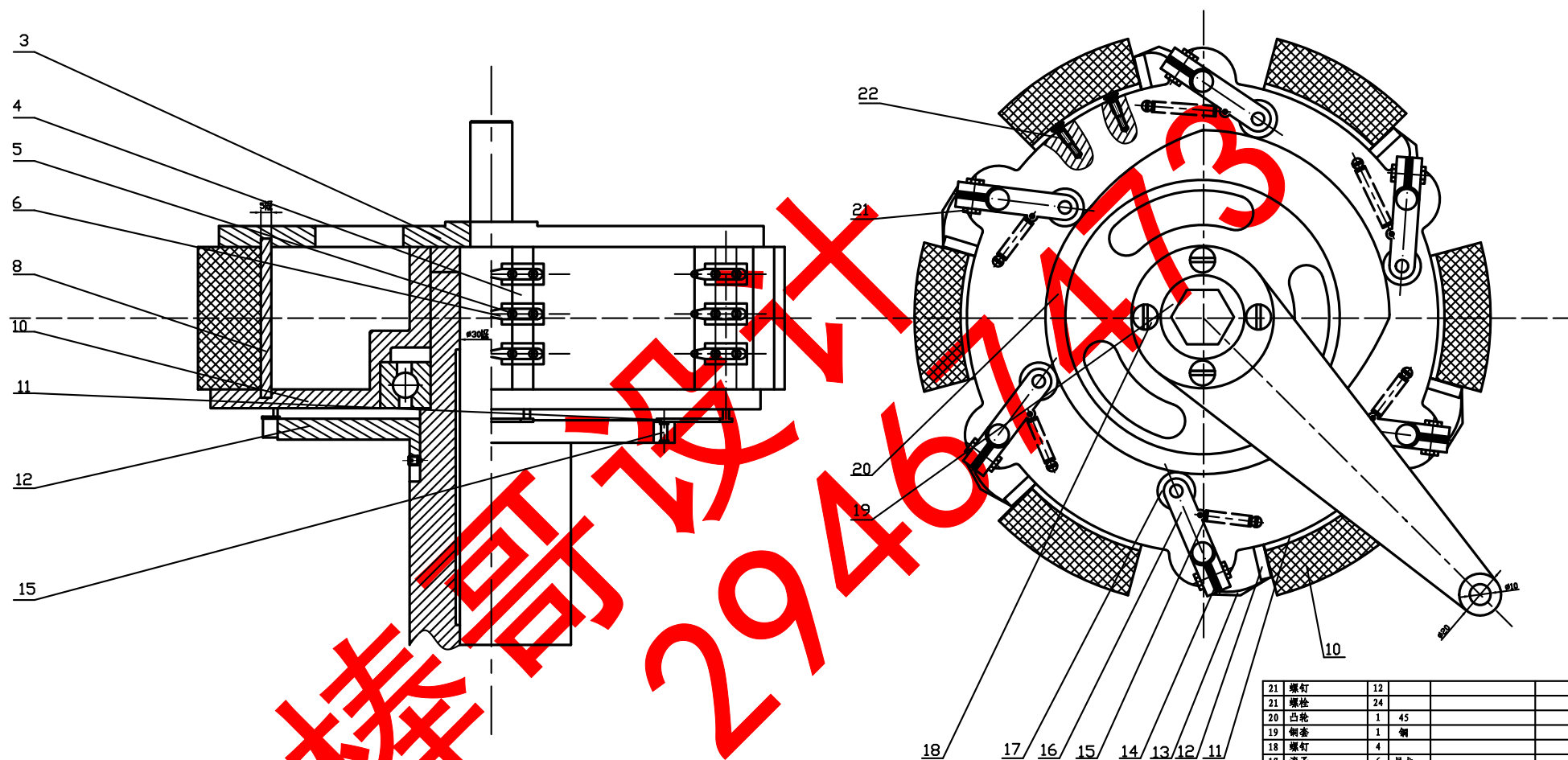
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| 56 | 螺栓     | 6  | 10C40M11 |           |            |            |
| 55 | 螺母     | 1  | 45       |           |            |            |
| 54 | 垫圈     | 1  |          |           | GB/T192-94 |            |
| 53 | 固定螺钉   | 1  |          |           | GB71-85    |            |
| 52 | 夹板凸块   | 1  | 200x10-1 | PTJ-02-52 |            |            |
| 51 | 凸块     | 6  | 45       |           |            |            |
| 50 | 螺母     | 1  | HT200    |           | GB933-83   |            |
| 49 | 角轴轴端密封 | 12 |          |           |            |            |
| 48 | 螺母     | 6  | 45       |           |            |            |
| 47 | 轴端密封   | 6  | 轴端       |           |            |            |
| 46 | 轴端     | 18 | 不锈钢      |           | GB 45-85   |            |
| 45 | 十字槽螺钉  | 36 |          |           |            |            |
| 44 | 轴端     | 1  | 45       |           |            |            |
| 43 | 固定螺钉   | 1  | HT200    | PTJ-02-43 |            | GB/T192-94 |
| 42 | 小轴     | 1  |          |           | GB4130-84  |            |
| 41 | 六角螺母   | 6  | M10      |           | GB44-74    |            |
| 40 | 十字槽螺钉  | 12 |          |           | GB115-85   | M10        |
| 39 | 轴端     | 6  | HT150    |           |            |            |
| 38 | 轴端     | 6  | HT150    |           |            |            |
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| 1  | 轴端     | 6  | 45       |           |            |            |

