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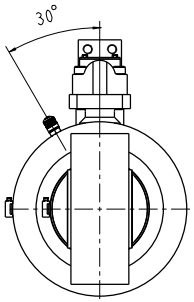
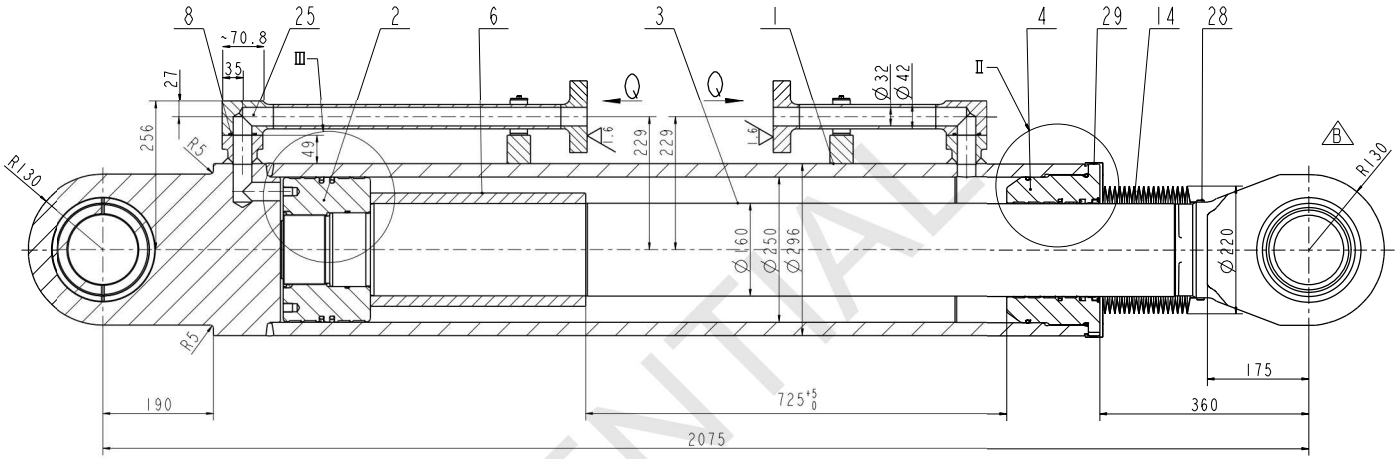
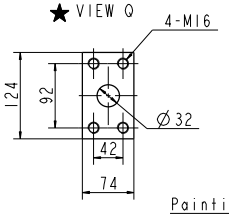
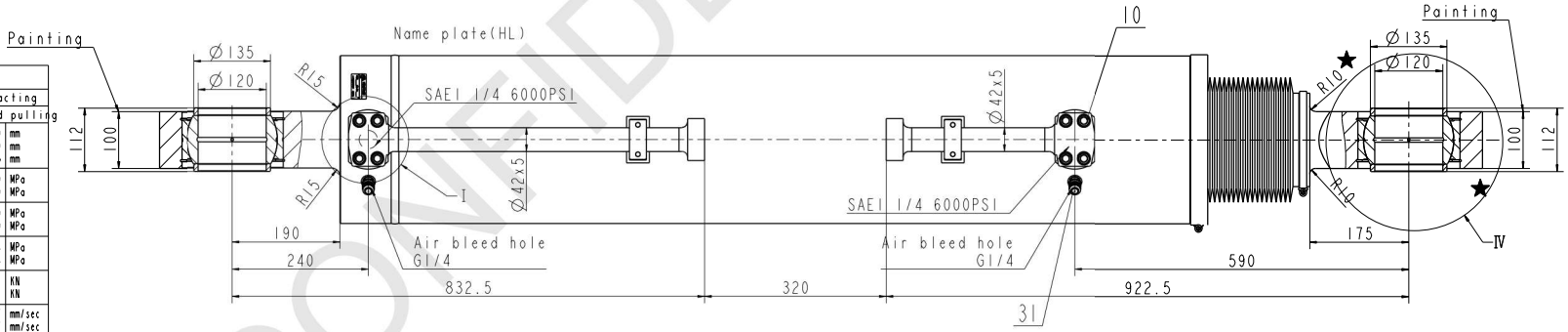
IHI-FI7111606

