

# **Разработка металлических моделей**

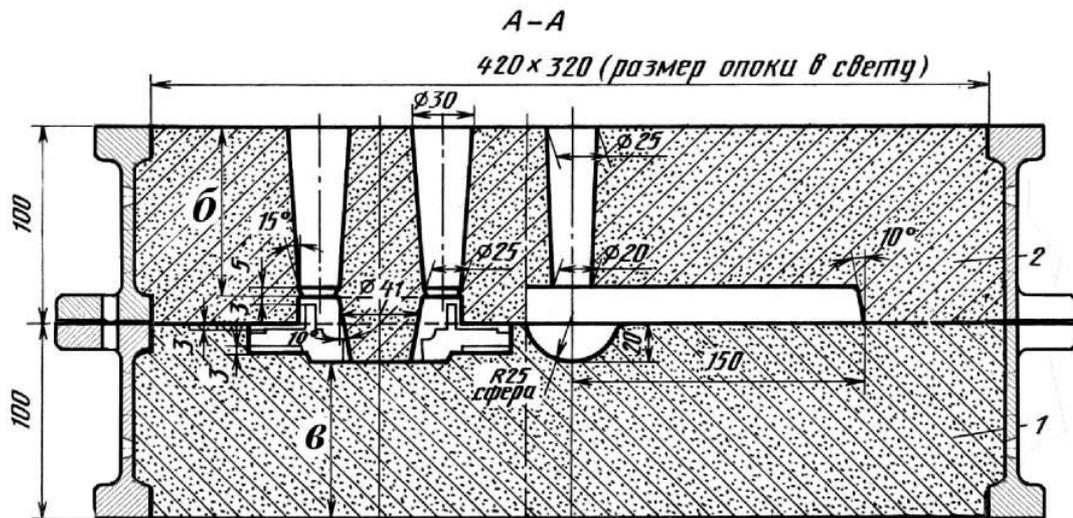
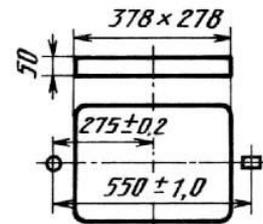
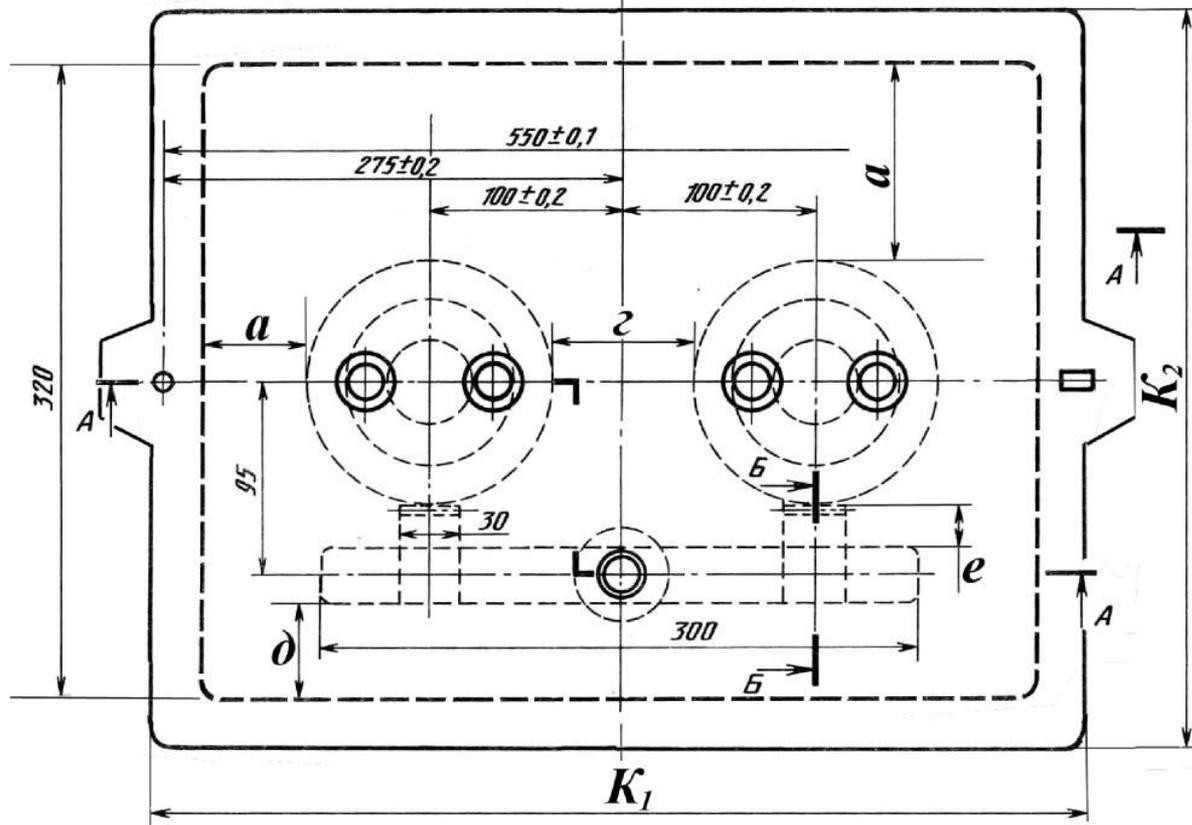


Схема врезки моделей  
верха и низа в металли-  
ческую модельную плиту

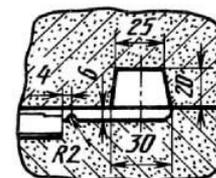


1. Форма низа  
2. Форма верха

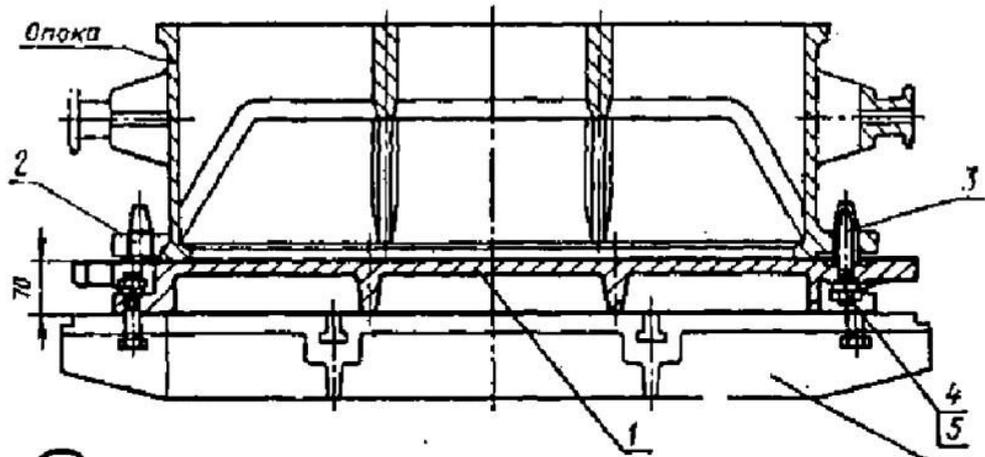
1. Материал отливки чугун.
2. При изготовлении модельного комплекта учесть:
  - 2.1. Усадку 1%, в проставленных размерах усадку не учитывать.
  - 2.2. Формовочные уклоны 3°.
3. Неуказанный припуск на механическую обработку - 3 мм.



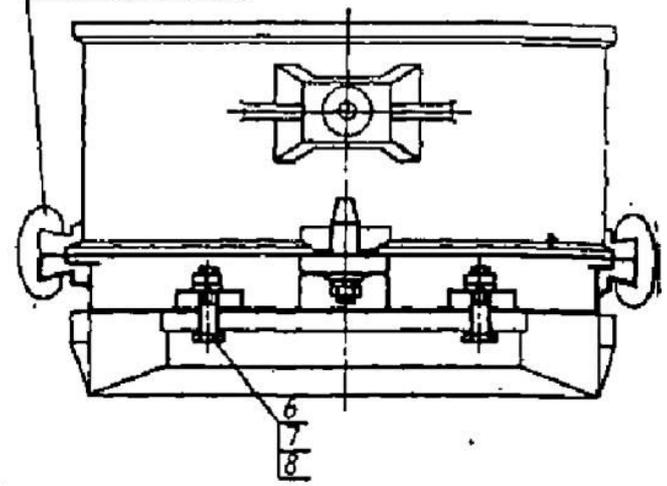
Б-Б



A-A

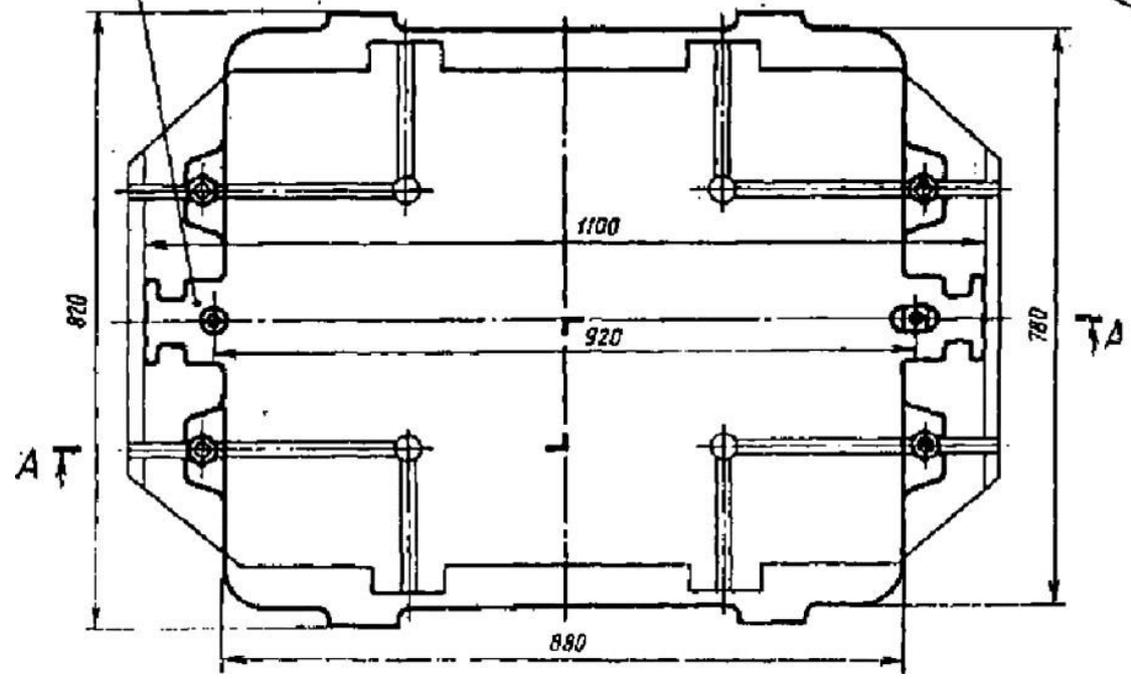


Скоба крепежная

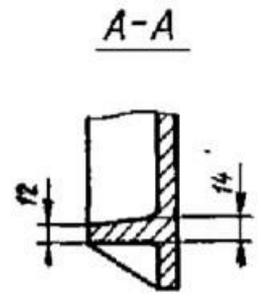
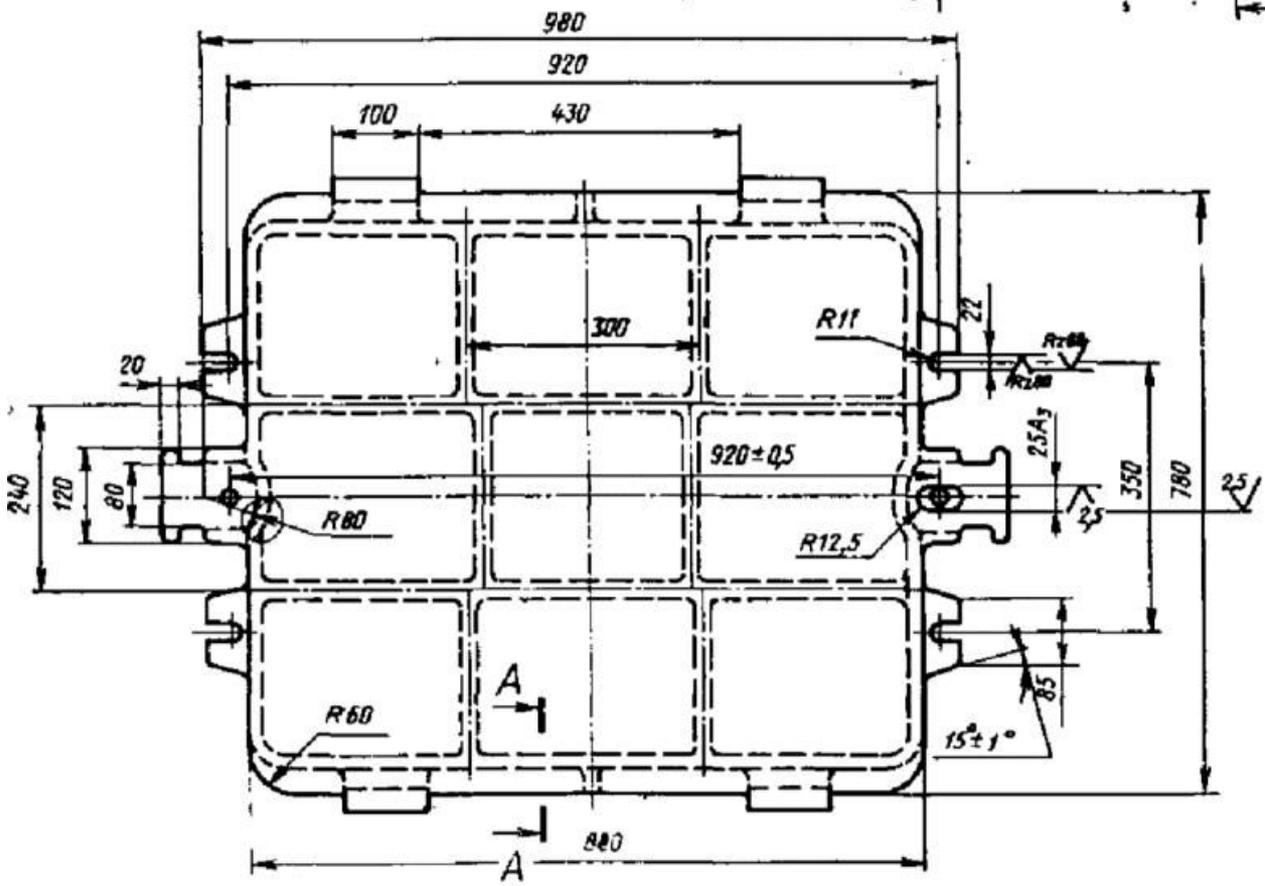
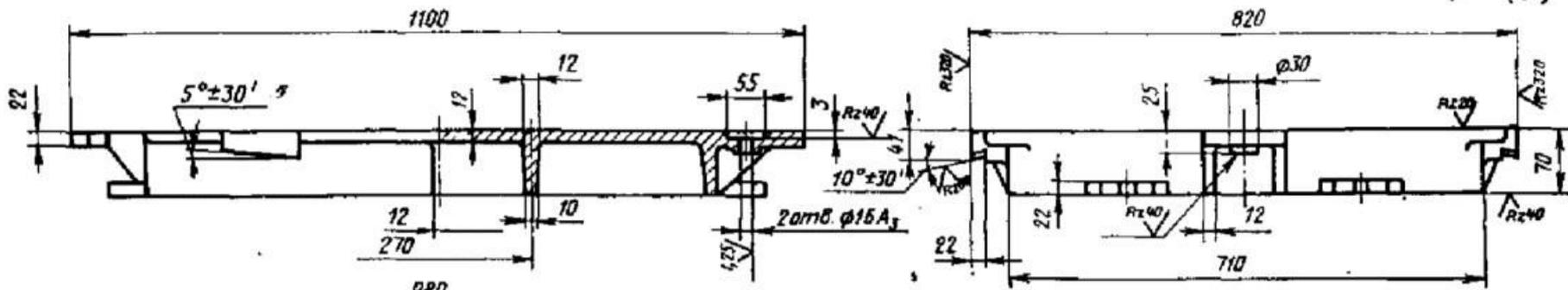


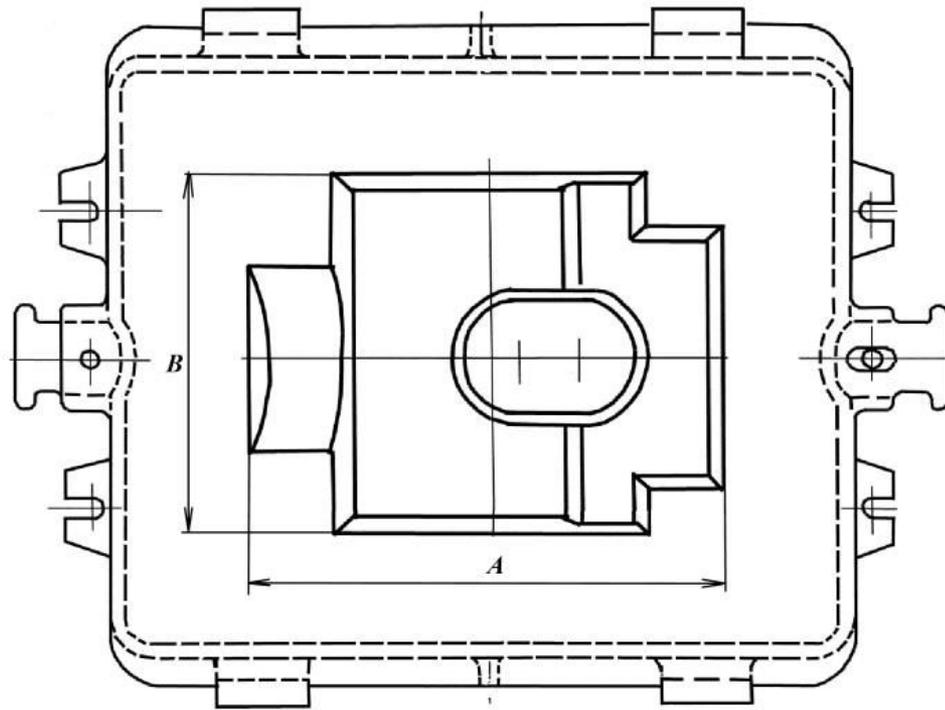
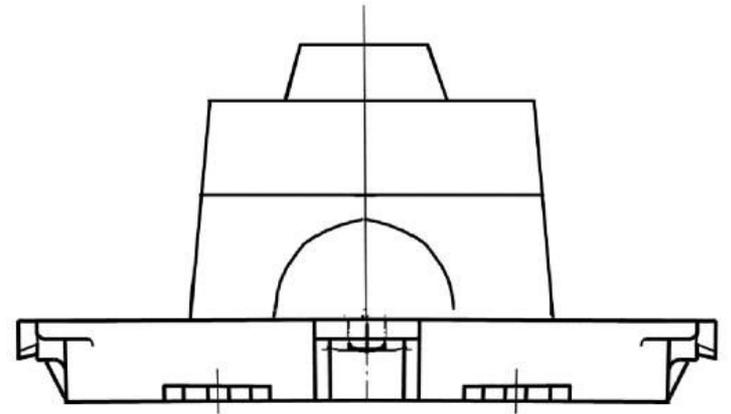
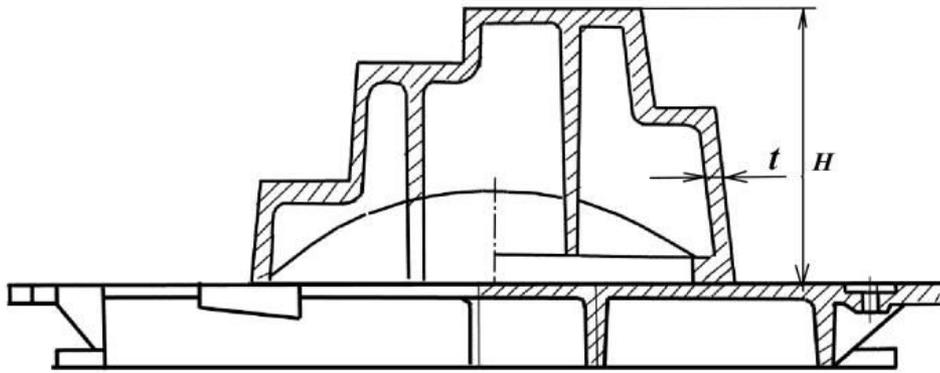
Стол формовочной машины

