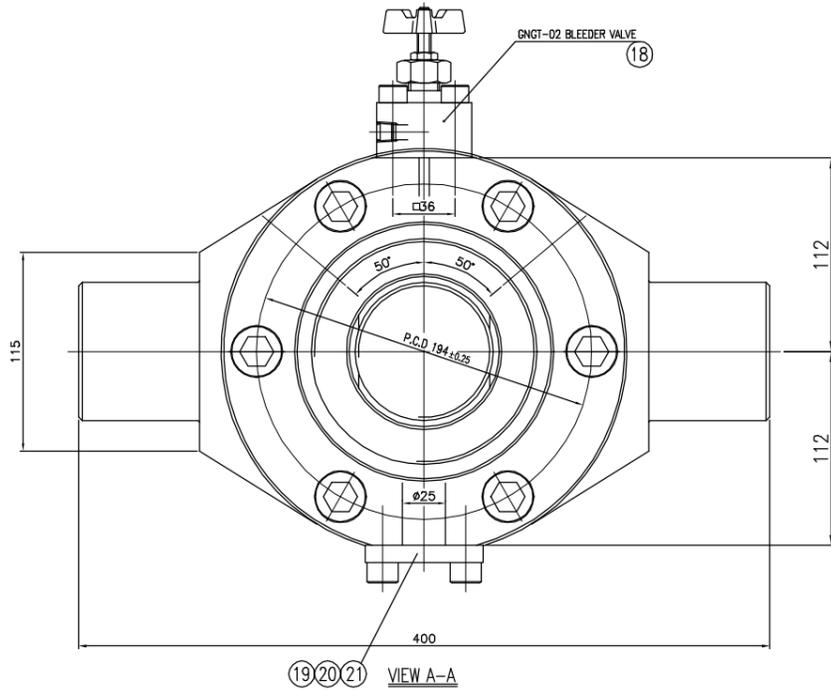


지사의 용량계수	지사의 모서리부분	지사의 일반계수 사용처 (KSB ISO 2768-1)						표면 거칠기 (KSB 0161, 0507, 0617)								
	지사의 일반 모서리 계기 $C = 0.5 \sim 0.8$ $R = 0.5 \sim 0.8$	정밀	중간급	일반급	저급	저급	저급	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25
		구분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 400	400 ~ 1000	1000 ~ 2000	Ra	0.45	0.85	1.65	3.25	6.35	12.55	255
		허용값	±0.1	±0.2	±0.3	±0.5	±0.8	Rmax	다듬질	▽▽▽	▽▽	▽				

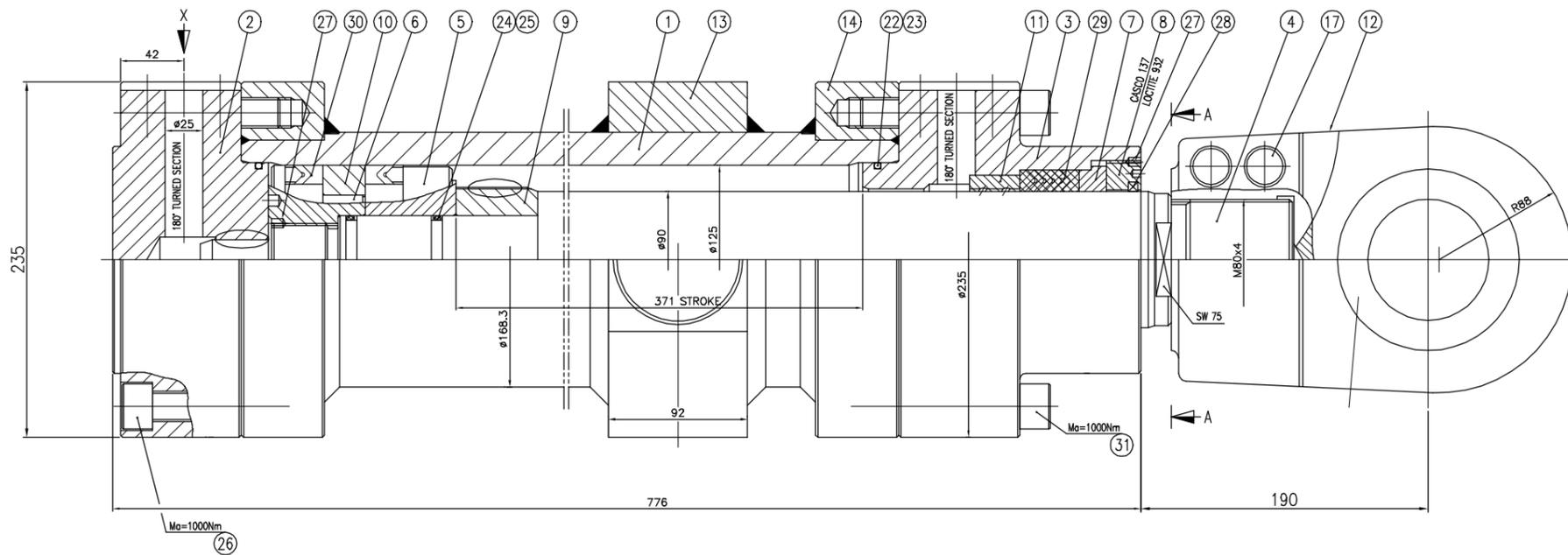


1	STEEL BALL	2	SUJ2	SPH#6.35
2	SET SCREW	2	SCM435	M8x8L
3	AIRVENT PLUG	2	SS400	
4	SPRING	2	SS400	
5	D-RING & BUR	#2	VITON/PRE	P7/T3P7
6	NEEDLE	2	SM45C	
7	HEX. NUT	2	SM45C	M8x1.25p
8	D-RING	2	VITON	P 18
9	VALVE PLUG	2	SM45C	
10	VALVE SET			

