



**技术要求**

- 1. 锻件不得有裂纹、结疤、缺料、氧化皮及未充满等缺陷；
- 2. 非加工面的残留飞边、凹坑必须打磨平整，锻件的错模量不大于 0.4；
- 3. 齿轮和油道堵头压装牢靠，正时标记准确；
- 4. 油道里无任何杂质；
- 5. 每一根曲轴加工后必须进行静平衡检测和修正，静平衡质量控制在 (470±15)g 范围内；
- 6. 吊线：将曲轴部件的输出端朝机尾方向装夹在机床上，用棉线将一重物悬挂输入端或输出端的油封位。机床正转，悬挂重物应向曲拐方向移动。

**Technical Requirements**

- 1. Forgings shall not have cracks, scarring, sort of material, oxidation, such as skin and not a defect;
- 2. The non-processing of the residual surface flash, the formation of pits must be polished, the fault of forging modulus not greater than 0.4;
- 3. Gear and plug solid press-fit, when the tag is accurate;
- 4. Doali oil without any impurities.
- 5. Each crankshaft processing static equilibrium must be carried out after the detection and correction, quality control of static equilibrium in the range of (470±15)g;
- 6. Suspension wire: the crankshaft component output end toward the tail direction clamped on a machine tool, with the thread will be a weight hanging input end or the output end of the oil seal position. The machine is transferred, hanging weight to move in the direction of the crank.

序号 Ser.No.	代号 Part No.	名称及规格 Name & pecification	数量 Q'ty	材料 Material	单件 Single	总计 Total	备注 Note
5	130300332-T470	曲轴 Crankshaft	1	40Cr GB/T 3077			
4	130230044-T430	正时主销轴 Gear, Timing	1	40Cr GB/T 3077			ADOPT
3	130460016-T430	平衡轴主销轴 Driving Gear, Balancer weight	1	40Cr GB/T 3077			ADOPT
2	381000243-T430	堵头 Crankshaft Plug	1	5A02			ADOPT
1	380620110-T430	半圆键 Woodruff Key	1	45 GB/T 699			ND

					130290449-T470			
					LC196FD			
					曲轴部件 Crankshaft Comp			
					隆鑫通用动力股份有限公司 通机本部 LONCIN MOTOR CO., LTD. General Purpose Engine Division			
设计 Designed by	校对 Checked by	工艺 Technics	审核 Audited by	批准 Approved by	图样标记 Drawing Marking	图幅 Size	质量 Mass	比例 Scale
					S A	01 A2		1:1
					页码 Sheet		1/1	