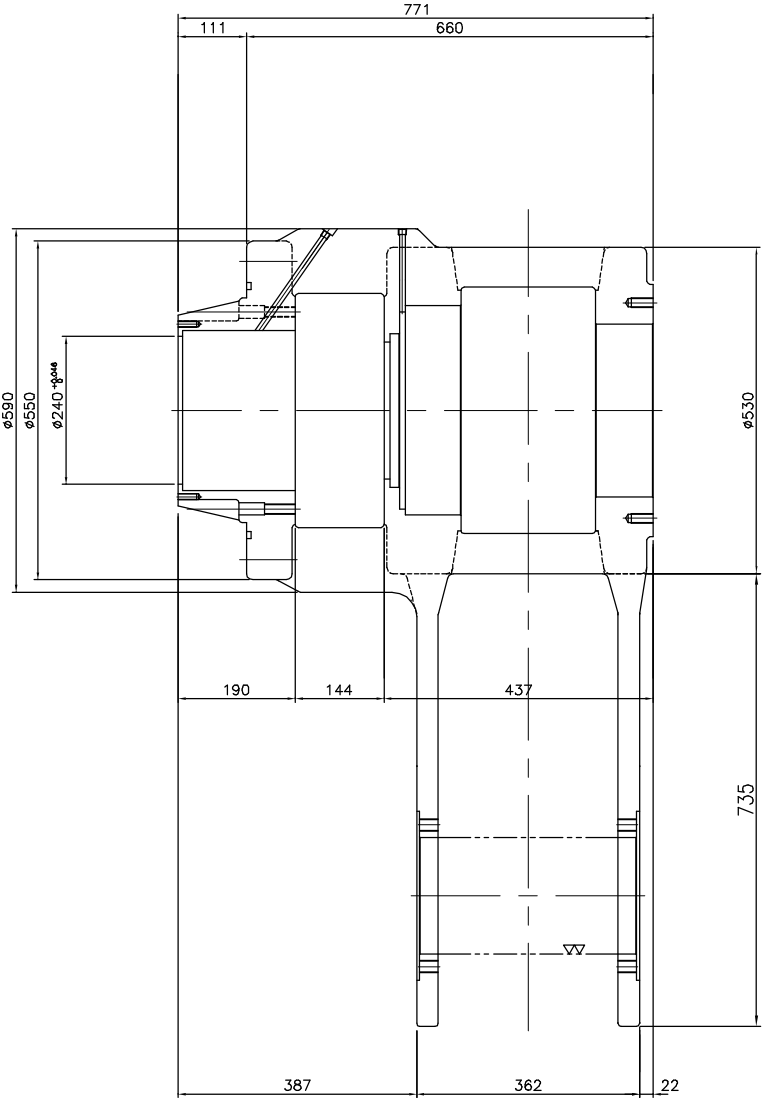
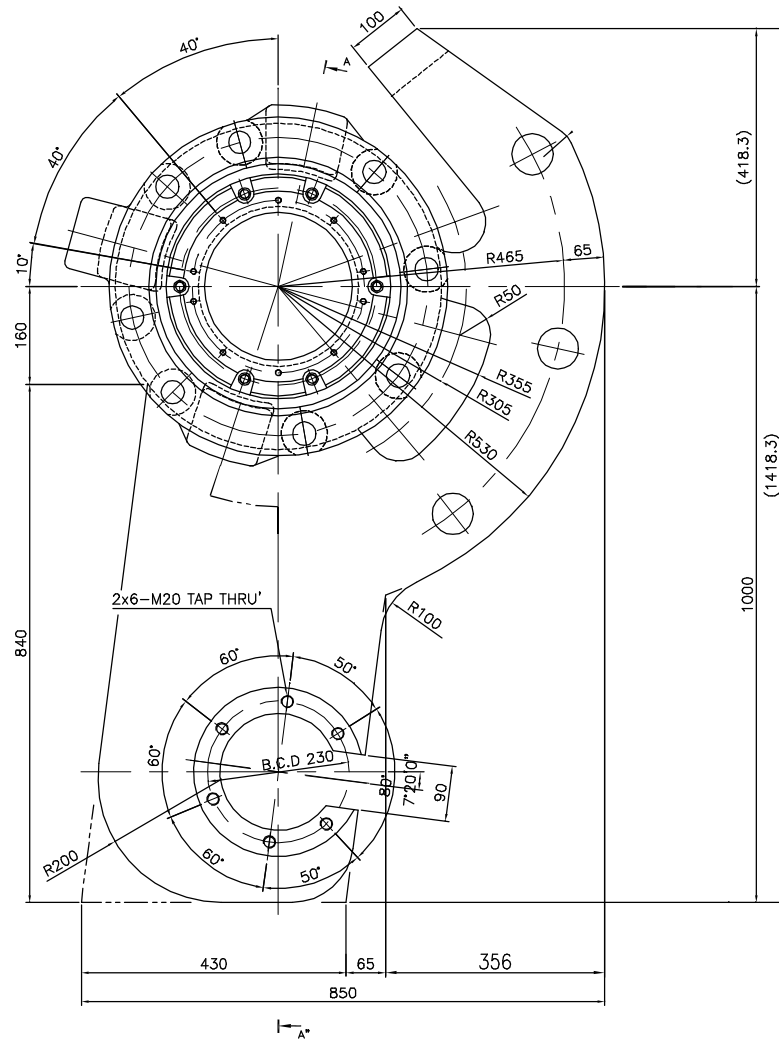


