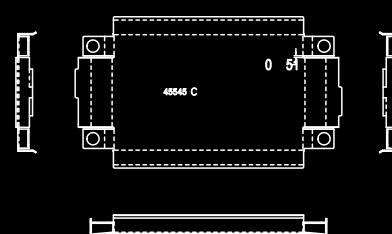
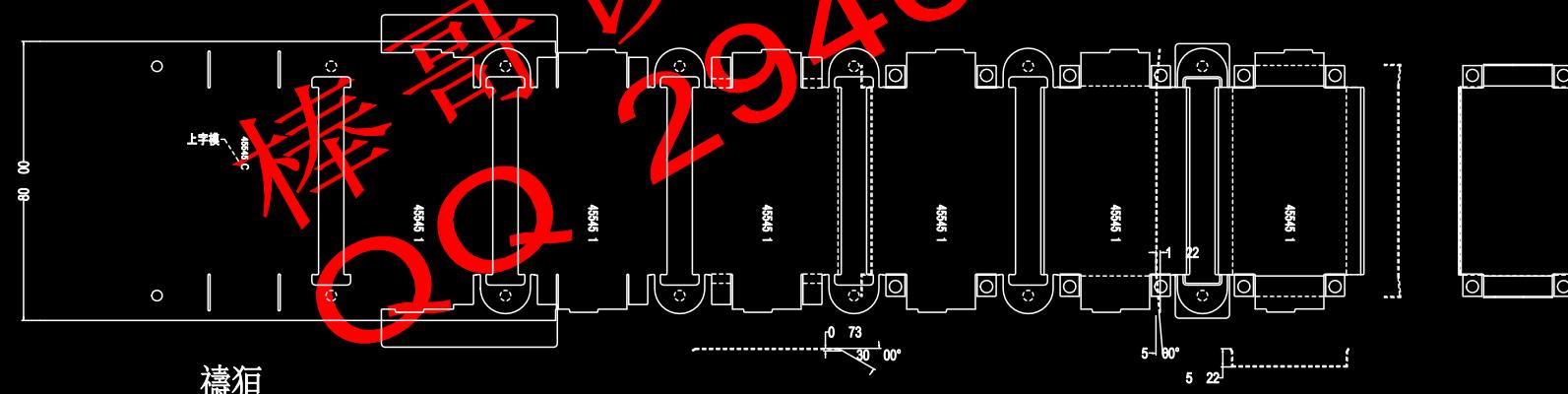
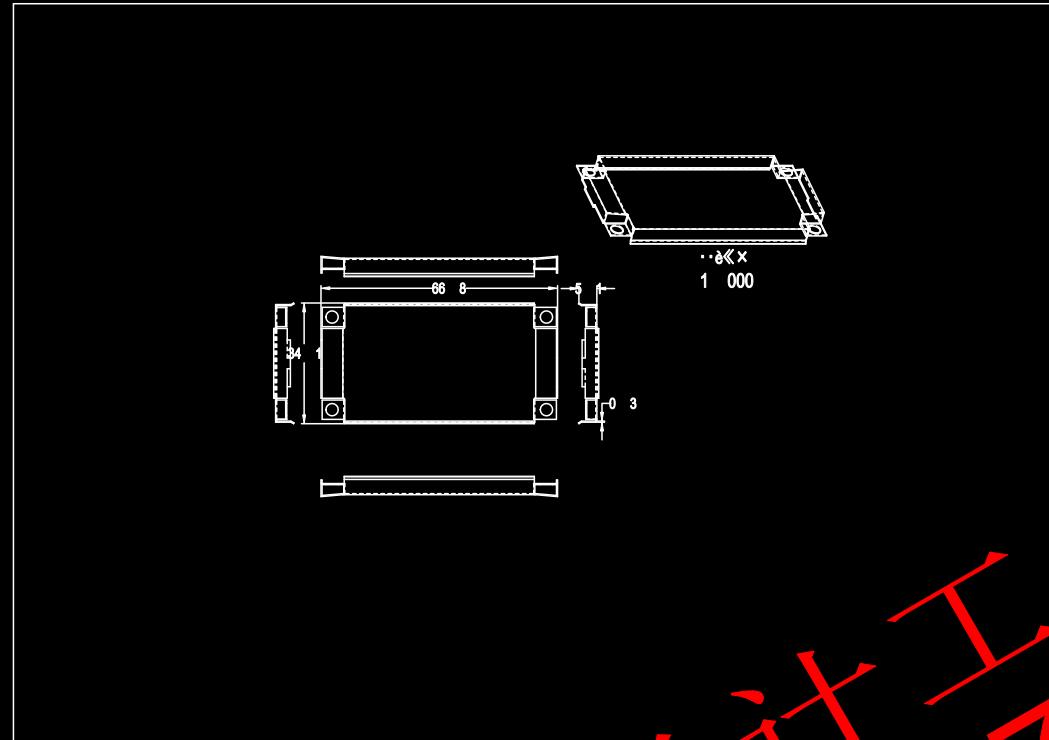
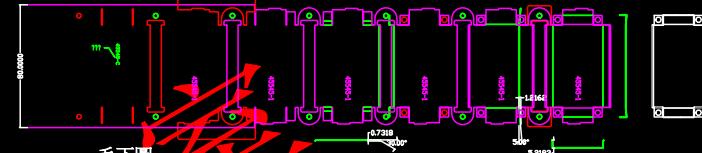
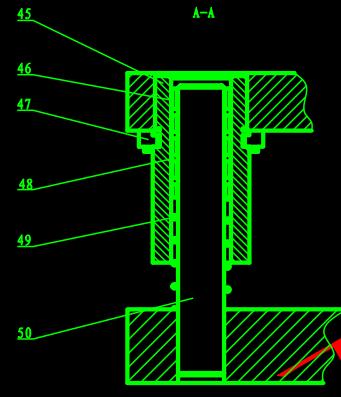
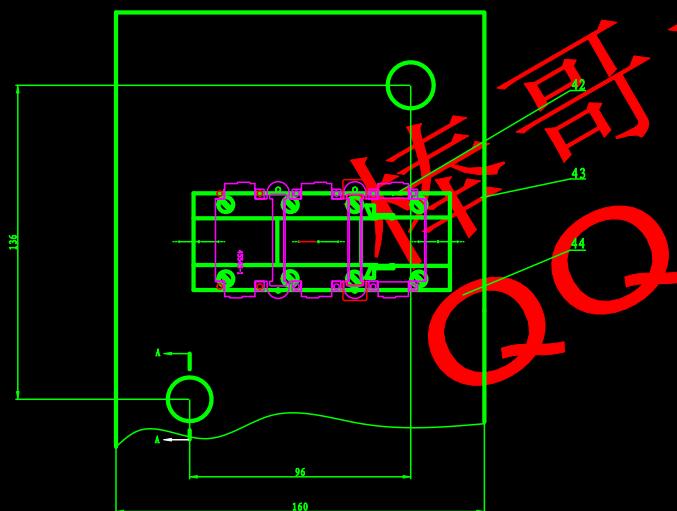
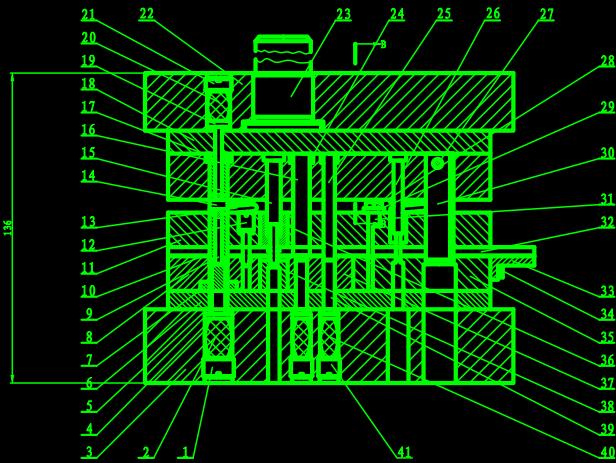