NOTE 1. TUBE BORE & ROD SURFACE HARD CHROMIUM PLATING(MIN,THK' 0.050)
2. ITEM # (27) M8x8L, DRILLED + CAULKED

NO.	DESCRIPTION	MAT'(KS)	QUANTITY		WEIGHT(KG)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
	HYDRAULIC CYLINDER		SET	1	-	195		PE
1	TUBE $\phi 125 \times \phi 168.3 \times 531$	STKM13A	EA	1	-	-		PE
2	HEAD COVER $\phi 235 \times 103$	SS275	EA	1	-	-		PE
3	ROD COVER $\phi 235 \times 178$	SM45C	EA	1	-	-		PE
4	PISTON ROD $\phi 90 \times \phi 818$	SM45C	EA	1	-	-		PE
5	PISTON A $\phi 80 \times \phi 125 \times 84$	SM45C	EA	1	-	-		PE
6	PISTON B $\phi 80 \times \phi 125 \times 40$	SM45C	EA	1	-	-		PE
7	PROFILE RING $\phi 90 \times \phi 115 \times 15$	CAC406	EA	1	-	-		PE
8	NUT $\phi 120 \times 30$	SM45C	EA	1	-	-		PE
9	CUSHION RING $\phi 95 \times 45$	SS275	EA	1	-	-		PE
10	PISTON BUSH $\phi 90 \times \phi 125 \times 40$	SS275	EA	1	-	-		PE
11	ROD BUSH $\phi 90 \times \phi 105 \times 30$	CAC406	EA	1	-	-		PE
12	ROD END $265 \times 190 \times 125$	FCD45	EA	1	-	-		PE
13	TRUNNION $400 \times 235 \times 92$	SS275	EA	1	-	-		PE
14	TUBE FLANGE $\phi 235 \times \phi 150 \times 55$	SS275	EA	2	-	-		PE
15	SPH' BEARING	PUR.	EA	1	-	-	GE80 ES	PE
16	SNAP RING	STC5	EA	2	-	-	C120 FOR HOLE	PE
17	S.H.C.S	SCM435	EA	2	-	-	GNGT-02	PE
18	BLEEDER VALVE		EA	2	-	-	M12x25L	PE
19	PLATE $110 \times 68 \times 68$	SS275	EA	1	-	-		PE
20	S.H.C.S	SCM435	EA	4	-	-	M12x25L	PE
21	O-RING	VITON	EA	2	-	-	G35	PE
22	O-RING	VITON	EA	2	-	-	G125	PE
23	BACK UP RING	PTFE	EA	2	-	-	G125-3T	PE
24	O-RING	VITON	EA	2	-	-	G55	PE
25	BACK UP RING	PTFE	EA	2	-	-	G55-3T	PE
26	S.H.C.S	SCM435	EA	6	-	-	M20x90L	PE
27	SET SCREW	SCM435	EA	2	-	-	M8x8L	PE
28	DUST SEAL $\phi 90 \times \phi 102 \times 12/7$	VITON	EA	1	-	-	P6V-90	PE
29	ROD SEAL $\phi 90 \times \phi 110 \times 40$	VITON	EA	1	-	-	E2V-90	PE
30	PISTON SEAL $\phi 125 \times \phi 100 \times 25$	VITON	EA	2	-	-	E3V-125	PE
31	S.H.C.S	SCM435	EA	6	-	-	M20x110L	PE
32	VALVE SETS		EA	2	-	-	M16x1.5P	PE

TOTAL WEIGHT : 195(Kg)X2SET=390(Kg)



