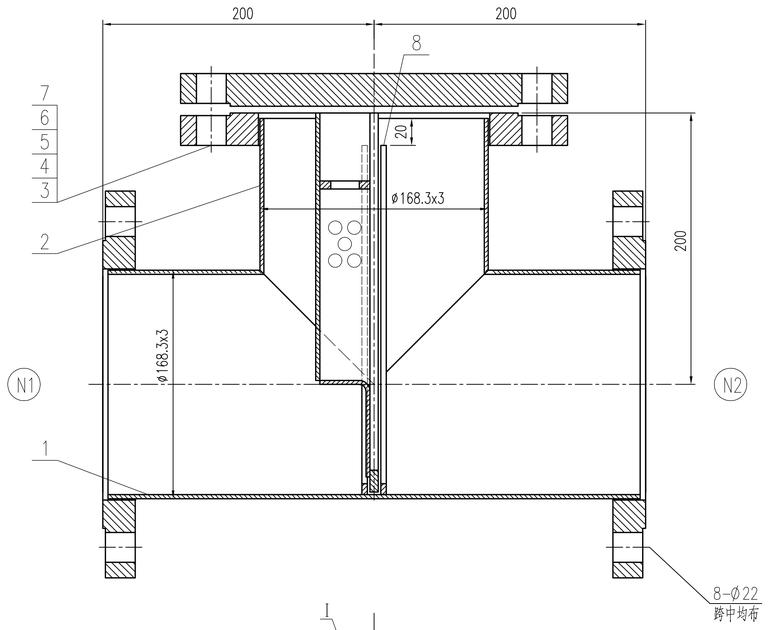

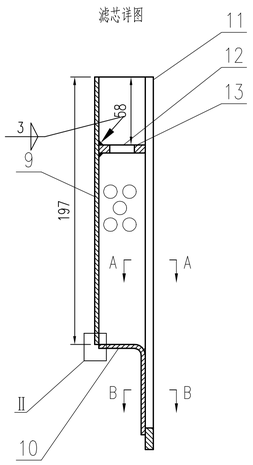

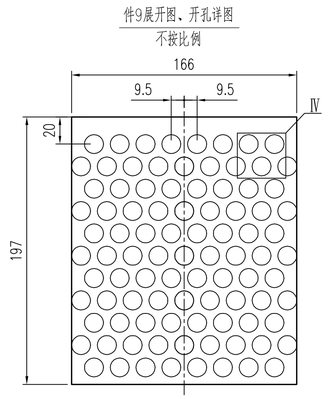

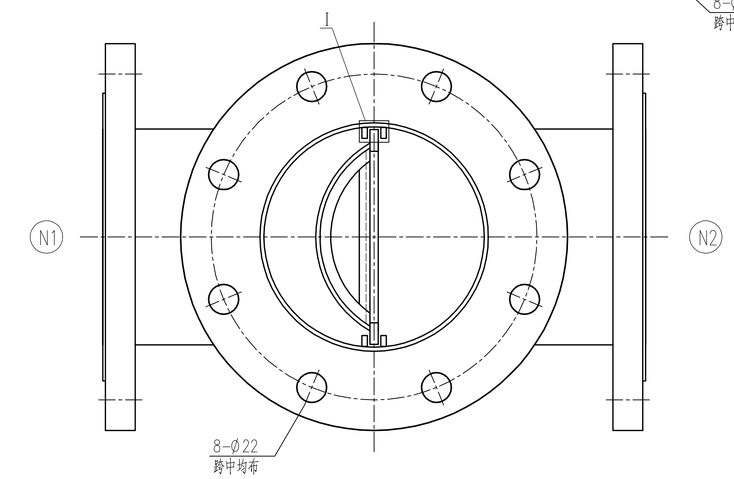

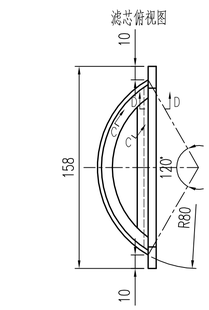

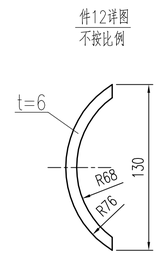

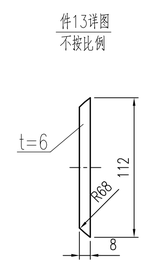

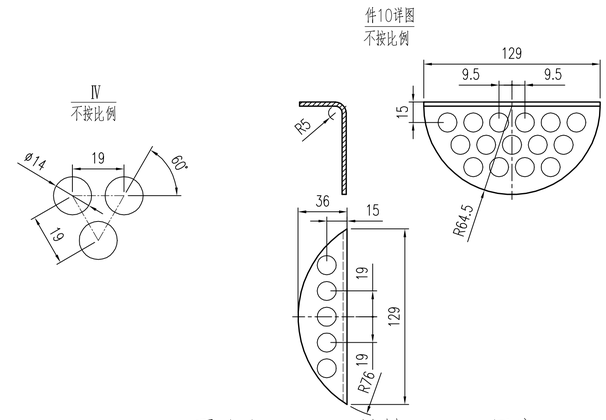

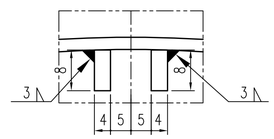

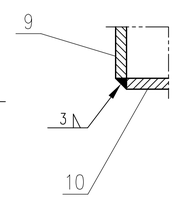

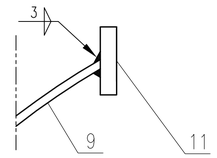

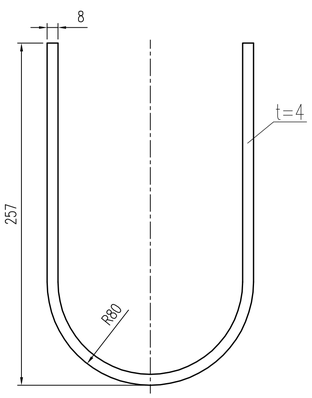

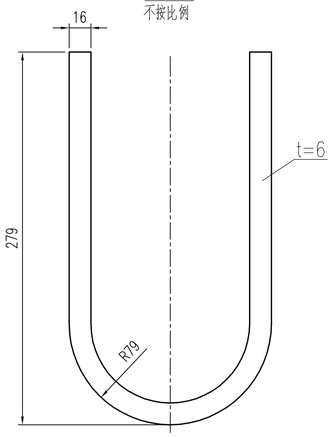

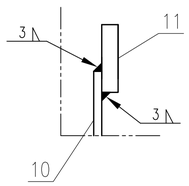

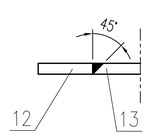

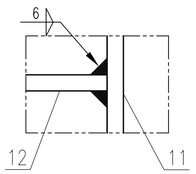

管口表

符号	公称尺寸	法兰标准	连接面型式	名称	外伸长度(mm)	备注
N1	150	HG/T20592 PL150-10	RF	进料口		
N2	150	HG/T20592 PL150-10	RF	出料口		

技术要求

1、焊接采用氩弧焊，焊丝牌号：ER2594，焊丝应符合NB/T47018的规定。

2、焊接接头形式及尺寸除图中注明外，按HG/T20583-2011中的规定；角焊缝焊角尺寸按较薄板的厚度；法兰的焊接按相应法兰标准中的规定。

3、过滤侧板开孔成正三角形排列，直径为14mm，开孔中心间距为19mm,总开孔数不少于118个。

4、未注尺寸公差按GB/T1804-2000中m级的规定。

