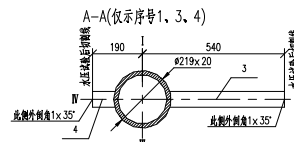
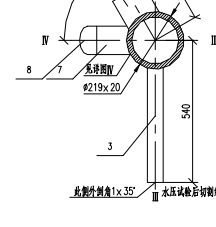
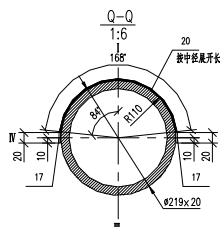
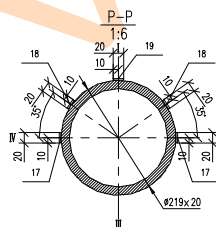
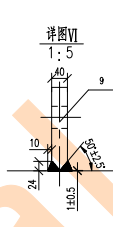
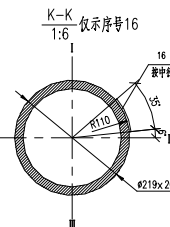
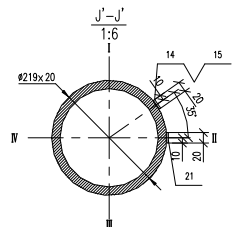
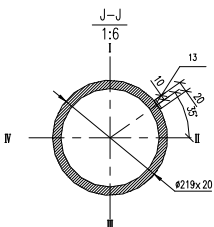
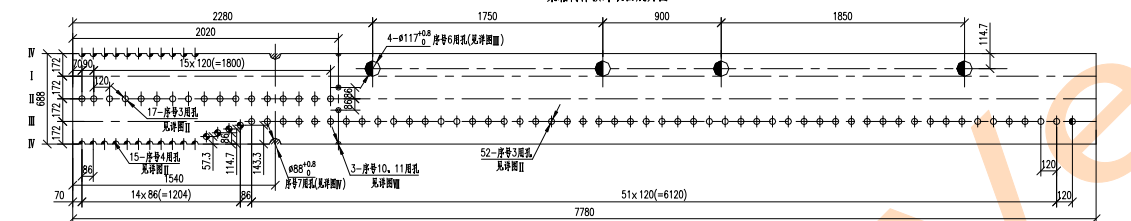
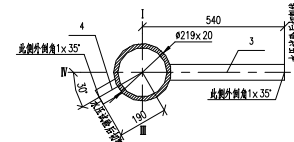


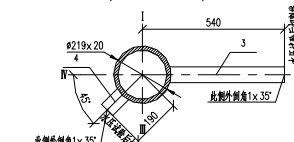
集箱筒体按外表面展开图



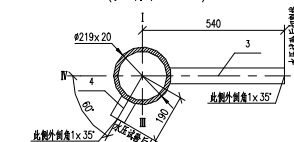
B-B(仅示序号1、3、4)



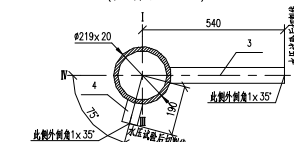
C-C(仅示序号1、3、4)




D-D(仅示序号1、3、4)

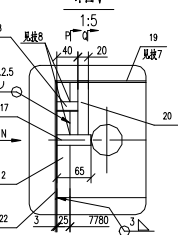
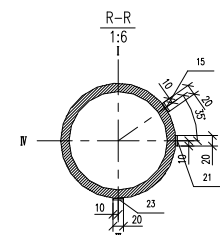
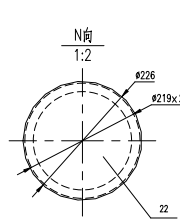
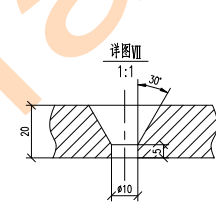
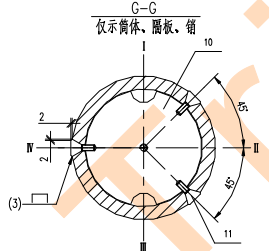
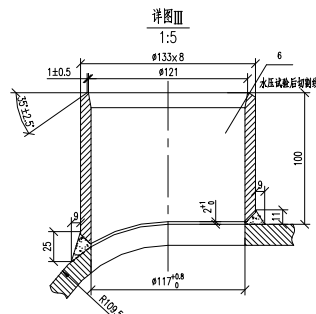


E-E(仅示序号1、3、4)



技术要求:

- 1.按UG0810“锅炉集箱制造条件”制造与验收。
- 2.工作压力 $P_g=5.45\text{MPa}$, 水压试验压力 $P_s=8.175\text{MPa}$ 。
- 3.集箱管孔及加工面粗糙度为 $\frac{25}{10}$ 。
- 4.集箱两端按图17开坡口。
- 5.扁钢与管接头等相碰处可适当修磨。
- 6.扁钢与集箱的焊接按 。
- 7.序号19与其他扁钢、耳板等相碰处可适当修磨。
- 8.此处集箱与端盖的焊缝需磨平以便焊接序号17、18、19。



										19 189T24-19-(19) 磨钢 3x 20L=1385 1 Q235B 0.65 0.65										12 98T24-16-18 耳板 销 8x 20 2 Q245R 1.3 2.6 磨用																			
										18 189T24-19-(18) 磨钢 3x 20L=40 2 Q235B 0.02 0.04										11 GB/T119.1 销 8x 20 3 Q235A 0.008 0.024																			
										17 189T24-19-(17) 磨钢 3x 20L=65 2 Q235B 0.03 0.06										10 98T24-12-10 隔板 1 Q235A 3 3 磨用																			
										16 189T24-19-(16) 磨钢 3x 20 5 Q235B 0.03 0.15										9 UG6406-86 夹板耳轴 d56; #219 5 Q245R 9.96 49.8																			
										15 189T24-19-(15) 磨钢 3x 20L=1485 1 Q235B 0.7 0.7										8 UG4115.2-01 手孔堵盖 1型 1 Q245R 2.8 2.8																			
										14 189T24-19-(14) 磨钢 3x 20L=2230 1 Q235B 1.05 1.05										7 134T24-11-7 管接头 φ108x10 1 20C/GB5310 2.6 2.6 磨用																			
										13 189T24-19-(13) 磨钢 3x 20L=960 1 Q235B 0.45 0.45										6 UG5010-80 管接头 φ133x8-110 4 20G/GB5310 2.824 11.296																			
										12 189T24-19-(23) 磨钢 3x 20L=100 1 Q235B 0.05 0.05										5 189T24-19-(22) 钢板 δ 3; #226 1 Q235B 0.94 0.94																			
										21 189T24-19-(21) 磨钢 3x 20L=4860 1 Q235B 2.29 2.29										4 189T24-19-(20) 磨钢 3x 20 1 Q235B 0.15 0.15																			
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										15 189T24-19-(15) 磨钢 3x 20L=1485 1 Q235B 0.7 0.7										14 189T24-19-(14) 磨钢 3x 20L=2230 1 Q235B 1.05 1.05																			
										13 189T24-19-(13) 磨钢 3x 20L=960 1 Q235B 0.45 0.45										12 189T24-19-(12) 磨钢 3x 20L=100 1 Q235B 0.05 0.05																			
										21 189T24-19-(21) 磨钢 3x 20L=4860 1 Q235B 2.29 2.29										20 189T24-19-(20) 磨钢 3x 20 1 Q235B 0.29 0.29																			
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