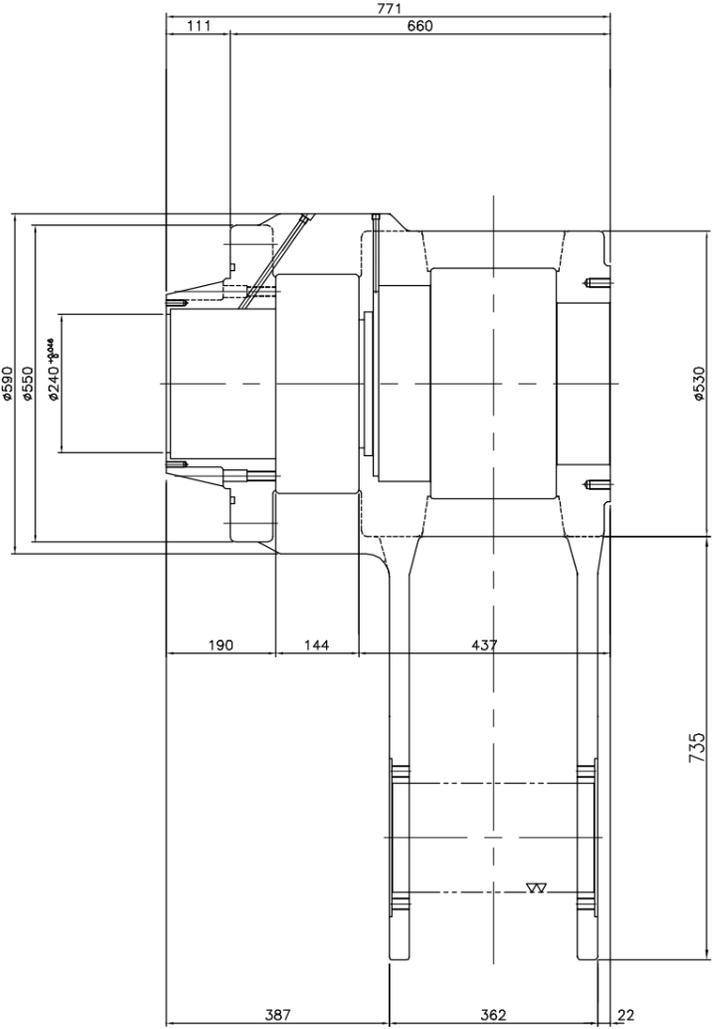
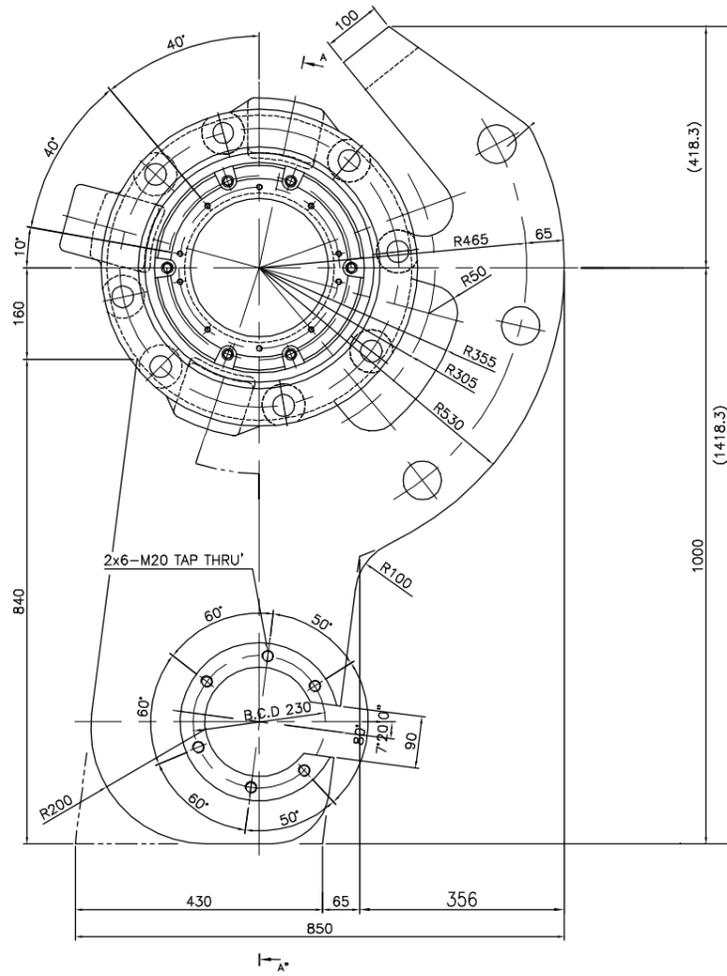
SPECIFICATION	
PISTON DIA.	$\phi 125$ mm
PISTON ROD DIA.	$\phi 90$ mm
STROKE	371 mm
OPERATING PRESSURE	210 kgf/cm ²
TEST PRESSURE	315 kgf/cm ²
FLUID	HYDRAULIC-OIL or PHOSPHATE-ESTER

				SCALE 1/2 PROJECTION			
24.11.20 FOR REFERENCE S.C.PARK - O.R.SONG K.S.SONG				TITLE 2고분 PLANT HOPPER SYSTEM (G2R2) GAS SEAL HOPPER 노정 FACILITY HYD' CYLINDER OF MATERIAL CONTROL GATE			
NO. DATE REVISION & DESCRIPTION DRAWN CHECKED REVIEWED APPROVED				ITEM MODEL NO. FSP-FT-MCD1-001 MAKER 214-M33-D5520 DWG. NO.			
				DRAWN S.C.PARK - O.R.SONG K.S.SONG 24.11.20 - 24.11.20 24.11.20			

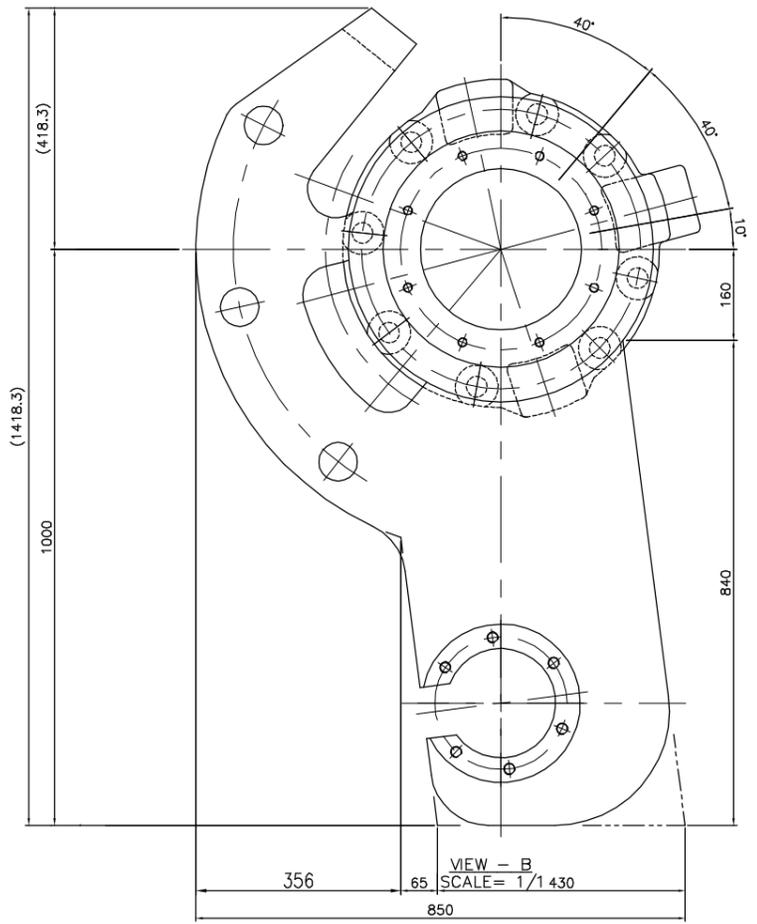
지시의 용접시수	지시의 모서리부분	지시의 일반시수 사용처 (KSB ISO 2768-1)	표면 거칠기 (KSB 0161, 0507, 0617)															
		0.5	6	30	120	400	1000	2000	Ra	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25
		30	120	400	1000	2000	Rmax	0.45	0.85	1.65	3.25	6.35	12.65	25.5	50.5	100.5		
지시의 일반 모서리 세기 C = 0.5~0.8 R = 0.5~0.8	중간급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽▽	▽▽▽	▽▽▽▽	▽▽▽▽▽	▽▽▽▽▽▽	▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽▽

