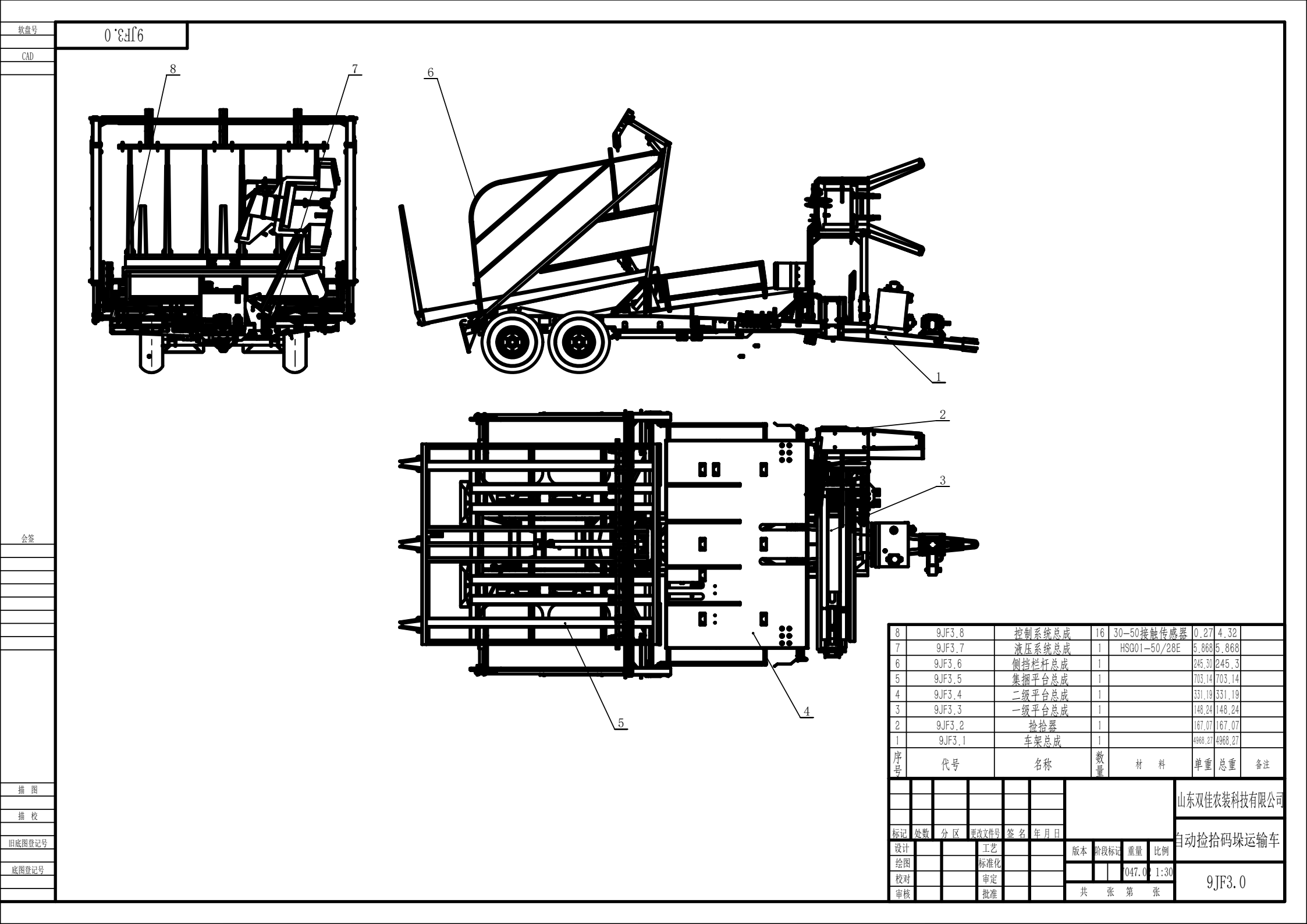




9JF3.0

软盘号

CAD

会签

描图

描校

旧底图登记号

底图登记号

|    |        |        |       |              |         |         |      |
|----|--------|--------|-------|--------------|---------|---------|------|
| 8  | 9JF3.8 | 控制系统总成 | 16    | 30-50接触传感器   | 0.27    | 4.32    |      |
| 7  | 9JF3.7 | 液压系统总成 | 1     | HSG01-50/28E | 5.868   | 5.868   |      |
| 6  | 9JF3.6 | 侧挡栏杆总成 | 1     |              | 245.30  | 245.3   |      |
| 5  | 9JF3.5 | 集捆平台总成 | 1     |              | 703.14  | 703.14  |      |
| 4  | 9JF3.4 | 二级平台总成 | 1     |              | 331.19  | 331.19  |      |
| 3  | 9JF3.3 | 一级平台总成 | 1     |              | 148.24  | 148.24  |      |
| 2  | 9JF3.2 | 拾拾器    | 1     |              | 167.07  | 167.07  |      |
| 1  | 9JF3.1 | 车架总成   | 1     |              | 4968.27 | 4968.27 |      |