# 排样图



# A0-装配图



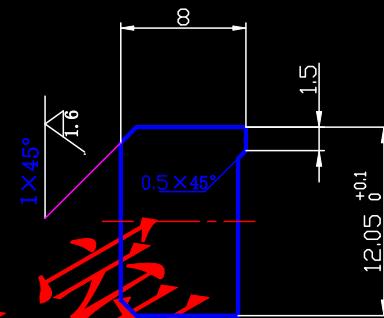
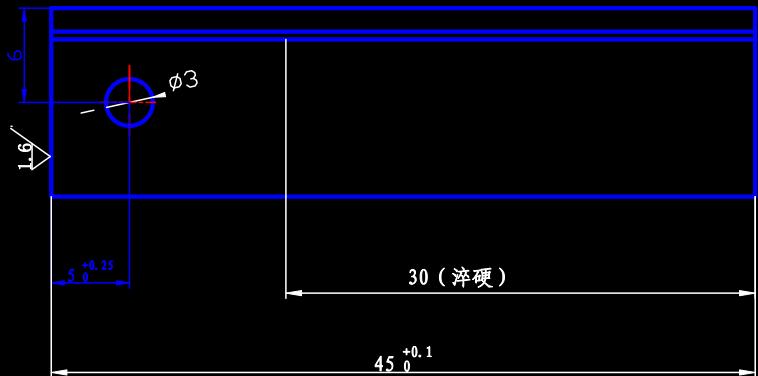
**技术要求**