NO.	DESCRIPTION	MAT(KS)	QUANTITY		WEIGHT(Kg)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
1	VALVE BODY	SC49	EA	1	-	980		PE

TOTAL WEIGHT : 980(Kg)X2SET=1,960(Kg)



SECTION A-A'
SCALE = 1/1



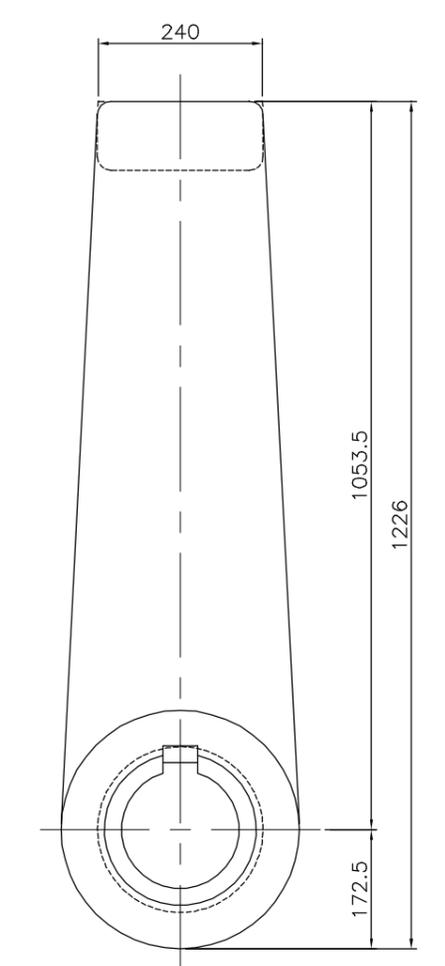
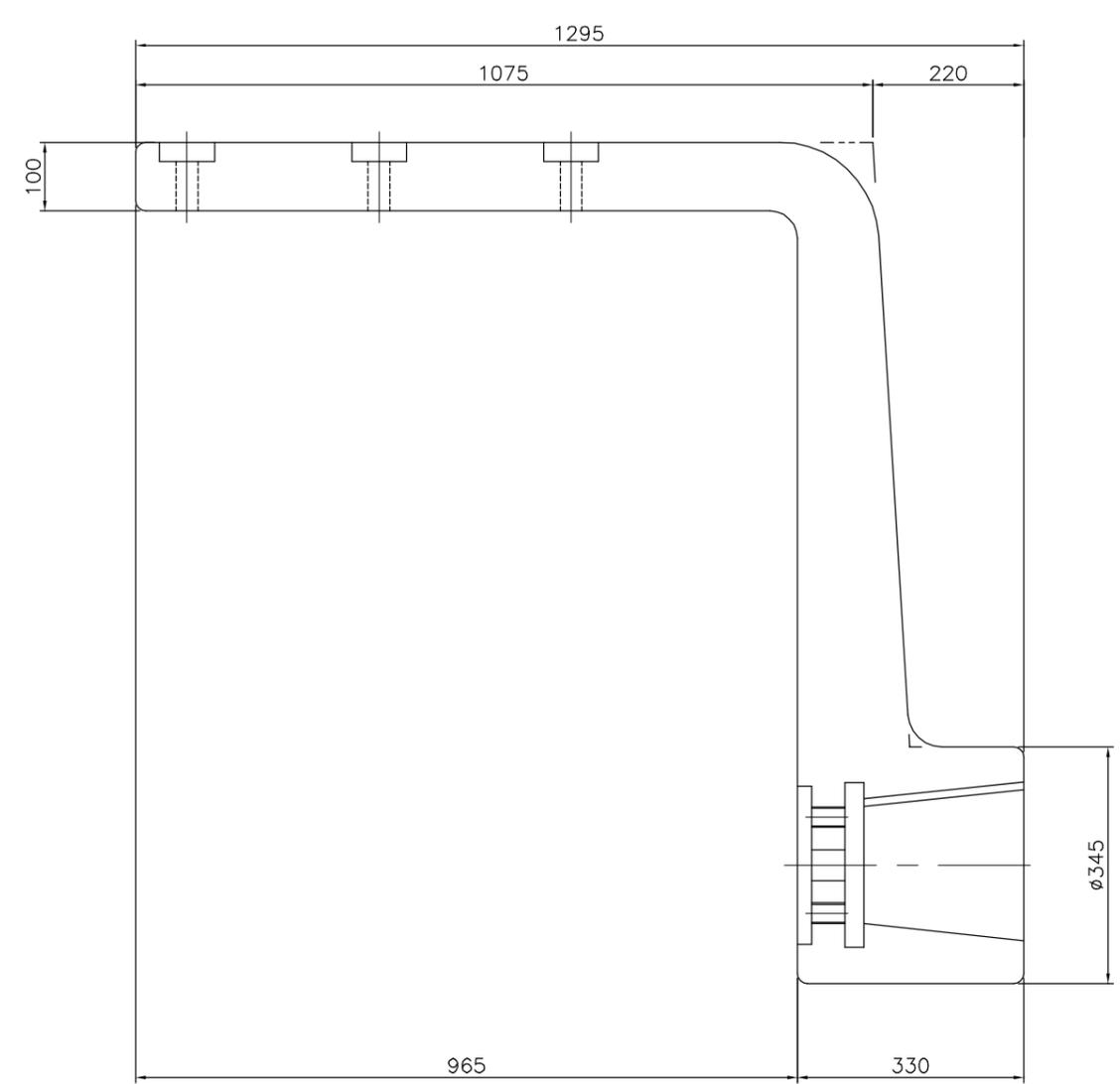
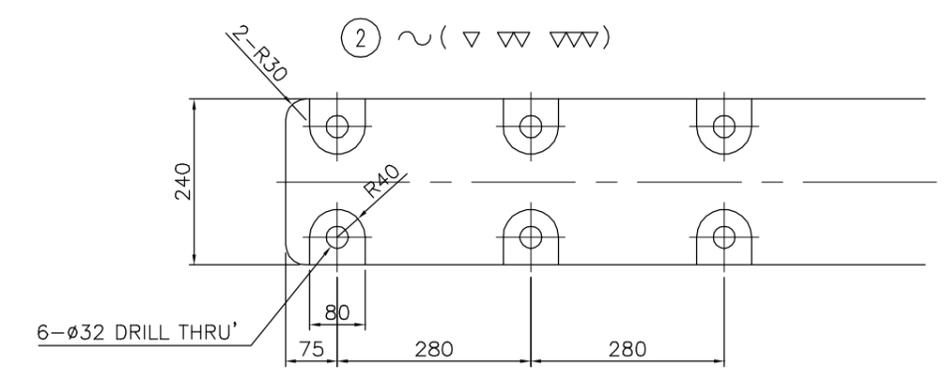
VIEW - B
SCALE = 1/1.430