| 序号 | 代号     | 名称     | 数量    | 材料           | 单重      | 总重      | 备注   |
|    |        |        |       |              |         |         |      |
|    |        |        |       |              |         |         |      |
|    |        |        |       |              |         |         |      |
| 标记 | 处数     | 分区     | 更改文件号 | 签名           | 年月日     |         |      |
| 设计 |        |        | 工艺    |              |         | 版本      | 阶段标记 |
| 绘图 |        |        | 标准化   |              |         | 重量      | 比例   |
| 校对 |        |        | 审定    |              |         | 047.0   | 1:30 |
| 审核 |        |        | 批准    |              |         | 共       | 张第   |
|    |        |        |       |              |         | 张       |      |

山东双佳农装科技有限公司

自动捡拾码垛运输车

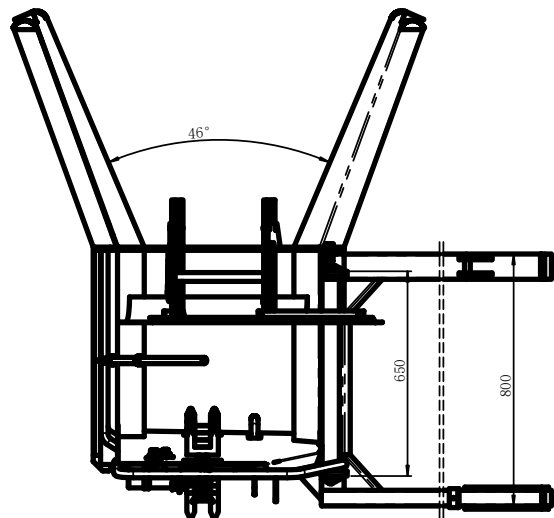
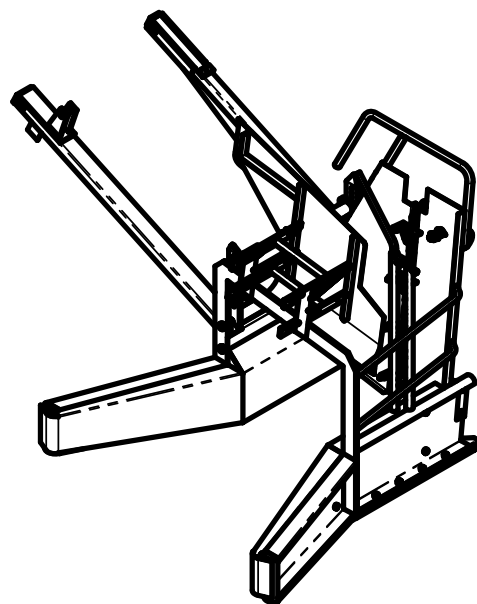
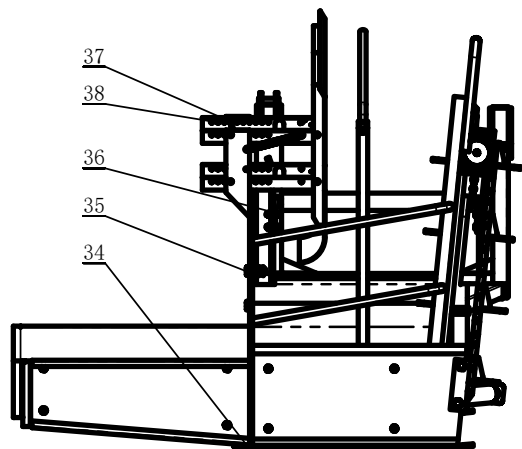
9JF3.0