지시의 용접시수	지시의 모서리부분	지시의 일반시수 사용처 (KSB ISO 2788-1)										표면 거칠기 (KSB 0161, 0507, 0617)															
		0.5	6	30	120	400	1000	2000	Ra	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	0.45	0.85	1.65	3.25	6.35	12.65	25.5	50.5	100.5
		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	Rmax																		
지시의 일반 모서리 세기 C = 0.5~0.8 R = 0.5~0.8												다듬질 															

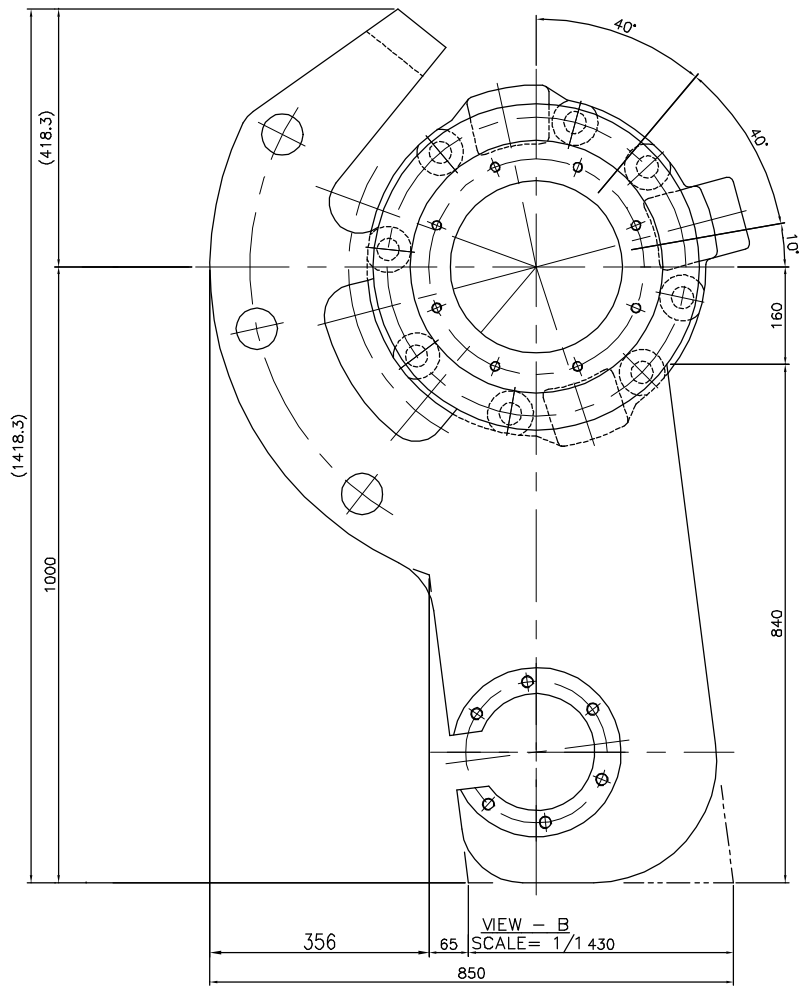
NO.	DESCRIPTION	MAT*(KS)	QUANTITY		WEIGHT(Kg)		REMARK'S	공급 구분
			UNIT	TOTAL	PERUNIT	TOTAL		
1	VALVE BODY	SC49	EA	1	-	980		PE