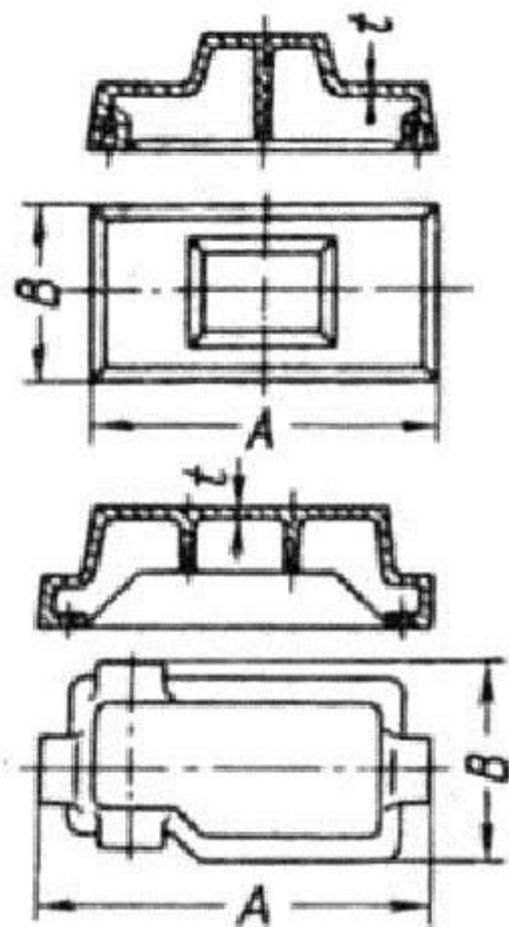
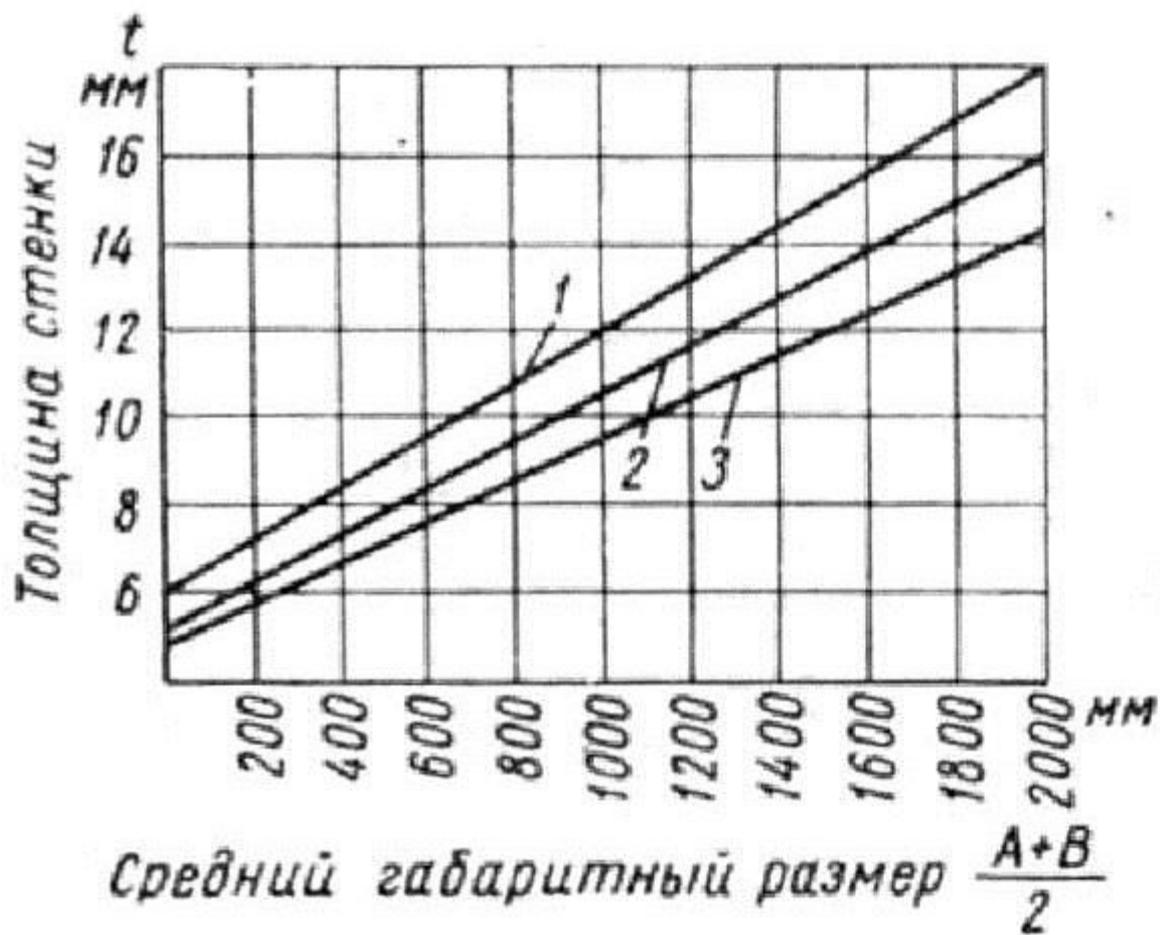
п.2



✓ (✓)





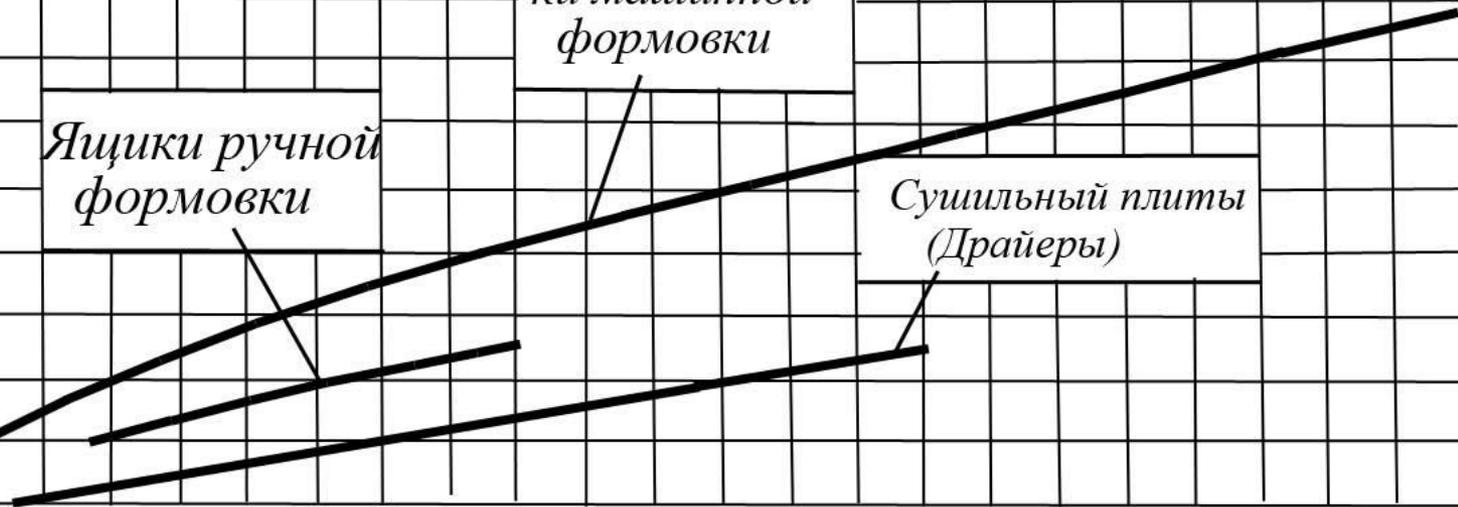


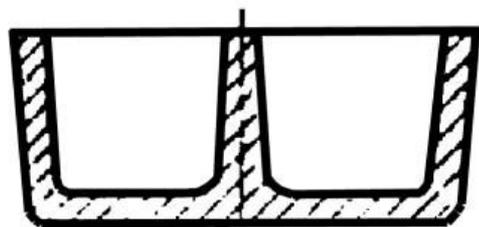
n, мм	h, мм	C, мм	t, мм	Средний габаритный размер, мм																				
				100	200	300	400	500	600	700	800	900	1000	1100	1200	1300	1400	1500	1600	1700	1800	1900	2000	2100
5	30	100	26																					
				25																				
				24																				
	28	90		23																				
				22																				
4	26	80		21																				
				20																				
	24	70		19																				
				18																				
	22	60		17																				
3	20	50		16																				
				15																				
	18	40		14																				
				13																				
	16	36	42	12																				
3	14	28	24	11																				
				10																				
	12	20		9																				
			8																					
			7																					
			6																					

Модели и ящики машинной формовки

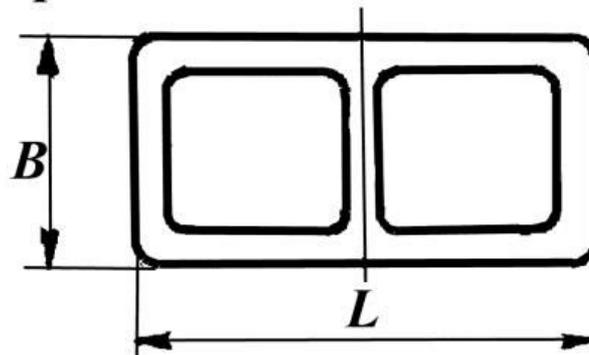
Ящики ручной формовки

Сушильные плиты (Драйеры)



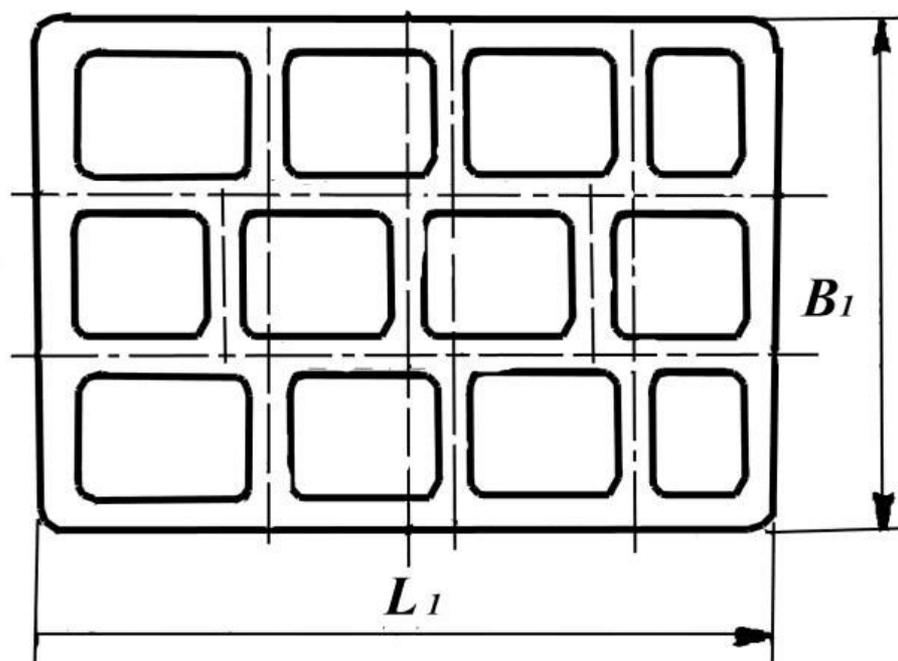
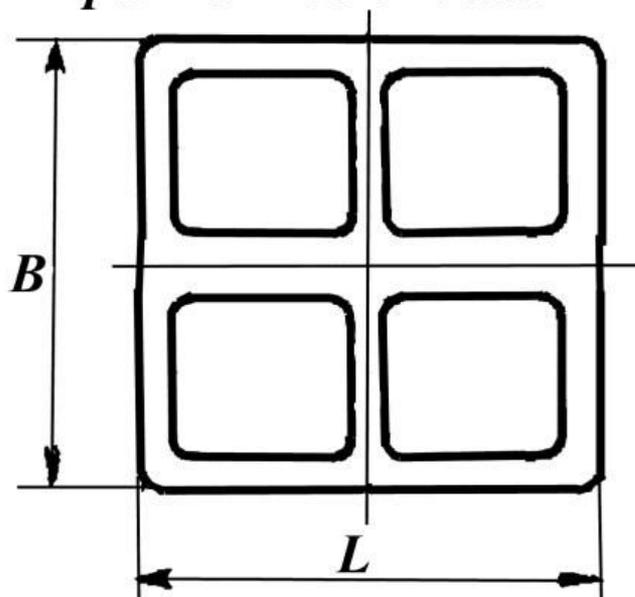


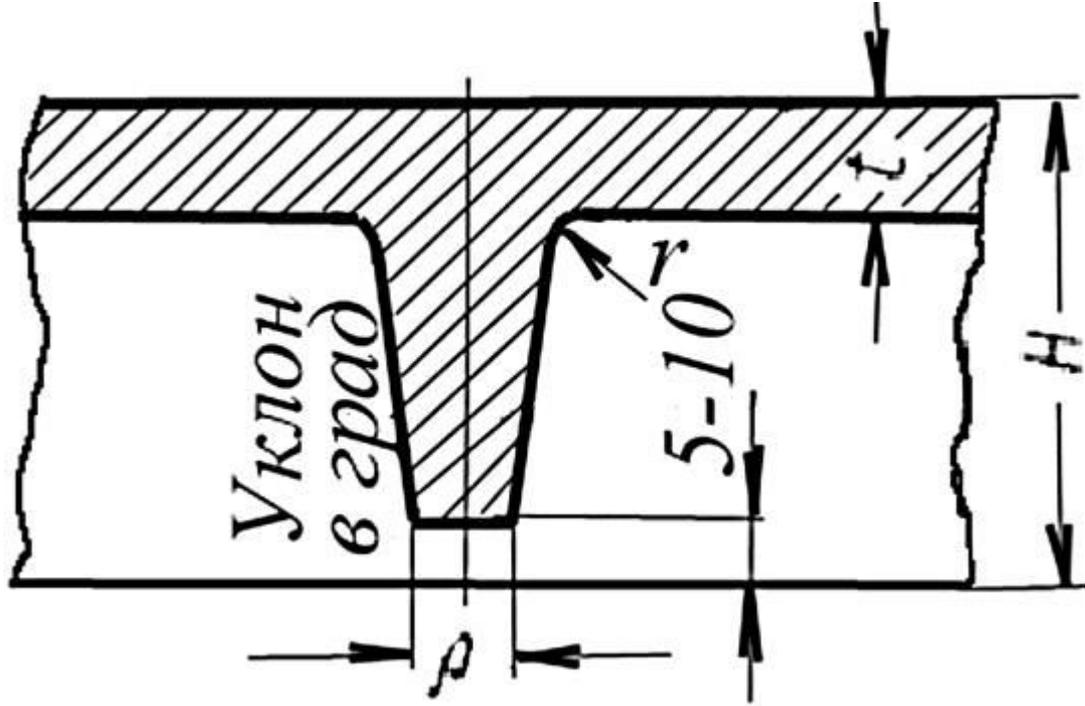
*При  $L$  до 320 и  $B$  до 160 мм*

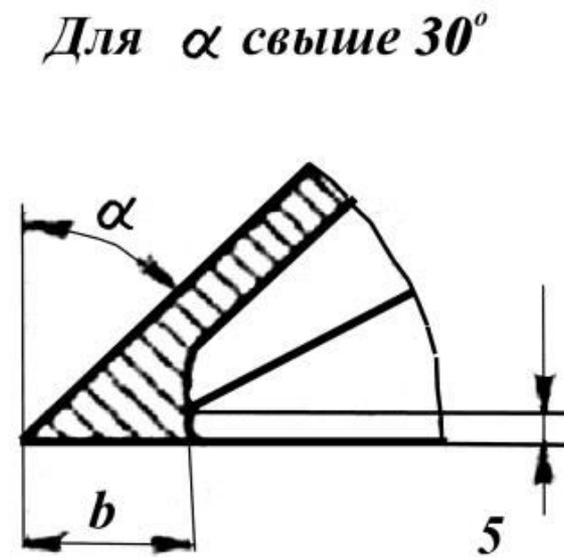
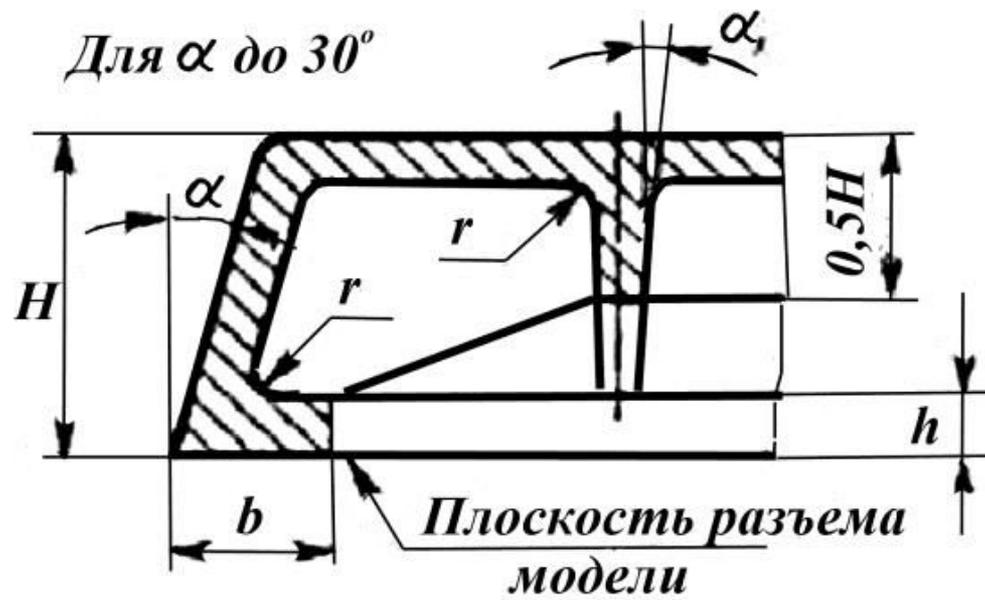