1. 模具制造按“冲模设计与制造”、“冲压模具技术条件”和“冲压模具技术条件”的有关规定执行。
2. 冲裁间隙要均匀，初始单边间隙为 $0.15 \pm 0.05$ mm。
3. 口模和凹模间隙采用 $0.15 \pm 0.05$ mm。
4. 弯曲和弹性卸料板采用 $0.15 \pm 0.05$ mm。

| 代<br>号 | 名<br>称        | 材<br>料   | 单<br>位 |          | 单<br>位 | 单<br>位 |
|--------|---------------|----------|--------|----------|--------|--------|
|        |               |          | 数<br>量 | 单<br>价   |        |        |
| 45     | GB76-85       | 内六角螺栓头螺钉 | 4      | 45       |        |        |
| 46     | JB/T72861.3   | 带盖       | 1      | 15.00    |        |        |
| 47     | GB/T2427      | 带盖       | 1      | 488.126M |        |        |
| 48     | GB/T72861     | 带盖       | 40     | W12C4V   |        |        |
| 49     | JB/T77181.5   | 压盖       | 2      | 45       |        |        |
| 50     | JB/T77181.4   | 平垫       | 1      | 11.00    |        |        |
| 51     | GB68-83       | 开槽圆头螺钉   | 6      | 45       |        |        |
| 52     | JB/T77148.5   | 导电片      | 2      | 45       |        |        |
| 53     | JB/T77148.2   | 刀形接触片    | 2      | 78.0     |        |        |
| 54     | JB/T77148.1   | 丝锥       | 2      | 45       |        |        |
| 55     | JB/T7650.9    | 橡胶绝缘体    | 1      | 45       |        |        |
| 56     | JB/T7650.3    | 铜线       | 2      | 45       |        |        |
| 57     | GB67-85       | 带盖螺母     | 1      | Cr2MoY   |        |        |
| 58     | GB67-85       | 带盖螺母     | 1      | Cr2MoY   |        |        |
| 59     | JB/T77148.4   | 导电片      | 1      | 45       |        |        |
| 60     | JB/T77148.1   | 丝锥       | 1      | 45       |        |        |
| 61     | JB/T77184.2   | 凸口凸缘     | 1      | Cr2MoY   |        |        |
| 62     | JB/T77184.1   | 刃形凹缘     | 1      | Cr2MoY   |        |        |
| 63     | JB/T77181.2   | 压盖       | 1      | 45       |        |        |
| 64     | GB67-85       | 开槽圆头螺钉   | 1      | 45       |        |        |
| 65     | GB115-85      | 带盖螺母     | 1      | 45       |        |        |
| 66     | JB/T77148.5   | 导电片      | 1      | Cr2MoY   |        |        |
| 67     | GB119-86      | 带盖凸缘     | 1      | Cr2MoY   |        |        |
| 68     | JB/T77146.4   | 带盖       | 2      | 45       |        |        |
| 69     | JB/T77184.3   | 上盖       | 1      | 45       |        |        |
| 70     | JB/T77148.1   | 丝锥       | 1      | 45       |        |        |
| 71     | JB/T7650.9    | 橡胶绝缘体    | 1      | 45       |        |        |
| 72     | JB/T7651.3    | 锁紧       | 3      | 45       |        |        |
| 73     | JB/T77184.1   | 上盖垫圈     | 1      | 45       |        |        |
| 74     | JB/T77184.2   | 凸口凸缘     | 1      | Cr2MoY   |        |        |
| 75     | JB/T77184.3   | 上盖       | 1      | Cr2MoY   |        |        |
| 76     | JB/T77184.1   | 刃形凹缘     | 1      | Cr2MoY   |        |        |
| 77     | JB/T77184.2   | 带盖       | 1      | Cr2MoY   |        |        |
| 78     | JB/T77184.3   | 下底座      | 1      | 45       |        |        |
| 79     | JB/T77184.1   | 带盖垫圈     | 1      | Cr2MoY   |        |        |
| 80     | JB/T77184.2   | 丝锥       | 1      | 45       |        |        |
| 81     | JB/T77184.3   | 下底座      | 1      | 45       |        |        |
| 82     | JB/T77184.1   | 带盖       | 1      | Cr2MoY   |        |        |
| 83     | JB/T77184.2   | 刃形凹缘     | 1      | Cr2MoY   |        |        |
| 84     | JB/T77184.3   | 上盖       | 1      | Cr2MoY   |        |        |
| 85     | JB/T77184.1   | 带盖       | 1      | Cr2MoY   |        |        |
| 86     | JB/T77184.2   | 凸口凸缘     | 1      | Cr2MoY   |        |        |
| 87     | JB/T77184.3   | 上盖       | 1      | Cr2MoY   |        |        |
| 88     | JB/T77184.1   | 带盖       | 1      | Cr2MoY   |        |        |
| 89     | JB/T77184.2   | 刃形凹缘     | 1      | Cr2MoY   |        |        |
| 90     | JB/T77184.3   | 下底座      | 1      | 45       |        |        |
| 91     | JB/T77184.1   | 带盖垫圈     | 1      | 98.27    |        |        |