**技术要求**

1. 焊接应无漏焊、虚焊、烧穿等焊接缺陷
2. 焊后清除焊渣

**1件/台**

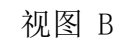
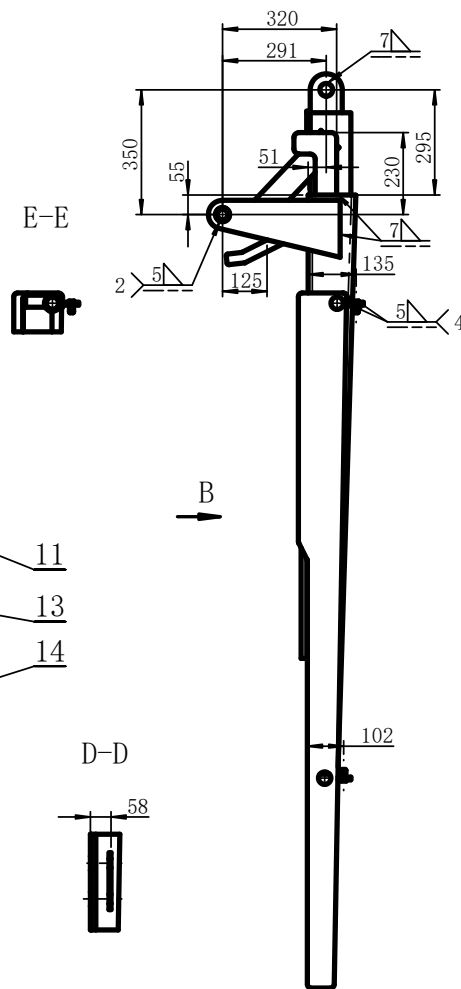
| 序号 | 代号           | 名称         | 数量 | 材料          | 单重   | 总重    | 备注 |
|----|--------------|------------|----|-------------|------|-------|----|
| 89 | 9F3.1.01-187 | 纵梁加强立柱I左   | 1  | 钢板8/Q235    | 1.55 | 1.55  |    |
| 88 | 9F3.1.01-181 | 斜拉X        | 2  | 钢板6/Q235    | 0.60 | 1.2   |    |
| 87 | 9F3.1.01-180 | 纵梁加强立柱III左 | 1  | 钢板8/Q235    | 1.47 | 1.47  |    |
| 86 | 9F3.1.01-178 | 集捆斜撑       | 2  | 钢板4/Q235    | 1.94 | 3.88  |    |
| 85 | 9F3.1.01-177 | 挡板挂板       | 2  | 钢板8/Q235    | 1.33 | 2.66  |    |
| 84 | 9F3.1.01-176 | 挡板挂板II     | 2  | 钢板8/Q235    | 1.33 | 2.66  |    |
| 83 | 9F3.1.01-171 | 侧挡套管II     | 2  | 钢管60X5/Q235 | 2.70 | 5.4   |    |
| 82 | 9F3.1.01-170 | 套管下托板      | 2  | 钢板6/Q235    | 5.76 | 11.52 |    |
| 81 | 9F3.1.01-167 | 板簧挂耳       | 12 | 钢板10/Q235   | 0.51 | 6.12  |    |
| 80 | 9F3.1.01-166 | 板簧座斜撑      | 6  | 钢板6/Q235    | 1.38 | 8.28  |    |
| 79 | 9F3.1.01-164 | 板簧支座       | 6  | 钢板8/Q235    | 4.60 | 27.6  |    |
| 78 | 9F3.1.01-162 | 斜拉IX       | 2  | 钢板6/Q235    | 0.54 | 1.08  |    |
| 77 | 9F3.1.01-154 | 纵梁加强立柱II   | 2  | 钢板8/Q235    | 2.09 | 4.18  |    |
| 76 | 9F3.1.01-153 | 二级吊耳       | 2  | 钢板12/Q235   | 0.76 | 1.52  |    |
| 75 | 9F3.1.01-132 | 二级立柱II     | 1  | 钢板8/Q235    | 3.87 | 3.87  |    |
| 74 | 9F3.1.01-151 | 传感器座III    | 1  | 钢板6/Q235    | 0.33 | 0.33  |    |
| 73 | 9F3.1.01-148 | 二级斜撑II     | 2  | 钢板6/Q235    | 3.86 | 7.72  |    |
| 72 | 9F3.1.01-144 | 二级立柱       | 1  | 钢板8/Q235    | 3.87 | 3.87  |    |
| 71 | 9F3.1.01-141 | 斜拉II       | 2  | 钢板6/Q235    | 7.48 | 14.96 |    |