SCALE	1/6	PROJECTION	1st Angle			
SIZE	A3	DIMENSION	mm			
ITEM MODEL NO.	FSP-FT-MCD1-001					
MAKER	214-M33-D55.30					
DWG. NO.						
TITLE	HOPPER SYSTEM GAS SEAL HOPPER VALVE BODY OF MATERIAL CONTROL GATE					
NO.	DATE	REVISION & DESCRIPTION	DRAWN	CHECKED	REVIEWED	APPROVED
	24.11.20	FOR REFERENCE	S.C.PARK	-	O.R.SONG	K.S.SONG
FINE INC.		DRAWN	CHECKED	REVIEWED	APPROVED	
S.C.PARK		-	O.R.SONG	K.S.SONG		
24.11.20		-	24.11.20	24.11.20		

지시의 용접시수	지시의 모서리부분	지시의 일반시수 사용처 (KSB ISO 2768-1)						표면 거칠기 (KSB 0161, 0507, 0617)												
	지시의 일반 모서리 계기 $C = 0.5 \sim 0.8$ $R = 0.5 \sim 0.8$	합시	구 분	0.5	6	30	120	400	1000	2000	Ra	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25
		가공부	중간급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	Rmax	0.4S	0.8S	1.6S	3.2S	6.3S	12.5S	25S	50S	100S
											다듬질	▽▽▽▽	▽▽▽▽	▽▽	▽					

NO.	DESCRIPTION	MAT(KS)	QUANTITY		WEIGHT(Kg)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
2	CARRING ARM	SC49	EA	1	-	490		PE

TOTAL WEIGHT : 490(Kg)X2SET=980(Kg)



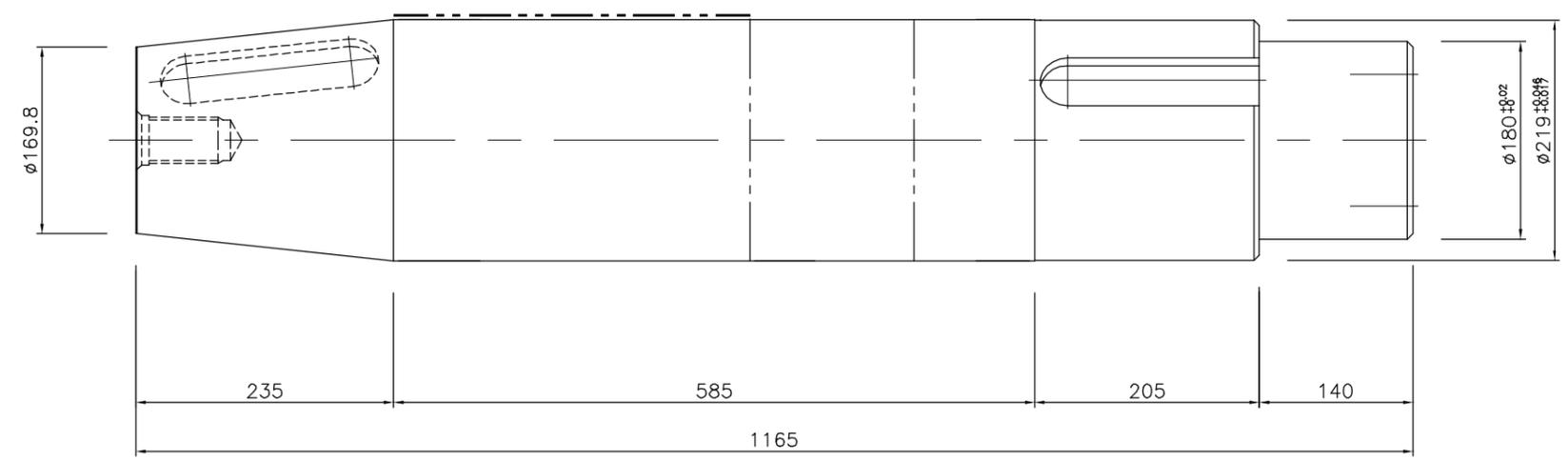
SCALE	1/5	PROJECTION	☉
SIZE	A3	DIMENSION	mm
ITEM MODEL NO.	FSP-FT-MCD1-001		
MAKER DWG. NO.	214-M33-D5540		
TITLE	HOPPER SYSTEM GAS SEAL HOPPER CARRING ARM OF MATERIAL CONTROL GATE		
NO.	DATE	REVISION & DESCRIPTION	DRAWN CHECKED REVIEWED APPROVED
	24.11.20	FOR REFERENCE	S.C.PARK - O.R.SONG K.S.SONG
		FINE INC. DRAWN: S.C.PARK CHECKED: - REVIEWED: O.R.SONG APPROVED: K.S.SONG 24.11.20 - 24.11.20 24.11.20	

