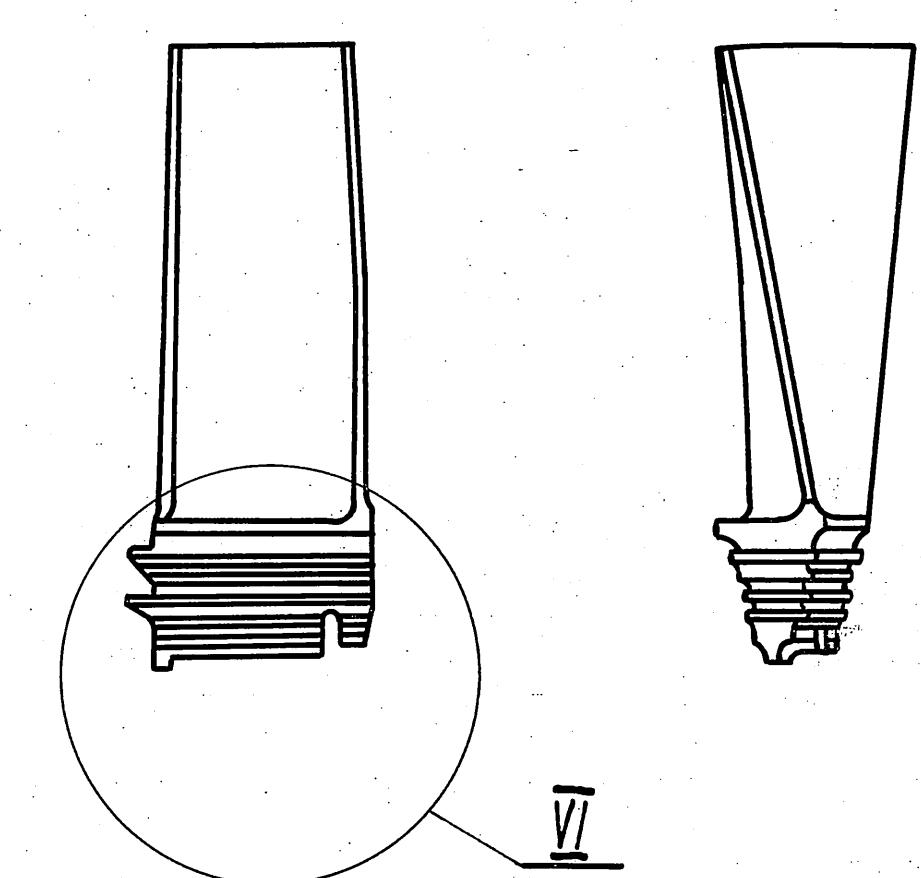
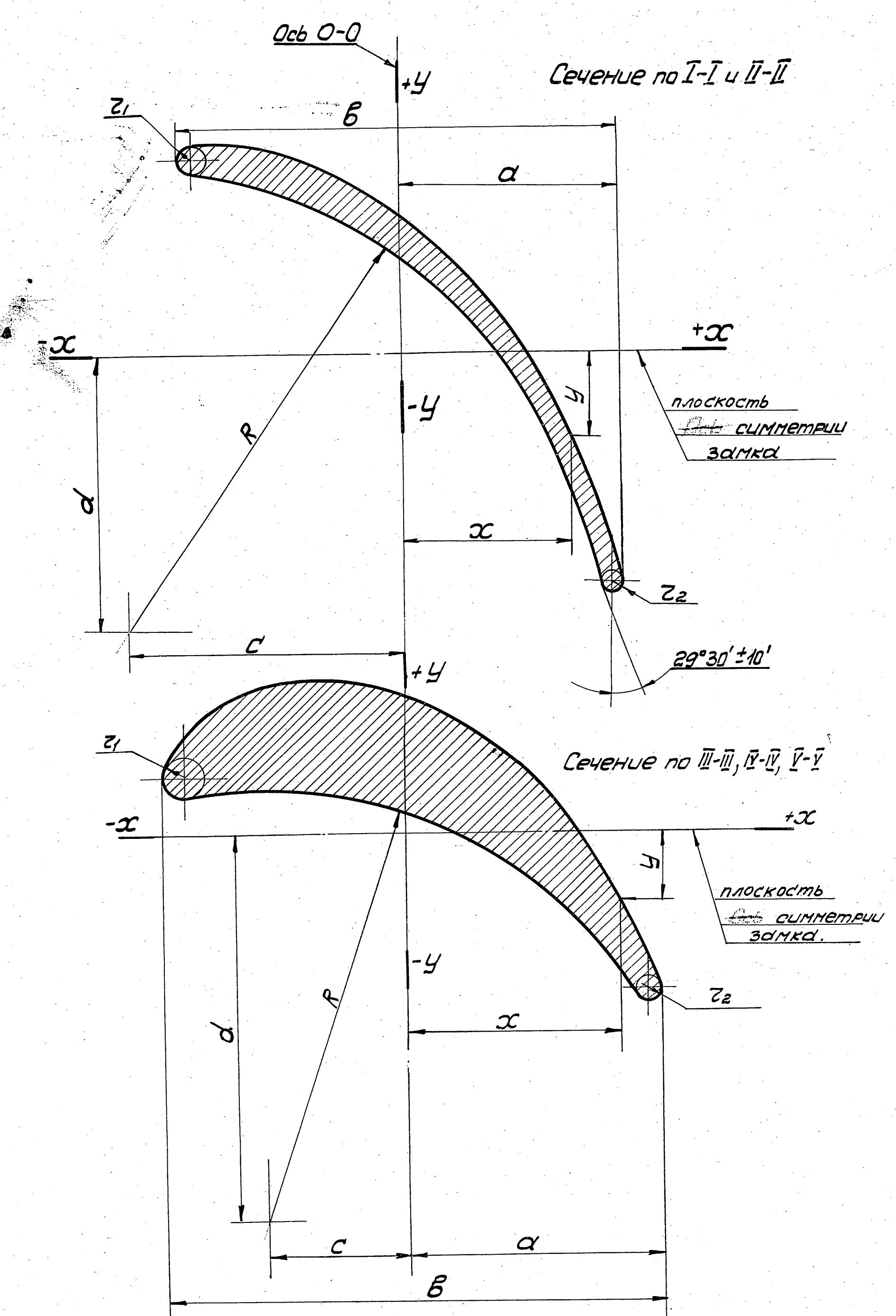
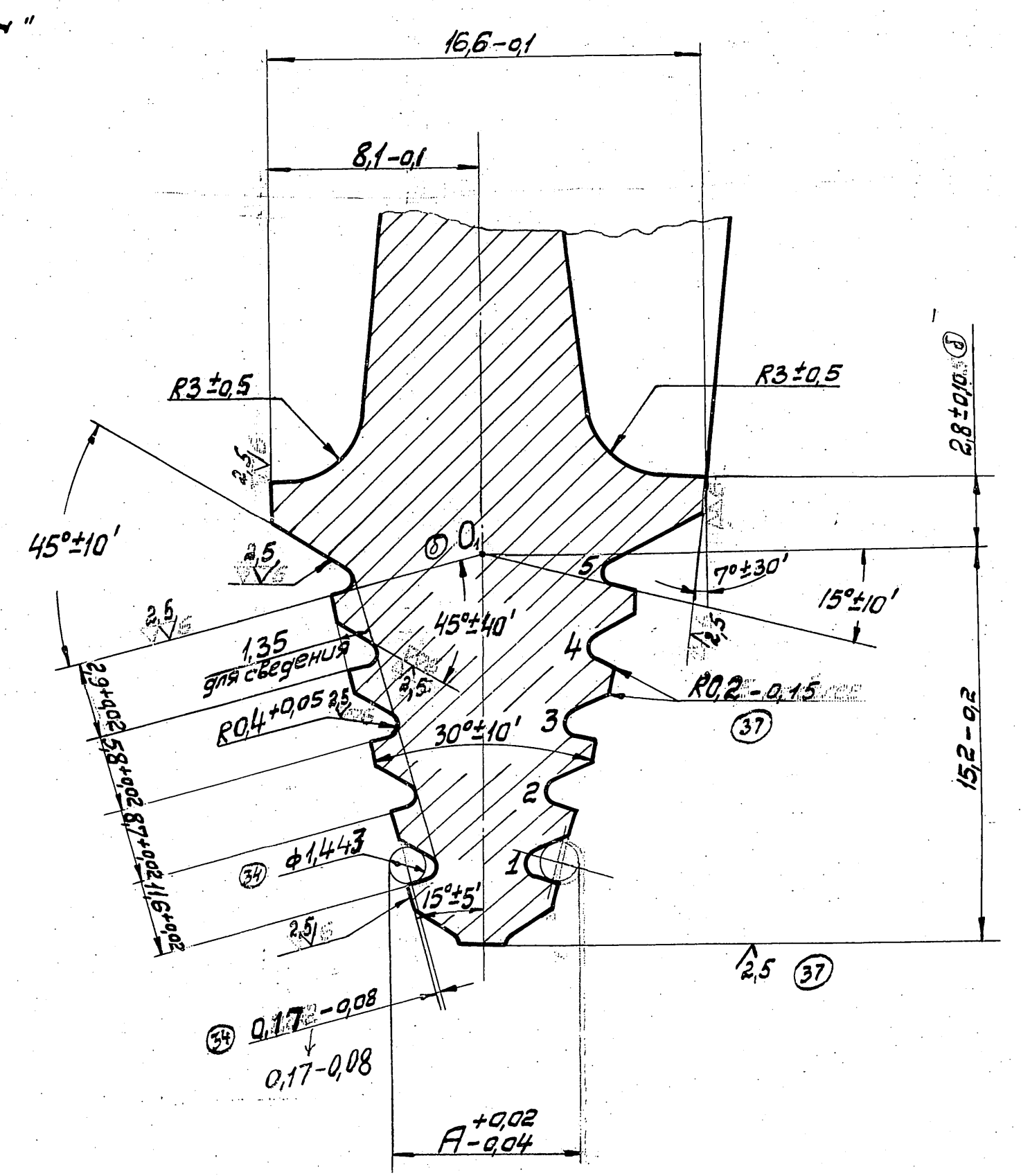
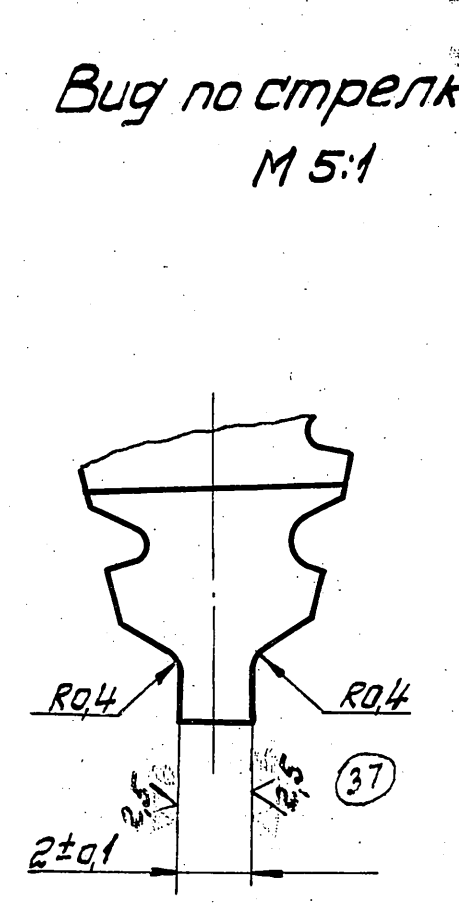
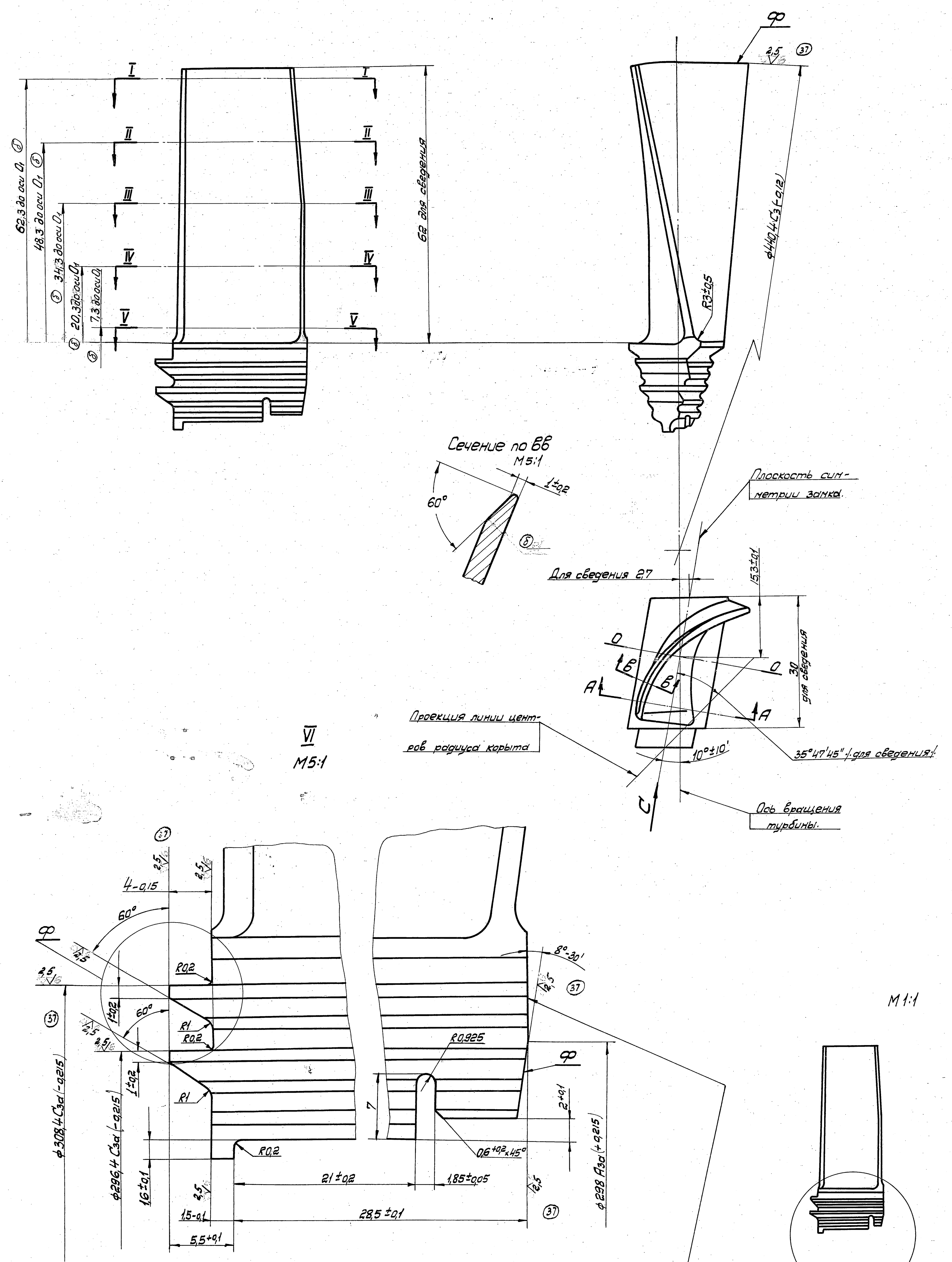


Таблица координат спинки по сечениям.

		X															α	β	c	d	R	z_1	z_2															
		-13.5	-13	-12	-11	-10	-9	-8	-7	-6	-5	-4	-3	-2	-1	0								+1	+2	+3	+4	+5	+6	+7	+8	+9	+10	+11	+12	+13	+14	+15