*При  $L_1$  и  $B_1$  св 320 мм*

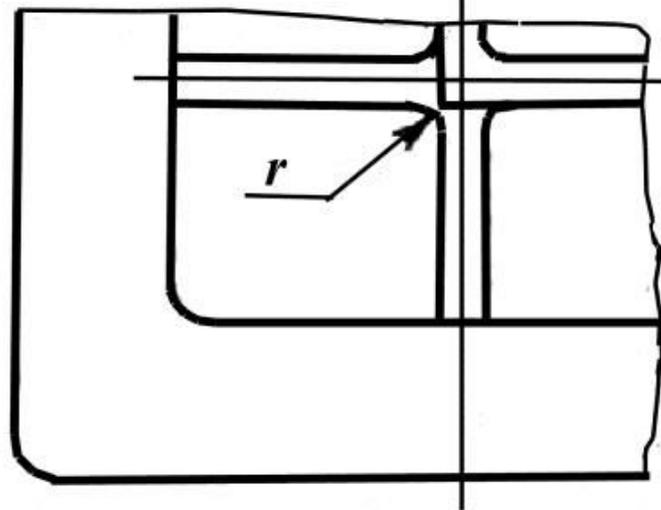
*При  $L$  и  $B$  до 320 мм*



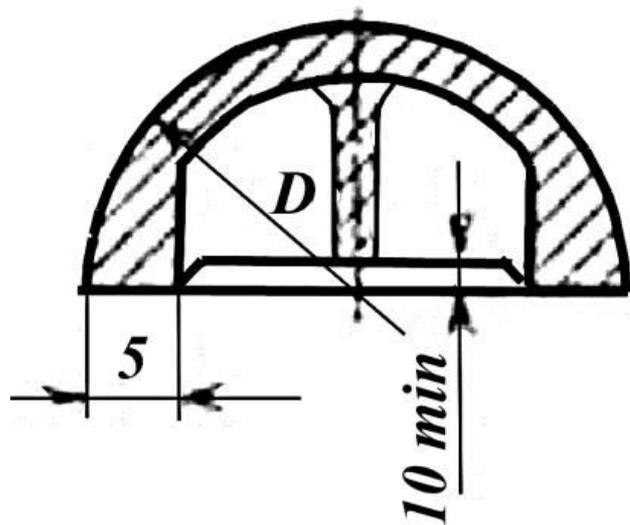




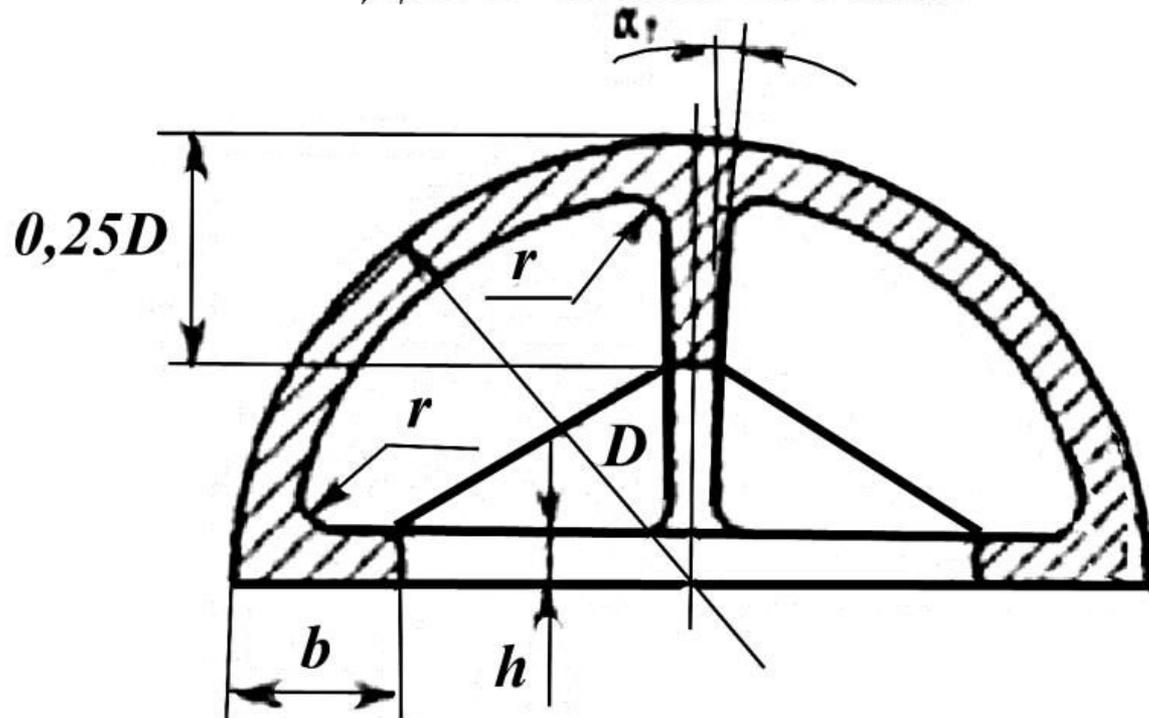
Вид А

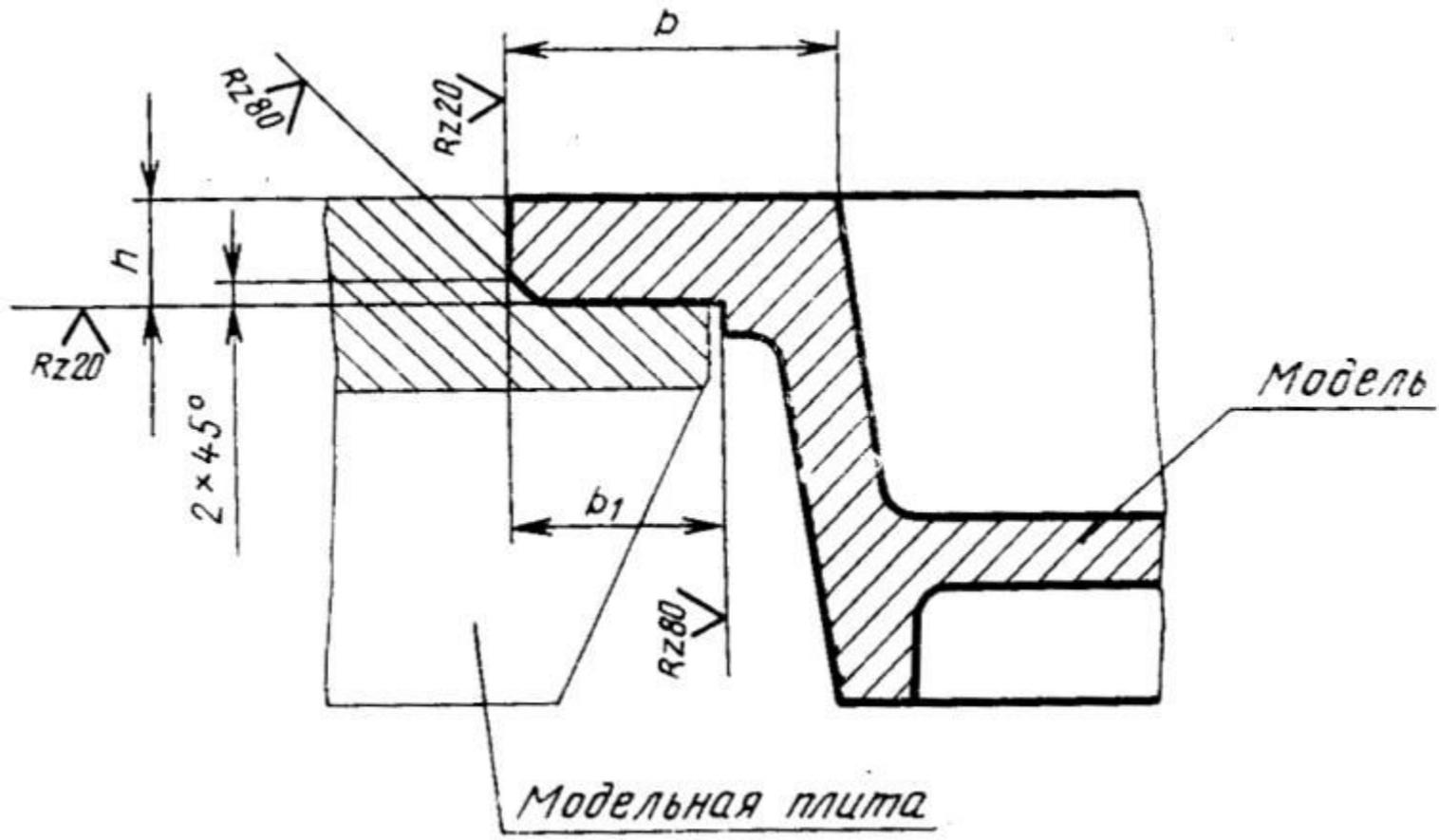


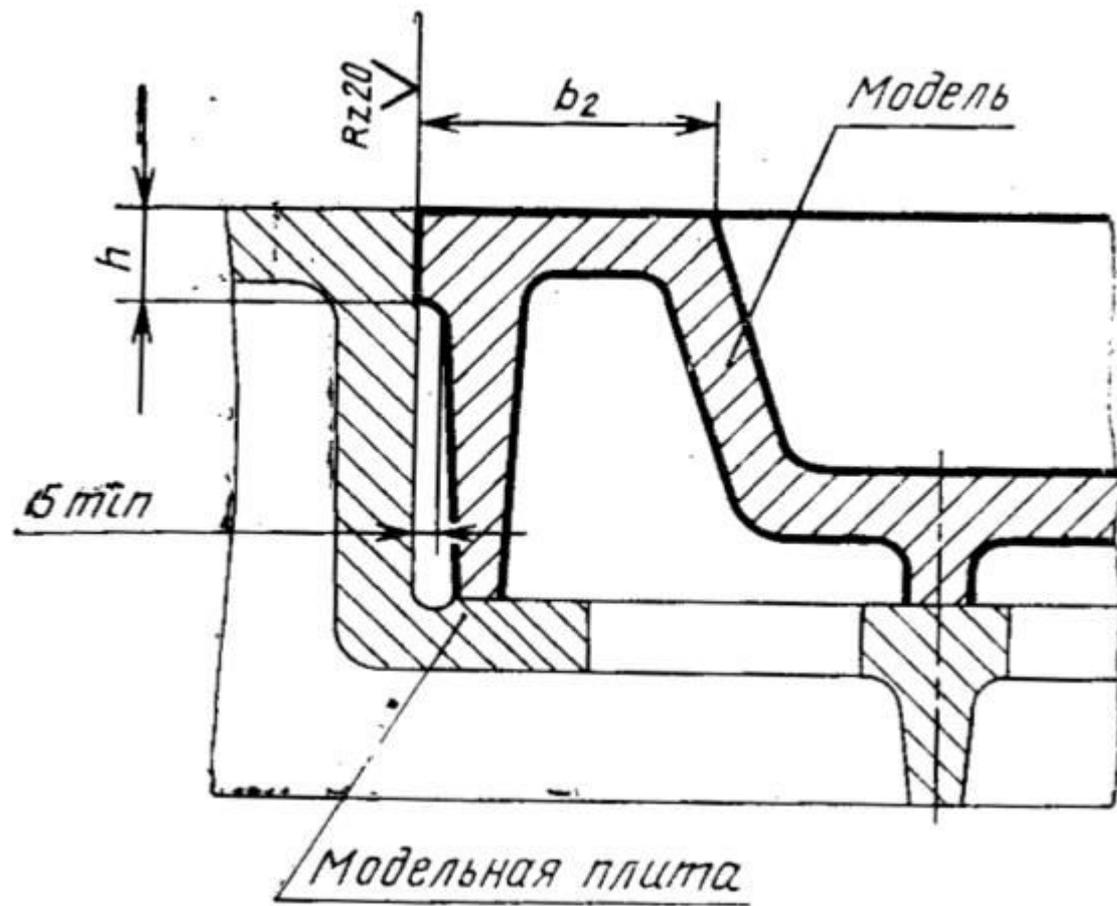
Для  $D$  до 250 мм



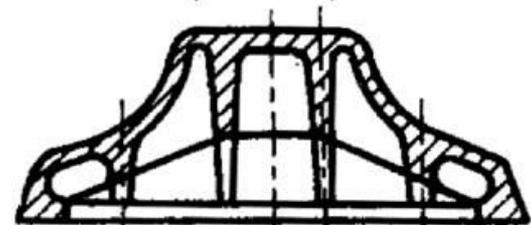
Для  $D$  свыше 250 мм



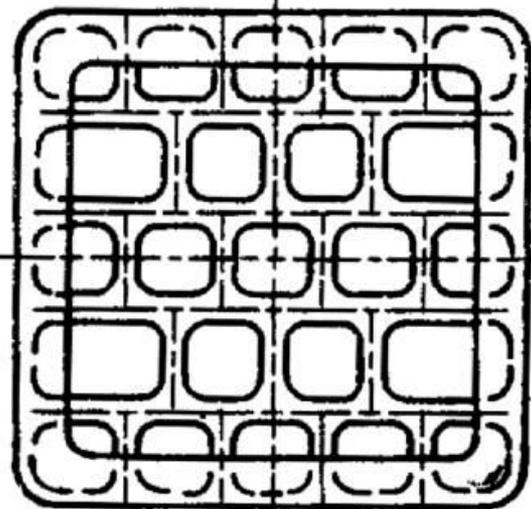




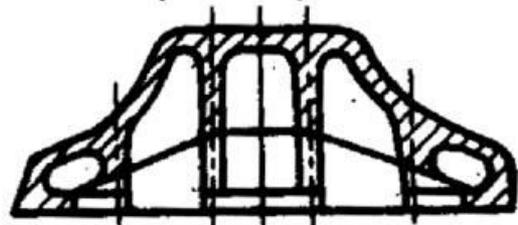
Пример 1



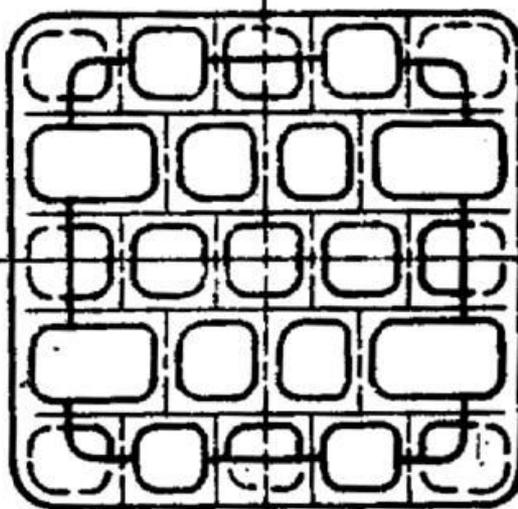
Вид А



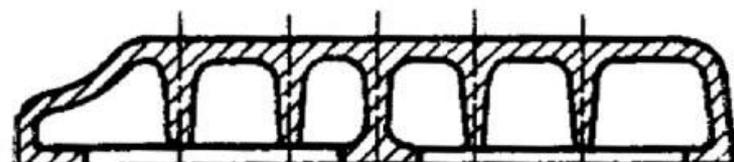
Пример 2



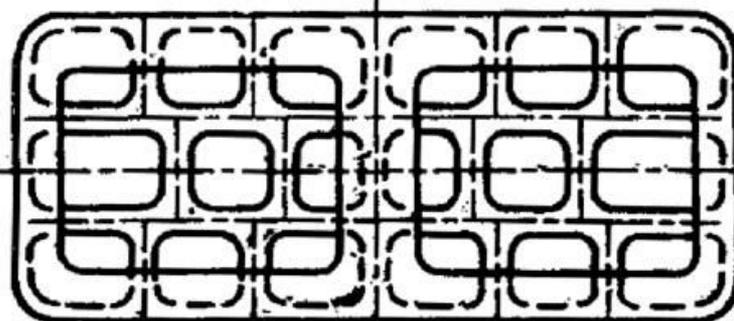
Вид А



Пример 3

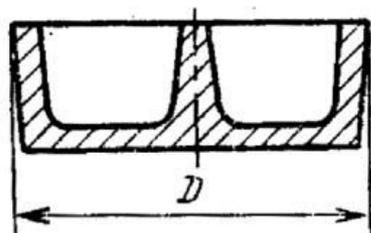


Вид А

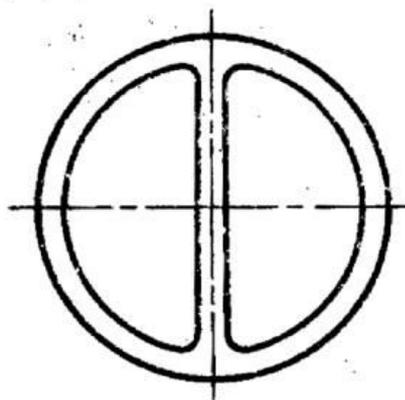


Пример 1

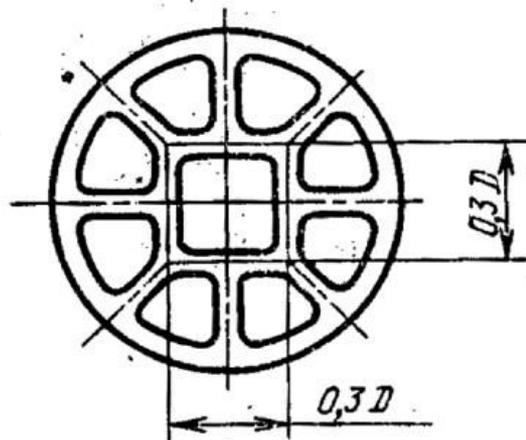
Для  $D$  св. 250 до 400 мм



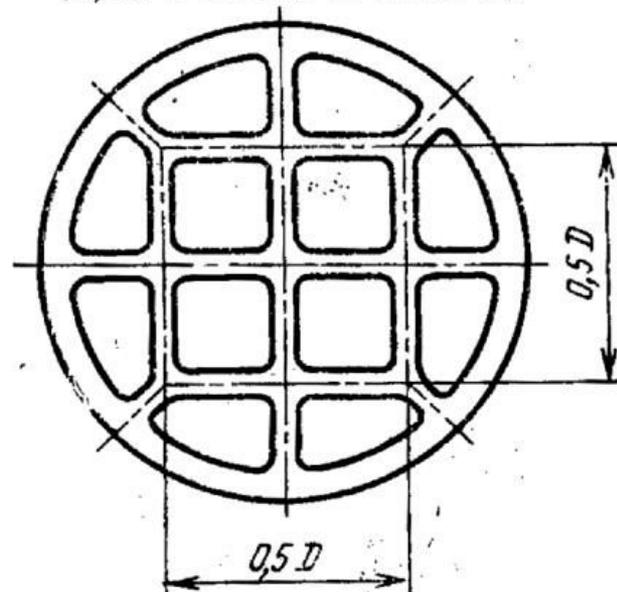
Для  $D$  св. 160 до 250 мм



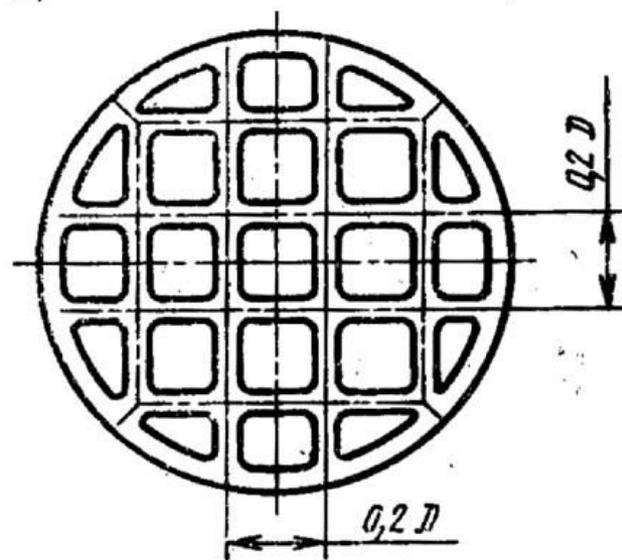
Для  $D$  св. 400 до 630 мм