| 92     | JB/T77184.2   | 丝锥       | 1      | 45       |        |        |
| 93     | JB/T77184.3   | 下底座      | 1      | 45       |        |        |
| 94     | JB/T77185.1   | 带盖       | 1      | 98.27    |        |        |
| 95     | JB/T77184.2   | 刃形凹缘     | 1      | Cr2MoY   |        |        |
| 96     | JB/T77184.3   | 上盖       | 1      | Cr2MoY   |        |        |
| 97     | JB/T77185.2   | 带盖       | 1      | 98.27    |        |        |
| 98     | JB/T77185.3   | 带盖       | 1      | 98.27    |        |        |
| 99     | JB/T77185.4   | 带盖       | 1      | 98.27    |        |        |
| 100    | JB/T77185.5   | 带盖       | 1      | 98.27    |        |        |
| 101    | JB/T77185.6   | 带盖       | 1      | 98.27    |        |        |
| 102    | JB/T77185.7   | 带盖       | 1      | 98.27    |        |        |
| 103    | JB/T77185.8   | 带盖       | 1      | 98.27    |        |        |
| 104    | JB/T77185.9   | 带盖       | 1      | 98.27    |        |        |
| 105    | JB/T77185.10  | 带盖       | 1      | 98.27    |        |        |
| 106    | JB/T77185.11  | 带盖       | 1      | 98.27    |        |        |
| 107    | JB/T77185.12  | 带盖       | 1      | 98.27    |        |        |
| 108    | JB/T77185.13  | 带盖       | 1      | 98.27    |        |        |
| 109    | JB/T77185.14  | 带盖       | 1      | 98.27    |        |        |
| 110    | JB/T77185.15  | 带盖       | 1      | 98.27    |        |        |
| 111    | JB/T77185.16  | 带盖       | 1      | 98.27    |        |        |
| 112    | JB/T77185.17  | 带盖       | 1      | 98.27    |        |        |
| 113    | JB/T77185.18  | 带盖       | 1      | 98.27    |        |        |
| 114    | JB/T77185.19  | 带盖       | 1      | 98.27    |        |        |
| 115    | JB/T77185.20  | 带盖       | 1      | 98.27    |        |        |
| 116    | JB/T77185.21  | 带盖       | 1      | 98.27    |        |        |
| 117    | JB/T77185.22  | 带盖       | 1      | 98.27    |        |        |
| 118    | JB/T77185.23  | 带盖       | 1      | 98.27    |        |        |
| 119    | JB/T77185.24  | 带盖       | 1      | 98.27    |        |        |
| 120    | JB/T77185.25  | 带盖       | 1      | 98.27    |        |        |
| 121    | JB/T77185.26  | 带盖       | 1      | 98.27    |        |        |
| 122    | JB/T77185.27  | 带盖       | 1      | 98.27    |        |        |
| 123    | JB/T77185.28  | 带盖       | 1      | 98.27    |        |        |
| 124    | JB/T77185.29  | 带盖       | 1      | 98.27    |        |        |
| 125    | JB/T77185.30  | 带盖       | 1      | 98.27    |        |        |
| 126    | JB/T77185.31  | 带盖       | 1      | 98.27    |        |        |
| 127    | JB/T77185.32  | 带盖       | 1      | 98.27    |        |        |
| 128    | JB/T77185.33  | 带盖       | 1      | 98.27    |        |        |
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| 131    | JB/T77185.36  | 带盖       | 1      | 98.27    |        |        |
| 132    | JB/T77185.37  | 带盖       | 1      | 98.27    |        |        |
| 133    | JB/T77185.38  | 带盖       | 1      | 98.27    |        |        |
| 134    | JB/T77185.39  | 带盖       | 1      | 98.27    |        |        |
| 135    | JB/T77185.40  | 带盖       | 1      | 98.27    |        |        |
| 136    | JB/T77185.41  | 带盖       | 1      | 98.27    |        |        |
| 137    | JB/T77185.42  | 带盖       | 1      | 98.27    |        |        |
| 138    | JB/T77185.43  | 带盖       | 1      | 98.27    |        |        |
| 139    | JB/T77185.44  | 带盖       | 1      | 98.27    |        |        |
| 140    | JB/T77185.45  | 带盖       | 1      | 98.27    |        |        |
| 141    | JB/T77185.46  | 带盖       | 1      | 98.27    |        |        |
| 142    | JB/T77185.47  | 带盖       | 1      | 98.27    |        |        |
| 143    | JB/T77185.48  | 带盖       | 1      | 98.27    |        |        |
| 144    | JB/T77185.49  | 带盖       | 1      | 98.27    |        |        |
