

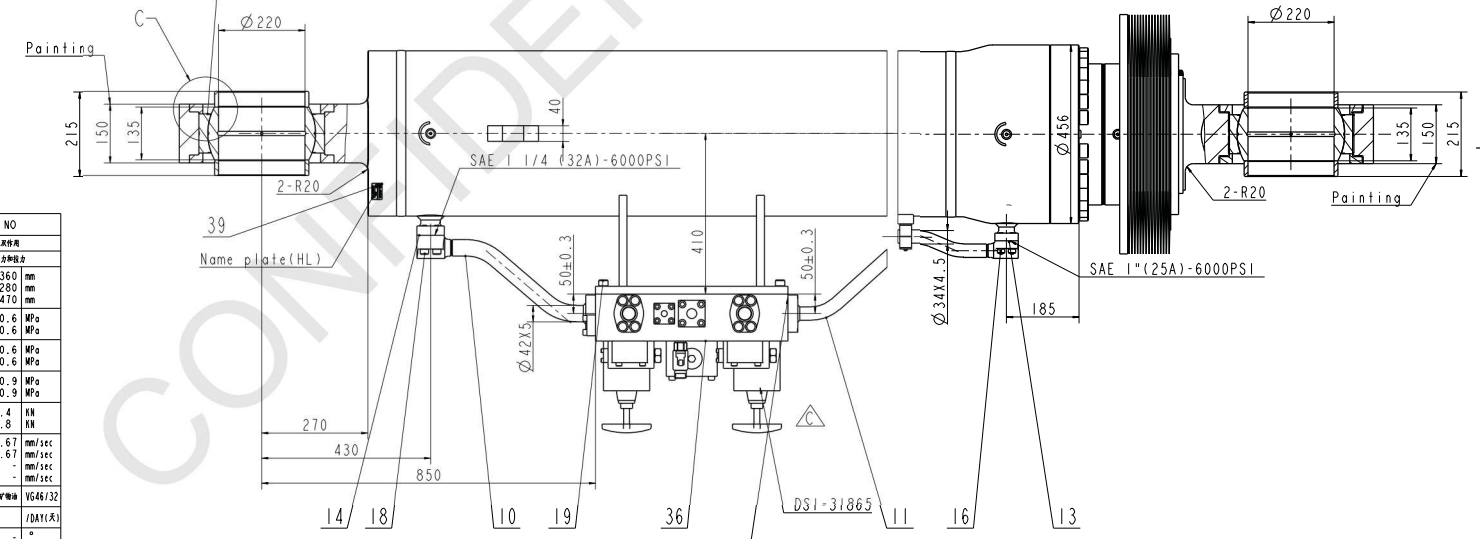
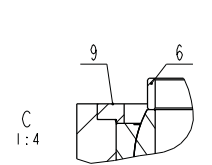
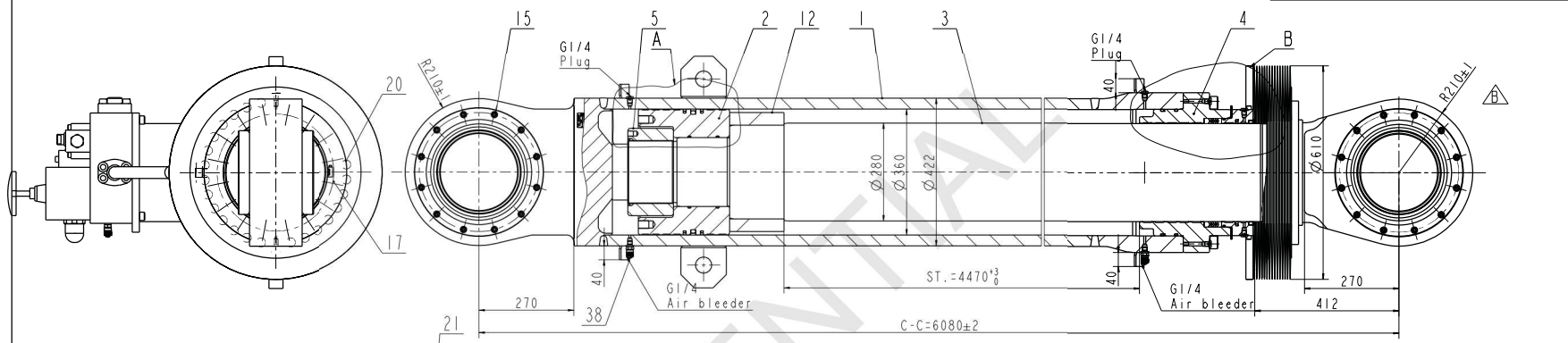
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行次	年月日	记事	行次编号	设计	批准
B	2021.10.17	Change SR210 to R210			
C	2021.10.23	Add the valve block			
D	2021.10.23	Add the Dustproof cover			