|    |        |    |          |           |            |            |
|----|--------|----|----------|-----------|------------|------------|
| 56 | 螺栓     | 6  | 10C40M11 |           |            |            |
| 55 | 螺母     | 1  | 45       |           |            |            |
| 54 | 垫圈     | 1  |          |           | GB/T192-94 |            |
| 53 | 固定螺钉   | 1  |          |           | GB71-85    |            |
| 52 | 夹板凸块   | 1  | 200x10-1 | PTJ-02-52 |            |            |
| 51 | 凸块     | 6  | 45       |           |            |            |
| 50 | 螺母     | 1  | HT200    |           | GB933-83   |            |
| 49 | 角轴轴端密封 | 12 |          |           |            |            |
| 48 | 螺母     | 6  | 45       |           |            |            |
| 47 | 轴端密封   | 6  | 轴端       |           |            |            |
| 46 | 轴端     | 18 | 不锈钢      |           | GB 45-85   |            |
| 45 | 十字槽螺钉  | 36 |          |           |            |            |
| 44 | 轴端     | 1  | 45       |           |            |            |
| 43 | 固定螺钉   | 1  | HT200    | PTJ-02-43 |            | GB/T192-94 |
| 42 | 小轴     | 1  |          |           | GB4130-84  |            |
| 41 | 六角螺母   | 6  | M10      |           | GB44-74    |            |
| 40 | 十字槽螺钉  | 12 |          |           | GB115-85   | M10        |
| 39 | 轴端     | 6  | HT150    |           |            |            |
| 38 | 轴端     | 6  | HT150    |           |            |            |
| 37 | 轴端     | 6  | 45       |           |            |            |
| 36 | 轴端     | 6  | 45       |           |            |            |
| 35 | 轴端     | 6  | 45       |           |            |            |
| 34 | 轴端     | 6  | 45       |           |            |            |
| 33 | 轴端     | 6  | 45       |           |            |            |
| 32 | 轴端     | 6  | 45       |           |            |            |
| 31 | 轴端     | 6  | 45       |           |            |            |
| 30 | 轴端     | 6  | 45       |           |            |            |
| 29 | 轴端     | 6  | 45       |           |            |            |
| 28 | 轴端     | 6  | 45       |           |            |            |
| 27 | 轴端     | 6  | 45       |           |            |            |
| 26 | 轴端     | 6  | 45       |           |            |            |
| 25 | 轴端     | 6  | 45       |           |            |            |
| 24 | 轴端     | 6  | 45       |           |            |            |
| 23 | 轴端     | 6  | 45       |           |            |            |
| 22 | 轴端     | 6  | 45       |           |            |            |
| 21 | 轴端     | 6  | 45       |           |            |            |
| 20 | 轴端     | 6  | 45       |           |            |            |
| 19 | 轴端     | 6  | 45       |           |            |            |
| 18 | 轴端     | 6  | 45       |           |            |            |
| 17 | 轴端     | 6  | 45       |           |            |            |
| 16 | 轴端     | 6  | 45       |           |            |            |
| 15 | 轴端     | 6  | 45       |           |            |            |
| 14 | 轴端     | 6  | 45       |           |            |            |
| 13 | 轴端     | 6  | 45       |           |            |            |
| 12 | 轴端     | 6  | 45       |           |            |            |
| 11 | 轴端     | 6  | 45       |           |            |            |
| 10 | 轴端     | 6  | 45       |           |            |            |
| 9  | 轴端     | 6  | 45       |           |            |            |
| 8  |        |    |          |           |            |            |