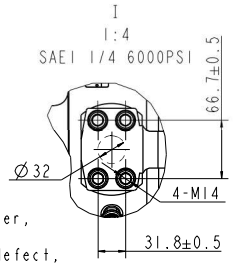
| REVISION | DATE | DESCRIPTION | DRAWING NO. | DESIGN | APPD |
|---|---|---|---|---|---|
| B | 2018.10.17 | Change SR130 to R130 | | | |

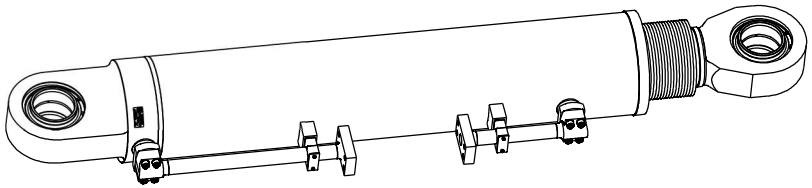


| CLASSIFICATION SOCIETY(船级社) | | -- | |
|---|---|---|---|
| MODE OF OPERATION(工作模式) | | Double acting Pushing and pulling | |
| BORE (缸径)<br>ROD DIAMETER (杆径)<br>STROKE (行程) | | 250<br>160<br>725 | mm<br>mm<br>mm |
| WORKING PRESSURE (工作压力) | ROD SIDE(有杆腔)<br>BOTTOM SIDE(无杆腔) | 18.9<br>18.9 | MPa<br>MPa |
| DESIGN PRESSURE (设计压力) | ROD SIDE(有杆腔)<br>BOTTOM SIDE(无杆腔) | 18.9<br>18.9 | MPa<br>MPa |
| TEST PRESSURE (试验压力) | ROD SIDE(有杆腔)<br>BOTTOM SIDE(无杆腔) | 28.4<br>28.4 | MPa<br>MPa |
| MAXIMUM PULLING FORCE (最大拉力)<br>MAXIMUM PUSHING FORCE (最大推力) | | 547.7<br>927.8 | KN<br>KN |
| MAXIMUM SPEED (最大速度)<br>MINIMUM SPEED (最小速度) | MOVING"OUT"(伸出)<br>MOVING"IN" (缩回)<br>MOVING"OUT"(伸出)<br>MOVING"IN" (缩回) | 16.67<br>16.67<br>-<br>- | mm/sec<br>mm/sec<br>mm/sec<br>mm/sec |
| HYDRAULIC MEDIUM(液压介质) | | Mineral oil | VG46/32 |
| MOVING FREQUENCY(工作频率) | | | /DAY(天) |
| MOUNTING ANGLE ROD TO HORIZONTAL (RETR,)(缩回)<br>(安装角度-活塞杆与水平线的夹角) (EXT,)(伸出) | | -<br>- | °<br>° |
| DESIGN TEMPERATURE(设计温度) | | -10~+60 | °C |
| LATERAL FORCES(径向力) | | | N(牛顿) |
| SURFACE CONDITION:(表面处理:)<br>BORE:(缸筒:)<br>ROD:(活塞杆:) | Ni≥30+HCr≥30 | | μm<br>μm |
| PRESERVATION:(喷涂:)<br>SHOTBLAST SA 2 1/2 ISO-8501-01(喷Sa2.5 ISO-8501-01)<br>Zinc rich epoxy primer<br>Epoxy intermediate primer<br>2-Comp,Polyurethane(Signal yellow,gloss,RAL 1003)<br>AVERAGE DRY FILM THICKNESS(D,F,T,)(总干膜厚度) | | 80<br>110<br>-240 | μm<br>μm<br>μm<br>μm |

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 carried out in the principle of GB/T2348-2001;
4. The oil ports should be protected by plugs after testing.

| 未注公差一览表 GENERAL DIMENSION TOLERANCE | | | |
|---|---|---|---|
| 尺寸区分 DIMENSION | 机加工 MACHINING | 焊接加工 WELDING | |
| 0.5≤L≤6 | ±0.1 | ±1 | |
| 6<L≤30 | ±0.2 | | |
| 30<L≤120 | ±0.3 | | |
| 120<L≤400 | ±0.5 | ±2 | |
| 400<L≤1000 | ±0.8 | | |
| 1000<L≤2000 | ±1 | ±3 | |
| 2000<L≤4000 | ±2 | ±4 | |
| L>4000 | ±2 | ±6 | |

| | | | |
|---|---|---|---|
| 设计 Drawn by | Liao Wei | | |
| 校对 Proofed by | | | |
| 审核 Checked by | Song Tao | | |
| 批准 Approved by | | | |
| DATE | 2018.10.17 | | |

