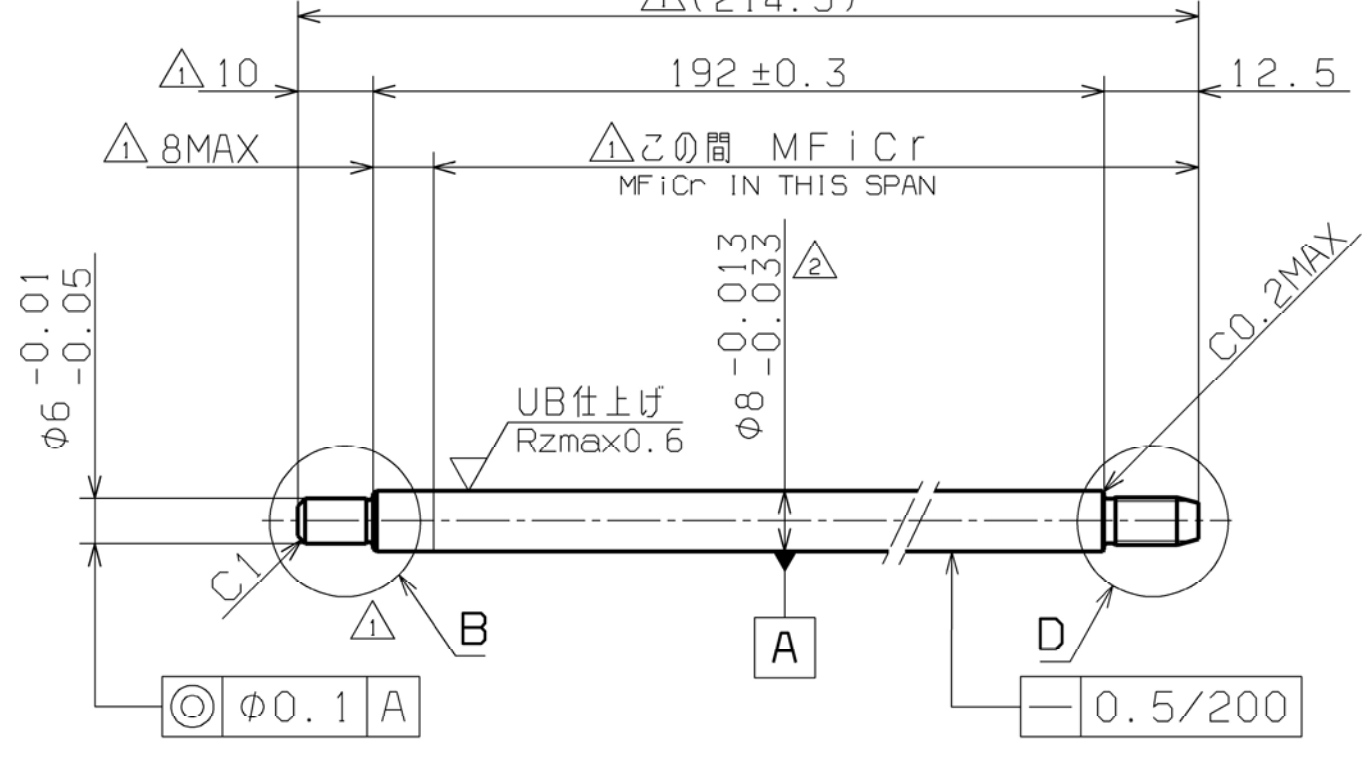
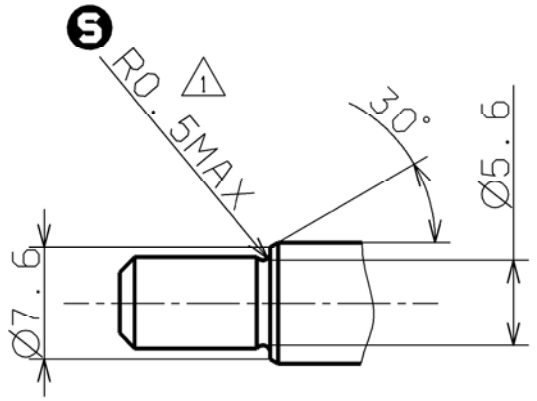
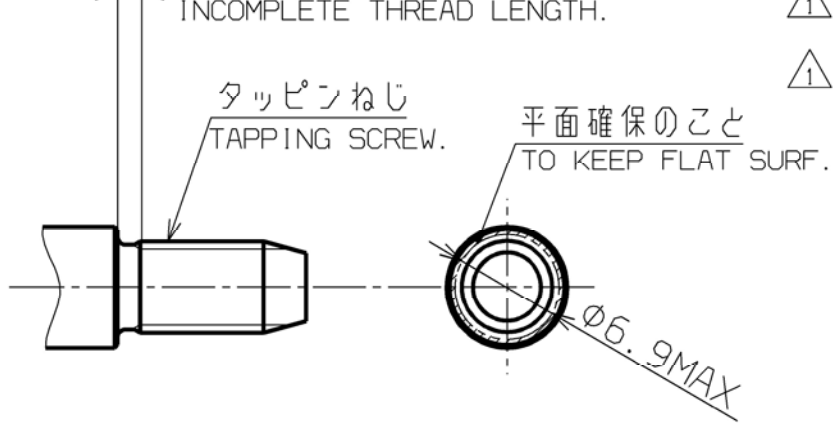
ISSUED DATE 2017/12/08 08:58 SHOWA R&D print:2017/12/11 09:06, user:123, computer:SSK-XJZLF, page:4/18