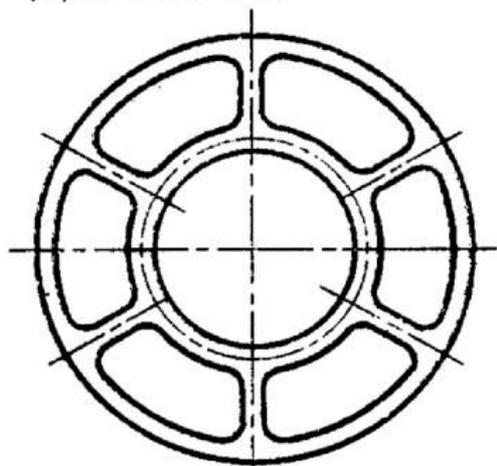
Для  $D$  св. 630 до 1000 мм



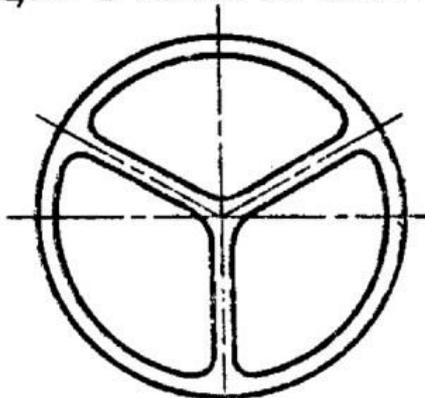
Для  $D$  св. 1000 до 2000 мм



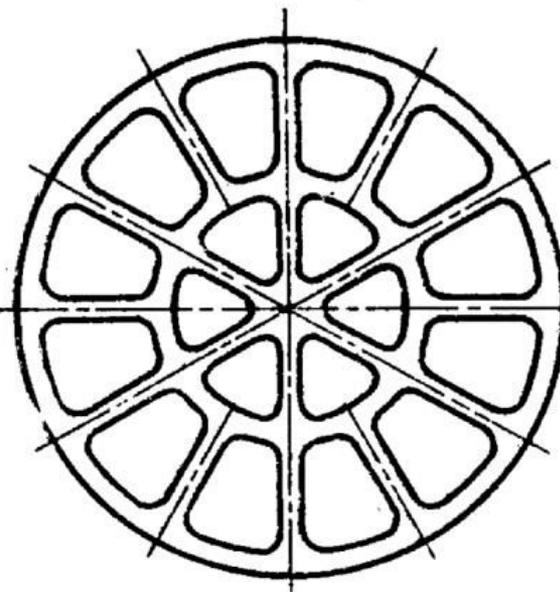
Для  $D$  св. 250 до 400 мм



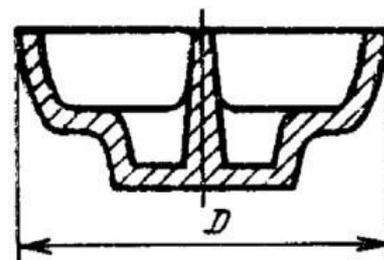
Для  $D$  св. 160 до 250 мм



Для  $D$  св. 630 до 1000 мм

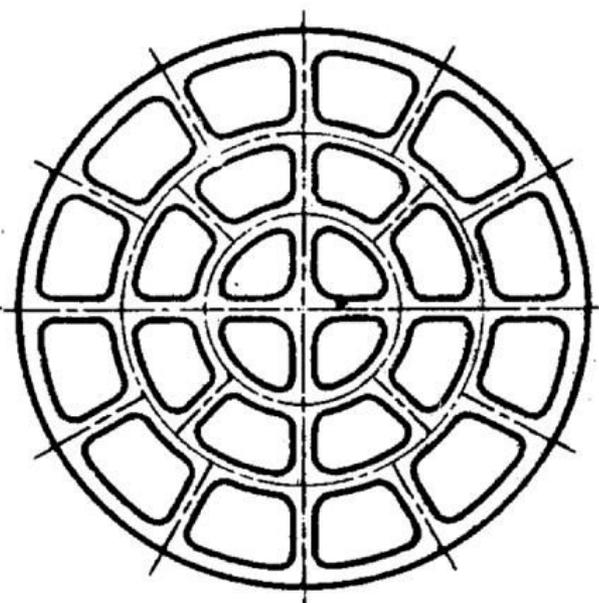
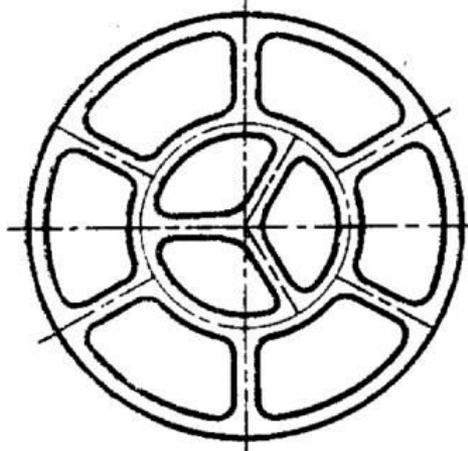


Пример 2



Для  $D$  св. 1000 до 2000 мм

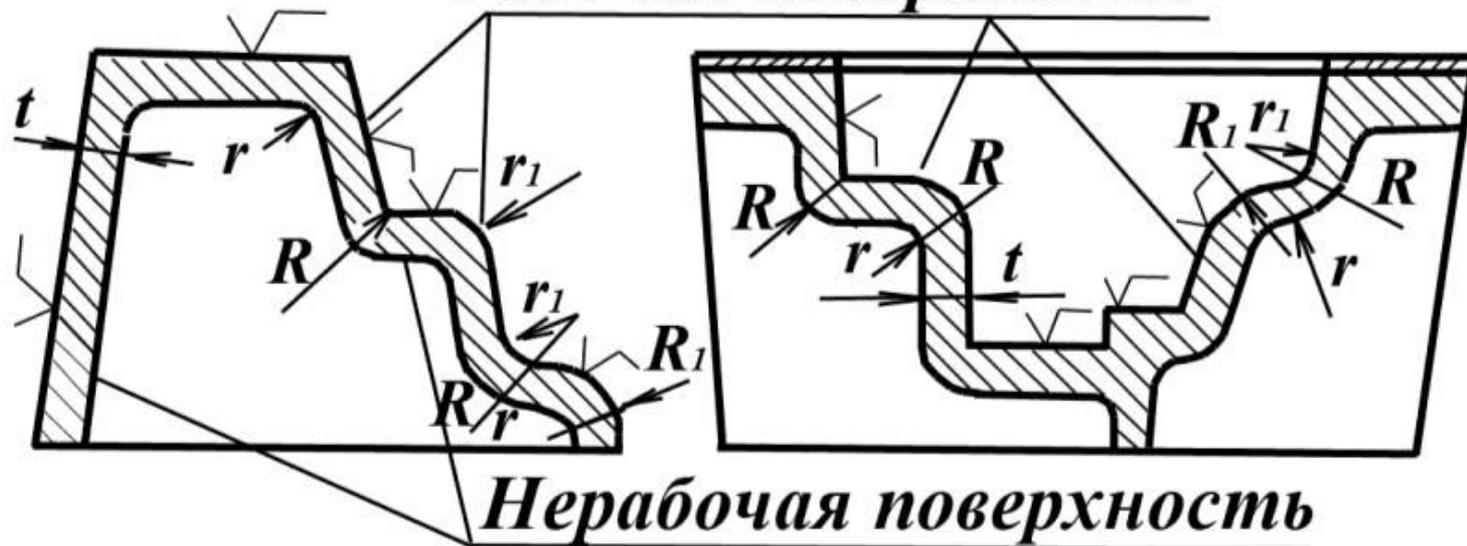
Для  $D$  св. 400 до 630 мм



*Модель*

*Стержневой ящик*

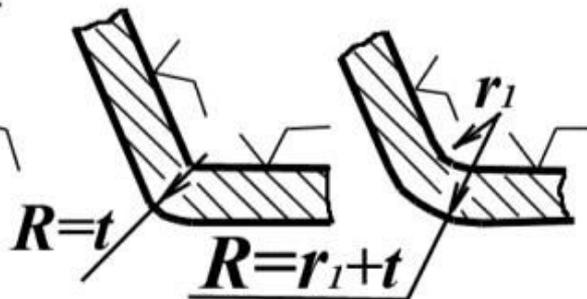
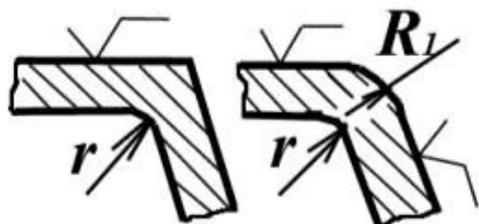
*Рабочая поверхность*



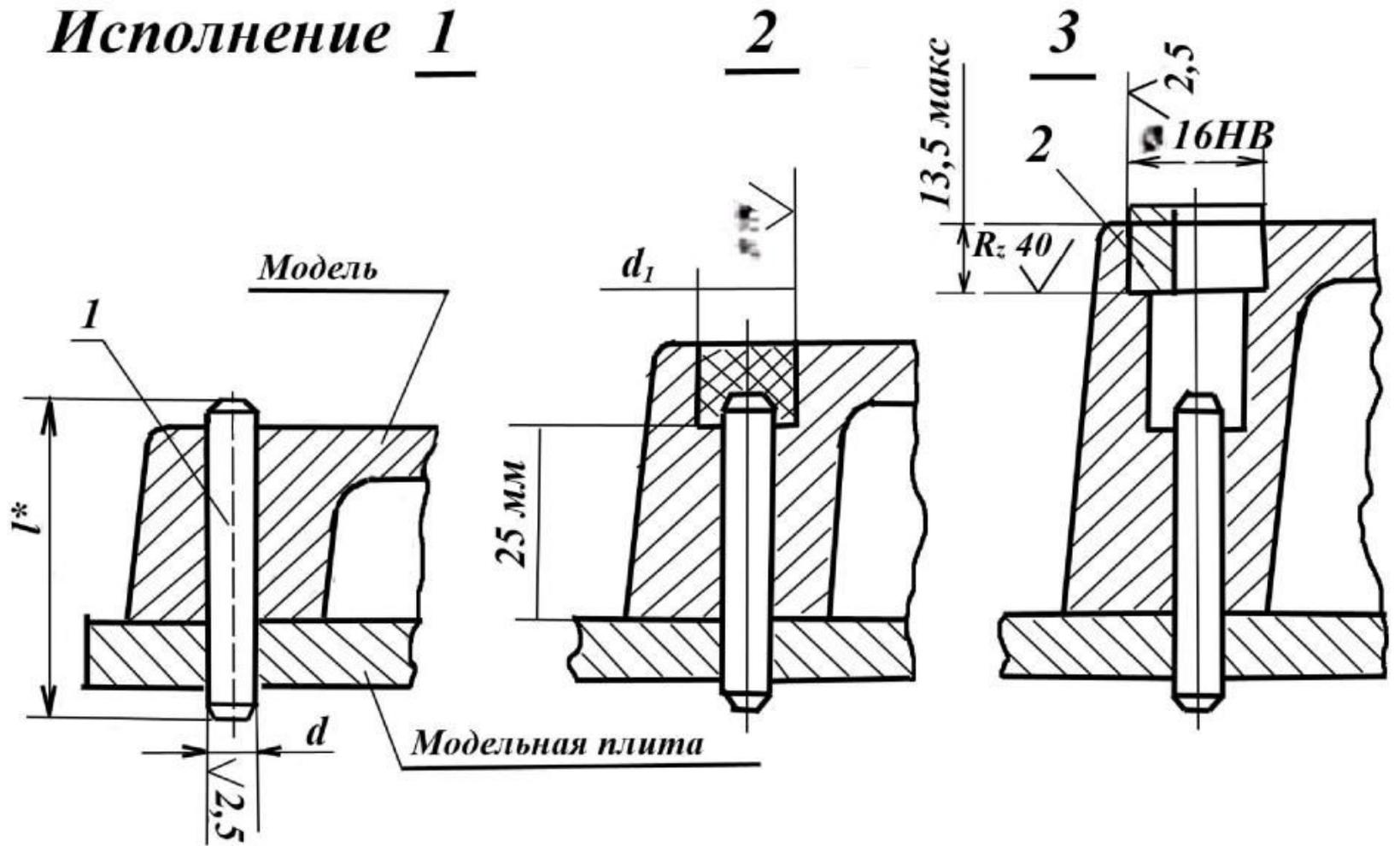
*Тип I*

*Тип II*

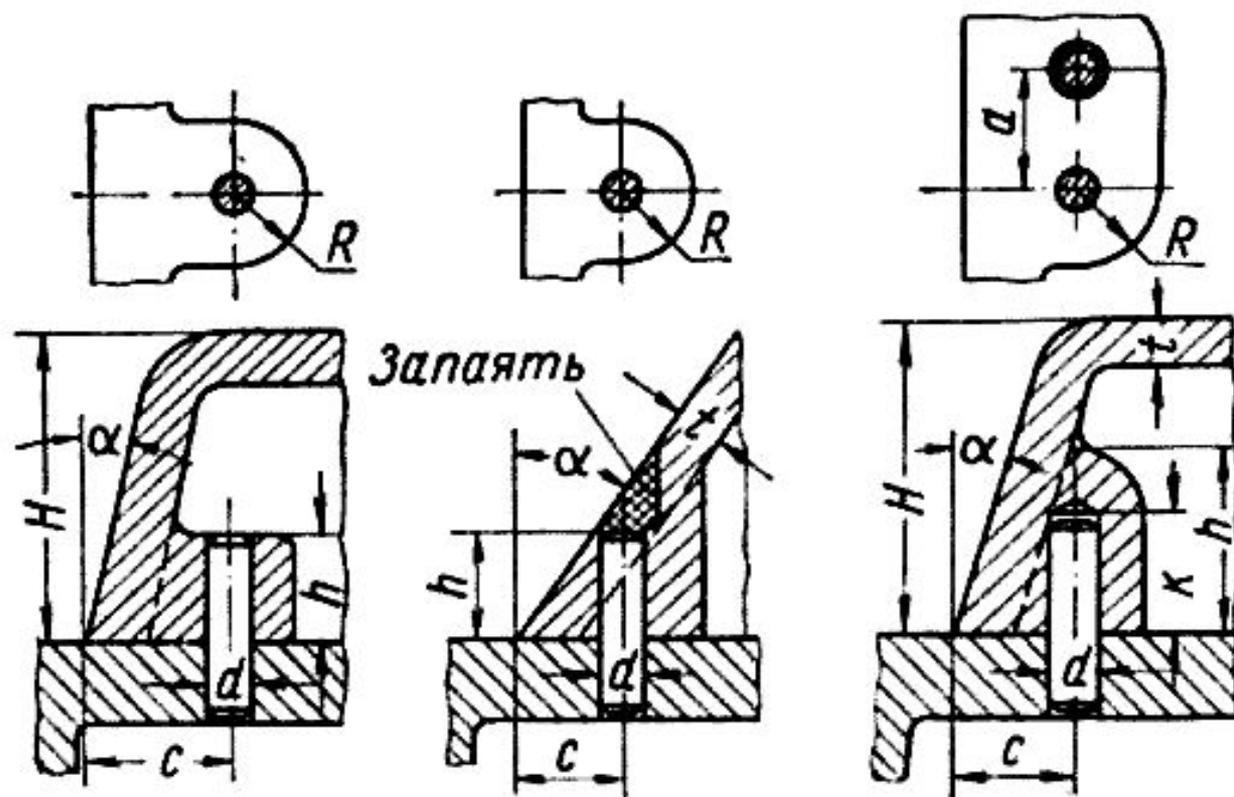
*Тип III*



# Исполнение 1

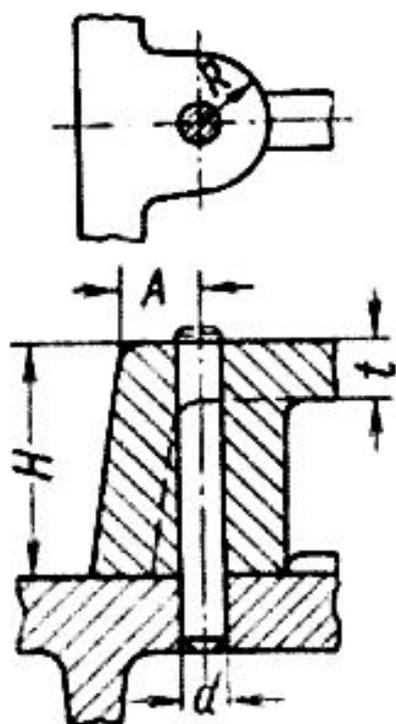


Для моделей с толщиной стенки  $t=6\div 20$  мм, при  $H > 6t$   
 Тип I  $\alpha \leq 10^\circ$     Тип II  $\alpha > 10^\circ$     Тип III  $\alpha \leq 45^\circ$