Telescopic Cylinder
BKIBA88

| 图样标记 PROJ | 重量 WEIGHT | 比例 SCALE |
|---|---|---|
| | 732.7kg | 1:6 |

共 1 张 第 1 页

江苏恒立液压股份有限公司
JIANGSU HENGLI HYDRAULIC CO.,LTD.

250/160x725-2075

IHI-FI7111606 A

| 借通用件登记 CURRENT REGISTER | |
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| 旧底图总号 OLD NO. | |
| 签 字 SIGNATURE | |
| 日 期 DATE | |

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| 标记 REVISION | 修订日期 DATE | 记录 DESCRIPTION | 订单编号 CHANGE ORDER NO. | 设计 DESIGN | 批准 APPD |
|---|---|---|---|---|---|
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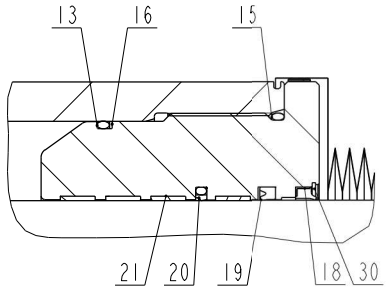


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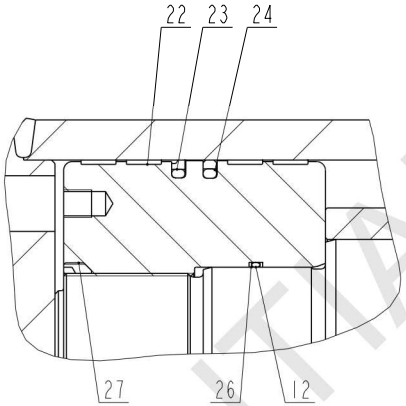


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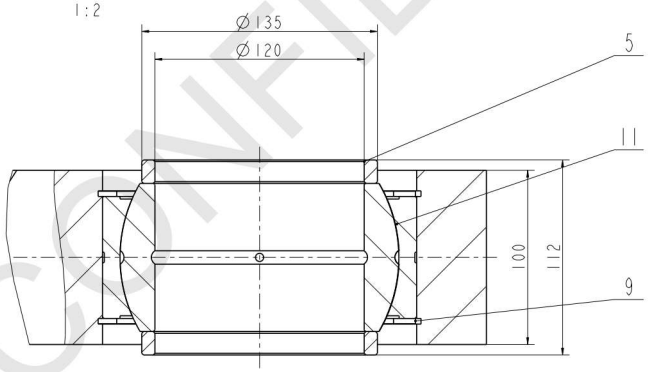