5、焊缝应清除油污做酸洗钝化处理(酸洗采用固态酸洗膏，避免产生环境污染及人身伤害)，所形成的钝化膜采用蓝点法检查，无蓝点为合格。

6、过滤器在科技公司组装完成后，整件发往项目现场。

DN150A 开孔Ø14mm 材料 2507 厚度 3mm　　总重：43kg

序号	图号或标准号	名称及规格	数量	材料	单件重量(Kg)	总件重量(Kg)	备注
13		加强筋二 t=6	1	2507		0.1	
12		加强筋一 t=6	1	2507		0.1	
11		定位条 t=6	1	2507		0.5	
10		滤板二 t=3	1	2507		0.2	
9		滤板一 t=3	1	2507		0.8	
8		限位条 t=4	2	2507	0.2	0.4	
7	GB/T6170-2000	螺母 M20	8	A2-70			
6	GB/T5783-2000	螺栓 M20x80	8	A2-70	0.28	2.3	
5	HG/T20606-2009	垫片 RF150-10 t=5	1	20%三元乙丙橡胶			
4	HG/T20592-2009	法兰盖 BL150-10 RF	1	Q235B+2507		10.5	衬不锈钢薄板
3	HG/T20592-2009	法兰 PL150-10 RF	3	Q235B+2507	7.0	21	衬不锈钢薄板
2		钢管ø168.3x3	1	2507		2.5	L≈196
1		钢管ø168.3x3	1	2507		4.9	L=392

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Jiangsu New Century Jiangnan Environmental Protection Inc.,Ltd.

用户 CLIENT
项目名称 PROJECT

设计 DESIGN
校核 CHECK
审核 REVIEW
审定 APPROVE
批准 AUTH'D

DN150 T型过滤器
(2507,有法兰)

图号 DWG NO. JNHB-G-BZ-8-3-1-02
比例 SCALE 1:3 | 专业 DISP. 设备专业 | 阶段 STAGE 详细设计 | 版次 ISSUE 0 | 第 1 张 SHEET | 共 1 张 TOT.

日期 DATE | 姓名 NAME | 专业 SPEC