| 70 | 9F3.1.01-131 | 一级安装板II    | 1  | 钢板6/Q235    | 1.05 | 1.05  |    |
| 69 | 9F3.1.01-130 | 一级安装板      | 1  | 钢板6/Q235    | 0.94 | 0.94  |    |
| 68 | 9F3.1.01-128 | 后纵梁加强板     | 2  | 钢板10/Q235   | 11.4 | 22.8  |    |
| 67 | 9F3.1.01-127 | 前纵梁加强板     | 2  | 钢板8/Q235    | 6.83 | 13.66 |    |
| 66 | 9F3.1.01-122 | 一级吊耳       | 2  | 钢板8/Q235    | 0.70 | 1.4   |    |
| 65 | 9F3.1.01-107 | 底盘后左纵梁     | 1  | 钢板8/Q345    | 95.4 | 95.4  |    |
| 64 | 9F3.1.01-188 | 纵梁加强立柱I    | 1  | 钢板8/Q235    | 1.55 | 1.55  |    |
| 63 | 9F3.1.01-179 | 纵梁加强立柱III  | 1  | 钢板8/Q235    | 1.47 | 1.47  |    |
| 62 | 9F3.1.01-108 | 底盘后右纵梁     | 1  | 钢板8/Q345    | 95.7 | 95.7  |    |
| 61 | 9F3.1.01-118 | 定位套        | 9  | 钢管40×6/Q235 | 0.08 | 0.72  |    |
| 60 | 9F3.1.01-163 | 集捆气缸座      | 2  | 钢板25/Q235   | 0.61 | 1.22  |    |
| 59 | 9F3.1.01-160 | 底盘横梁VI     | 1  | 钢板16/Q235   | 19.0 | 19.0  |    |
| 58 | 9F3.1.01-161 | 斜拉VIII     | 2  | 钢板8/Q235    | 1.83 | 3.66  |    |
| 57 | 9F3.1.01-175 | 二级气缸座      | 1  | 钢板30/Q235   | 2.06 | 2.06  |    |
| 56 | 9F3.1.01-173 | 底盘横梁VII    | 1  | 钢板8/Q345    | 11.7 | 11.7  |    |
| 55 | 9F3.1.01-174 | 斜拉XI       | 2  | 钢板8/Q235    | 8.42 | 16.84 |    |
| 54 | 9F3.1.01-172 | 集捆支承       | 2  | 钢板20/Q235   | 4.98 | 9.96  |    |
| 53 | 9F3.1.01-168 | 底盘横梁VIII   | 1  | 钢板8/Q345    | 17.1 | 17.1  |    |
| 52 | 9F3.1.01-156 | 传感器座IV     | 3  | 钢板6/Q235    | 0.34 | 1.02  |    |
| 51 | 9F3.1.01-165 | 板簧支架加强板    | 6  | 钢板5/Q235    | 1.83 | 10.98 |    |
| 50 | 9F3.1.01-169 | 套管上托板      | 2  | 钢板6/Q235    | 6.39 | 12.78 |    |
| 49 | 9F3.1.01-147 | 二级斜撑       | 2  | 钢板6/Q235    | 2.93 | 5.86  |    |
| 48 | 9F3.1.01-184 | 传感器座V      | 1  | 钢板5/Q235    | 0.35 | 0.35  |    |