| 145    | JB/T77185.50  | 带盖       | 1      | 98.27    |        |        |
| 146    | JB/T77185.51  | 带盖       | 1      | 98.27    |        |        |
| 147    | JB/T77185.52  | 带盖       | 1      | 98.27    |        |        |
| 148    | JB/T77185.53  | 带盖       | 1      | 98.27    |        |        |
| 149    | JB/T77185.54  | 带盖       | 1      | 98.27    |        |        |
| 150    | JB/T77185.55  | 带盖       | 1      | 98.27    |        |        |
| 151    | JB/T77185.56  | 带盖       | 1      | 98.27    |        |        |
| 152    | JB/T77185.57  | 带盖       | 1      | 98.27    |        |        |
| 153    | JB/T77185.58  | 带盖       | 1      | 98.27    |        |        |
| 154    | JB/T77185.59  | 带盖       | 1      | 98.27    |        |        |
| 155    | JB/T77185.60  | 带盖       | 1      | 98.27    |        |        |
| 156    | JB/T77185.61  | 带盖       | 1      | 98.27    |        |        |
| 157    | JB/T77185.62  | 带盖       | 1      | 98.27    |        |        |
| 158    | JB/T77185.63  | 带盖       | 1      | 98.27    |        |        |
| 159    | JB/T77185.64  | 带盖       | 1      | 98.27    |        |        |
| 160    | JB/T77185.65  | 带盖       | 1      | 98.27    |        |        |
| 161    | JB/T77185.66  | 带盖       | 1      | 98.27    |        |        |
| 162    | JB/T77185.67  | 带盖       | 1      | 98.27    |        |        |
| 163    | JB/T77185.68  | 带盖       | 1      | 98.27    |        |        |
| 164    | JB/T77185.69  | 带盖       | 1      | 98.27    |        |        |
| 165    | JB/T77185.70  | 带盖       | 1      | 98.27    |        |        |
| 166    | JB/T77185.71  | 带盖       | 1      | 98.27    |        |        |
| 167    | JB/T77185.72  | 带盖       | 1      | 98.27    |        |        |
| 168    | JB/T77185.73  | 带盖       | 1      | 98.27    |        |        |
| 169    | JB/T77185.74  | 带盖       | 1      | 98.27    |        |        |
| 170    | JB/T77185.75  | 带盖       | 1      | 98.27    |        |        |
| 171    | JB/T77185.76  | 带盖       | 1      | 98.27    |        |        |
| 172    | JB/T77185.77  | 带盖       | 1      | 98.27    |        |        |
| 173    | JB/T77185.78  | 带盖       | 1      | 98.27    |        |        |
| 174    | JB/T77185.79  | 带盖       | 1      | 98.27    |        |        |
| 175    | JB/T77185.80  | 带盖       | 1      | 98.27    |        |        |
| 176    | JB/T77185.81  | 带盖       | 1      | 98.27    |        |        |
| 177    | JB/T77185.82  | 带盖       | 1      | 98.27    |        |        |
| 178    | JB/T77185.83  | 带盖       | 1      | 98.27    |        |        |
| 179    | JB/T77185.84  | 带盖       | 1      | 98.27    |        |        |
| 180    | JB/T77185.85  | 带盖       | 1      | 98.27    |        |        |
| 181    | JB/T77185.86  | 带盖       | 1      | 98.27    |        |        |
| 182    | JB/T77185.87  | 带盖       | 1      | 98.27    |        |        |
| 183    | JB/T77185.88  | 带盖       | 1      | 98.27    |        |        |
| 184    | JB/T77185.89  | 带盖       | 1      | 98.27    |        |        |
| 185    | JB/T77185.90  | 带盖       | 1      | 98.27    |        |        |
| 186    | JB/T77185.91  | 带盖       | 1      | 98.27    |        |        |
| 187    | JB/T77185.92  | 带盖       | 1      | 98.27    |        |        |
| 188    | JB/T77185.93  | 带盖       | 1      | 98.27    |        |        |
| 189    | JB/T77185.94  | 带盖       | 1      | 98.27    |        |        |
| 190    | JB/T77185.95  | 带盖       | 1      | 98.27    |        |        |
| 191    | JB/T77185.96  | 带盖       | 1      | 98.27    |        |        |
| 192    | JB/T77185.97  | 带盖       | 1      | 98.27    |        |        |
| 193    | JB/T77185.98  | 带盖       | 1      | 98.27    |        |        |
| 194    | JB/T77185.99  | 带盖       | 1      | 98.27    |        |        |
| 195    | JB/T77185.100 | 带盖       | 1      | 98.27    |        |        |
| 196    | JB/T77185.101 | 带盖       | 1      | 98.27    |        |        |