| 序号 ITEM | 代号 SUB NO. | 版本 REV. | 名称 DESIGNATION | 规格 TYPE | 数量 QTY | 材料 MATERIAL | 重量 WEIGHT | 品牌 BRAND | 备注 REMARK |
|---|---|---|---|---|---|---|---|---|---|
| 31 | SKK-20-G1/4-PC-C6F | | Testing pressure adapter | | 2 | Carbon steel | | Stauff | |
| 30 | Q/HL 102222-2016 | | Ring | d160/ϕ182x2 | 1 | 65Mn | | | |
| 29 | Q/HL 102207-2011 | | Hose clamps | 290-310 | 1 | 1Cr18Ni9Ti | | | |
| 28 | Q/HL 102207-2011 | | Hose clamps | 150-170 | 1 | 1Cr18Ni9Ti | | | |
| 27 | GB/T 78 | | Set screw | M12x16 | 2 | 45H | | | |
| 26 | Q/HL 102204-2010 | | Back-up ring | ϕ132.5xϕ127x1.5 | 2 | PTFE+Cu | | | |
| 25 | 11410.0011Y.700 | A | Pipe assembly | | 1 | 316L | 5.9 | | |
| 24 | OMK-MR 24179250 | | Piston Seal | ϕ250xϕ229x8.1 | 1 | PTFE+Cu+NBR-70 | | Merkel | |
| 23 | OMK-E 24263958 | | Piston seal | ϕ250xϕ229.5x8.1 | 1 | PTFE+Cu+NBR-70 | | Merkel | |
| 22 | Q/HL 102203-2010 | | Wear ring | ϕ250xϕ245x20 | 4 | RS40 | | Soltri | |
| 21 | Q/HL 102203-2010 | | Wear ring | ϕ165xϕ160x20 | 4 | RS40 | | Soltri | |
| 20 | OD 1600 052 00171D | | Buffer Ring | ϕ160xϕ175.1x6.3 | 1 | PTFE+Cu+NBR-70 | | | |
| 19 | B3 160A P5008 | | Rod Seal | ϕ160xϕ175x10 | 1 | PU | | Parker | |
| 18 | GA 160X175X9X12 | | Wiper ring | ϕ160xϕx175x9x12 | 1 | NBR | | SKF | |
| 17 | 00000.0113Y.000 | | Name plate | 铭牌不干胶-恒立英文标牌(小)-58*26.5*0.5mm | | | | | |
| 16 | Q/HL 102204-2010 | | Back-up ring | ϕ251xϕ242.3x1.5 | 1 | PTFE+Cu | | | |
| 15 | 2-376 | | O-Ring | ϕ247.02x5.33 | 1 | NBR-90 | | Trelleborg | |
| 14 | Q/HL 102215-2013 | | Dustproof cover | 220/170X300/165X150/900X30/30(挂钩A) | 1 | injection moulding canvas | | | |
| 13 | 2-374 | | O-Ring | ϕ234.32x5.33 | 1 | NBR-90 | | Trelleborg | |
| 12 | 2-250 | | O-Ring | ϕ126.59x3.53 | 1 | NBR-90 | | Trelleborg | |
| 11 | GE120ES-2RS | | Spherical bearing | GE120ES-2RS | 2 | | | 无锡 | |
| 10 | GB/T 70.1 | | Screw | M14x60 | 8 | 10.9 | | | |
| 9 | GB 893.1 | | Circlips | ϕ180 | 4 | 65Mn | | | |
| 8 | 2-223 | | O-Ring | ϕ40.87x3.53 | 2 | NBR-90 | | Trelleborg | |
| 7 | 11410.0011Y.600 | A | Pipe assembly | | 1 | 316L | 4.7 | | |
| 6 | 11410.0011Y.006 | A | Stop tube | | 1 | Q345D | 29.1 | | |
| 5 | 11410.0011Y.005 | A | Ring | | 4 | 316L | 0.3 | | |
| 4 | 11410.0011Y.004 | A | Guide bushing | | 1 | Q345D | 38.1 | | |
| 3 | 11410.0011Y.300 | A | Rod | | 1 | Q345D | 272.6 | | |
| 2 | 11410.0011Y.002 | A | Piston | | 1 | Q345D | 41.3 | | |
| 1 | 11410.0011Y.100 | A | Barrel | | 1 | Q345D | 320.6 | | |

| 未注公差一览表 GENERAL DIMENSION TOLERANCE | | | 设计 Drawn by | Liao Wei | Telescopic Cylinder | 江苏恒立液压股份有限公司 JIANGSU HENGLI HYDRAULIC CO,.LTD. |
|---|---|---|---|---|---|---|
| 尺寸区分 DIMENSION | 机加工 MACHINING | 焊接加工 WELDING | 校对 Proofed by | | | |
| 0.5≤L≤6 | ±0.1 | ±1 | 审核 Checked by | Song Tao | | 250/160x725-2075 |
| 6<L≤30 | ±0.2 | | | | | |
| 30<L≤120 | ±0.3 | | 批准 Approved by | | 图样标记 PROJ / 重量 WEIGHT 732.7kg / 比例 SCALE 1:6 | |
| 120<L≤400 | ±0.5 | ±2 | 工艺员 Engr'g | | | IHI-FI7111606 A |
| 400<L≤1000 | ±0.8 | ±3 | 日期 DATE | 2018.12.18 | 共 3 张 第 2 页 | |
| 1000<L≤2000 | ±1.2 | ±4 | | | | |
| 2000<L≤4000 | ±2 | ±6 | | | | |
| L>4000 | ±2 | | | | | |

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