지시의 용접치수	지시의 모서리부분	지시의 일반치수 허용치 (KSB ISO 2768-1)								표면 거칠기 (KSB 0161, 0507, 0617)							
		구분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 400	400 ~ 1000	1000 ~ 2000	2000 ~ 4000	Ra	▽	▽	▽	▽	▽	▽	▽
	지시의 일반 모서리 제거 C = 0.5~0.8 R = 0.5~0.8	정밀	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽	▽	▽	▽	▽	
		중간급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽	▽	▽	▽	▽	
		일반급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽	▽	▽	▽	▽	

NO.	DESCRIPTION	MAT(KS)	QUANTITY		WEIGHT(Kg)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
3	LINK SHAFT	SM45C	EA	1	-	335		PE

TOTAL WEIGHT : 335(Kg)X2SET=670(Kg)

③ (▽▽▽▽▽▽▽▽^G)



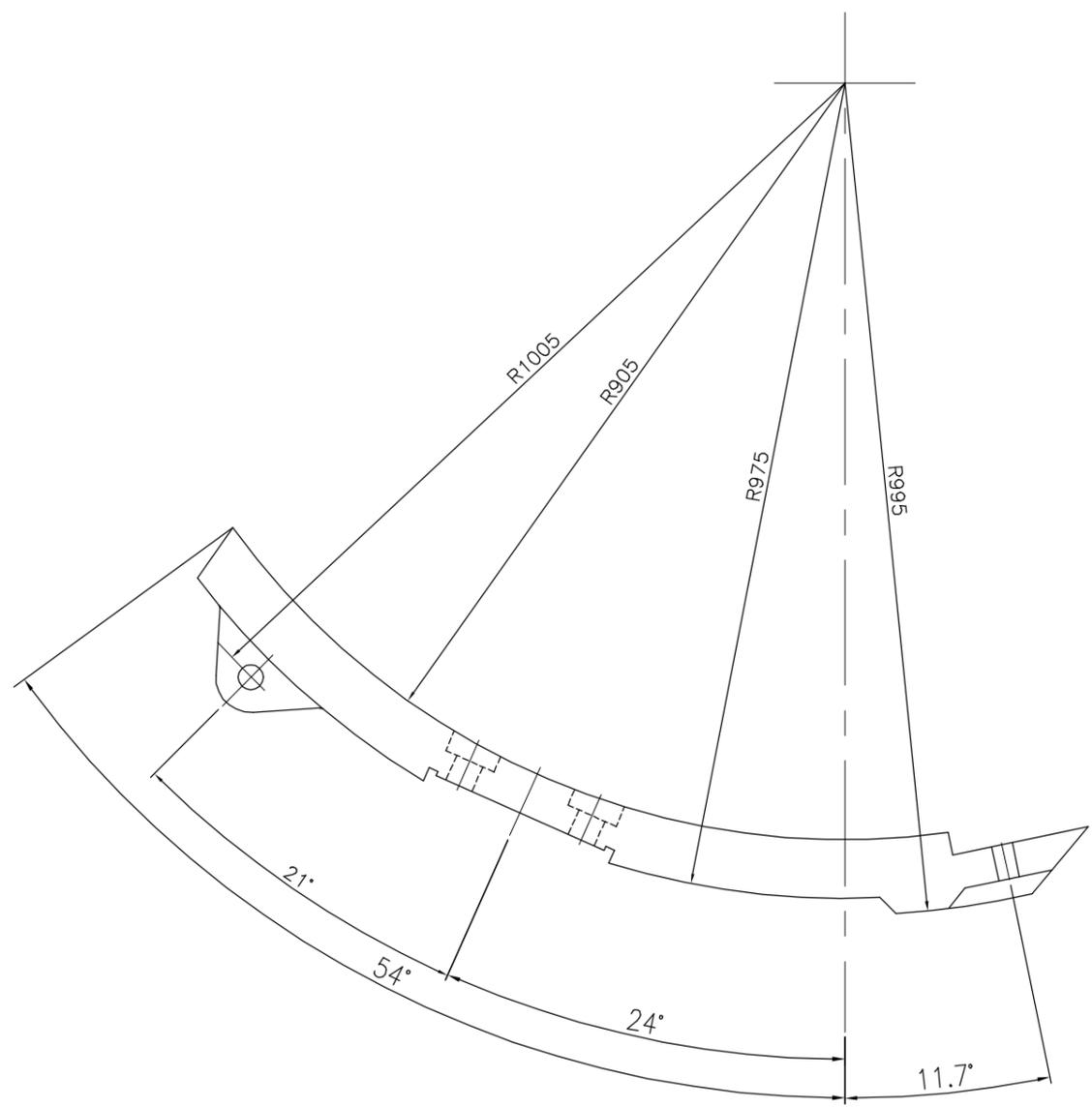
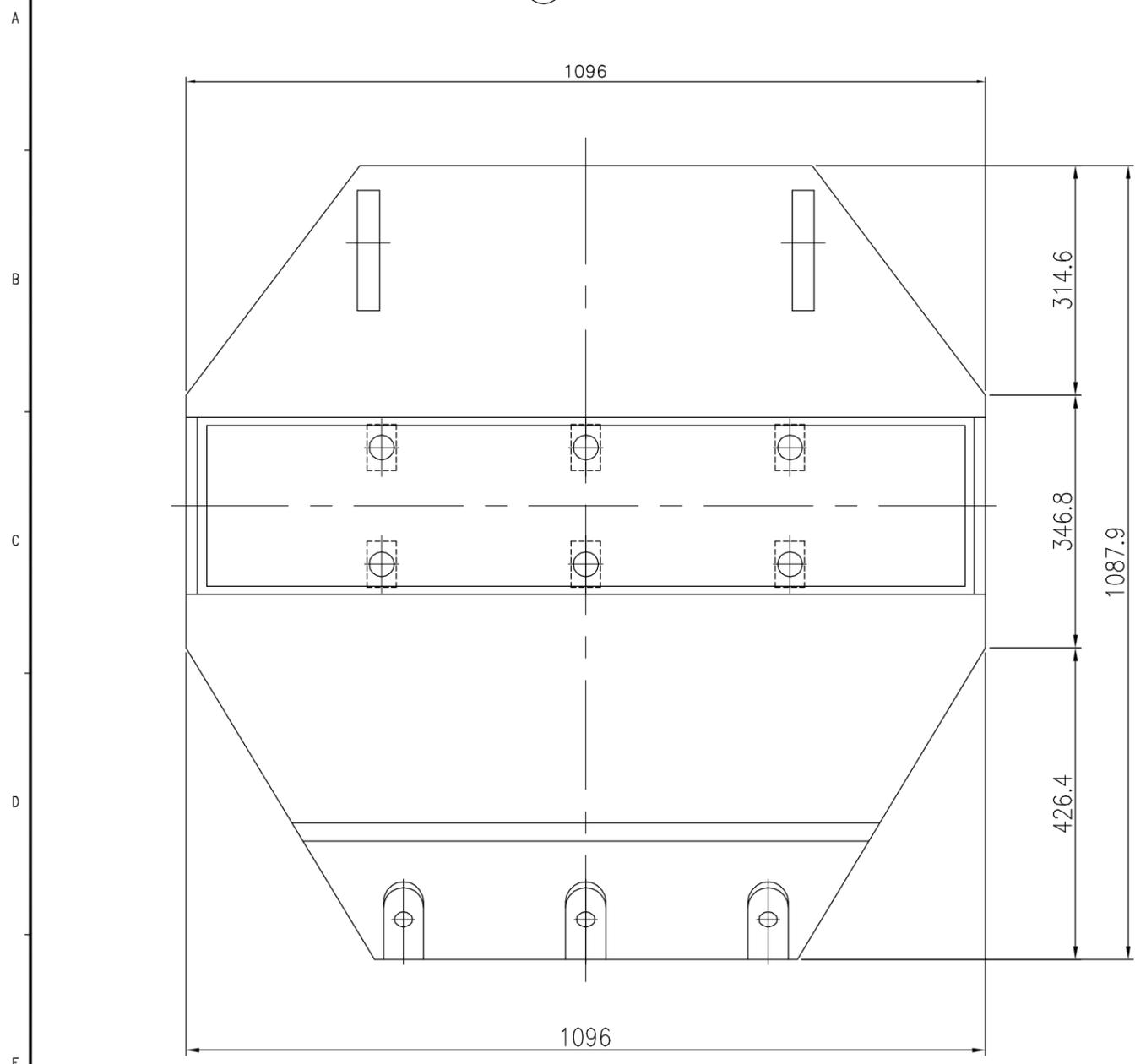
- NOTE.
- 날카로운 모서리부 및 BURR 제거 할 것.
 - 지시없는 일반 공차 : ±0.1
 - 지시없는 모서리 & 라운딩 : C0.5 / R0.5
 - 소재 열처리 : QUENCHING & TEMPERING (HB210~270)