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The flange and manifold block supply by IUK, and weld with pipe by Hengli.

Note:

1. All parts must be cleaned, without fragment and water, fit surfaces with clean lipa;
2. The surface of all seals and O-rings without any defect, such as crush injury, sgraffito etc;
3. Assembling, testing and delivery of hydraulic cylinder should be done in the oil-free environment, verify that this is the correct version before use. The oil parts should be protected by plugs after testing.

CLASSIFICATION SOCIETY(规格)	NO
MODE OF OPERATION(工作模式)	直动式
BORE (缸径)	360 mm
ROD DIAMETER (杆径)	280 mm
STROKE (行程)	4470 mm
WORKING PRESSURE (工作压力)	ROD SIDE (有杆侧) 20.6 MPa BOTTOM SIDE (无杆侧) 20.6 MPa
DESIGN PRESSURE (设计压力)	ROD SIDE (有杆侧) 20.6 MPa BOTTOM SIDE (无杆侧) 20.6 MPa
TEST PRESSURE (试验压力)	ROD SIDE (有杆侧) 30.9 MPa BOTTOM SIDE (无杆侧) 30.9 MPa
MAXIMUM PULLING FORCE (最大拉力)	828.4 kN
MAXIMUM PUSHING FORCE (最大推力)	2096.8 kN
MAXIMUM SPEED (最大速度)	MOVING "OUT" (伸出) 22.67 mm/sec MOVING "IN" (缩回) 22.67 mm/sec
MINIMUM SPEED (最小速度)	MOVING "OUT" (伸出) - mm/sec MOVING "IN" (缩回) - mm/sec
HYDRAULIC MEDIA(液压油规格)	规格 VG46/32
MOVING FREQUENCY(工作频率)	/BAT(次)
MOUNTING ANGLE ROD TO HORIZONTAL (RETR.) (销轴安装角度-垂直于水平线角度)	-
DESIGN TEMPERATURE(设计温度)	-10~+45 °C
LATERAL FORCE(侧向力)	0 N(牛)
SURFACE CONDITION:(表面状况)	
BORE:(缸径)	Honed mm
ROD:(杆径)	Ni=30+HCr>30 mm
PRESERVATION:(涂装)	
SHOTBLAST SA 2 1/2 ISO 8501-01(喷丸 SA 2 1/2 ISO 8501-01)	mm
Zinc rich epoxy primer	80 mm
Epoxy intermediate primer	110 mm
2-Comp.Polyurethane(Signal yellow,RAL1003)	50 mm
AVERAGE DRY FILM THICKNESS(D, F, T)(平均膜厚)	-240 mm