| 197    | JB/T77185.102 | 带盖       | 1      | 98.27    |        |        |
| 198    | JB/T77185.103 | 带盖       | 1      | 98.27    |        |        |
| 199    | JB/T77185.104 | 带盖       | 1      | 98.27    |        |        |
| 200    | JB/T77185.105 | 带盖       | 1      | 98.27    |        |        |
| 201    | JB/T77185.106 | 带盖       | 1      | 98.27    |        |        |
| 202    | JB/T77185.107 | 带盖       | 1      | 98.27    |        |        |
| 203    | JB/T77185.108 | 带盖       | 1      | 98.27    |        |        |
| 204    | JB/T77185.109 | 带盖       | 1      | 98.27    |        |        |
| 205    | JB/T77185.110 | 带盖       | 1      | 98.27    |        |        |
| 206    | JB/T77185.111 | 带盖       | 1      | 98.27    |        |        |
| 207    | JB/T77185.112 | 带盖       | 1      | 98.27    |        |        |
| 208    | JB/T77185.113 | 带盖       | 1      | 98.27    |        |        |
| 209    | JB/T77185.114 | 带盖       | 1      | 98.27    |        |        |
| 210    | JB/T77185.115 | 带盖       | 1      | 98.27    |        |        |
| 211    | JB/T77185.116 | 带盖       | 1      | 98.27    |        |        |
| 212    | JB/T77185.117 | 带盖       | 1      | 98.27    |        |        |
| 213    | JB/T77185.118 | 带盖       | 1      | 98.27    |        |        |
| 214    | JB/T77185.119 | 带盖       | 1      | 98.27    |        |        |
| 215    | JB/T77185.120 | 带盖       | 1      | 98.27    |        |        |
| 216    | JB/T77185.121 | 带盖       | 1      | 98.27    |        |        |
| 217    | JB/T77185.122 | 带盖       | 1      | 98.27    |        |        |
| 218    | JB/T77185.123 | 带盖       | 1      | 98.27    |        |        |
| 219    | JB/T77185.124 | 带盖       | 1      | 98.27    |        |        |
| 220    | JB/T77185.125 | 带盖       | 1      | 98.27    |        |        |
| 221    | JB/T77185.126 | 带盖       | 1      | 98.27    |        |        |
| 222    | JB/T77185.127 | 带盖       | 1      | 98.27    |        |        |
| 223    | JB/T77185.128 | 带盖       | 1      | 98.27    |        |        |
| 224    | JB/T77185.129 | 带盖       | 1      | 98.27    |        |        |
| 225    | JB/T77185.130 | 带盖       | 1      | 98.27    |        |        |
| 226    | JB/T77185.131 | 带盖       | 1      | 98.27    |        |        |
| 227    | JB/T77185.132 | 带盖       | 1      | 98.27    |        |        |
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| 232    | JB/T77185.137 | 带盖       | 1      | 98.27    |        |        |
| 233    | JB/T77185.138 | 带盖       | 1      | 98.27    |        |        |
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| 235    | JB/T77185.140 | 带盖       | 1      | 98.27    |        |        |
| 236    | JB/T77185.141 | 带盖       | 1      | 98.27    |        |        |
| 237    | JB/T77185.142 | 带盖       | 1      | 98.27    |        |        |
| 238    | JB/T77185.143 | 带盖       | 1      | 98.27    |        |        |
| 239    | JB/T77185.144 | 带盖       | 1      | 98.27    |        |        |
| 240    | JB/T77185.145 | 带盖       | 1      | 98.27    |        |        |
| 241    | JB/T77185.146 | 带盖       | 1      | 98.27    |        |        |
| 242    | JB/T77185.147 | 带盖       | 1      | 98.27    |        |        |
| 243    | JB/T77185.148 | 带盖       | 1      | 98.27    |        |        |
| 244    | JB/T77185.149 | 带盖       | 1      | 98.27    |        |        |
| 245    | JB/T77185.150 | 带盖       | 1      | 98.27    |        |        |
| 246    | JB/T77185.151 | 带盖       | 1      | 98.27    |        |        |
| 247    | JB/T77185.152 | 带盖       | 1      | 98.27    |        |        |
| 248    | JB/T77185.153 | 带盖       | 1      | 98.27    |        |        |
| 249    | JB/T77185.154 | 带盖       | 1      | 98.27    |        |        |
| 250    | JB/T77185.155 | 带盖       | 1      | 98.27    |        |        |
| 251    | JB/T77185.156 | 带盖       | 1      | 98.27    |        |        |

