

安装后请注油
fill in grease oil after assembly

件6的凸出配合面应设置手
Each end face of spine of piece 6 & 9 should be horizontal

现场调整高度，保证间隙为4.5mm。
Adjust on site to keep the clearance 4.5mm.

参数表 Parameter Table	
小车速 Trolley Speed	d750m/min
额定重量 Rated Load	d65t
水平侧力(max) Level Lateral Force	d10t

型号表

卷型号	油孔尺寸M
I	Rc1/4"
II	Rc1/8"
III	NPT1/4"
IV	NPT1/8"
V	M10x1
VI	Rp1/4"
VII	Rp1/8"

技术要求

1. 图示位置为偏心轴处于中位，偏心轴的偏心距为15mm，水平轮可调整。
2. 件8支脚用螺栓连在小车架主梁上，水平轮与轨道侧面的距离3~5mm。
3. 对称安装，支脚的开口朝小车架外。
4. 件B7管束密封圈B1安装如图。
5. 本套装置每台有4套左右对称各一套。
6. M20螺栓螺母的预紧力为107.8kN，预紧力矩为315Nm(扭矩系数K=0.145)。
7. 按图示安装螺栓B2及止动垫圈14，止动垫圈防止螺栓转动。

Technical Requirements

1. The eccentric degree of eccentric shaft is 15mm. The adjustable range of the roller center is 30mm along the rail.
2. Piece 8 is to be connected to the trolley frame with bolts. The roller flange is 3~5mm off the flank of the rail.
3. Mount symmetrically with the hatch in the support deviating off the trolley frame.
4. Piece B7 is to be set as the drawing shows.
5. 4 sets per crane with each two of them end-to-end.
6. The pretightening force of bolts and nuts(M20) is 107.8kN, and their pretightening torque is 315Nm(Torque Coefficient K=0.145).
7. Fix the bolts (B2) and position plate (piece 14) as the drawing shows. The position plate shall be able to prevent the bolts from rotating.

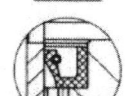
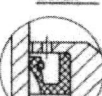
NO.	SUB-NO. OR STD.	VER.	NAME & SIZE	MTRL	QTY	EACH(Kg)	TOTAL(Kg)	NOTE
B7	GB13874-92		密封圈 B100x125x12 Seal	外购成 品 Pur.	2	0.0	0.0	
B6	GB1288-94		轴承 23218CC/W33 Bearing	外购成 品 Pur.	1	4.4	4.4	
B5	GB/T294-1994		轴承 QJ218 Bearing	外购成 品 Pur.	1	2.9	2.9	
B4	GB321-88		螺栓 M12x25 Bolt	A2-70	8	0.0	0.0	
B3	GB889-86		锁紧螺母 M20 Lock nut	8.8	10	0.0	0.0	'Dacro'
B2	GB5782-85		螺栓 M20x70 Bolt	8.8	10	0.2	2.0	'Dacro'
B1	GB971-85		平垫圈 20 Washer	100HV	10	0.0	0.0	'Dacro'
17	Z17-020801-18	0	密封装置 Seal Ass.	组件 Ass.	1	0.1	0.1	
16	GB4240-84		不锈钢丝 1.5 1-1500 Stainless wire	0Cr18Ni9Ti	1	0.0	0.0	

NO.	SUB-NO. OR STD.	VER.	NAME & SIZE	MTRL	QTY	EACH(Kg)	TOTAL(Kg)	NOTE
15	Z17-020801-17	0	防落架 Bracket	组件 Ass.	1	2.9	2.9	
14	Z17-020801-15	0	止动垫圈 Position Plate	Q345-B	1	1.3	1.3	
13	Z17-020801-13	0	垫片组2 Washer group 2	1Cr18Ni9Ti	1	0.0	0.0	
12	Z17-020801-12	0	垫片组1 Washer group 1	1Cr18Ni9Ti	1	0.0	0.0	
11	Z17-020801-10	0	轴套3 Sleeve3	Q235-A	1	0.2	0.2	
10	Z17-020801-16	0	楔形挡块组 Wedge-shaped Blocks	Q345-B	4	0.2	0.8	
9	Z17-020801-09	0	定位盘 Positioning plate	45	1	2.9	2.9	
8	Z17-020801-08	0	支架 Support	焊接件 Weld	1	33.7	33.7	
7	Z17-020801-07	0	剖分套 Divided sleeve	组件 Ass.	1	1.7	1.7	
6	Z17-020801-06	0	偏心轴 Eccentric shaft	35CrMo	1	9.6	9.6	
5	Z17-020801-05	0	轴套2 Sleeve 2	20	1	0.6	0.6	
4	Z17-020801-04	0	透盖 Through-hole cover	Q235-A	1	1.8	1.8	
3	Z17-020801-03	0	轴套3 Sleeve 3	Q235-A	1	0.1	0.1	
2	Z17-020801-02	0	轴套1 Sleeve 1	20	1	0.3	0.3	
1	Z17-020801-01	0	滚轮 Roller	42CrMo	1	30.3	30.3	

