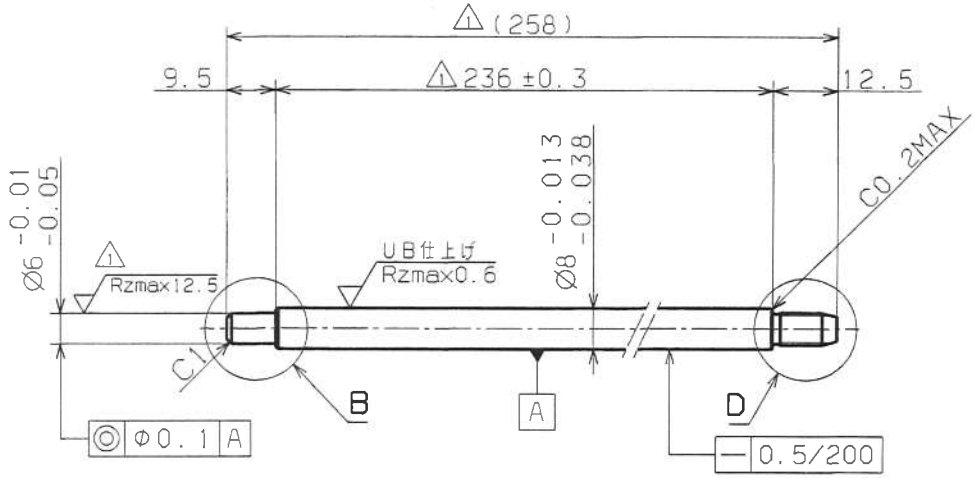
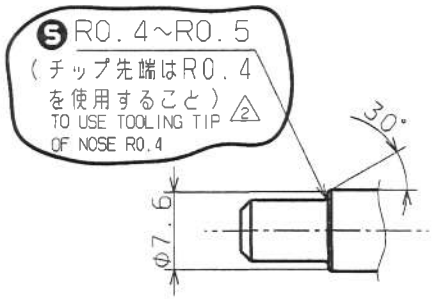
QUALITY\COST

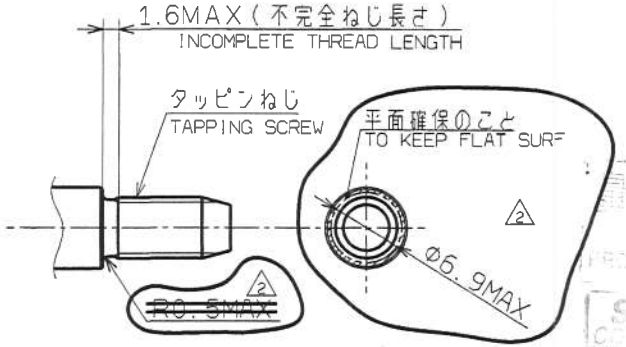
ISSUED DATE 2011/01/27 11:50 SHOWA R&D print:2011-01-28 12:08, user:061-xjz, computer:065-XJZ, page:47/47

Rz100 (Rzmax12.5 , Rzmax0.6)

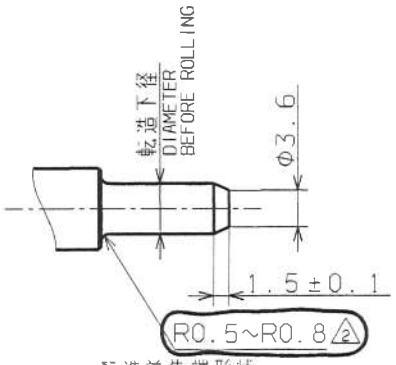




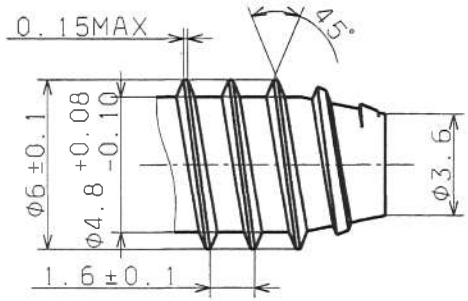
DETAIL AREA B(2:1)



DETAIL AREA D(2:1)



転造前先端形状
・SHAPE OF TOP BEFORE ROLLING



タッピンねじ詳細図
DETAIL OF TAPPING SCREW

NOTES

1. 表面処理
SURFACE TREATMENT

方法 METHOD	GSN+ホモ処理 GSN + STEAM TREATMENT
該当部 APPLICABLE AREA	全面 WHOLE SURFACE
化合物層深さ COMPOUND LAYER DEPTH	窒化層 0.008MIN NITRING DEPTH
	ホモ層 0.001MIN STEAM TREATMENT DEPTH
硬度 HARDNESS	表面HMV(100g) 450MIN

2. Ø8部表面にキズなきこと。
NO SCRATCHES ON Ø8 SURFACE.

3. 耐食性：SST．72hr後、腐食生成物の発生面積は、Ø8において
CORROSION RESISTANCE: CORROSION PRODUCT AREA AFTER 72hr SST TEST IS 0.05% MAX ON Ø8.
0．05%以下(レイティングNO．9．5以上)のこと
(RATING NO.9.5 MIN.)
120hr後、一般部(Ø8)は0．5mm以上の点錆なきこと。
AFTER 120hr, RUST OF GENERAL AREA (Ø8) SHOULD BE 0.5mm MAX.
但し、試料保持の支持部は除く
EXCEPT FOR ROD HOLDING PORTION.
試料の保持：鉛直方向から15~30°傾け、噴霧の自由落下だけに
HOLDING METHOD: SLANT ROD 15~30° FROM VERTICAL DIRECTION, FIX IT PLACE OF
ざらされる位置に置くこと
SHOWERD FREE-FALL MIST ONLY.

S STOCK MATERIAL No.	素材NO	92009-30S-1 -CH
AFTER MACHINING No.	加工完NO	

S2RA U4 20

M NO	REVISION RECORD		DATE	DRAWN	DESIGNED	APPR
2	改訂図 首元R拡大	114-N0001	11・01・27	K.AOKI	K.Aoki	K.KITOH
1	改訂図 長手変更	08G-X0045	08・11・25	T.WATANABE	M.WATANABE	K.ITOH
0	新 図 量産図	08G-X0035	08・08・08	--	--	--

SHOWA

DRAWN	DESIGNED	CHECKED	APPR
T.WATANABE	M.WATANABE	K.TAKAYA	K.ITOH
08・08・07	08・08・07	08・08・07	08・08・07

APPLICABLE DWG.	- -
SCALE	1:1
MATERIAL	
MASS	R 97.9 L 9.9
CUSTOMER DWG NO.	X
CUSTOMER NAME	
CATIA 2D	
SHOWA DWG NO.	XJ685-300-02-CH
SHOWA NAME	ロッド
ENGLISH NAME	ROD
PREVIOUS NO.	XJ685-300-01-CH
	A3

SHOWA CONFIDENTIAL

CATIA V5 ZAN