|    |       |              |    |       |           |
|----|-------|--------------|----|-------|-----------|
| 16 | 轴承    |              | 1  |       | GB292-83  |
| 15 | 圆柱销   |              | 1  | 45    |           |
| 14 | 刮胶板   | PTJ-01-09-19 | 1  | 45    |           |
| 13 | 弹簧    |              | 2  | 弹簧钢   |           |
| 12 | 轴承    |              | 1  |       | GB292-83  |
| 11 | 小垫圈M5 |              | 4  |       | GB848-76  |
| 10 | 螺栓    |              | 4  |       | GB5781-86 |
| 9  | 轴承盖   | PTJ-01-09-14 | 1  | HT150 |           |
| 8  | 螺母    |              | 1  |       | GB808-86  |
| 7  | 螺母    |              | 1  |       | GB808-88  |
| 6  | 喷胶嘴   | PTJ-01-09-11 | 1  | 45    |           |
| 5  | 轴     | PTJ-01-09-10 | 1  | 45    |           |
| 4  | 胶辊轮   | PTJ-01-09-09 | 1  | HT150 |           |
| 3  | 支架    |              | 1  | 45    |           |
| 2  | 底座    | PTJ-01-09-07 | 1  | HT150 |           |
| 1  | 轴     |              |    |       |           |
| 序号 | 名称    | 代号           | 数量 | 材料    | 备注        |
|    |       |              |    | 胶 辊   |           |
|    |       |              |    |       | 部装图       |
|    |       |              |    |       | PTJ-02-03 |

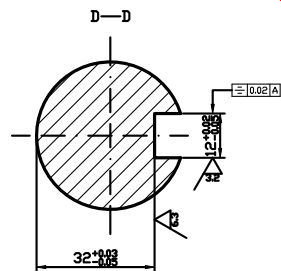
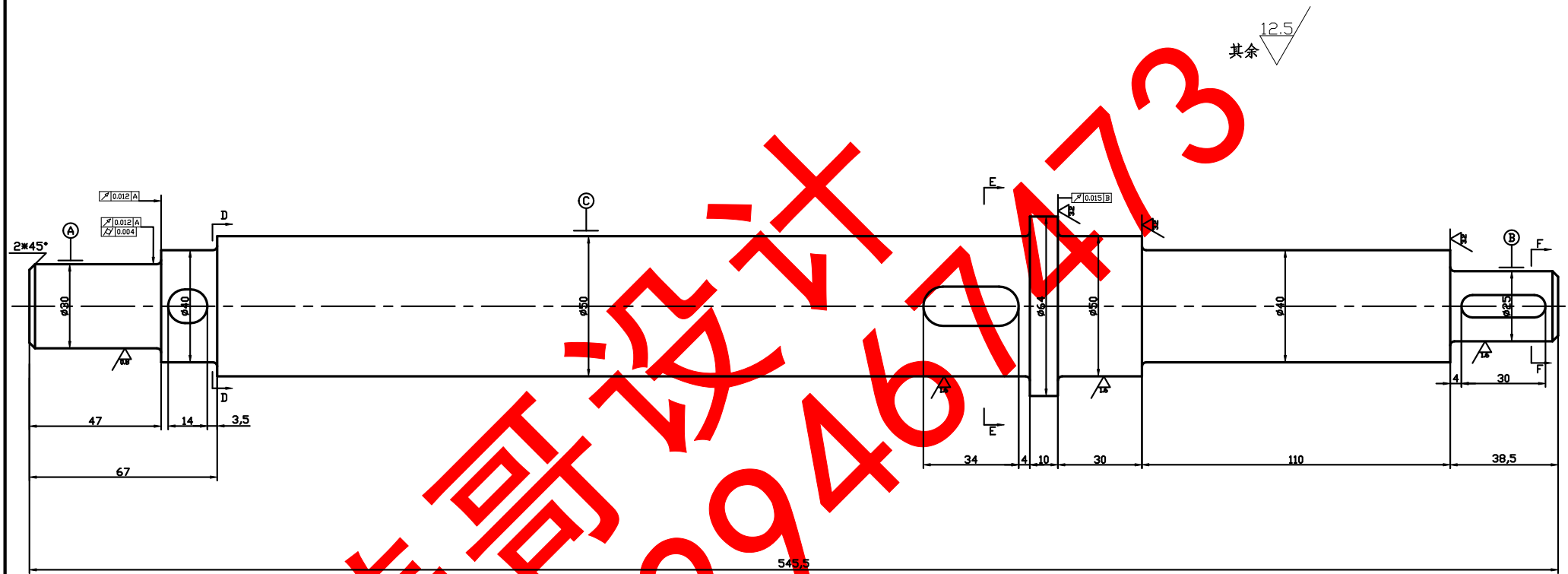
## A1-取标转鼓