I-I	y	-	16.10	15.30	16.10	16.44	16.42	15.32	15.20	16.00	15.72	15.43	15.05	14.63	14.18	13.68	13.10	12.47	11.80	11.05	10.23	-0.70	-1.64	-2.78	-4.08	-5.58	-7.22	-8.93	-10.67	-12.36	-	14.95	28.62	11.39	21.54	25	0.75	0.50
II-II		-	14.00	14.62	15.00	15.30	15.48	15.59	15.60	15.58	15.47	15.34	15.13	14.88	14.50	14.10	13.66	13.15	12.60	12.00	11.30	-0.80	-1.22	-2.30	-3.44	-4.72	-6.10	-7.70	-9.38	-11.15	15.63	29.21	8.97	22.28	25	0.85	0.52	
III-III		-	12.20	13.25	13.94	14.40	14.80	15.08	15.24	15.32	15.37	15.32	15.21	15.08	14.84	14.45	14.20	13.80	13.36	12.90	12.40	11.70	11.00	+0.21	-0.67	-1.67	-2.79	-3.99	-5.41	-6.97	-8.69	16.12	29.77	6.35	24.17	25	0.90	0.53
IV-IV		-1.00	10.42	12.00	12.95	13.66	14.25	14.68	14.95	15.17	15.32	15.39	15.42	15.38	15.25	15.06	14.83	14.50	14.15	13.70	13.13	12.48	11.79	10.97	10.08	-0.93	-2.00	-3.23	-4.50	-5.92	-7.46	15.83	29.41	3.68	26.10	25	1.10	0.57
V-V	-0.17	10.91	12.40	13.36	14.09	14.68	15.03	15.35	15.57	15.74	15.81	15.82	15.79	15.69	15.56	15.28	15.00	14.60	14.10	13.53	12.87	12.15	11.36	10.50	-0.45	-1.51	-2.70	-4.02	-5.44	-7.00	15.38	29.19	1.49	27.68	25	1.50	0.70	

- заготовка - штамповка.
- Направляющие балок и штамповка - провальное.
- 19) Термообработка и методы контроля - по ТУ 108.02.015-87.
- Поверхности, обозначенные буквой Ф, окончательно обработать в узле.
- 20) Профильную часть лопатки полировать кругом 003. Чистоту поверхности профильной части принимать по эталону.