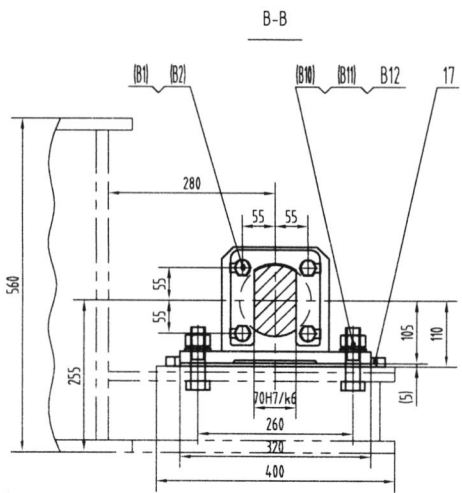
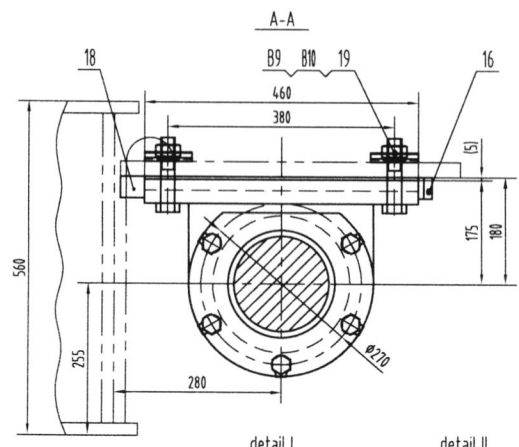
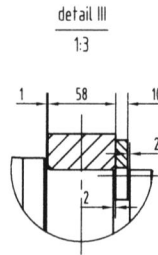
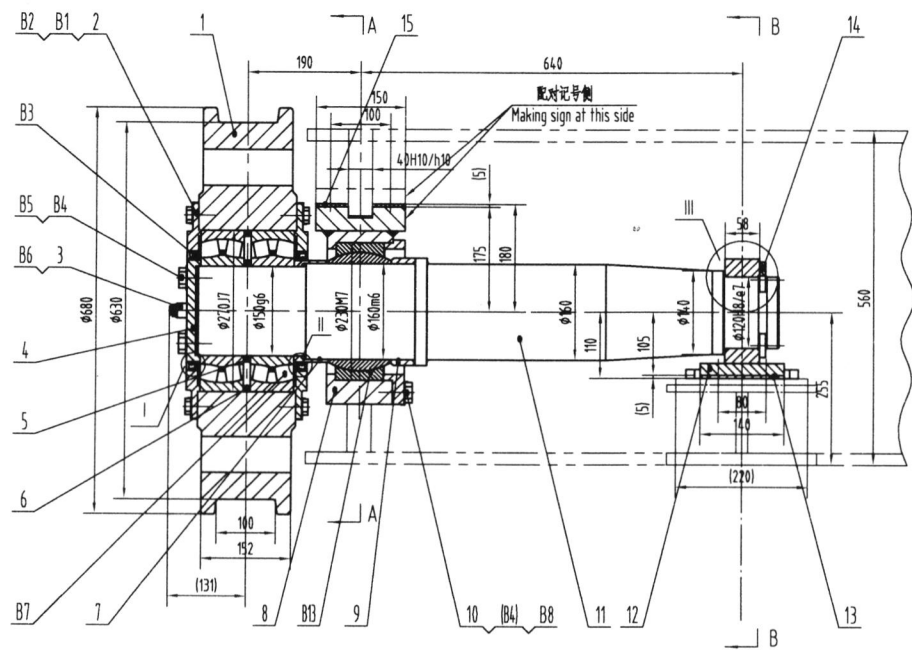
审核 11-11-11	批准 11-11-11	日期 2011-10-11	比例 1:1	图号 Z17-020801-00	图名 水平轮装配 Guide roller ass.	图例
ZPMC 上海振华重工集团						

