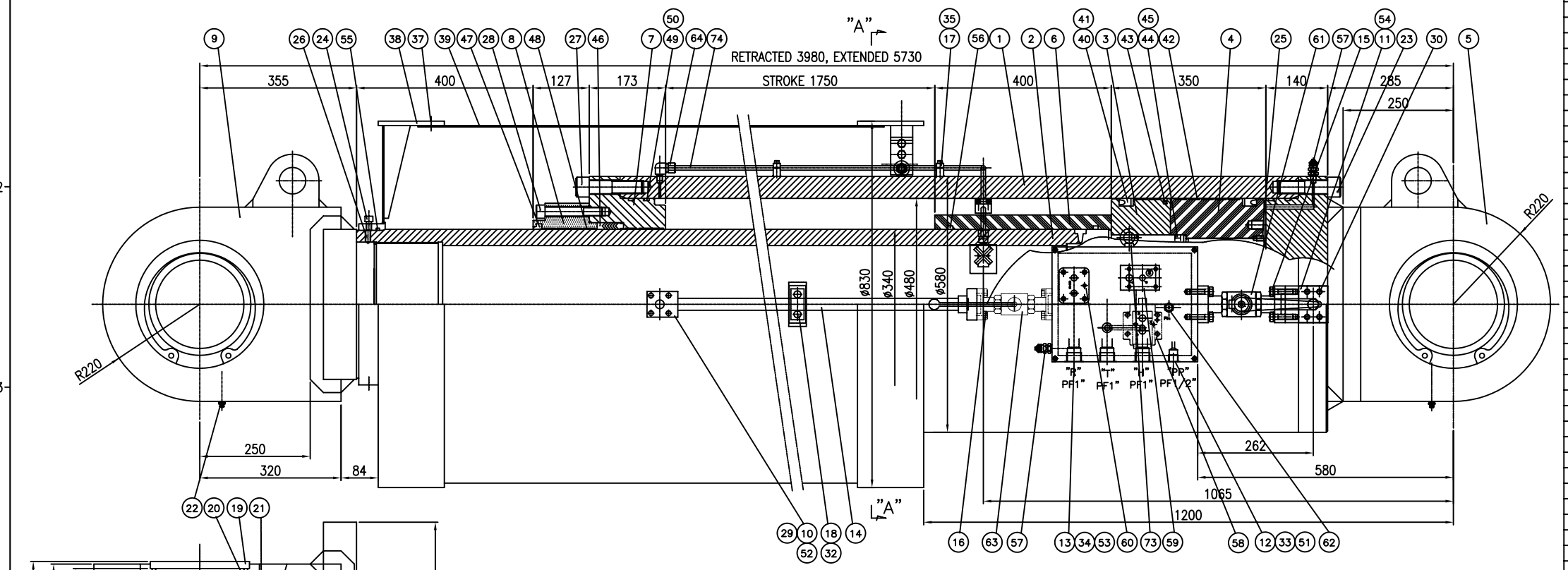
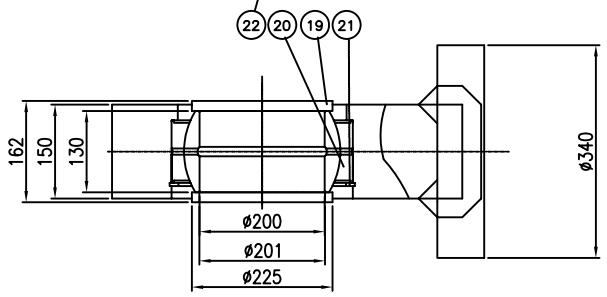
지시의 용접치수	지시의 모서리부분
a= 0	지시의일반 모서리제거 C = 0.3~1.2 R = 0.3~1.2

지시의 일반 허용공차	구분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 315	315 ~ 1000	1000 ~ 2000
	허용 공차	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2

표면거칠기								
Ra	✓	25	12.5	6.3	3.2	1.6	0.8	0.2	0.1
Rmax		100S	50S	25S	12.5S	6.3S	3.2S	0.8S	0.4S
다듬질	~	▽		▽▽		▽▽▽		▽▽▽▽	