- 21) Допустимое отклонение от теоретического профиля лопатки (на профиле) не более 0,3мм, кроме участков образованных радиусами 1, 1,5, 2, 3, 5, 10, 15, 20, 30, 40, 50, 60, 70, 80, 90, 100, 120, 150, 200, 250, 300, 350, 400, 450, 500, 600, 700, 800, 900, 1000, 1200, 1500, 2000, 2500, 3000, 3500, 4000, 4500, 5000, 6000, 7000, 8000, 9000, 10000, 12000, 15000, 20000, 25000, 30000, 35000, 40000, 45000, 50000, 60000, 70000, 80000, 90000, 100000, 120000, 150000, 200000, 250000, 300000, 350000, 400000, 450000, 500000, 600000, 700000, 800000, 900000, 1000000, 1200000, 1500000, 2000000, 2500000, 3000000, 3500000, 4000000, 4500000, 5000000, 6000000, 7000000, 8000000, 9000000, 10000000, 12000000, 15000000, 20000000, 25000000, 30000000, 35000000, 40000000, 45000000, 50000000, 60000000, 70000000, 80000000, 90000000, 100000000, 120000000, 150000000, 200000000, 250000000, 300000000, 350000000, 400000000, 450000000, 500000000, 600000000, 700000000, 800000000, 900000000, 1000000000, 1200000000, 1500000000, 2000000000, 2500000000, 3000000000, 3500000000, 4000000000, 4500000000, 5000000000, 6000000000, 7000000000, 8000000000, 9000000000, 10000000000, 12000000000, 15000000000, 20000000000, 25000000000, 30000000000, 35000000000, 40000000000, 45000000000, 50000000000, 60000000000, 70000000000, 80000000000, 90000000000, 100000000000, 120000000000, 150000000000, 200000000000, 250000000000, 300000000000, 350000000000, 400000000000, 450000000000, 500000000000, 600000000000, 700000000000, 800000000000, 900000000000, 1000000000000, 1200000000000, 1500000000000, 2000000000000, 2500000000000, 3000000000000, 3500000000000, 4000000000000, 4500000000000, 5000000000000, 6000000000000, 7000000000000, 8000000000000, 9000000000000, 10000000000000, 12000000000000, 15000000000000, 20000000000000, 25000000000000, 30000000000000, 35000000000000, 40000000000000, 45000000000000, 50000000000000, 60000000000000, 70000000000000, 80000000000000, 90000000000000, 100000000000000, 120000000000000, 150000000000000, 200000000000000, 250000000000000, 300000000000000, 350000000000000, 400000000000000, 450000000000000, 500000000000000, 600000000000000, 700000000000000, 800000000000000, 900000000000000, 1000000000000000, 1200000000000000, 1500000000000000, 2000000000000000, 2500000000000000, 3000000000000000, 3500000000000000, 4000000000000000, 4500000000000000, 5000000000000000, 6000000000000000, 7000000000000000, 8000000000000000, 9000000000000000, 10000000000000000, 12000000000000000, 15000000000000000, 20000000000000000, 25000000000000000, 30000000000000000, 35000000000000000, 40000000000000000, 45000000000000000, 50000000000000000, 60000000000000000, 70000000000000000, 80000000000000000, 90000000000000000, 100000000000000000, 120000000000000000, 150000000000000000, 200000000000000000, 250000000000000000, 300000000000000000, 350000000000000000, 400000000000000000, 450000000000000000, 500000000000000000, 600000000000000000, 700000000000000000, 800000000000000000, 900000000000000000, 1000000000000000000, 1200000000000000000, 1500000000000000000, 2000000000000000000, 2500000000000000000, 3000000000000000000, 3500000000000000000, 4000000000000000000, 4500000000000000000, 5000000000000000000, 6000000000000000000, 7000000000000000000, 8000000000000000000, 9000000000000000000, 10000000000000000000, 12000000000000000000, 15000000000000000000, 20000000000000000000, 25000000000000000000, 30000000000000000000, 35000000000000000000, 40000000000000000000, 45000000000000000000, 50000000000000000000, 60000000000000000000, 70000000000000000000, 80000000000000000000, 90000000000000000000, 100000000000000000000, 120000000000000000000, 150000000000000000000, 200000000000000000000, 250000000000000000000, 300000000000000000000, 350000000000000000000, 400000000000000000000, 450000000000000000000, 500000000000000000000, 600000000000000000000, 700000000000000000000, 800000000000000000000, 900000000000000000000, 1000000000000000000000, 1200000000000000000000, 1500000000000000000000, 2000000000000000000000, 2500000000000000000000, 3000000000000000000000, 35000



Размеры по роликам

№ благотель	Размер А
1	7,45
2	8,95
3	10,45
4	11,95
5	13,45