NO.	DATE	REVISION & DESCRIPTION	DRAWN	CHECKED	REVIEWED	APPROVED	TITLE	SCALE	PROJECTION
24.11.20		FOR REFERENCE	S.C.PARK	-	O.R.SONG	K.S.SONG	HOPPER SYSTEM GAS SEAL HOPPER LINK SHAFT OF MATERIAL CONTROL GATE	1/3	1st Angle
<p style="text-align: center;">FINE (주) 파인 FINE INC</p>							<p>2교본 PLANT (G2R2) 노정 FACILITY</p>	<p>ITEM MODEL NO. FSP-FT-MCD1-001 MAKER DWG. NO. 214-M33-D5550</p>	<p>SCALE SIZE A3 DIMENSION mm</p>
							<p>DRAWN CHECKED REVIEWED APPROVED</p> <p>S.C.PARK - O.R.SONG K.S.SONG</p> <p>24.11.20 - 24.11.20 24.11.20</p>	<p>DWG. NO.</p>	

지시의 용접치수		지시의 일반치수 사용치 (KSB ISO 2768-1)							표면 거칠기 (KSB 0161, 0507, 0617)												
단	지시의 일반 치수	정밀	일반	6	30	120	400	1000	2000	4000	Ra	▽1	▽2	▽3	▽4	▽5	▽6	▽7	▽8	▽9	▽10
±0.1	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽

NO.	DESCRIPTION	MAT*(KS)	QUANTITY		WEIGHT(Kg)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
22	GATE	SC49	EA	1	-	468		PE

TOTAL WEIGHT : 468(Kg)X2SET=936(Kg)



- NOTE.
1. 날카로운 모서리부 및 BURR 제거 할 것.
 2. 지시없는 일반 공차 : ±0.1
 3. 지시없는 모서리 & 라운딩 : C0,5 / R0.5

