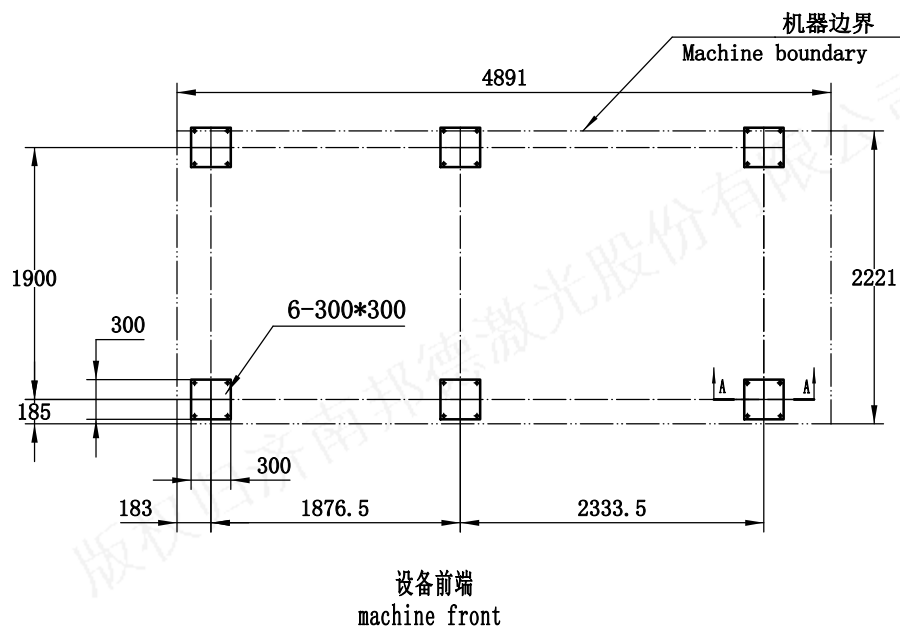


地基图  
(Foundation map)

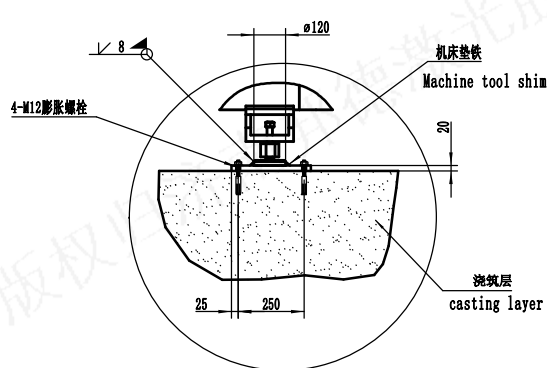
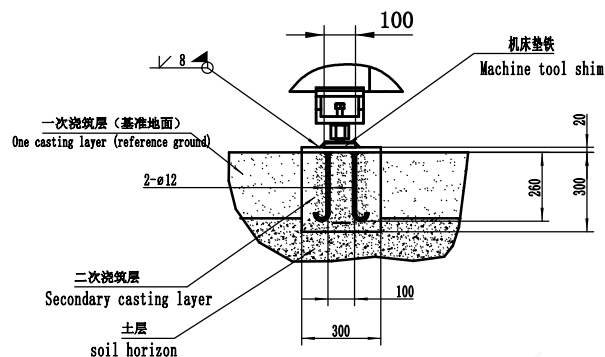


A-A 图1(A-A View 1)

浇筑混凝土层厚度 < 300mm, 需进行二次浇灌  
If the thickness of pouring concrete layer is less than 300mm, secondary pouring is required

A-A 图2(A-A View 2)

浇筑混凝土层厚度 ≥ 300mm  
Cast concrete layer thickness ≥ 300mm



技术要求

- 1、基础用425号水泥混凝土浇筑；一次浇灌地面水平度公差为3/1000；注意各固定件上平面与一次浇灌地面的尺寸关系；
- 2、若浇灌层厚度 < 300mm (A-A 图1)，在一次浇灌基准凝固合格后，放上固定件 (材质为Q235-A) 进行二次浇灌，浇灌时要保证铁板与下边水泥贴紧，并对各固定件用水准仪检查，水平高度允差2mm；
- 3、浇筑混凝土层厚度 ≥ 300mm (A-A 图2)，将固定件 (材质为Q235-A) 直接用4-M12膨胀螺栓固定在浇筑后的水平地面上，并对各固定件用水准仪检查，水平高度允差2mm；
- 4、基础用固定件为用户自备，用户应完成二次浇灌工作，固定件尺寸保证不影响接料小车正常进出；
- 5、外漏电缆可根据实际用槽钢覆盖，或根据自身情况设置地沟；
- 6、调整好机床位置和水平后，将机床垫铁与固定件焊接。

skills requirement

1. The foundation is cemented with 425 cement; the horizontal tolerance of the first watering is 3/1000; pay attention to the dimensional relationship between the upper plane of each fixing member and the watering ground;
2. If the thickness of the casting layer is less than 300mm (A-A View 1), after the primary solidification is qualified, place fixed parts (Material: Q235-A) for secondary irrigation. When casting, make sure that the iron plate is attached to the cement below, and check the level of each fixed part. The horizontal height difference is 2mm.
3. When pouring concrete layer thickness is ≥ 300mm (A-A View 2), fix fixed parts (Material: Q235-A) directly on the horizontal ground after pouring with 4-m12 expansion bolt, and check each fixed parts with level, with the tolerance of horizontal height 2mm;
4. The fixed parts for the foundation shall be provided by the user, and the user shall complete the secondary irrigation work. The size of the fixed parts shall not affect the normal access of the material receiving trolley.
5. The outer leakage cable can be covered with channel steel according to the actual situation, or the ground groove can be set according to its own situation;
6. After adjusting the position and level of the bed, weld the iron of the machine mattress to the fixture.

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阶段标记		Foundation map
审核		i7-V3.5-DJ
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