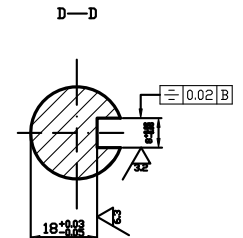
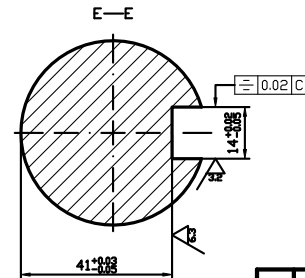
|                                                                                                                                                                                                                                           |        |     |          |              |     |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|-----|----------|--------------|-----|--------------|
| 21                                                                                                                                                                                                                                        | 螺钉     | 12  |          |              |     | GB/T19-20    |
| 21                                                                                                                                                                                                                                        | 螺栓     | 24  |          |              |     | GB5782-86    |
| 20                                                                                                                                                                                                                                        | 凸轮     | 1   | 45       |              |     |              |
| 19                                                                                                                                                                                                                                        | 铜套     | 1   | 铜        |              |     |              |
| 18                                                                                                                                                                                                                                        | 螺钉     | 4   |          |              |     | GB1968-1985  |
| 17                                                                                                                                                                                                                                        | 滚子     | 6   | 尼龙       |              |     |              |
| 16                                                                                                                                                                                                                                        | 凸轮摆杆   | 6   | HT200    |              |     |              |
| 15                                                                                                                                                                                                                                        | 弹簧     | 6   |          |              |     | GB1973-1989  |
| 14                                                                                                                                                                                                                                        | 垫片     | 6   |          |              |     |              |
| 13                                                                                                                                                                                                                                        | 夹指     | 6   | HT150    |              |     |              |
| 12                                                                                                                                                                                                                                        | 垫套     | 6   | 橡胶       |              |     |              |
| 11                                                                                                                                                                                                                                        | 海绵支撑板  | 6   | A3       |              |     |              |
| 10                                                                                                                                                                                                                                        | 贴标海绵   | 6   | 海绵       |              |     |              |
| 9                                                                                                                                                                                                                                         | 滚轮     | 6   | 45       |              |     |              |
| 8                                                                                                                                                                                                                                         | 夹标凸轮   | 1   | Q28n10-1 |              |     |              |
| 7                                                                                                                                                                                                                                         | 凸轮架    | 6   | 45       |              |     |              |
| 6                                                                                                                                                                                                                                         | 转鼓座    | 1   | HT200    |              |     | GB292-83     |
| 5                                                                                                                                                                                                                                         | 海绵架    | 6   | 45       |              |     |              |
| 4                                                                                                                                                                                                                                         | 贴标海绵   | 6   | 海绵       |              |     |              |
| 3                                                                                                                                                                                                                                         | 标夹     | 18  | 不锈钢      |              |     | GB 1965-1985 |
| 2                                                                                                                                                                                                                                         | 标夹轴    | 1   | 45       | PTJ-02-02-11 |     |              |
| 1                                                                                                                                                                                                                                         | 取标转鼓压差 | 1   | HT200    |              |     | GB/T7292-94  |
| 序号                                                                                                                                                                                                                                        | 名 称    | 数 量 | 材 料      | 代 号          | 备 注 |              |
|                                                                                                                                                                                                                                           |        |     |          | 取标转鼓         |     |              |
| <div> <div>             土 8 4 1 6 y + 0 0 0 变 文 件 名 0 0 A 0 8 1 0 0 0 0 0           </div> <div>             8 8 月 0 0 0 2 0 0 8 . 0 0 土 8 X 0 0           </div> <div>             4 X 1 1 土 8 4 0 0 A 1 土 8 A 0           </div> </div> |        |     |          |              |     |              |
| 部 装 图                                                                                                                                                                                                                                     |        |     |          |              |     |              |
| PTJ-02-02                                                                                                                                                                                                                                 |        |     |          |              |     |              |