Detail

Detail a



NO.	SUB-NO. OR STD.	VER.	NAME & SIZE	MTRL	QTY	EACH(Kg)	TOTAL(Kg)	NOTE
B8	GB321-88		螺栓 M12x40 Bolt	A2-70	8	0.0	0.0	



B13	Outsource acc to the drawing TRWA03b-B13外购	Spherical plain bearing 自润滑球轴承	160x230x105x80	1	14.3	14.3	Barrow
B12	GB5782-86	Bolt 螺栓 M24x90	Dacro 达克罗	4		10.9S	
B11	GB971-85	Washer 垫圈 24	Dacro 达克罗	4		45HRC	
B10	SPL6175-PT	Nut 螺母 M24	Dacro 达克罗	8		10H	
B9	GB5782-86	Bolt 螺栓 M24x110	Dacro 达克罗	4		10.9S	
B8	GB855-88	Washer 垫圈 20	Dacro 达克罗	5		200HV	
NO.	SUB-NO. or STDD	NAME & SIZE	MTRL or STYLE	Q'TY/SET	SET*WEIGHT	SCALE	

技术要求

1. 安装前, 轴承要加适量润滑脂。安装后, 再注满润滑脂。
2. 车轮安装调试完后, 件16, 17, 18 焊接牢固。
3. 件B13为要求其球形工作表面为铜合金, 并镶嵌固体润滑剂。
4. 安装时, 件8与小车架相应件间应打配对记号, 以便以后维修。

Technical Requirements

1. Fill in appropriate grease oil to bearings before assembling. While completing assembly, inject grease full.
2. Weld piece 16, 17, 18 firmly after finishing the Trolley Wheel Assembly.
3. Piece B13 the spherical operating surface adopts copper alloy and being inlaid with solid lubricant.
4. Make matching signs between Piece 8 and trolley frame.

螺栓规格 Bolt spec.	件号 Item No.	等级 Grade	螺栓预紧力(KN) Pretightening force	螺栓预紧力矩(Nm) Pretightening torque
M24	B9, B12	施必牢螺母10级 SPL Nut 10s	238.1	1200(k=0.2)
M20	B4	8.8级 8.8s	107.8	252(k=0.145)
M16	B1	8.8级 8.8s	70.6	128(k=0.145)

B7		Bearing 轴承 22230CC/W33	φ270xφ150x73	2	18.6	37.2	inches
B6	JISB0203	Grease Fitting 油嘴 PT1/4"	Stainless 不锈钢	1			
B5	GB856-88	Washer 垫圈 20	Dacro 达克罗	4			200HV
B4	GB5783-86	Bolt 螺栓 M20x55	Dacro 达克罗	9			8.8S
B3	GB9877.1-88	Seal Ring 密封	B170x200x15	2			
B2	GB855-88	Washer 双耳止动垫圈 16	Dacro 达克罗	20			200HV
B1	GB5783-86	Bolt 螺栓 M16x35	Dacro 达克罗	20			8.8S
19	GB95-85	Washer 垫圈 M24	Dacro 达克罗	4	0.25	1	
18	TRWA0315	Block 挡块	Q235	1	1.2	1.2	Barrow
17	ZP3A	Block 模块	Q235	4 sets	0.3	1.2	Barrow
16	TRWA0314	Block 模块	Q235	1 sets	0.4	0.4	Barrow
15	TRWA0313	Shim1 调整垫片1	A709-50-2	2	0.9	1.8	Barrow
14	TRWA0312	Baffle 卡轴板	A709-50-2	1	1.1	1.1	Barrow
13	TRWA0311-J392A	Shim2 调整垫片2	Q235	1	1.7	1.7	Barrow
12	TRWA0316	Support2 支座2	Welded 焊接件	1	16	16	
11	TRWA0317	Shaft 轴	35CrMo	1	140.6	140.6	
10	TRWA0308	Cover 端盖	Q235	1	7	7	Barrow
9	TRWA0307	Sleeve2 轴套2	A709-50-2	1	1.5	1.5	Barrow
8	TRWA0306a	Support1 支座1	Welded 焊接件	1	54	54	Barrow
7	TRWA0305	Sleeve1 轴套1	A709-50-2	1	1.4	1.4	Barrow
6	TRWA0304	Outer Spacer 外隔圈	Q235	1	0.8	0.8	Barrow
5	TRWA0303	Inner Spacer 内隔圈	Q235	1	0.7	0.7	Barrow
4	TRWA0302	Cover 压盖	Q235	1	3	3	Barrow
3	NPC2a-R174	Joint 油嘴接头 A50	Q235	1	0.1	0.1	
2	TRWA0301	Through-hole Cover 通盖	Q235	2	7.7	15.4	Barrow
1	TWF1-630x75	Trolley Wheel 小车轮	42CrMo	1	310	310	Standard
NO.	SUB-NO. or STDD	NAME & SIZE	MTRL or STYLE	Q'TY/SET	SET*WEIGHT	SCALE	
	TRWA03c-630x75-J392A	Trolley Wheel Assembly 小车轮总成	Ass. 组件	1	610.4	1.6	
ZPMC		DRAW	TECH.	TRACE			
		CHCK	STDD	CHCK			