# A3-侧刃凸模

其余<sup>0.8</sup> ✓



楼哥设计 29467473  
QQ

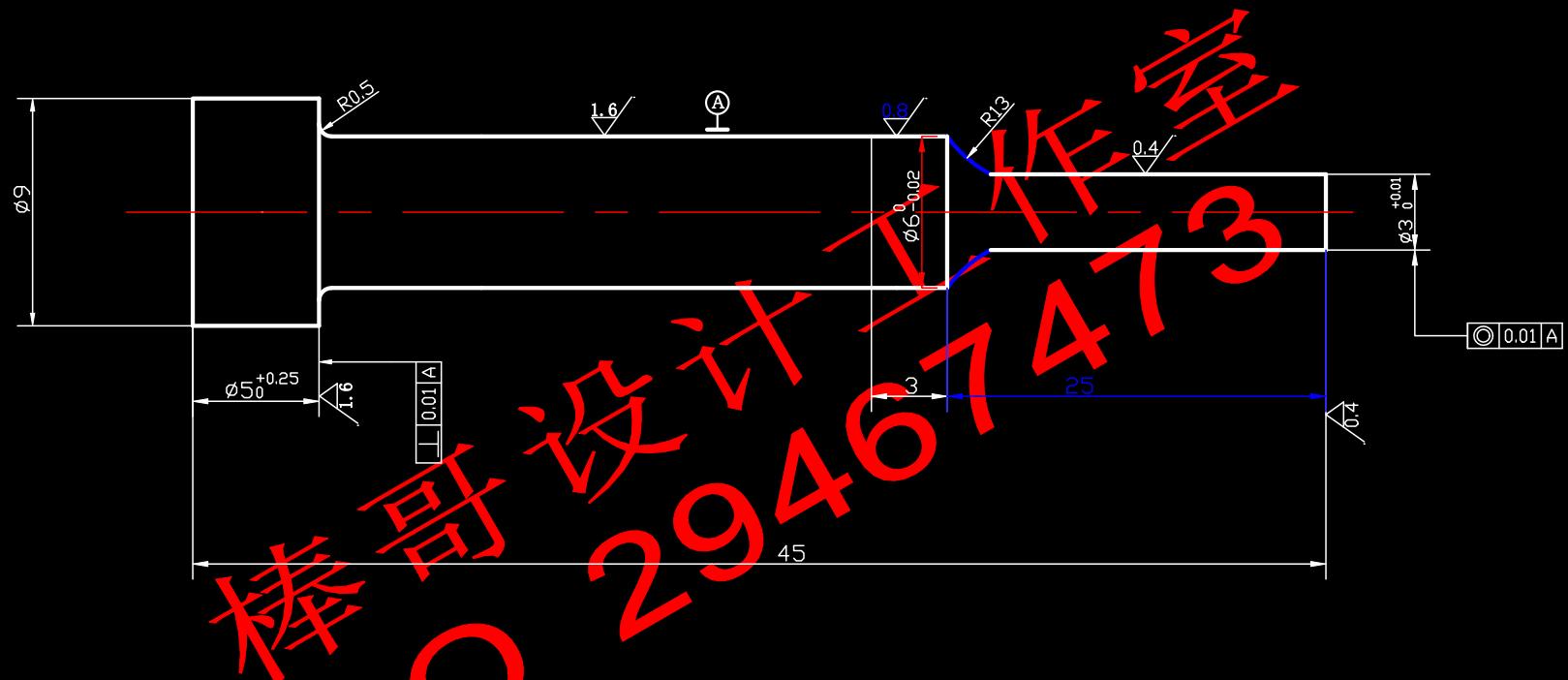
## 技术要求

1. 热处理：工作部分局部淬硬；硬度：HRC58~62。

| Cr12MoV |    |    |       |    |     |      |
|---------|----|----|-------|----|-----|------|
| 标记      | 处数 | 分区 | 更改文件号 | 签名 | 年月日 |      |
| 设计      |    |    | 标准化   |    |     | 阶段标记 |
|         |    |    |       |    |     | 质量   |
| 审核      |    |    |       |    |     | 比例   |
| 工艺      |    |    |       | 批准 |     | 3: 1 |