# A2-取标轴

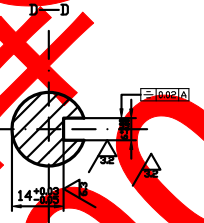
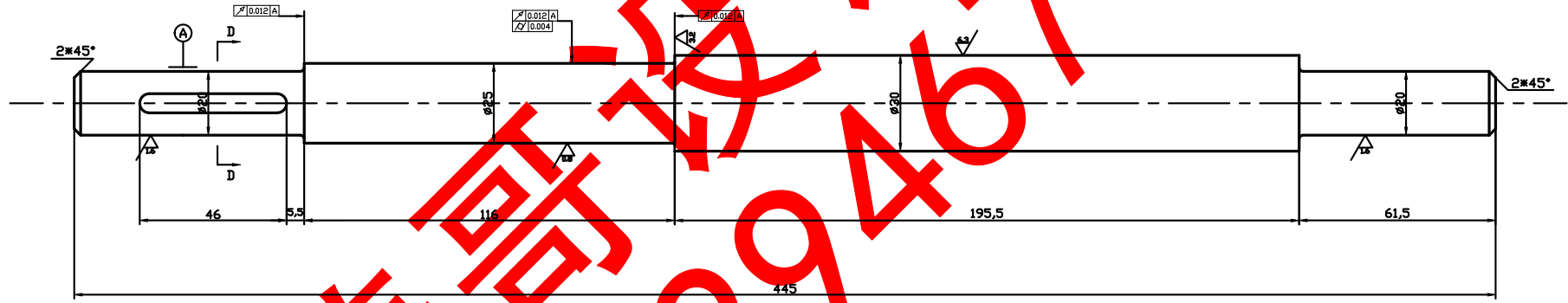


- 技术要求
1. 调质处理, 230~250HBS;
  2. 圆角半径1.5mm;
  3. 未注尺寸公差按GB/T12.1.



|          |  |  |  |          |  |  |  |             |  |
|----------|--|--|--|----------|--|--|--|-------------|--|
|          |  |  |  | 取标轴      |  |  |  | 零件图         |  |
|          |  |  |  |          |  |  |  |             |  |
| ±0.012 A |  |  |  | ±0.015 B |  |  |  | 1:1.5       |  |
| ±0.004 A |  |  |  | ±0.02 C  |  |  |  |             |  |
| ±0.02 B  |  |  |  | ±0.02 B  |  |  |  | 共 9 张 第 7 张 |  |
| ±0.02 C  |  |  |  | ±0.02 B  |  |  |  |             |  |