1. 工作表面, 配合表面不得有碰伤、刻痕;
2. 所有装配件装配前应清洗干净, 不得有铁屑、沙粒、氧化皮等;
3. 所有螺纹紧固件必须拧紧, 可靠锁止.
4. 所有轴承安装到位后必须充分润滑.

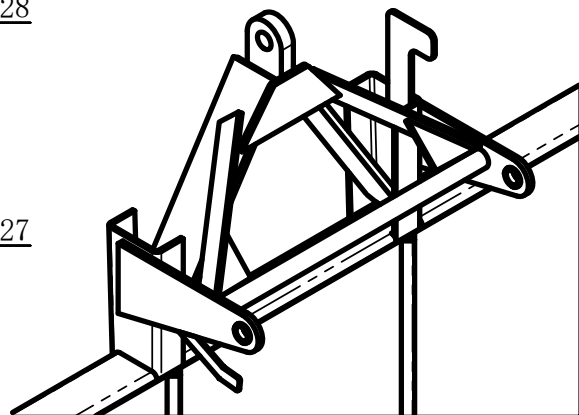
1件/台

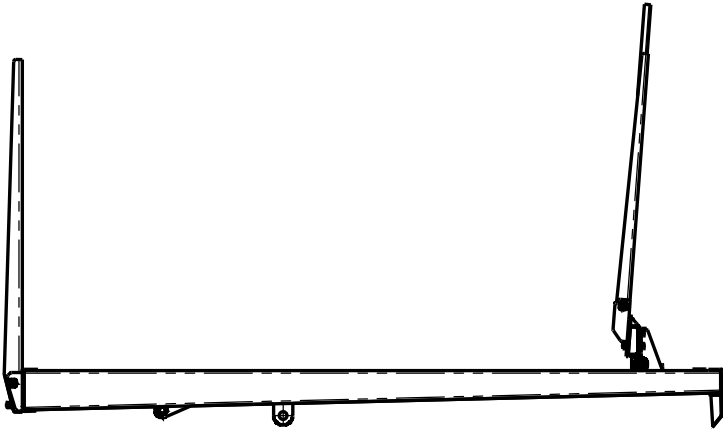
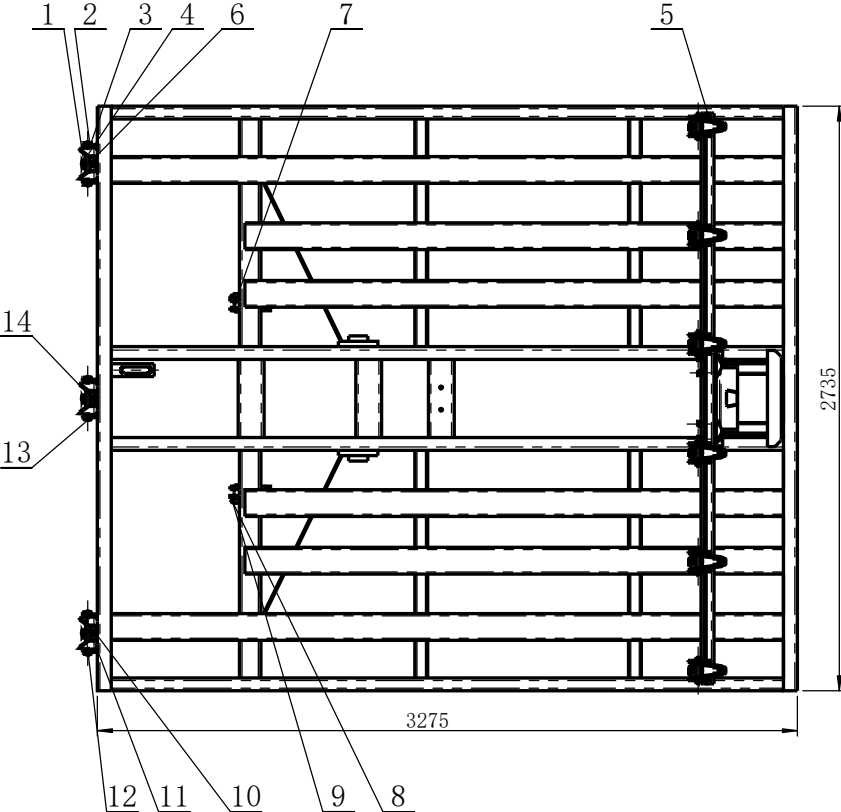
|    |                      |               |       |            |       |        |              |
|----|----------------------|---------------|-------|------------|-------|--------|--------------|
| 38 | GB/T91-2000-1.6×16   | 开口销1.6×16     | 4     |            | 0     | 0      |              |
| 37 | 9JF3.2.07-102        | 转动销           | 4     | 圆钢12/45    | 0.01  | 0.04   |              |
| 36 | GB/T5782-2000-M8×30  | 螺栓M8×30       | 4     |            | 0     | 0      |              |
| 35 | GB/T5782-2000-M16×50 | 螺栓M16×50      | 2     |            | 0     | 0      |              |
| 34 | 9JF3.2-101           | 滑板            | 2     | 钢板8/Q235   | 3.62  | 7.24   |              |
| 33 | GB/T5783-2000-M6×20  | 螺栓M6×20       | 2     |            | 0     | 0      |              |
| 32 | GB/T91-2000-4×20     | 销4×20         | 2     |            | 0     | 0      |              |
| 31 | 9JF3.2-104           | 弹簧调节螺栓        | 1     | 普通碳钢       | 0     | 0      |              |
| 30 | GB/T5782-2000-M8×25  | 螺栓M8×25       | 6     |            | 0     | 0      |              |
| 29 | GB/T95-2002-10       | 垫圈10          | 4     |            | 0     | 0      |              |
| 28 | 9JF3.2.03            | 拾拾链           | 1     |            | 13.5  | 13.56  |              |
| 27 | 9JF3.2.01            | 拾拾架           | 1     | 焊合件        | 48.5  | 48.51  |              |
| 26 | GB/T5783-2000-M16×45 | 螺栓M16×45      | 2     |            | 0     | 0      |              |
| 25 | GB/T5782-2000-M10×25 | 螺栓M10×25      | 16    |            | 0     | 0      |              |
| 24 | GB/T93-1987-16       | 垫圈16          | 4     |            | 0     | 0      |              |
| 23 | GB/T12-1988-M10×25   | 半圆头方头螺栓M10×25 | 8     |            | 0     | 0      |              |
| 22 | 9JF3.2.06            | 衬导板焊合         | 1     | 焊合件        | 10.9  | 10.94  |              |
| 21 | GB/T6170-2000        | 螺母M16         | 6     |            | 0     | 0      |              |