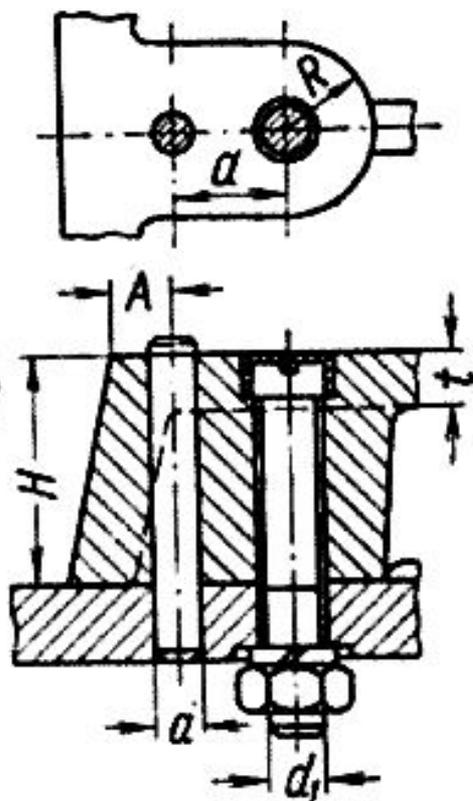


Для моделей с толщиной стенки  $t=6\div 20\text{мм}$ , при  $H < 6t$

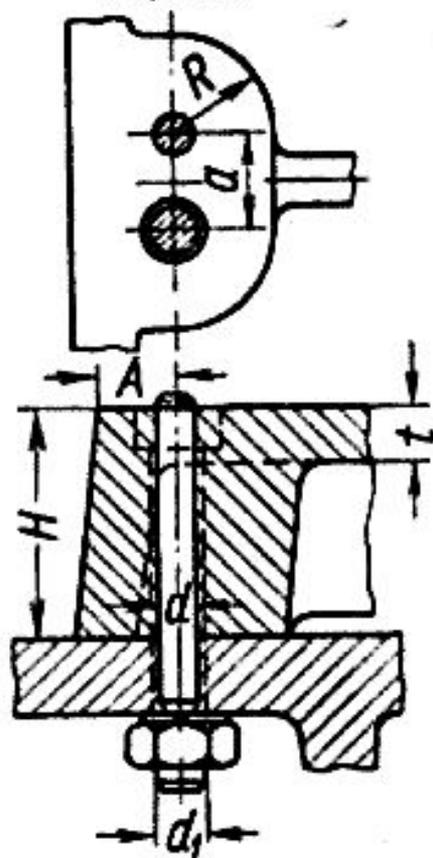
Тип I



Тип II

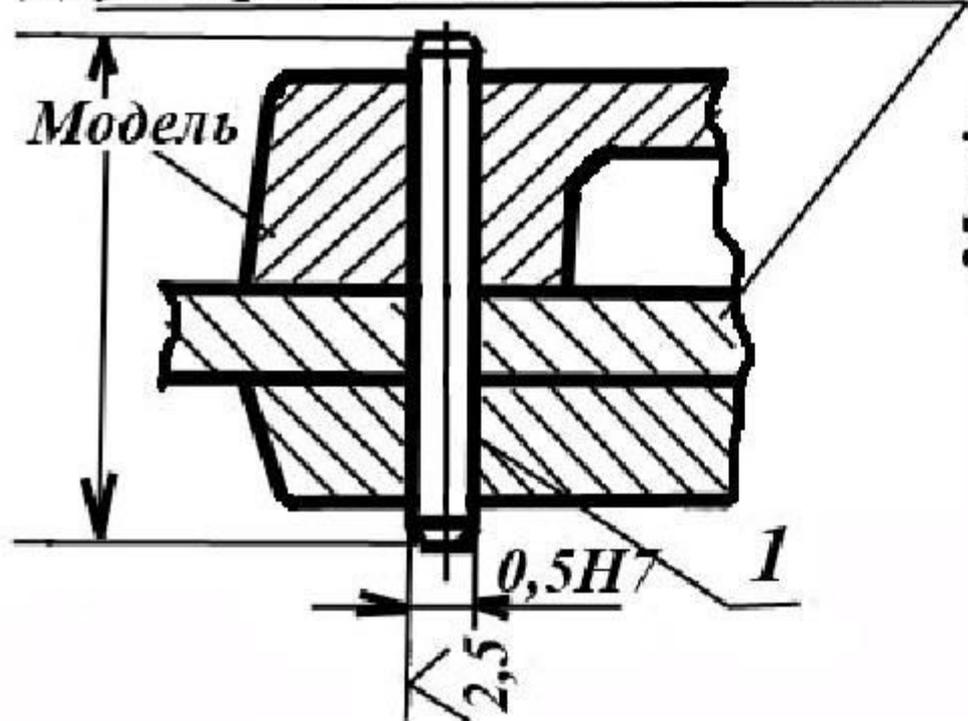


Тип III

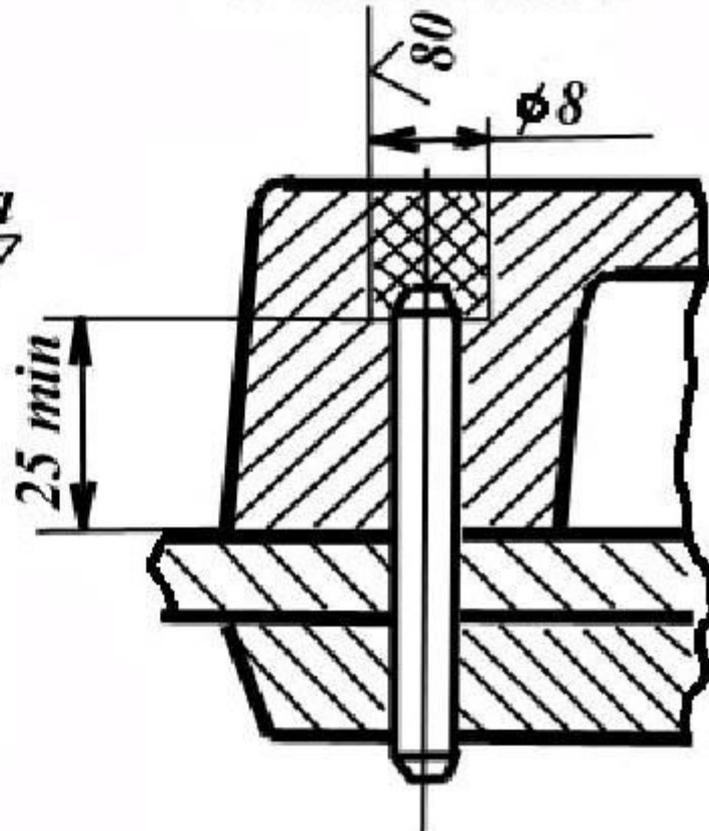


### Исполнение 1

Двусторонняя модельная плита

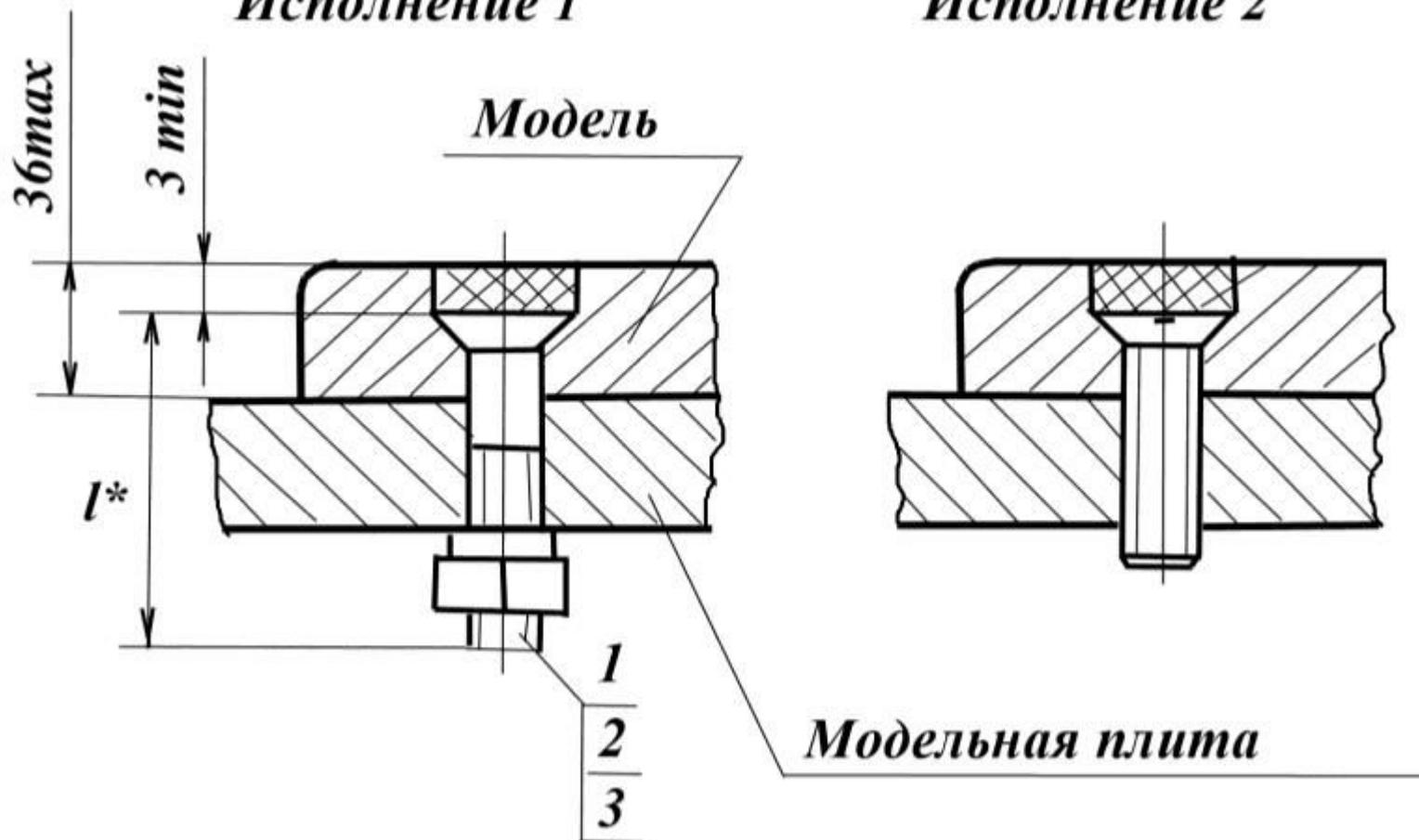


### Исполнение 2



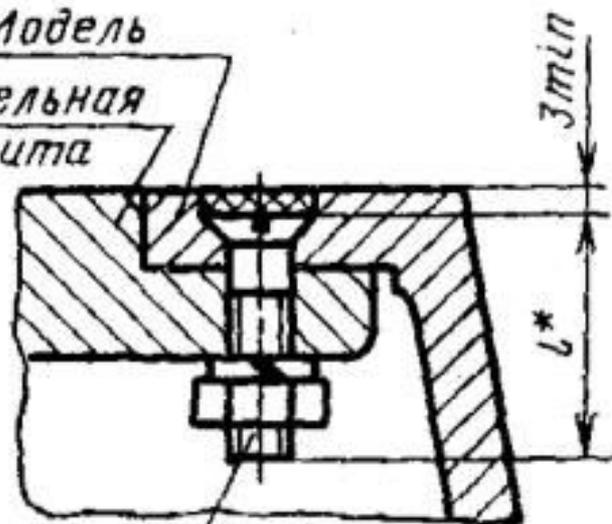
*Исполнение 1*

*Исполнение 2*



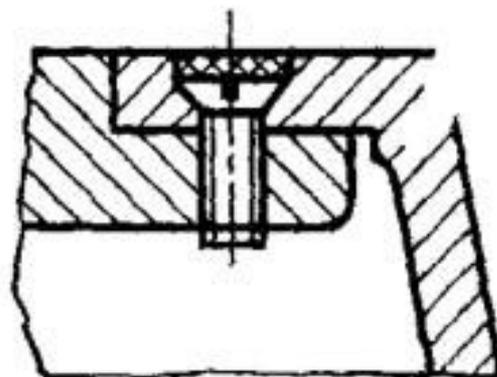
Исполнение 1

Модель  
Модельная  
плита

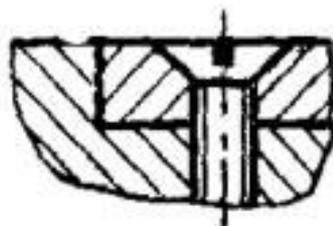


- 1
- 2
- 3

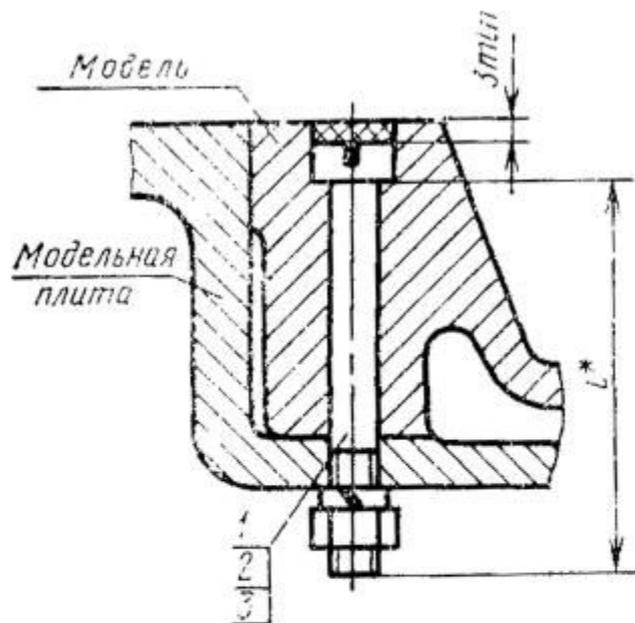
Исполнение 2



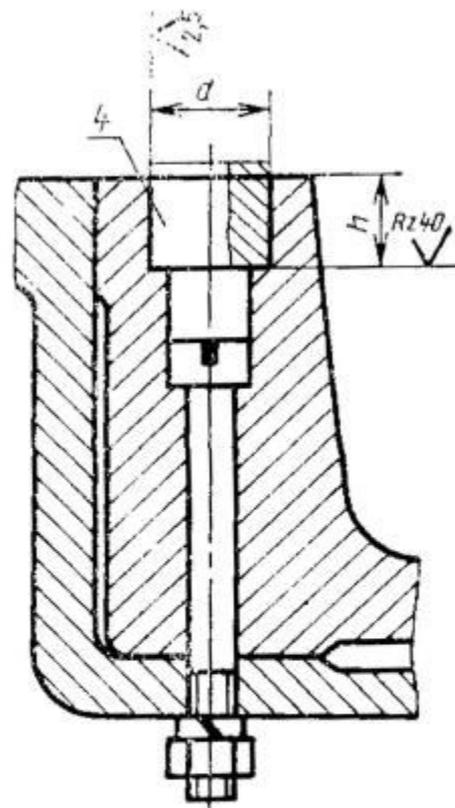
Исполнение 3



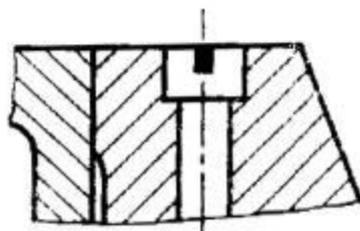
Исполнение 1



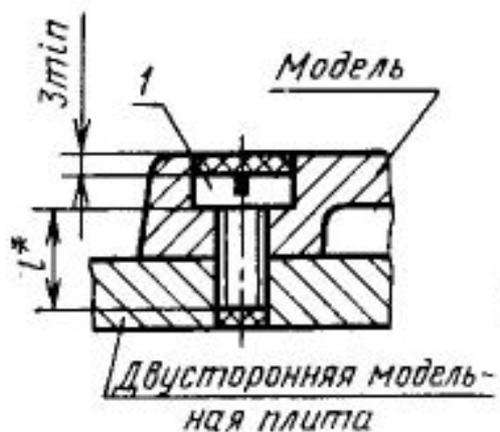
Исполнение 2



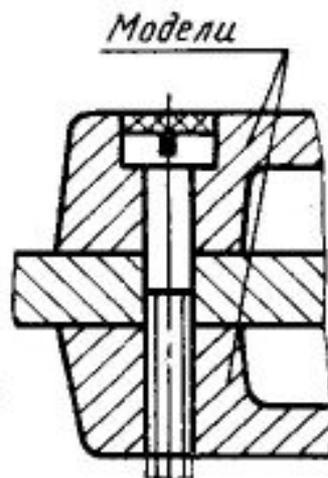
Исполнение 3



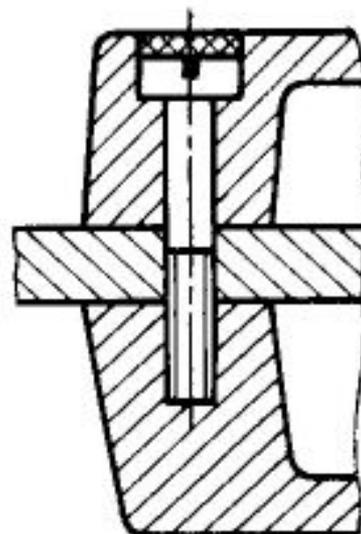
Исполнение 1



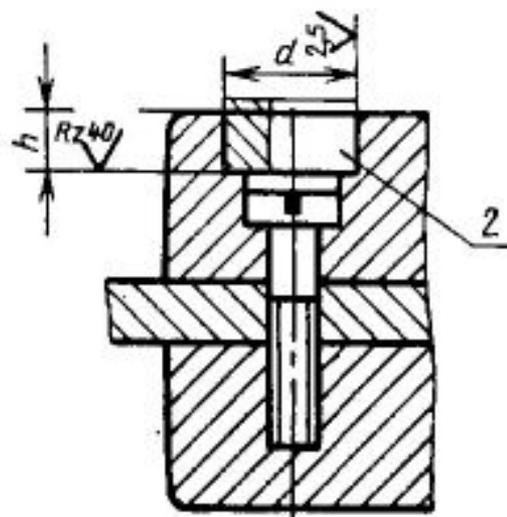
Исполнение 2



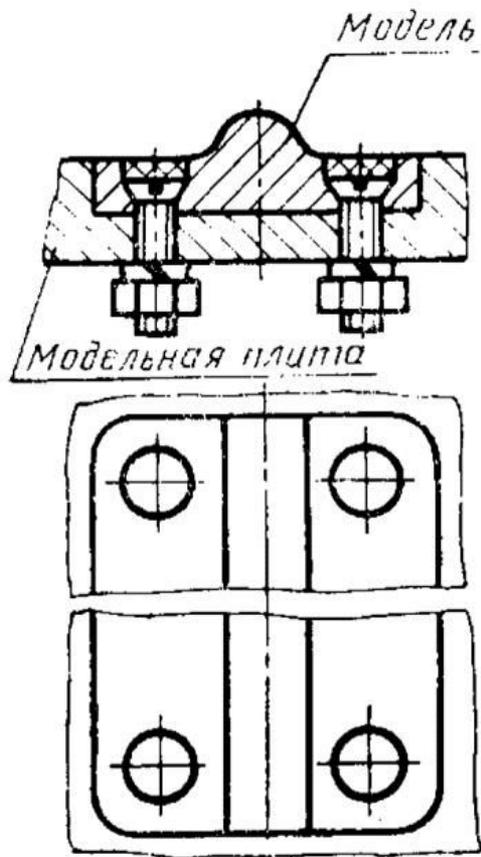
Исполнение 3



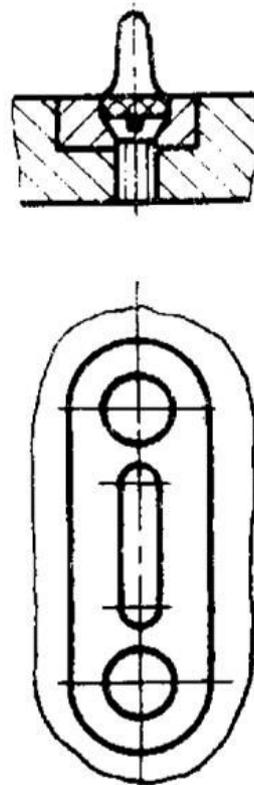
Исполнение 4



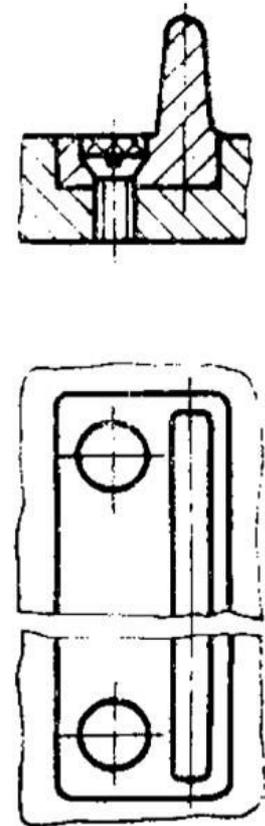
Пример 1



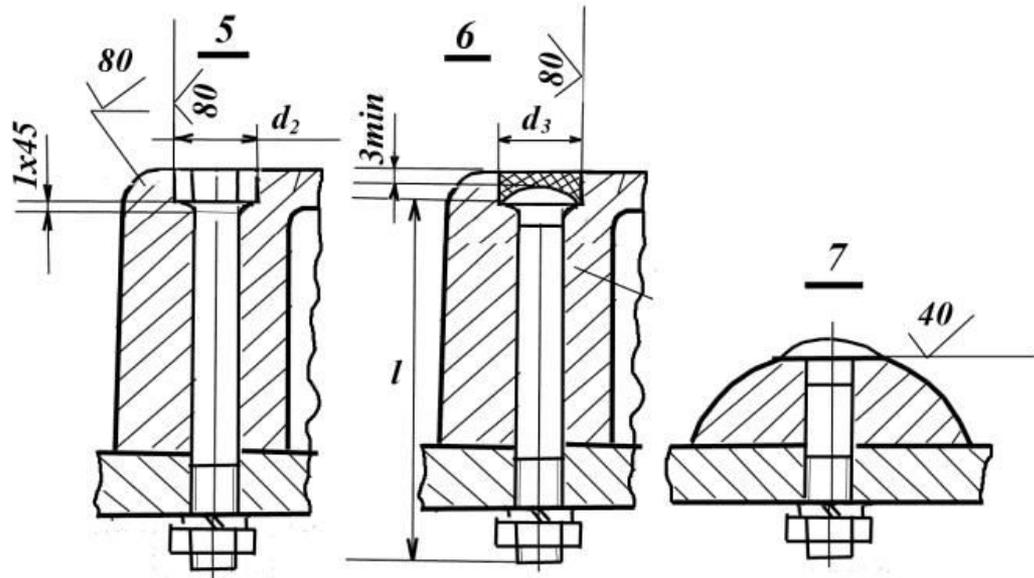
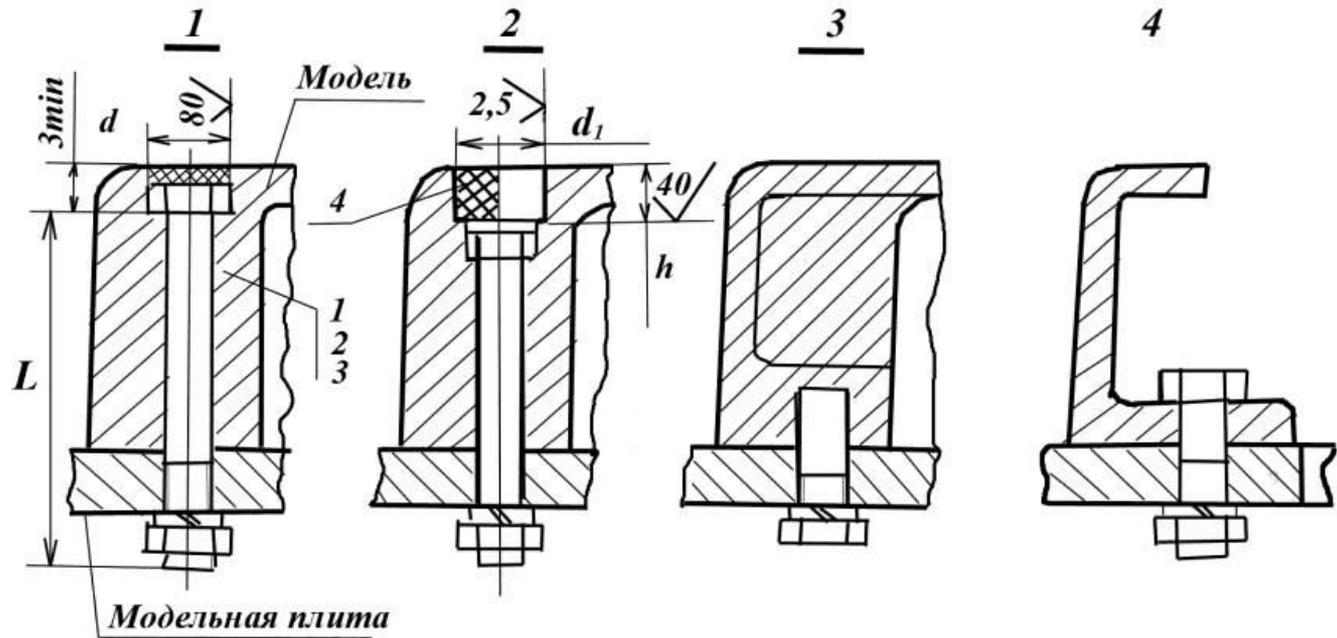
Пример 2