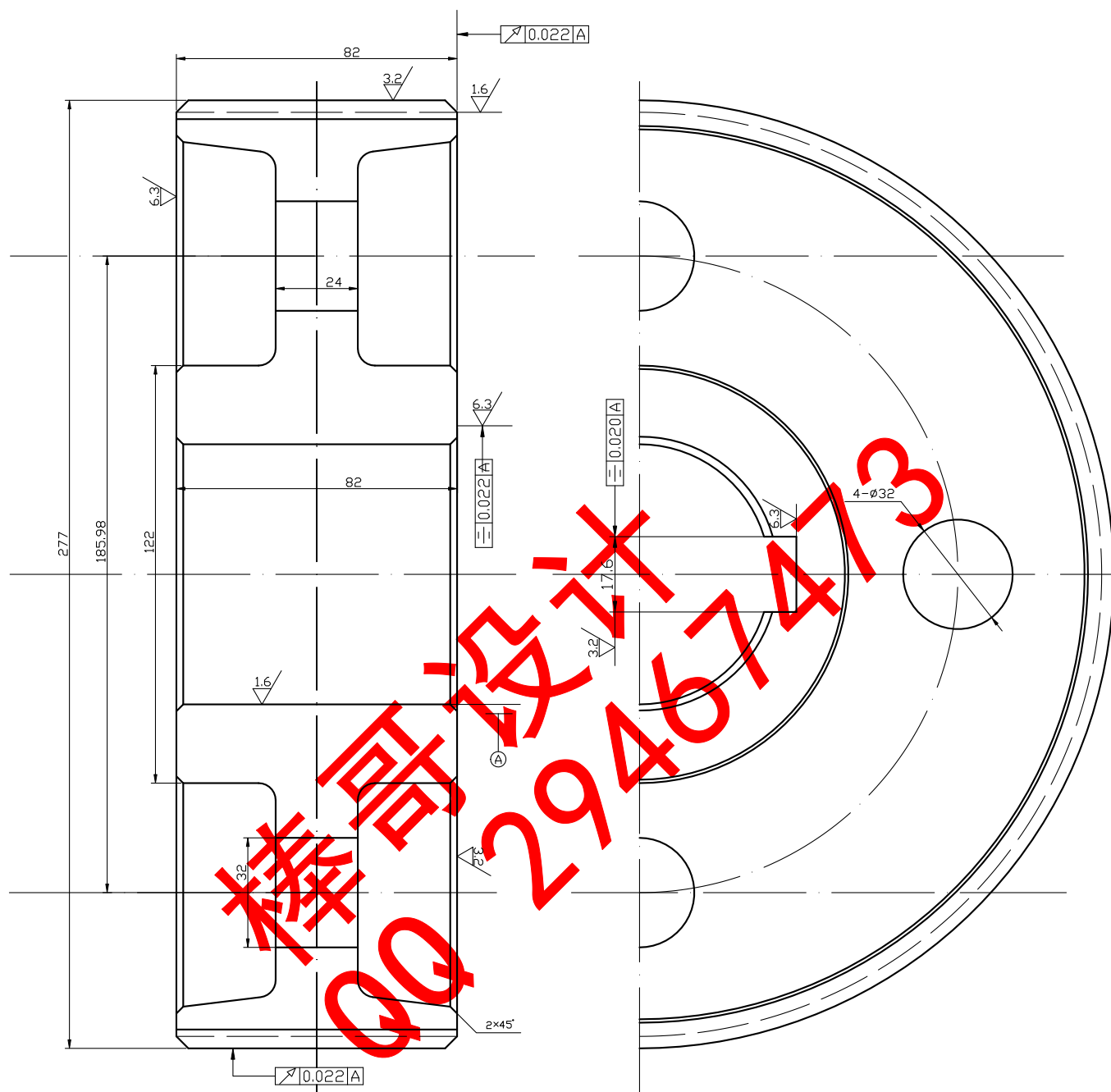
A2-贴标轴



- 技术要求
1. 调质处理, 230 ~250HBS;
  2. 圆角半径1.5mm;
  3. 未注尺寸公差按GB/T12.

|        |        |         |        |        |        |        |        |              |
|--------|--------|---------|--------|--------|--------|--------|--------|--------------|
|        |        |         |        | 贴标轴    |        |        |        | 零件图          |
| ±0.012 | ±0.012 | ±0.012  | ±0.012 | ±0.012 | ±0.012 | ±0.012 | ±0.012 |              |
| 设计     | 周强     | 2008.06 | ±0.012 | ±0.012 | ±0.012 | ±0.012 | ±0.012 | PTJ-02-02-01 |
| 共      | 9      | 张       | 第      | 8      | 张      |        |        |              |

# A3-齿轮



| 法向模数  | 齿 数 | 齿形角        | 螺旋角              | 齿全高  |
|-------|-----|------------|------------------|------|
| $m_n$ | Z   | $\angle A$ | $\angle \hat{A}$ | h    |
| 2.5   | 105 | 20°        | 13° 32' 24"      | 5.63 |

## 技术要求

1. 热处理调质, 230 ~ 250HBS;
2. 未注圆角半径R5;
3. 未注倒角C2;
4. 清除毛刺。

|       |  |  |  |         |  |  |  |              |  |  |  |
|-------|--|--|--|---------|--|--|--|--------------|--|--|--|
|       |  |  |  | 齿 轮     |  |  |  | 零 件 图        |  |  |  |
|       |  |  |  |         |  |  |  |              |  |  |  |
| 更改文件号 |  |  |  | 2008.06 |  |  |  | PTJ-02-02-03 |  |  |  |
| 共 9 张 |  |  |  | 第 9 张   |  |  |  |              |  |  |  |