| 20 | GB/T 95-2002-16      | 垫圈16          | 8     |            | 0     | 0      |              |
| 19 | GB/T5783-2000-M6×30  | 螺栓M6×30       | 2     |            | 0     | 0      |              |
| 18 | 9JF3.2.04            | 拾拾控制臂         | 1     | 焊合件        | 0.72  | 0.72   |              |
| 17 | 30-50接触传感器           | 30-50接触传感器    | 1     | 30-50接触传感器 | 0.27  | 0.27   |              |
| 16 | 9JF3.2.05            | 衬导板焊合         | 1     | 焊合件        | 10.0  | 10.01  |              |
| 15 | 9JG3.2-105           | 控制臂弹簧         | 1     | 弹簧钢丝3/65Mn | 0.04  | 0.04   |              |
| 14 | GB/T 5782-2000-M6×40 | 六角螺栓M6×40     | 1     |            | 0     | 0      |              |
| 13 | GB/T6170-2000-M6     | 螺母M6          | 3     |            | 0     | 0      |              |
| 12 | 9JF3.2-103           | 控制转轴          | 1     | 圆钢12/45    | 0.05  | 0.059  |              |
| 11 | GB/T95-2002-12       | 垫圈12          | 2     |            | 0     | 0      |              |
| 10 | 9JF3.2.02            | 拾拾合           | 1     | 焊合件        | 54.8  | 54.8   |              |
| 9  | 9JF3.2.08            | 挡料棍           | 1     |            | 4.37  | 4.37   |              |
| 8  | 9JF3.2.07            | 挡料板           | 1     |            | 13.5  | 13.52  |              |
| 7  | GB/T93-1987-8        | 垫圈8           | 8     |            | 0     | 0      |              |
| 6  | GB/T6170-2000-M8     | 螺母M8          | 10    |            | 0     | 0      |              |
| 5  | GB/T95-2002-8        | 垫圈8           | 2     |            | 0     | 0      |              |
| 4  | 9JF3.2-102           | 挡料杆           | 1     | 圆钢20/Q235  | 1.02  | 1.026  |              |
| 3  | GB/T6170-2000-M10    | 螺母M10         | 13    |            | 0     | 0      |              |
| 2  | GB/T93-1987-10       | 垫圈10          | 28    |            | 0     | 0      |              |
| 1  | GB/T5782-2000-M10×40 | 螺栓M10×40      | 4     |            | 0     | 0      |              |
| 序号 | 代号                   | 名称            | 数量    | 材 料        | 单重    | 总重     | 备注           |
|    |                      |               |       |            |       |        |              |
|    |                      |               |       |            |       |        |              |