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

A
B
C
D
E
F



SECTION A-A'
SCALE = 1/1



VIEW - B
SCALE = 1/1 430

										SCALE	1/6	PROJECTION	
										SIZE	A3	DIMENSION	mm
										TITLE 2호분 PLANT HOPPER SYSTEM 노정 FACILITY GAS SEAL HOPPER VALVE BODY OF MATERIAL CONTROL GATE			
										ITEM MODEL NO. FSP-FT-MCD1-001 MAKER 214-M33-D55.30 DWG. NO.			
NO.	DATE	REVISION & DESCRIPTION	DRAWN	CHECKED	REVIEWED	APPROVED							

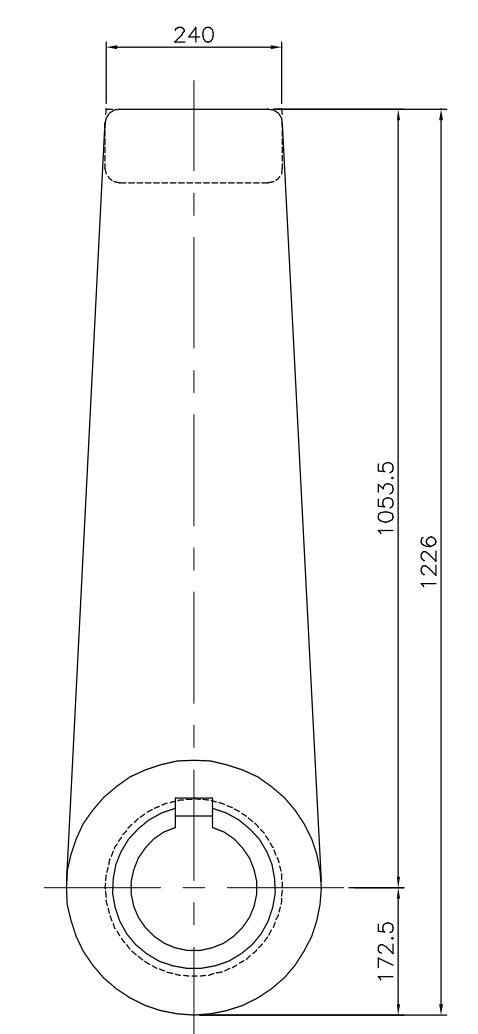
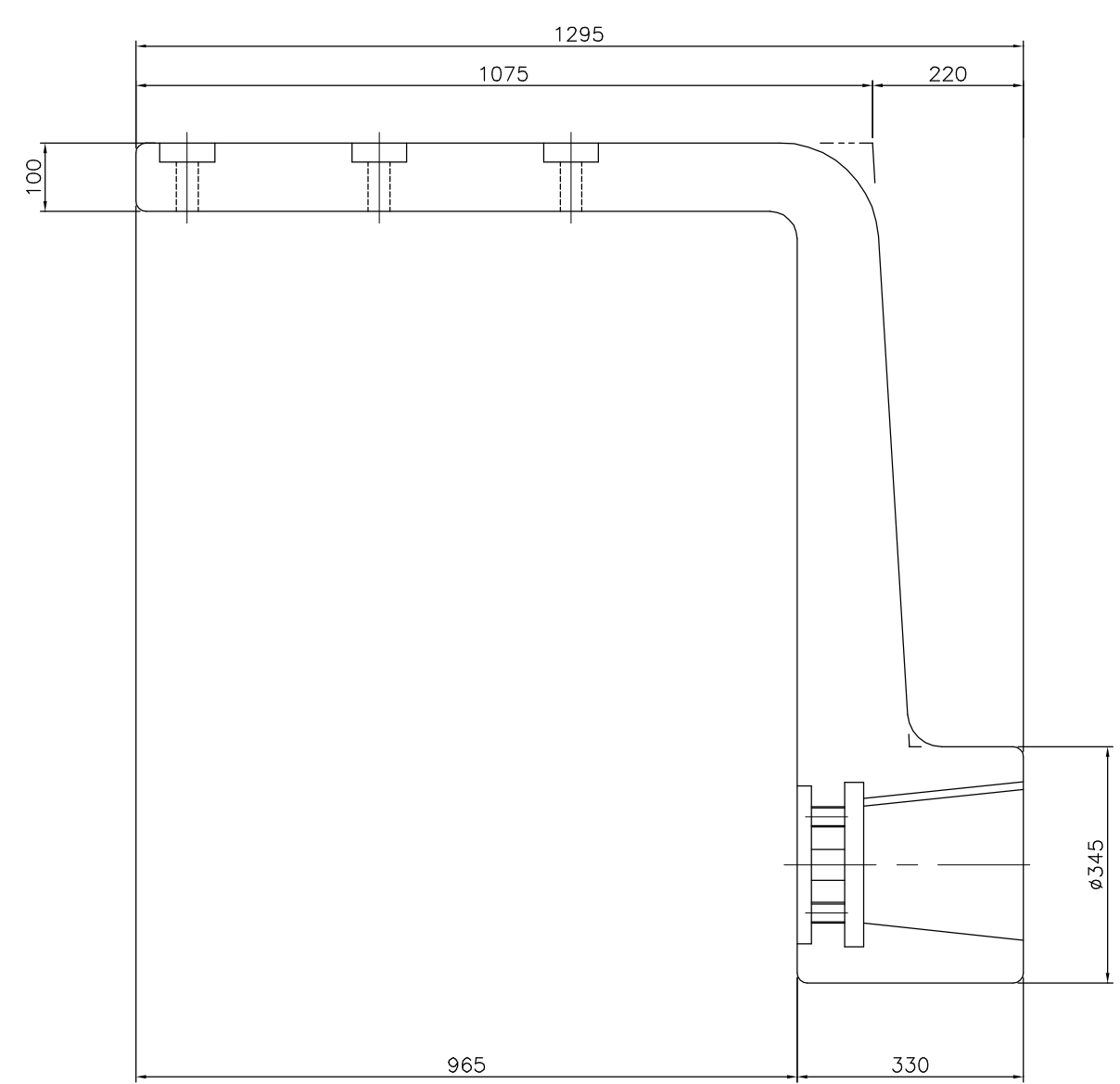
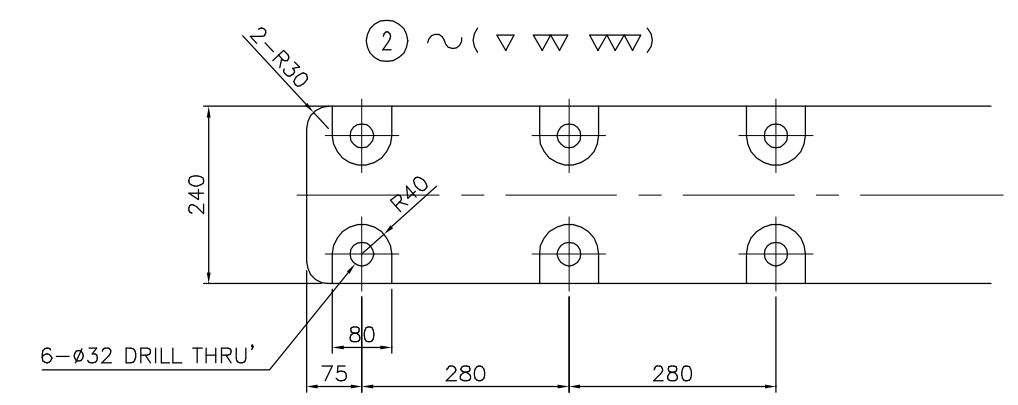


