



Technology requirement:

- 1.Unspecified fillet is R2-R3. The draft angle is 1 ° 30 MAX
- 2.No air hole, cinder inclusion, shrinkage cavity on the casting.
- 3.The casting needs to be executed according to GB/T 1348-2009. Graphitization degree of casting is no less than 3 level. When casting, the cast needs artificial ageing treatment. The hardness is HB 170-230.
- 4.The casting needs shot blast. No silver sand in the groove.
- 5.Unspecified machining chamfer is 0.5 × 45 ° . Unspecified process fillet is R0.5. Remove sharp corner, burrs.

casting unspecified size limit deviation(MM)					
basic size	greater than	0	63	100	160 250
to	63	100	160	250	400
greater than	±1.0	±1.1	±1.3	±1.6	±2.2

casting unspecified size limit deviation(MM)					
basic size	greater than	0.5	3	6	30 120
to	3	6	30	120	400
greater than	±0.1	±0.1	±0.2	±0.3	±0.5

标记	数量	日期
设计		标准审查
校对		审定
审核		批准
工艺审查		日期

casting 1

QT500-7

73.00A.6P05-001

图样标记 重量 比例

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