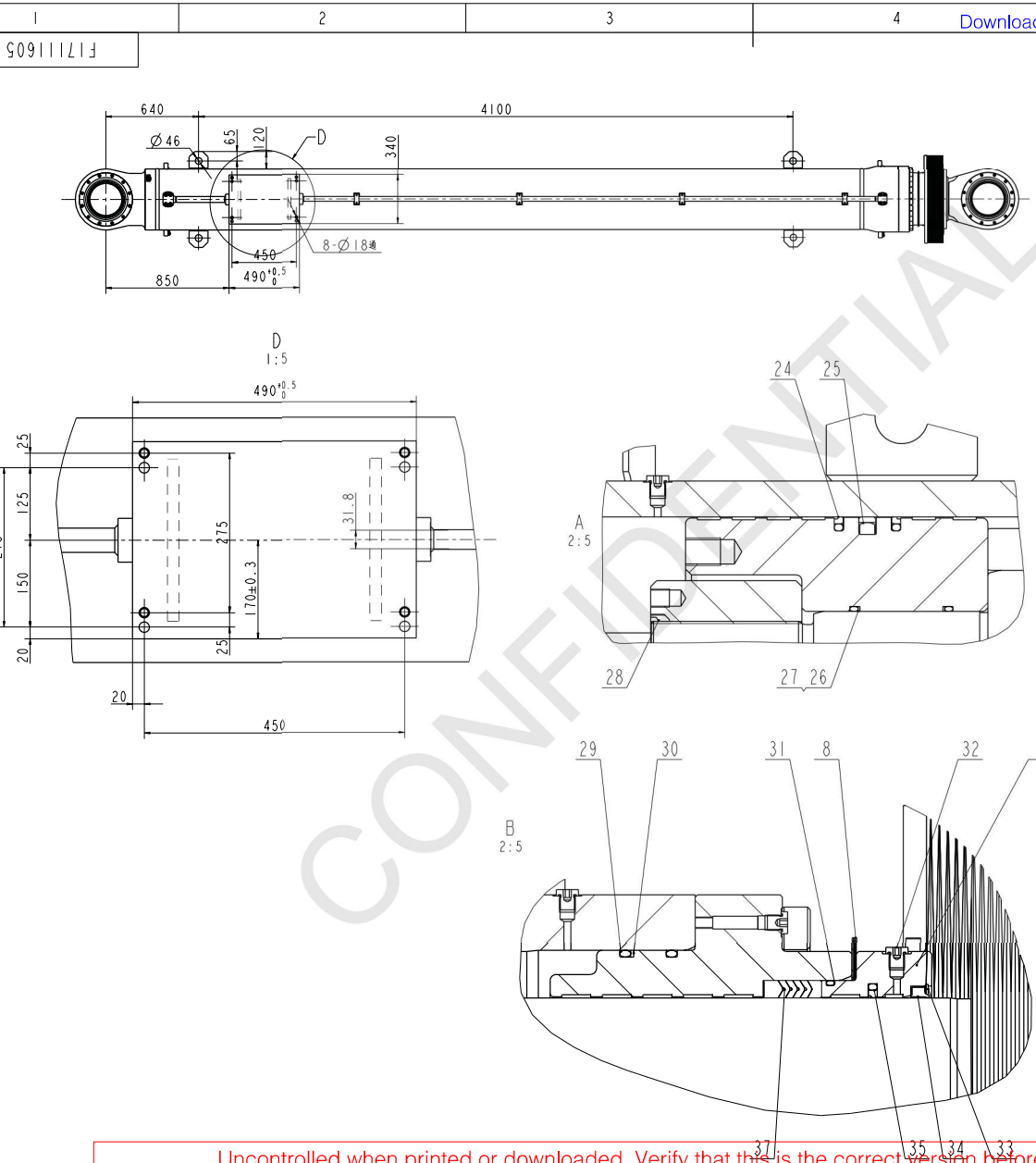
公差等级	公差	公差	公差	公差	公差
尺寸公差	0.25	0.1	0.1	0.1	0.1
位置公差	0.1	0.1	0.1	0.1	0.1
形状公差	0.1	0.1	0.1	0.1	0.1
表面粗糙度	0.4	0.3	0.3	0.3	0.3
硬度	22	22	22	22	22
热处理	H2	H2	H2	H2	H2
材料	42CrMo	42CrMo	42CrMo	42CrMo	42CrMo

江苏恒立液压股份有限公司 JIANGSU HENGLI HYDRAULIC CO.,LTD.	Boom Luffing Cylinder JOB NO. BK1B888	360/280x4470
图样标记	数量	比例
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5109.2kg		F17111605