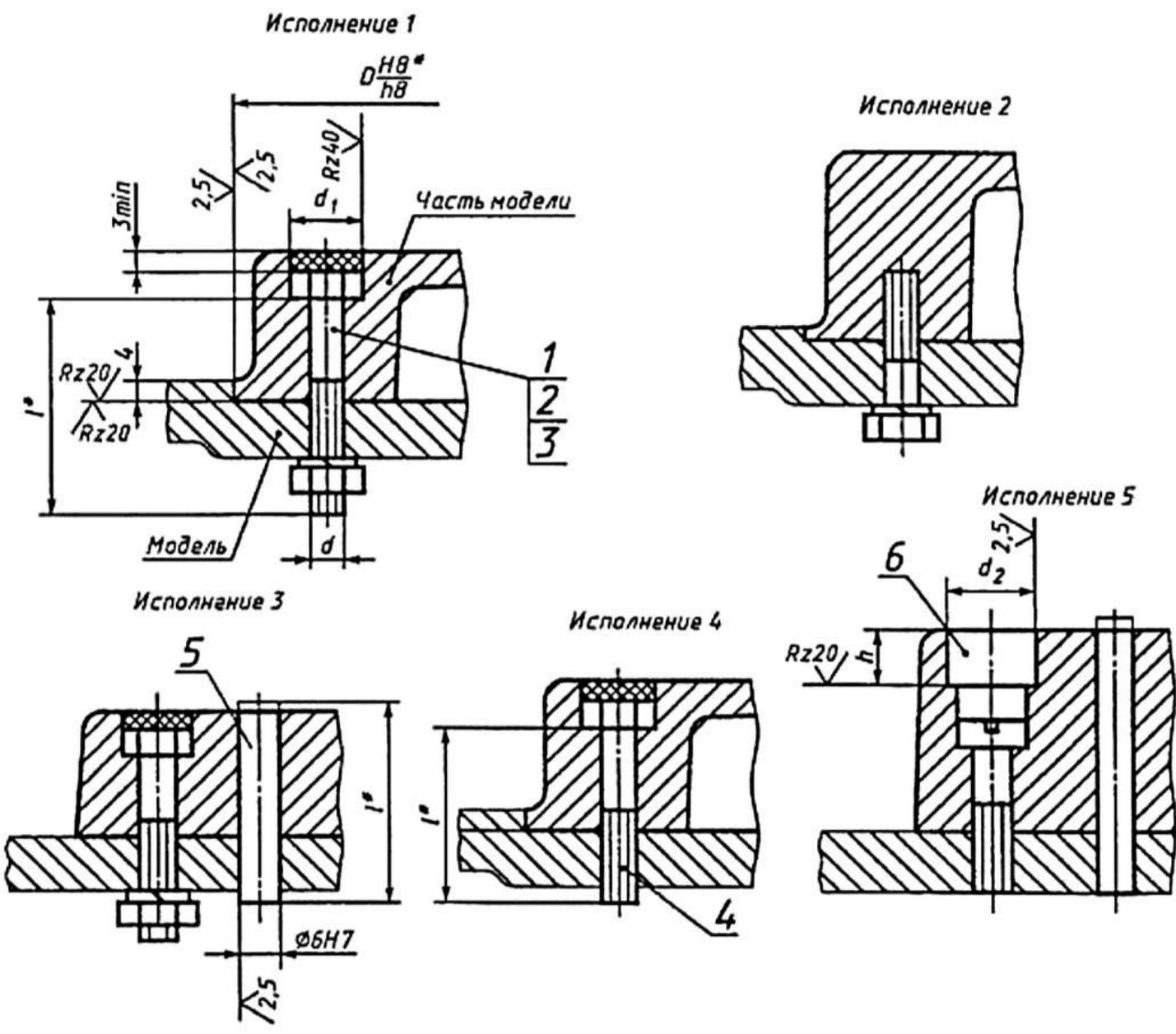


Пример 3

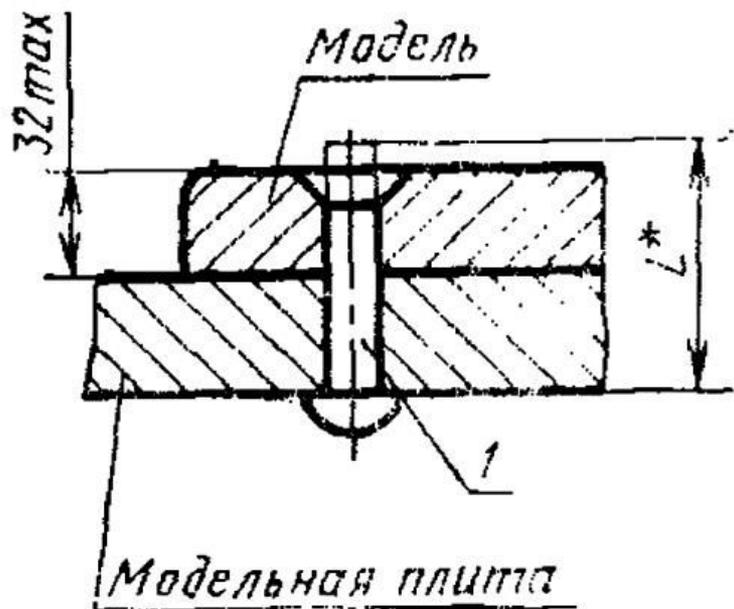


# Исполнение

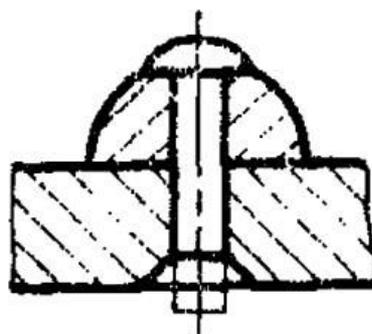




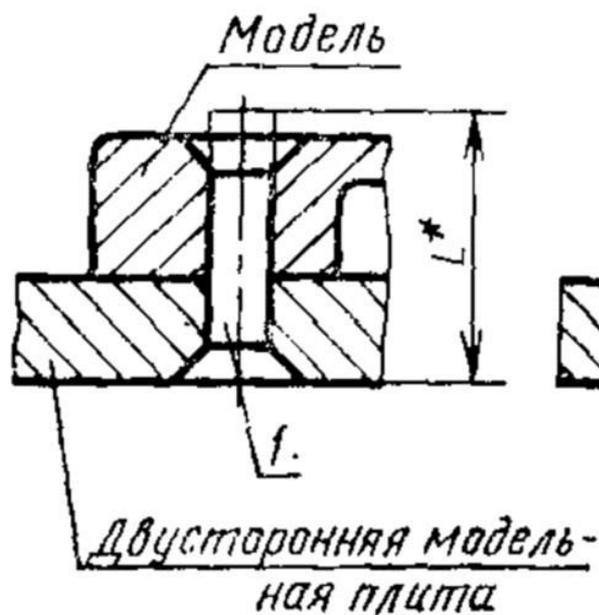
Исполнение 1



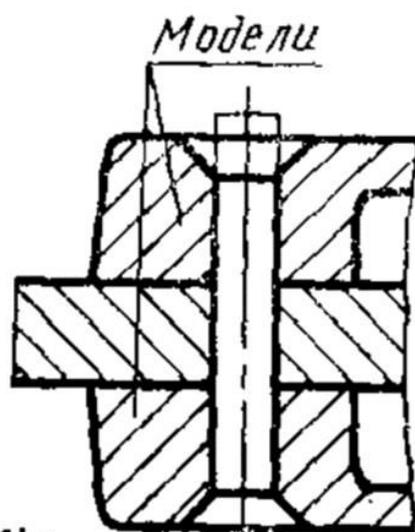
Исполнение 2

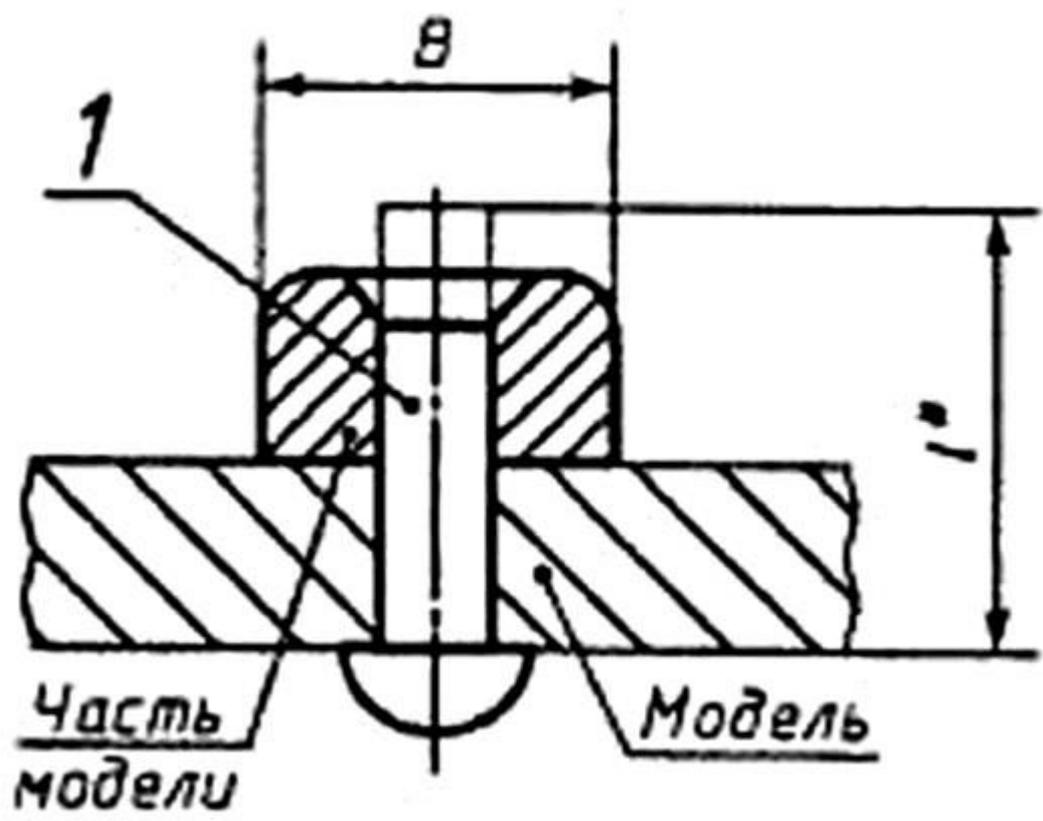


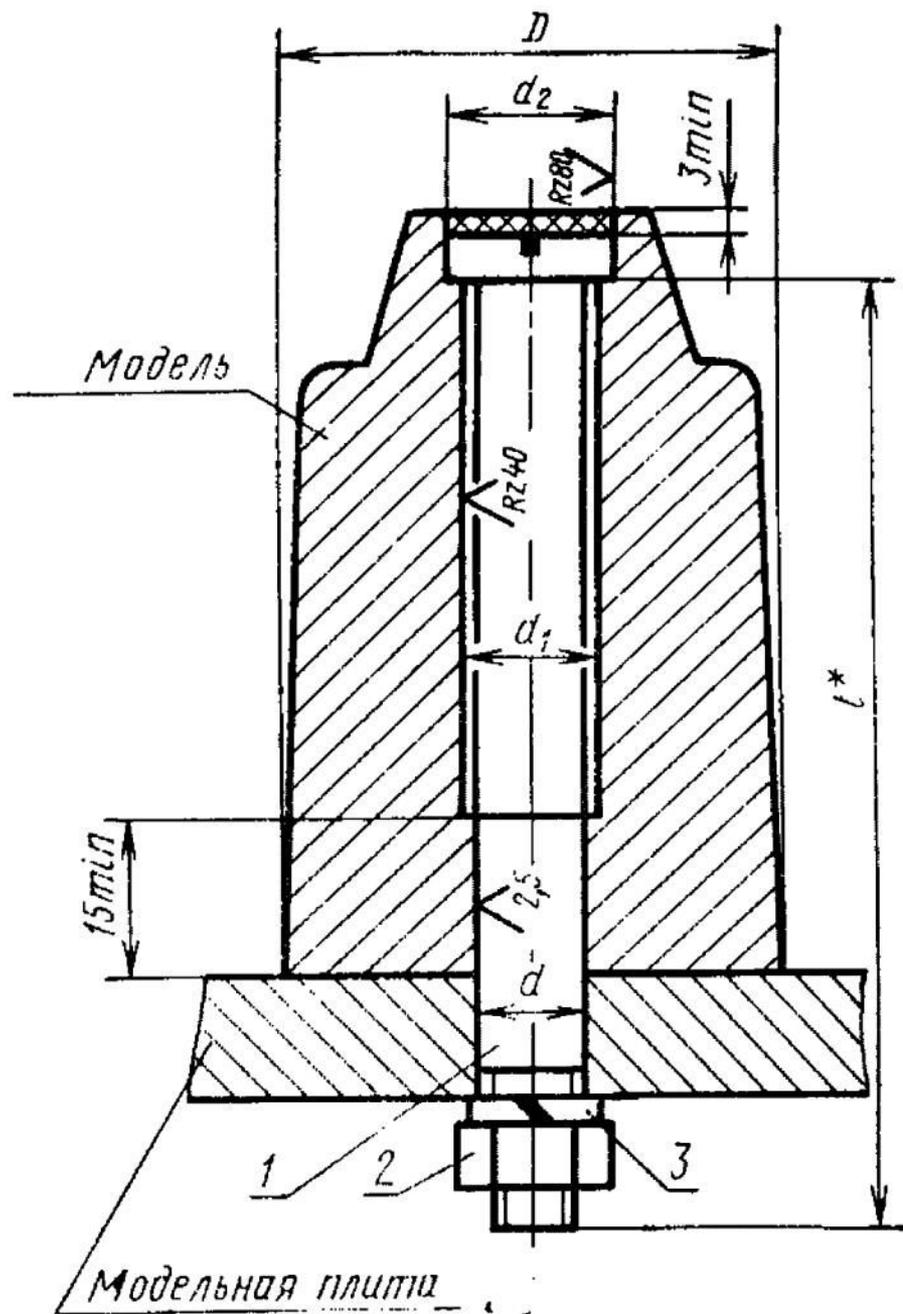
Исполнение 1



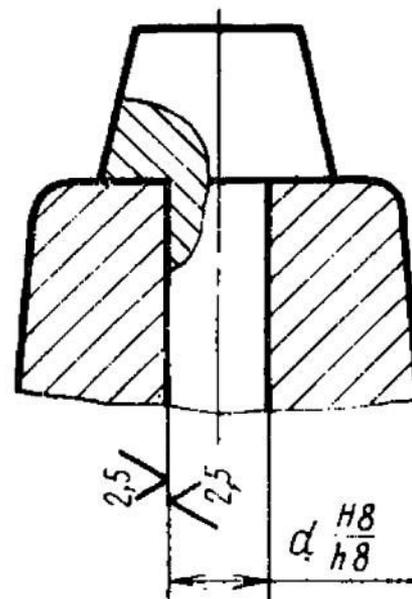
Исполнение 2



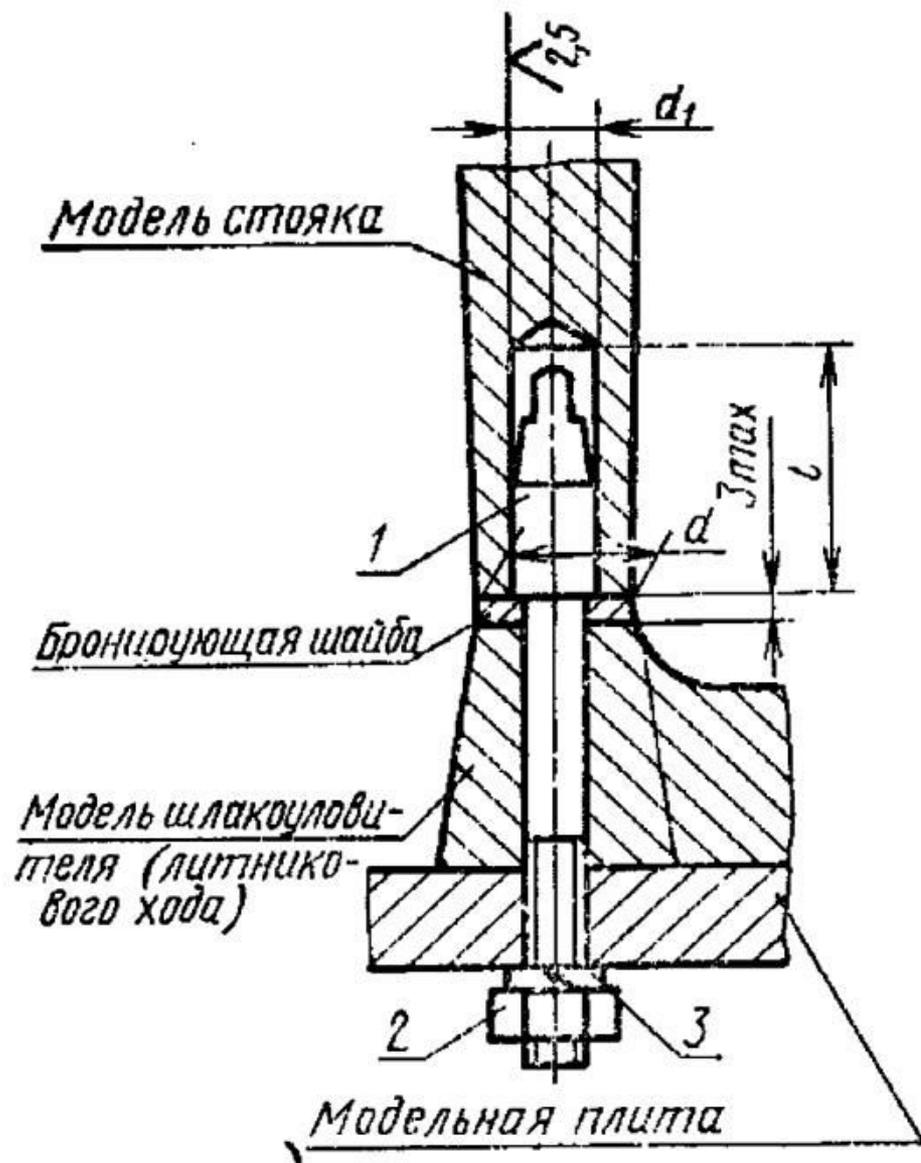




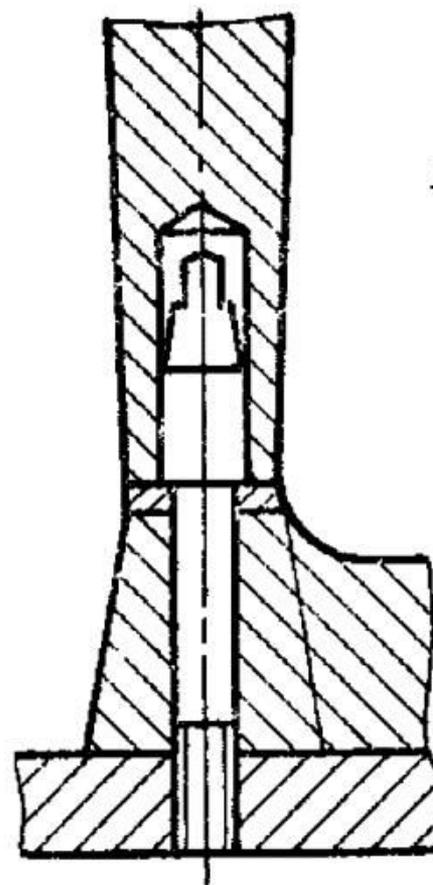