|    |                      |               |       |            |       |        |              |
| 标记 | 处数                   | 分 区           | 更改文件号 | 签 名        | 年 月 日 |        | 山东双佳农装科技有限公司 |
| 设计 | 张琦峰                  | 2017/12/6     | 工艺    |            |       |        | 拾拾器          |
| 绘图 |                      |               | 标准化   |            |       |        |              |
| 校对 |                      |               | 审定    |            |       |        |              |
| 审核 |                      |               | 批准    |            |       |        |              |
|    |                      |               |       | 版本         | 阶段标记  | 重量     | 比例           |
|    |                      |               |       | A          |       | 167.07 | 1:12         |
|    |                      |               |       | 共          | 张     | 第      | 张            |
|    |                      |               |       |            |       |        | 9JF3.2       |



1. 焊接应无漏焊、虚焊、烧穿等焊接缺陷
2. 焊后清除焊渣

1件/台

9JF3.4.01

|        |                                                                                     |  |  |  |  |  |  |  |  |  |
|--------|-------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|
| 软盘号    | 9JF3.5                                                                              |  |  |  |  |  |  |  |  |  |
| CAD    |                                                                                     |  |  |  |  |  |  |  |  |  |
|        |   |  |  |  |  |  |  |  |  |  |
| 会签     |                                                                                     |  |  |  |  |  |  |  |  |  |
|        |  |  |  |  |  |  |  |  |  |  |
| 描 图    |                                                                                     |  |  |  |  |  |  |  |  |  |
| 描 校    |                                                                                     |  |  |  |  |  |  |  |  |  |
| 旧底图登记号 |                                                                                     |  |  |  |  |  |  |  |  |  |
| 底图登记号  |                                                                                     |  |  |  |  |  |  |  |  |  |
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