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变更 REVISE	年月日 DATE	内容 DESCRIPTION	变更编号 CHANGE NO.	设计 DESIGN	批准 APP

序号 ITEM	代号 SUB NO.	版本 REV.	名称 DESIGNATION	规格 TYPE	数量 QTY	材料 MATERIAL	重量 WEIGHT	品牌 BRAND	备注 REMARK
42	Q/HL 102207-2011		Hose clamps	280-300	1	Cr18Ni9Ti			
41	Q/HL 102207-2011		Hose clamps	360-380	1	Cr18Ni9Ti			
40	Q/HL 102215-2013		Dustproof cover	610/290*370/290*110/4600*30/30	1	Asbestos			
39	00000.012Y.000		Name plate	名称: 电液换向阀(A)-58 *26.5*0.5mm	1	Stainless steel			
38	SM-20-G1/4-PC-C6F		Testing pressure adapter	G1/4	2	Carbon steel			Stauff
37	ES 24219179		Rod Seal	*280x*310x50.5(1+3)	1	MBR			Merkel
36	1H1-SW-31065-BY-001	A	Valve		1		217.5		
35	BP000300-P200		Buffer Ring	*280x*304x8.1	1	PMM/NTU			HRD
34	GA 280X300X12X16		Wiper ring	*280x*300x12x16	1	MBR			SKF
33	Q/HL 102222-2016		Ring	*280x*306x2.5	1	65Mn			
32	4BN-04WD		Plug	G1/4	6	Carbon steel			ttc
31	2-380		O-Ring	*291.47x5.33	1	MBR-90			Trelleborg
30	Q/HL 102204-2010		Back-up ring	*362x*350.4x2.5	1	PTFE/Cu			
29	2-456		O-Ring	*342.27x6.99	2	MBR-90			Trelleborg
28	GB/T 78		Set screw	M12x16	2	45#			MP
27	2-368		O-Ring	*196.22x5.33	2	MBR-90			Trelleborg
26	Q/HL 102204-2010		Back-up ring	*205.7x*197x1.5	2	PTFE/Cu			
25	GM-S 2431159		Piston seal	*360x*330x15	1	PTFE/MBR-70			Merkel
24	BP000300-P200		Buffer ring	*360x*336x8.1	2	PMM/NTU			HRD
23	GM730010-C480		Wear ring	2.5x25	6	C480			Trelleborg
22	GM740010-C480		Wear ring	2.5x20	6	C480			Trelleborg
21	GE220ES-2RS		Spherical bearing	GE220ES-2RS	2				AA
20	GB/T 70.1		Screw	M24x110	28	10.9			
19	GB/T 70.1		Screw	M16x40	4	10.9			
18	GB/T 70.1		Screw	M14x60	4	10.9			
17	GB/T 70.1		Screw	M12x80	16	10.9			
16	GB/T 70.1		Screw	M12x40	4	10.9			
15	GB/T 70.1		Screw	M10x25	48	A4-70			
14	2-228		O-Ring	*56.74x3.53	1	MBR-90			Trelleborg
13	2-223		O-Ring	*40.87x3.53	1	MBR-90			Trelleborg
12	Q/HL 102223.1-2010		Stop label	*268x*340x155	1	Q345			
11	11410.00107.011	A	Pipe B		1	316L	15.0		
10	11410.00107.010	A	Pipe A		1	316L	4.4		
9	11410.00107.009	A	Bearing cover		4	Q345	5.6		
8	11410.00107.008	A	Gaskei		4	316L	0.1		
7	11410.00107.007	A	Cover		1	Q345	19.1		
6	11410.00107.006	A	Stop sleeve		4	Cr17Ni2	2.2		
5	11410.00107.005	A	Nut		1	Q345	25.0		
4	11410.00107.004	A	Guide bush		1	Q345	90.8		
3	11410.00107.300	A	Rod		1	Q345	2623.5		
2	11410.00107.002	A	Piston		1	Q345	120.0		
1	11410.00107.100	A	Barrel		1	Q345	1815.5		

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