Вариант  
фиксирования и  
крепления моделей



Исполнение 1

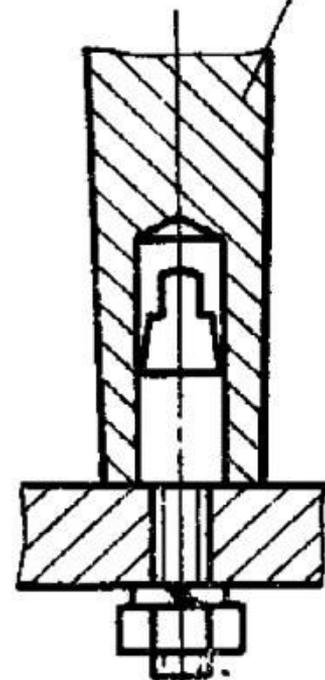


Исполнение 2

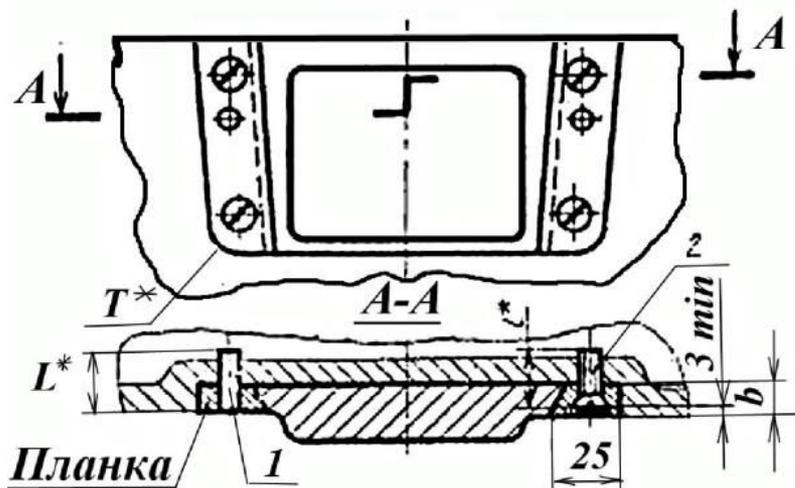


Исполнение 3

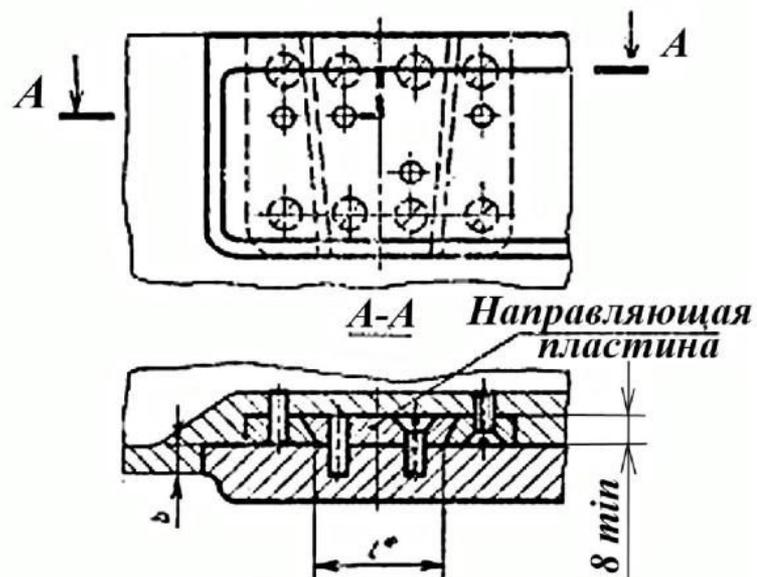
Модель стояка или  
выпора



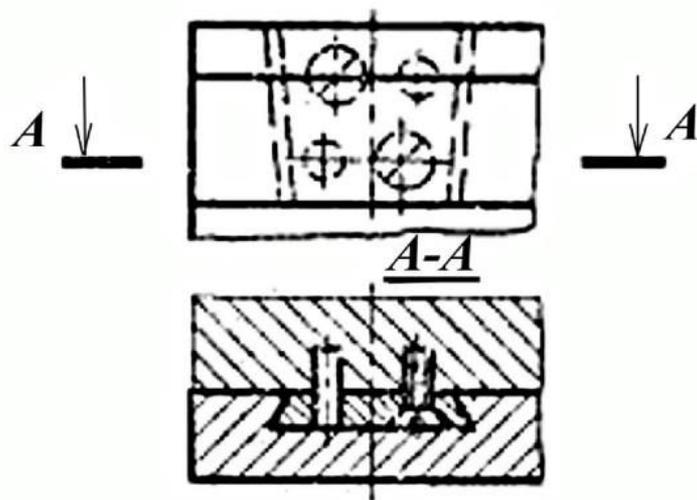
*Исполнение 3*



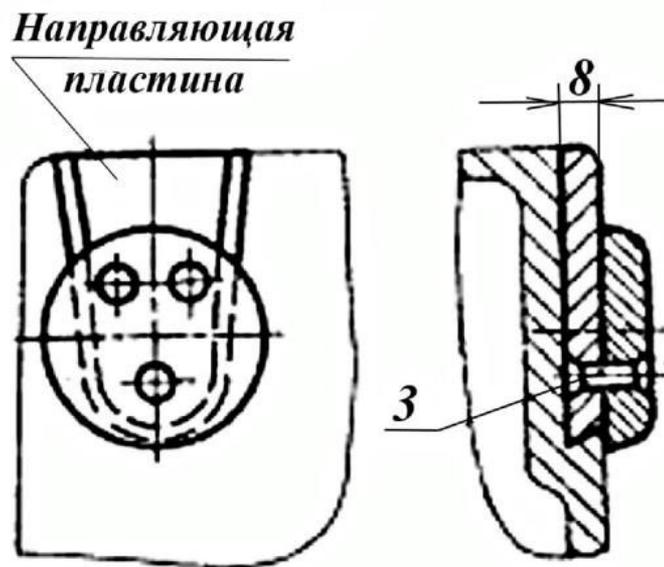
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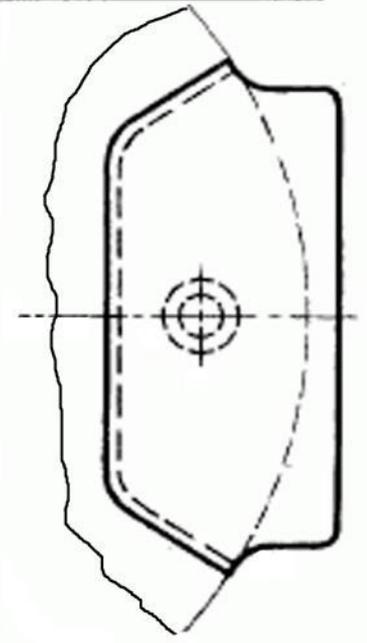
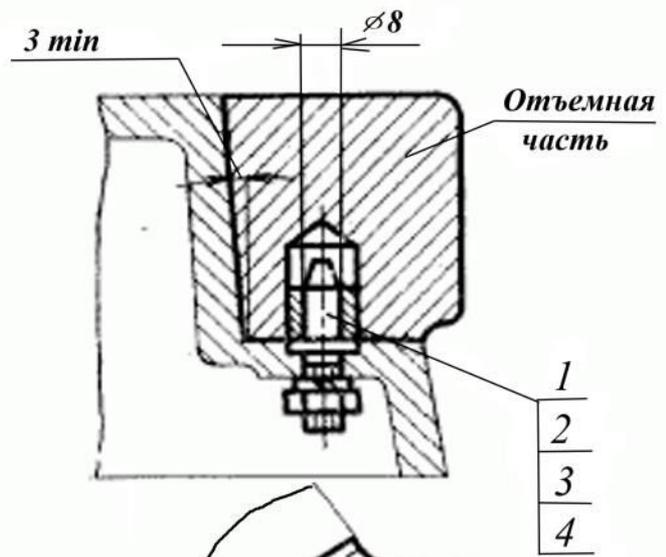