DRAWN	CHECKED	REVIEWED	APPROVED
S.C.PARK	-	O.R.SONG	K.S.SONG
24.11.20	-	24.11.20	24.11.20

지시의 용접시수	지시의 모서리부분	지시의 일반시수 사용처 (KSB ISO 2768-1)						표면 거칠기 (KSB 0161, 0507, 0617)													
	지시의 일반 모서리 계기 $C = 0.5 \sim 0.8$ $R = 0.5 \sim 0.8$	필시	구분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 400	400 ~ 1000	1000 ~ 2000	2000 ~ 4000	Ra	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	
		종간급	±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)

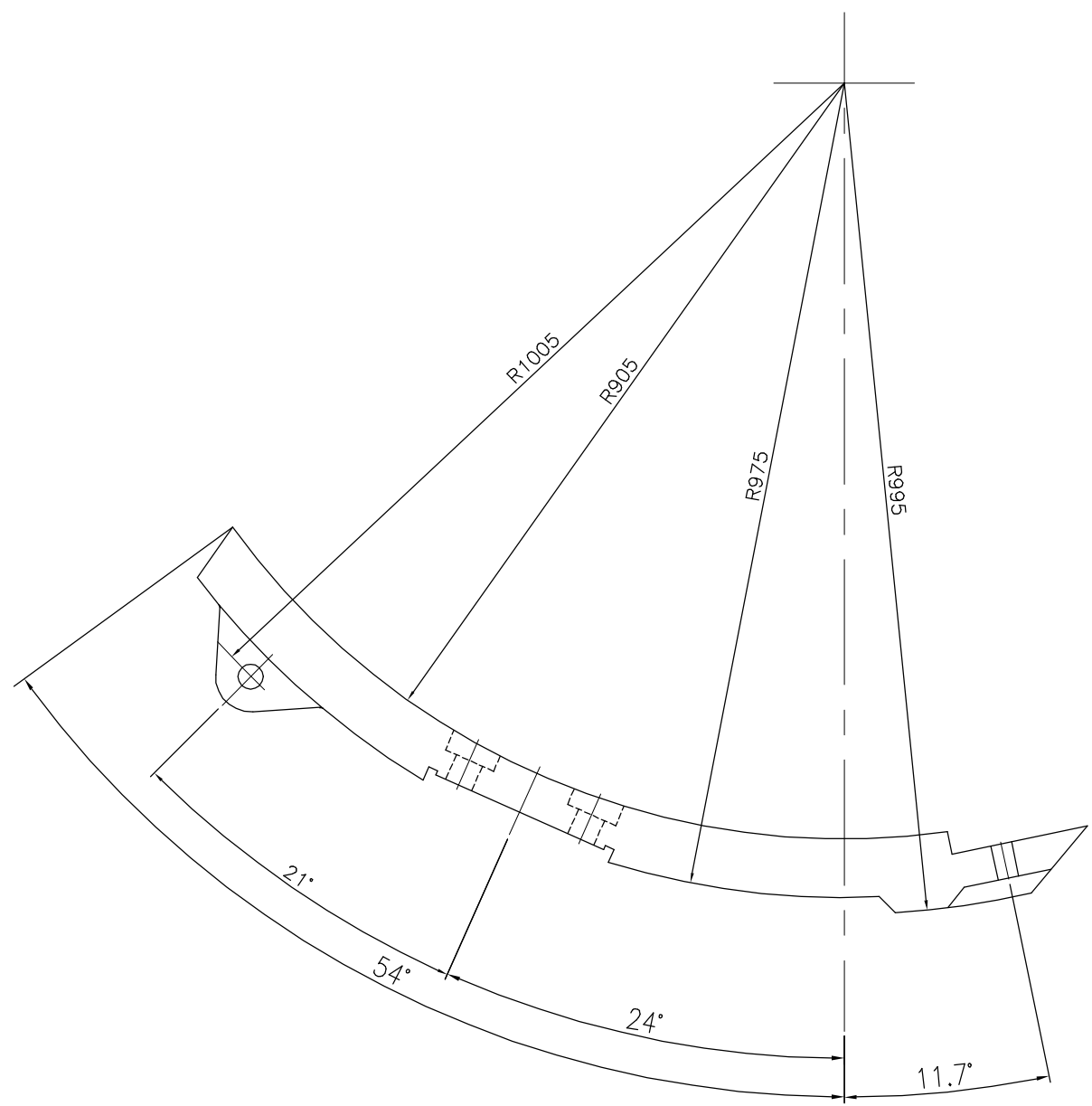
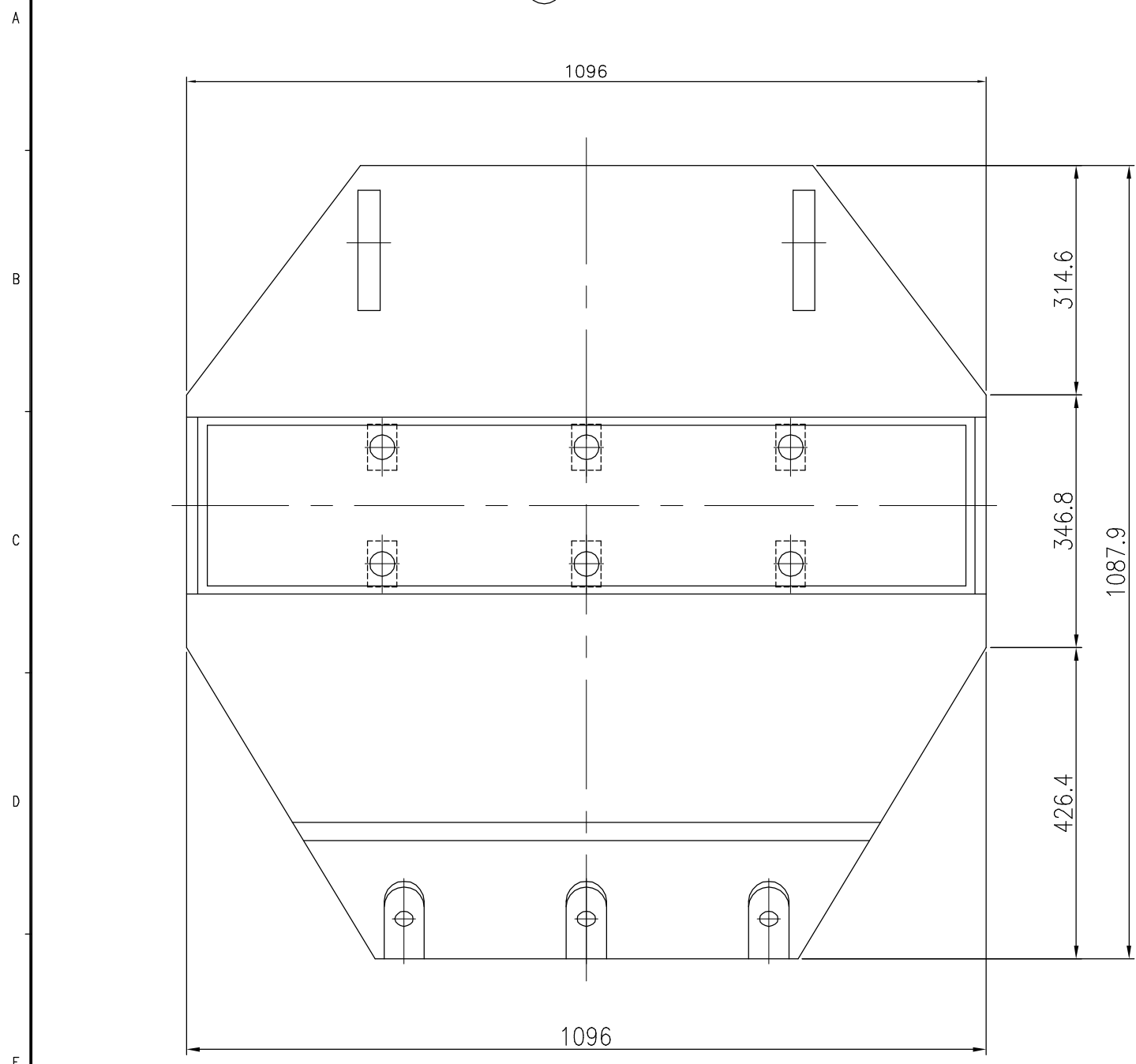