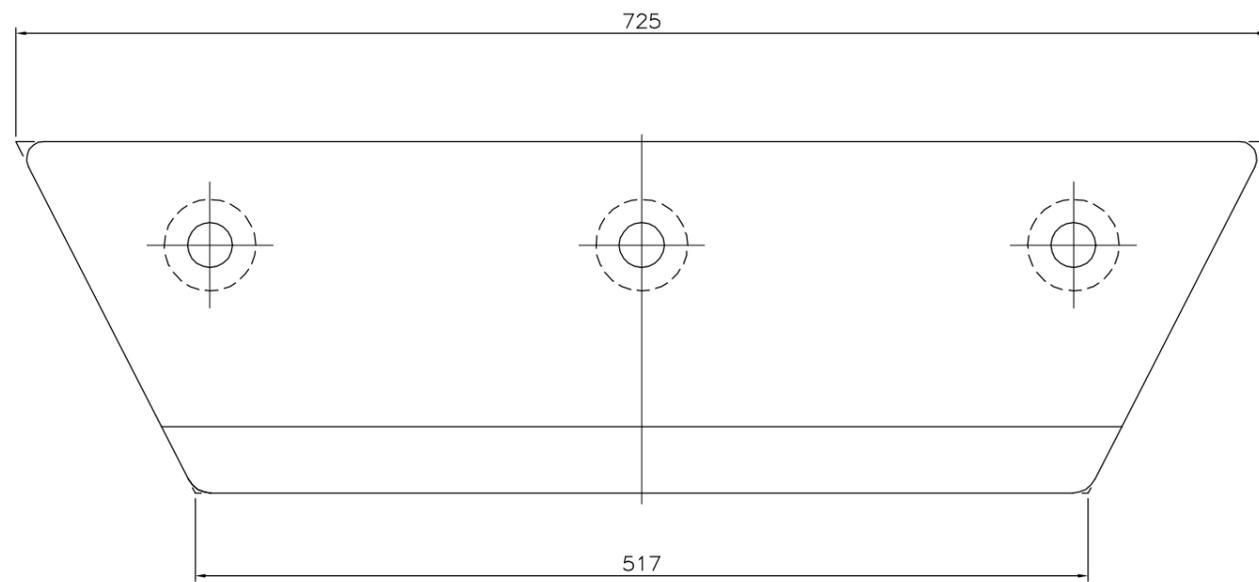
NO.	DATE	REVISION & DESCRIPTION	DRAWN	CHECKED	REVIEWED	APPROVED	TITLE	SCALE	PROJECTION
24.11.20		FOR REFERENCE	S.C.PARK	-	O.R.SONG	K.S.SONG	HOPPER SYSTEM GAS SEAL HOPPER GATE OF MATERIAL CONTROL GATE	1/4	1st Angle
<p>FINE INC. (주) 파인</p>							<p>2교본 PLANT (G2R2) 노정 FACILITY</p>	<p>ITEM MODEL NO. FSP-FT-MCD1-001</p> <p>MAKER DWG. NO. 214-M33-D5570</p>	<p>SCALE 1/4</p> <p>SIZE A1</p> <p>PROJECTION 1st Angle</p>
<p>FINE INC.</p>							<p>DRAWN S.C.PARK</p> <p>CHECKED -</p> <p>REVIEWED O.R.SONG</p> <p>APPROVED K.S.SONG</p>	<p>DWG. NO.</p>	<p>DATE 24.11.20</p>

지시의 용량치수	지시의 모서리부분	지시의 일반치수 허용치 (KSB ISO 2768-1)								표면 거칠기 (KSB 0161, 0507, 0617)									
		구분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 400	400 ~ 1000	1000 ~ 2000	2000 ~ 4000	Ra	▽	▽	▽	▽	▽	▽	▽	▽	▽
	지시의 일반 모서리 제기 C = 0.5~0.8 R = 0.5~0.8	중간급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽	▽	▽	▽	▽	▽	▽	▽

NO.	DESCRIPTION	MAT(KS)	QUANTITY		WEIGHT(Kg)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
23	LINER	25Cr-Fc	EA	1	-	43.9		PE

TOTAL WEIGHT : 43.9(Kg)X2SET=87.8(Kg)

(23) ~ (▽)



25Cr-FC 성분표

C	Mn	Si	S	Ni	Cr	Mo	HARDNESS
2.0 ~ 3.3	2.0 이하	1.5 이하	0.1 이하	2.5 이하	30.0 이하	3.0 이하	H _B 600이상

- NOTE.
- 날카로운 모서리부 및 BURR 제거 할 것.
 - 지시없는 일반 공차 : ±0.1
 - 지시없는 모서리 & 라운딩 : C0.5 / R0.5

NO.	DATE	REVISION & DESCRIPTION	DRAWN	CHECKED	REVIEWED	APPROVED	TITLE	SCALE	PROJECTION	
24.11.20		FOR REFERENCE	S.C.PARK	-	O.R.SONG	K.S.SONG	HOPPER SYSTEM GAS SEAL HOPPER LINER OF MATERIAL CONTROL GATE	1/2	1st Angle	
<p>FINE INC. (주) 파인</p>							<p>2교본 (G2R2) PLANT 노장 FACILITY</p>	<p>ITEM MODEL NO. FSP-FT-MCD1-001</p>	<p>MAKER DWG. NO. 214-M33-D5580</p>	
<p>FINE INC.</p>							<p>DRAWN S.C.PARK</p>	<p>CHECKED -</p>	<p>REVIEWED O.R.SONG</p>	<p>APPROVED K.S.SONG</p>
<p>24.11.20</p>							<p>24.11.20</p>	<p>24.11.20</p>	<p>24.11.20</p>	<p>DWG. NO.</p>