QUALITY\COST

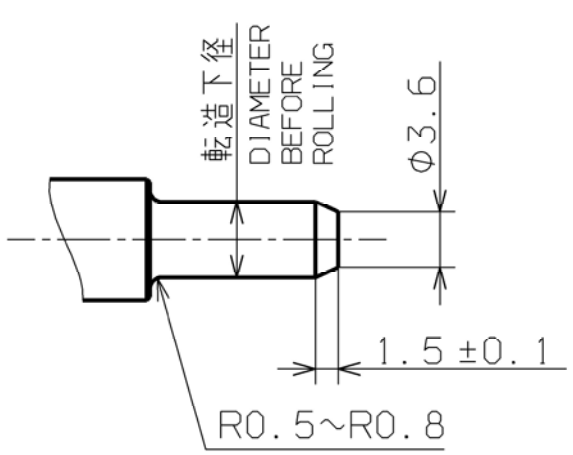




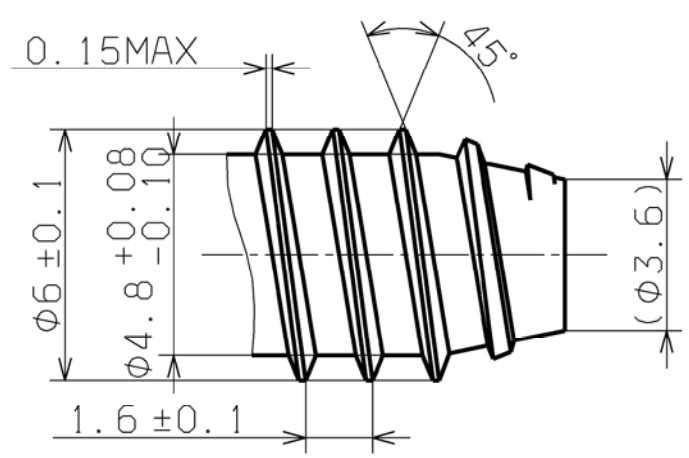
DETAIL AREA B(2:1)



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

Rz100 (Rzmax0.6)

NOTES

1. 表面処理：MFiCr（ヒーフめっき） 18μm以上（指示部）
SURFACE TREATMENT: MFiCr(HEEF PLATING) 18μm MIN.(DESIGNATE AREA)
（研磨前めっき厚；22μm以上）
(PLATING THICKNESS BEFORE POLISHING; 22μm MIN.)
耐食性 ：SST．72hr後、腐食生成物の発生面積は、めっき指示部
CORROSION RESISTANCE: CORROSION PRODUCT AREA AFTER 72hr SST.
において0．05%以下（レイティングNO．9．5以上）のこと
TEST IS 0.05% MAX. (RATING NO.9.5 MIN.)
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,
さらされる位置に置くこと
FIX IT PLACE OF SHOWERD FREE-FALL MIST ONLY.
2. マイクロクラック数：1000本／cm 以上
NUMBER OF MICRO-CRACKS : 1000 LINE/cm MIN.
3. めっき硬度：Hv900 MIN.
HARDNESS OF PLATING: Hv900 MIN.
4. めっき前寸法：∅8部；∅8 -0.061 -0.071
DIMENSION BEFORE PLATING: ∅8 PORTION; ∅8 -0.061 -0.071
5. ∅8部表面にキズなきこと。
NO SCRATCHES ON ∅8 SURFACE.
6. 現調メーカー；切断／めっき；上海众新五金有限公司
LOCAL SUPPLIER; CUT/SURFACE TREATMENT; SHANGHAI ZHONGXIN HARDWARE MANUFACTURE CO.,LTD.
加工／研磨 ；上海昭和汽車配件有限公司
MACHINING/GRINDING; SHANGHAI SHOWA AUTOPARTS CO.,LTD.

S STOCK MATERIAL No.	素材NO	92009-30S-0 -CH
AFTER MACHINING No.	加工完NO	

S2R.A. U4 U2 U1

NO	REVISION RECORD		DATE	DRAWN	DESIGNED	APPR
4	REV DWG .	17G-F0041	17•12•08	M.KONISHI	K.Aoki	K.Itoh
3	REV DWG .	17G-N0011	17•05•24	M.KONISHI	K.TAKAYA	K.ITOH
2	REV DWG [PLATING THICKNESS CHANGE]	16G-N0058	16•11•30	M.KONISHI	K.TAKAYA	K.ITOH
1	REV DWG [ROD SURFACE TREATMENT CHANGE]	16G-N0026	16•05•18	M.KONISHI	K.TAKAYA	K.ITOH
0	M/P DWG .	15G-N0020	15•12•21	--	--	--

SHOWA

APPLICABLE DWG.	DRAWN	DESIGNED	CHECKED	APPR
	H.TESHIGAWARA	K.TAKAYA	K.AOKI	K.ITOH
	15•12•15	15•12•18	15•12•18	15•12•18

SCALE 1:1 | MATERIAL . | MASS R L 80 g g

CUSTOMER DWG NO. N | CUSTOMER NAME

SHOWA DWG NO. N32U5-300-34-CH
SHOWA NAME ロッド
ENGLISH NAME ROD
PREVIOUS NO. N32U5-300-33-CH

CATIA 2D めっきロッド | A3

SHOWA CONFIDENTIAL

CATIA V5