SCALE	1/5	PROJECTION	☺												
SIZE	A3	DIMENSION	mm												
ITEM MODEL NO.	FSP-FT-MCD1-001														
MAKER DWG. NO.	214-M33-D5540														
TITLE	HOPPER SYSTEM GAS SEAL HOPPER CARRING ARM OF MATERIAL CONTROL GATE														
NO.	DATE	REVISION & DESCRIPTION	DRAWN CHECKED REVIEWED APPROVED												
	24.11.20	FOR REFERENCE	S.C.PARK - O.R.SONG K.S.SONG												
		FINE (주) 파인 FINE INC													
		<table border="1"> <tr> <th>DRAWN</th> <th>CHECKED</th> <th>REVIEWED</th> <th>APPROVED</th> </tr> <tr> <td>S.C.PARK</td> <td>-</td> <td>O.R.SONG</td> <td>K.S.SONG</td> </tr> <tr> <td>24.11.20</td> <td>-</td> <td>24.11.20</td> <td>24.11.20</td> </tr> </table>		DRAWN	CHECKED	REVIEWED	APPROVED	S.C.PARK	-	O.R.SONG	K.S.SONG	24.11.20	-	24.11.20	24.11.20
DRAWN	CHECKED	REVIEWED	APPROVED												
S.C.PARK	-	O.R.SONG	K.S.SONG												
24.11.20	-	24.11.20	24.11.20												

지시의 용량치수		지시의 일반치수 사용치 (KSB ISO 2768-1)							표면 거칠기 (KSB 0161, 0507, 0617)											
단	지시의 일반 치수	정밀	일반	0.5	6	30	120	400	1000	2000	4000	Ra	▽1	▽2	▽3	▽4	▽5	▽6	▽7	▽8
±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											
<table border="1"> <tr> <td>DRWN</td> <td>CHEK</td> <td>REVIEW</td> <td>APPROV</td> </tr> <tr> <td>S.C.PARK</td> <td>-</td> <td>O.R.SONG</td> <td>K.S.SONG</td> </tr> <tr> <td>24.11.20</td> <td>-</td> <td>24.11.20</td> <td>24.11.20</td> </tr> </table>							DRWN	CHEK	REVIEW	APPROV	S.C.PARK	-	O.R.SONG	K.S.SONG	24.11.20	-	24.11.20	24.11.20	ITEM MODEL NO.	FSP-FT-MCD1-001
DRWN	CHEK	REVIEW	APPROV																	
S.C.PARK	-	O.R.SONG	K.S.SONG																	
24.11.20	-	24.11.20	24.11.20																	
<table border="1"> <tr> <td>MAKER</td> <td>DWG. NO.</td> </tr> <tr> <td>214-M33-D5570</td> <td></td> </tr> </table>							MAKER	DWG. NO.	214-M33-D5570		SCALE	1/4								
MAKER	DWG. NO.																			
214-M33-D5570																				
<table border="1"> <tr> <td>SIZE</td> <td>A1</td> <td>DIMENSION</td> <td>mm</td> </tr> </table>							SIZE	A1	DIMENSION	mm										
SIZE	A1	DIMENSION	mm																	