*Исполнение 5*



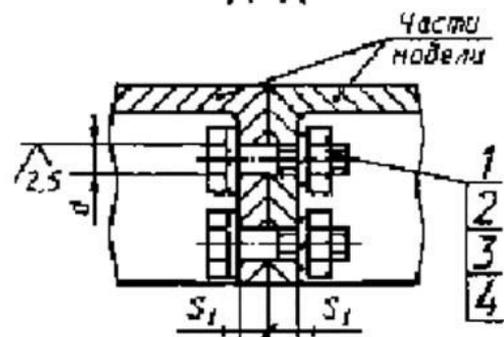
*Исполнение 6*





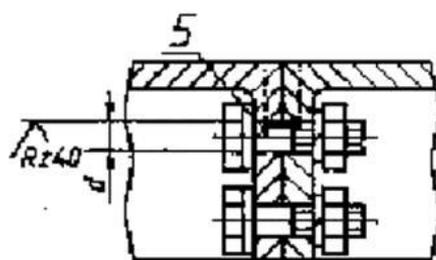
Исполнение 1

A-A



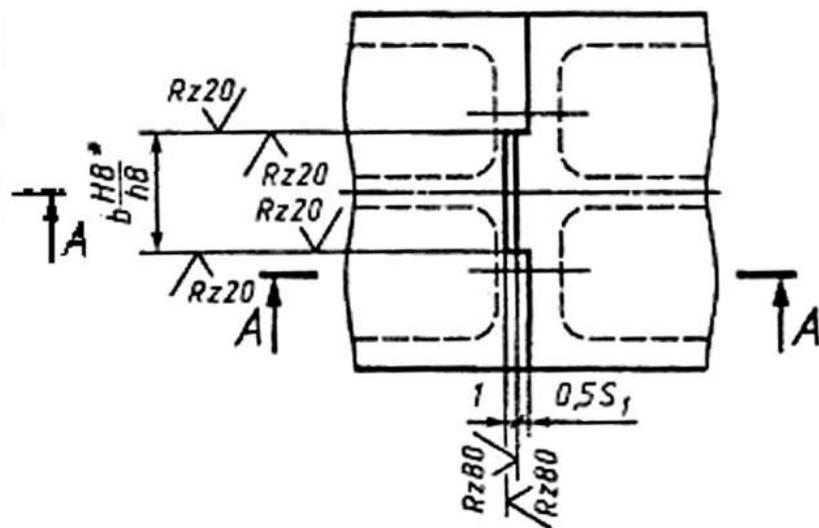
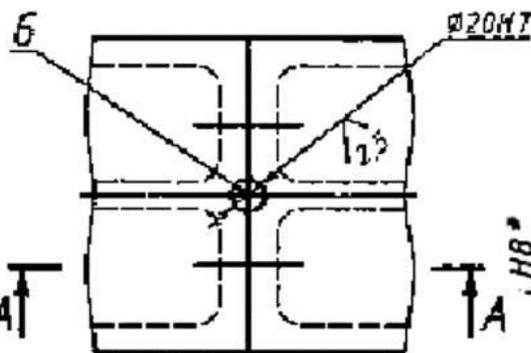
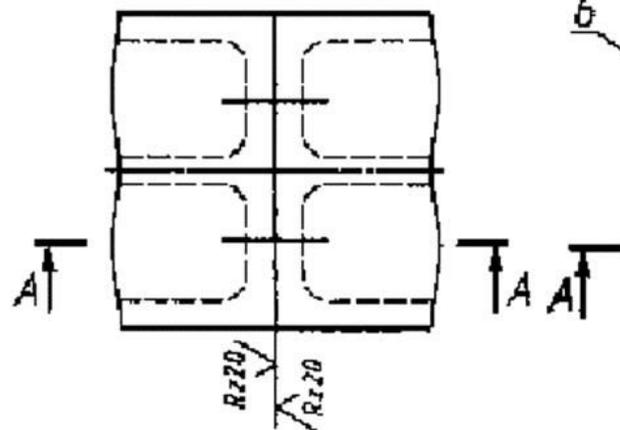
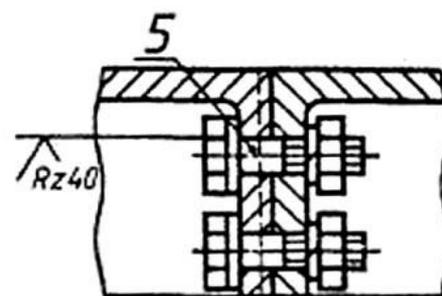
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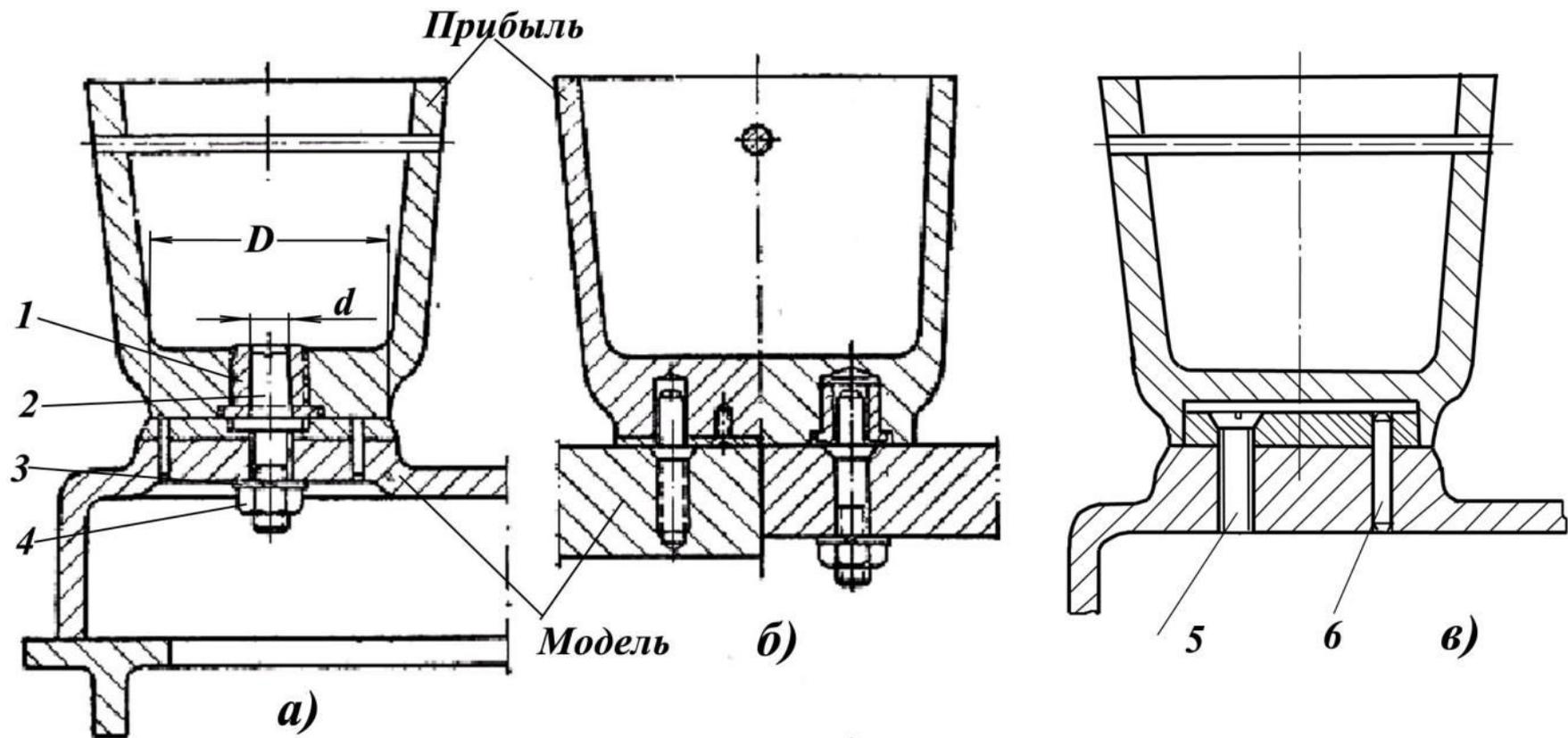
A-A

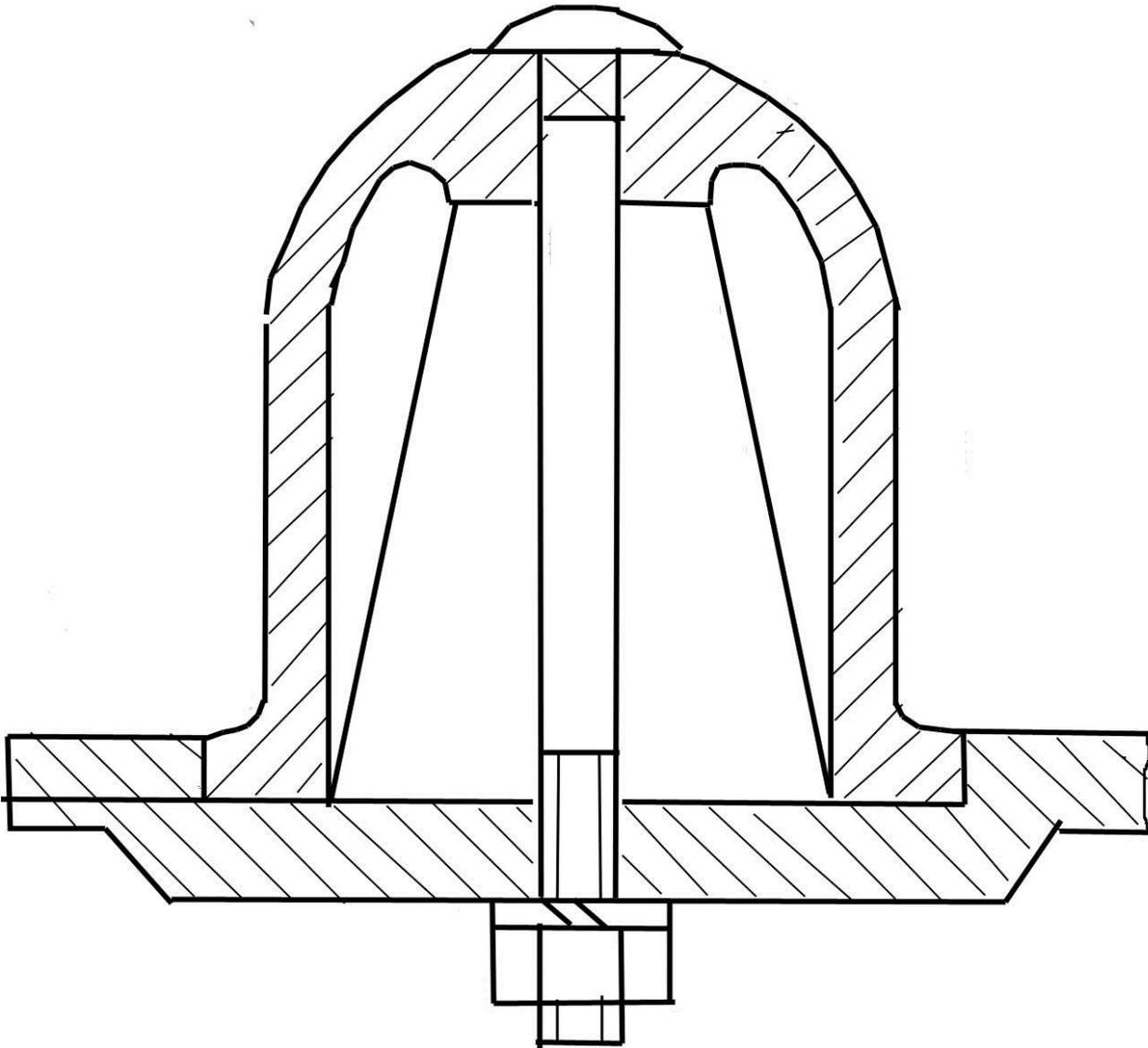


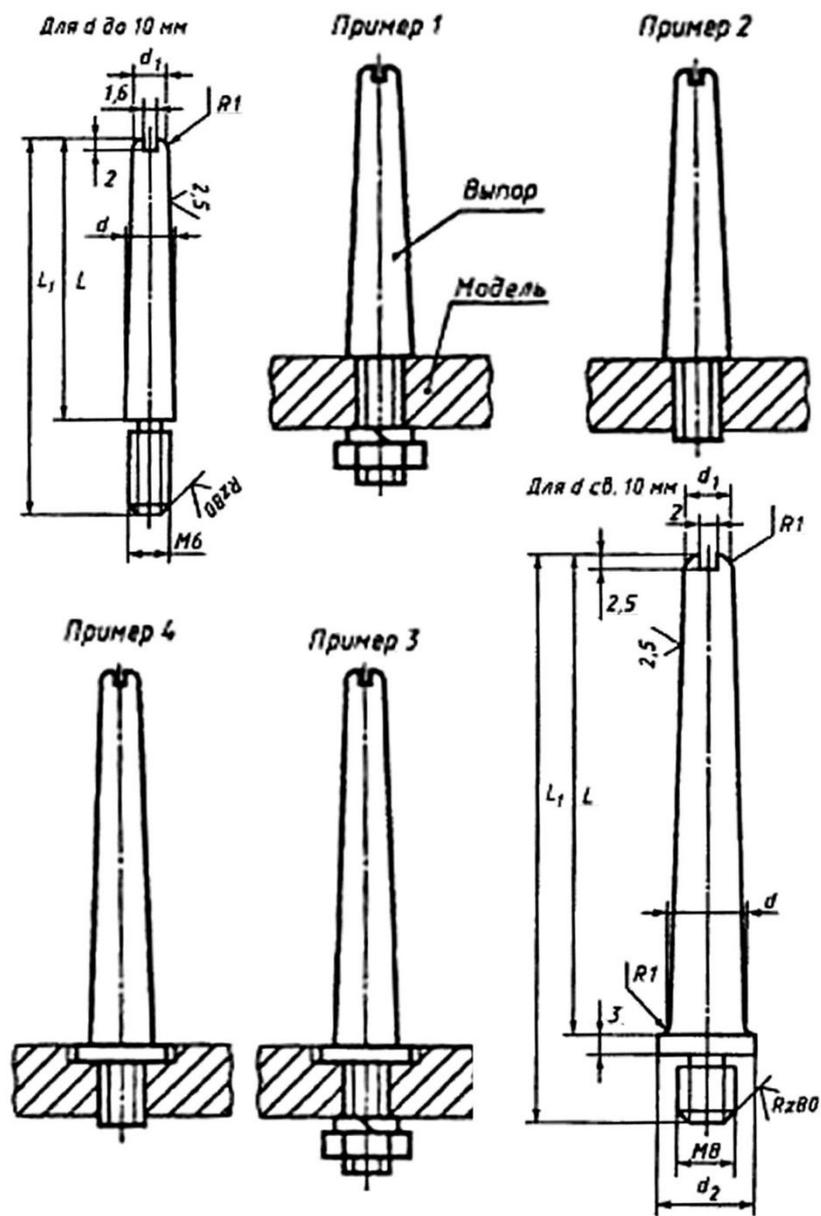
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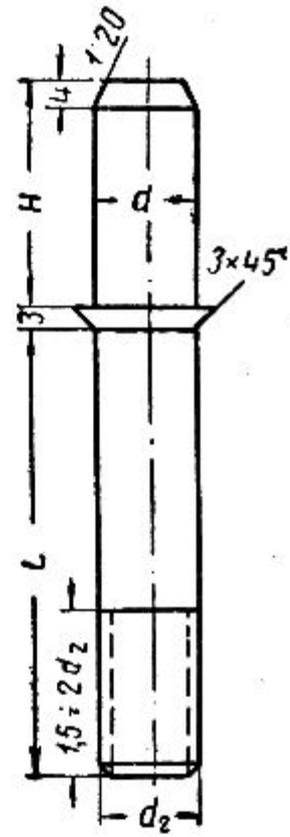
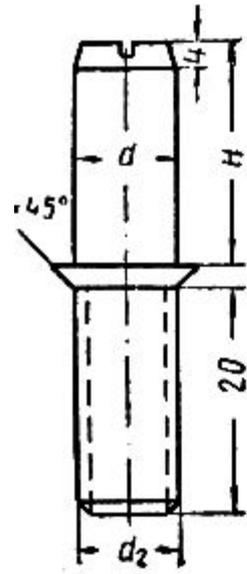
A-A



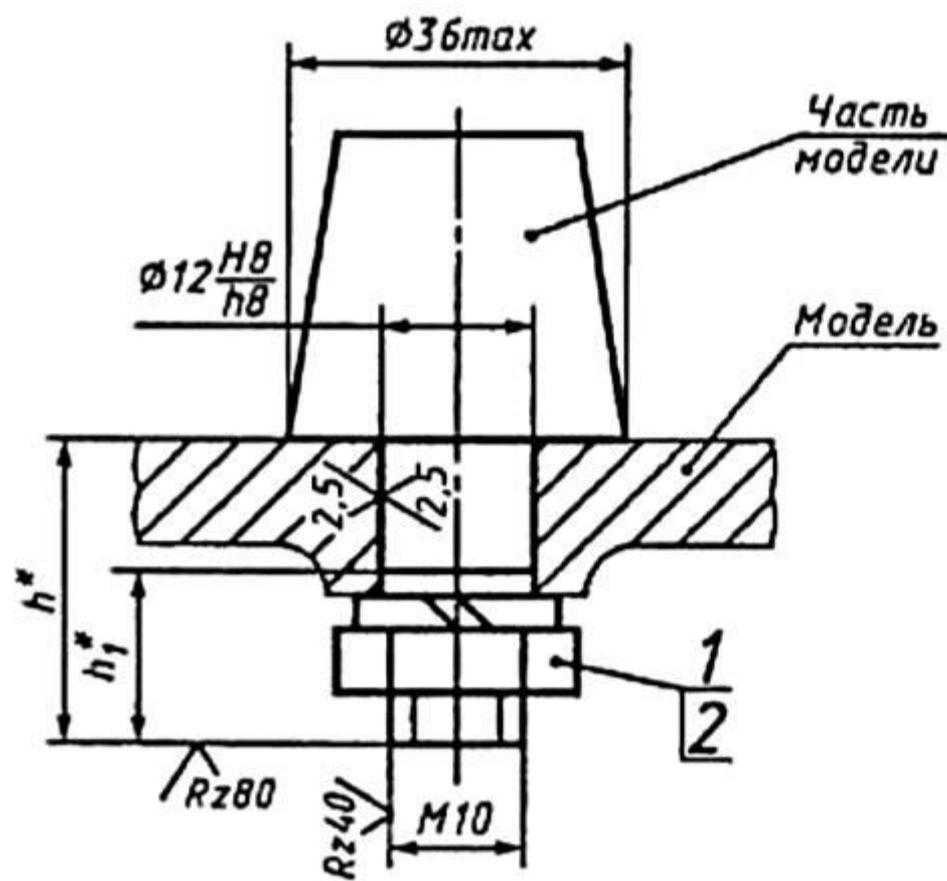








Исполнение 1



Исполнение 2