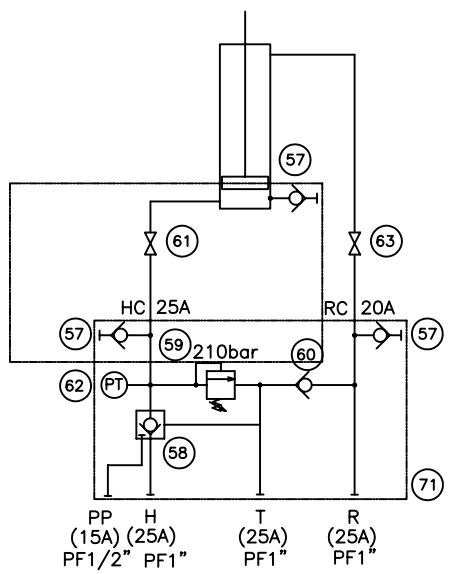
NO.	DATE	REVISION & DESCRIPTION	SIGNATURE REVIEWED	SIGNATURE CHECKED
3				
2				



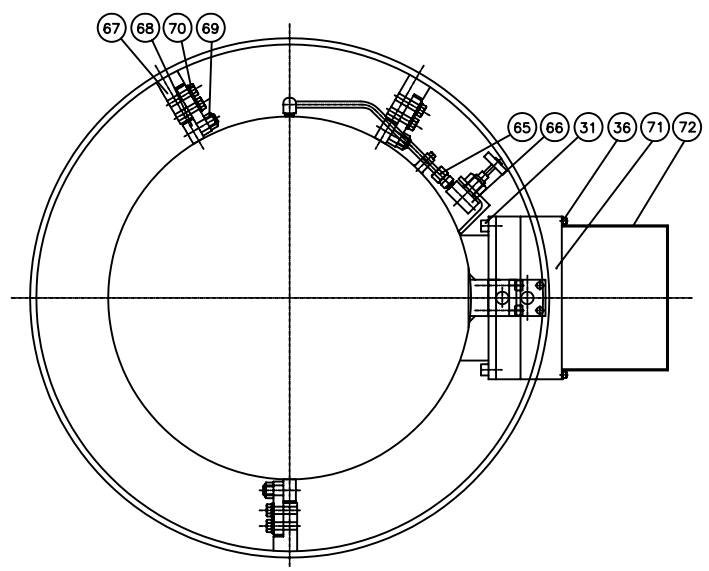


CYLINDER SPECIFICATION	
TYPE	복동 CA TYPE
SIZE	ø480xø340x1750ST
RATING PRESSURE	170 kgf/cm 2
PROOF PRESSURE	255 kgf/cm 2
WORKING FLUID	ISO VG32
WEIGHT (NET)	kg

SYSTEM SPECIFICATION		
LUFFING FORCE	PULLING	40 TON
	PUSHING	300TON
LUFFING SPEED	LIFT	6.0 mm/sec
	FAILL	6.0 mm/sec



CIRCUIT DIAGRAM



VIEW "A-A"

NO.	DESCRIPTION	MAT'(KS)	UNIT QUANTITY	TOTAL QUANTITY	PER UNIT WEIGHT(kg)	TOTAL WEIGHT(kg)	REMARK'S

NO.	DATE	REVISIONS & DESCRIPTION	ENG'R	APPR'D
3				
2				
1				

HYSYS
GIMHAE KOREA

TITLE	PLANT / FACILITY	TITLE: BOOM CYL'D ASS'Y FOR DERRICKING & SLEWING
SCALE	NONE	PROJECTION
SIZE	A1	DIMENSION mm
REF. DWG. NO.	EQUIPMENT	
MAKER DWG. NO.	HS-SRC-0401	0
POSCO DWG. NO.		

	DRAWN	CHECKED	REVIEWED	APPROVED	DRAWN	CHECKED	REVIEWED	APPROVED
SIGNATURE								
DATE								