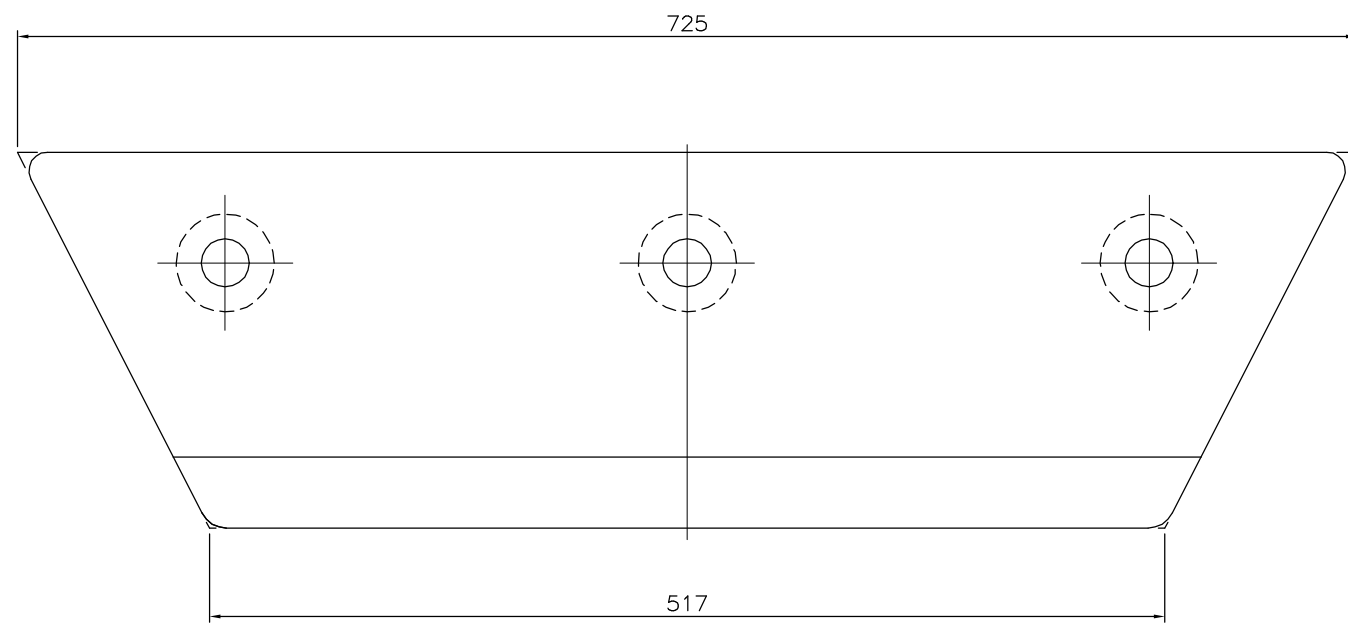


지시의 용접시수	지시의 모서리부분	지시의 일반시수 허용치 (KSB ISO 2768-1)								표면 거칠기 (KSB 0161, 0507, 0617)													
	지시의 일반 모서리 세기 C = 0.5~0.8 R = 0.5~0.8	형식	구분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 400	400 ~ 1000	1000 ~ 2000	2000 ~ 4000	Ra	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	
		종간급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	다듬질	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽
											0.4S	0.8S	1.6S	3.2S	6.3S	12.5S	25S	50S	100S				

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	0.06 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

SCALE	1/2	PROJECTION	☺												
SIZE	A1	DIMENSION	mm												
ITEM MODEL NO.	FSP-FT-MCD1-001														
MAKER DWG. NO.	214-M33-D5580														
TITLE	HOPPER SYSTEM GAS SEAL HOPPER LINER 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.		<table border="1"> <tr> <th>DRAWN</th> <th>CHECKED</th> <th>REVIEWED</th> <th>APPROVED</th> </tr> <tr> <td>S.C.PARK</td> <td>-</td> <td>O.R.SONG</td> <td>K.S.SONG</td> </tr> <tr> <td>24.11.20</td> <td>-</td> <td>24.11.20</td> <td>24.11.20</td> </tr> </table>		DRAWN	CHECKED	REVIEWED	APPROVED	S.C.PARK	-	O.R.SONG	K.S.SONG	24.11.20	-	24.11.20	24.11.20
DRAWN	CHECKED	REVIEWED	APPROVED												
S.C.PARK	-	O.R.SONG	K.S.SONG												
24.11.20	-	24.11.20	24.11.20												