# A3-冲孔凸模

其余  $\frac{6.3}{\vee}$

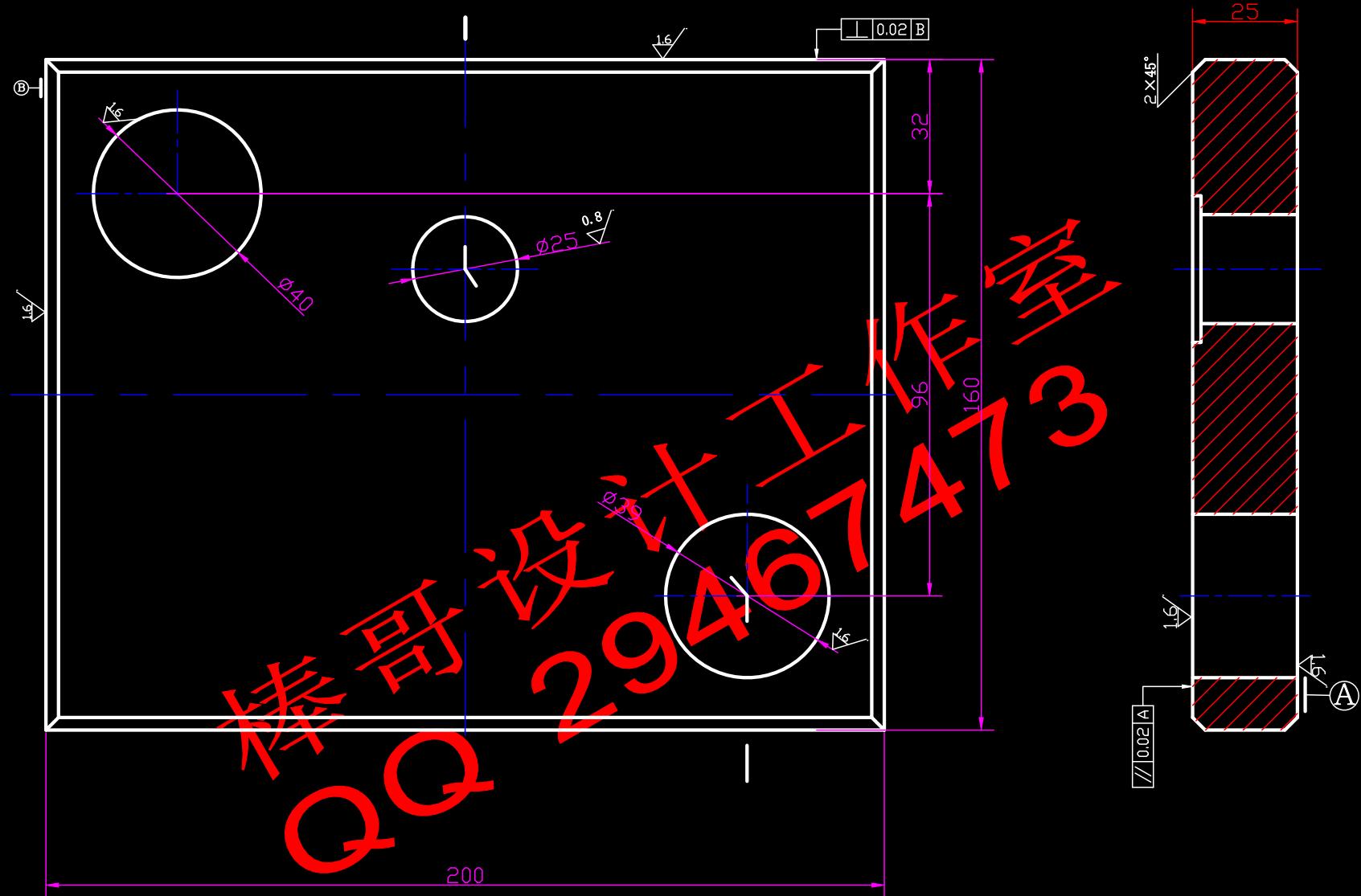


技术要求  
热处理: 工作部分局部淬火, 硬度HRC58~62。

| Cr12MnV |    |    |       |    |     |      |
|---------|----|----|-------|----|-----|------|
| 标记      | 处数 | 分区 | 更改文件号 | 签名 | 年月日 |      |
| 设计      |    |    | 标准化   |    |     | 阶段比例 |
|         |    |    |       |    |     | 质量   |
| 审核      |    |    |       |    |     | 比例   |
|         |    |    |       |    |     | 3: 1 |
| 工艺      |    |    |       | 批准 |     |      |

冲孔凸模

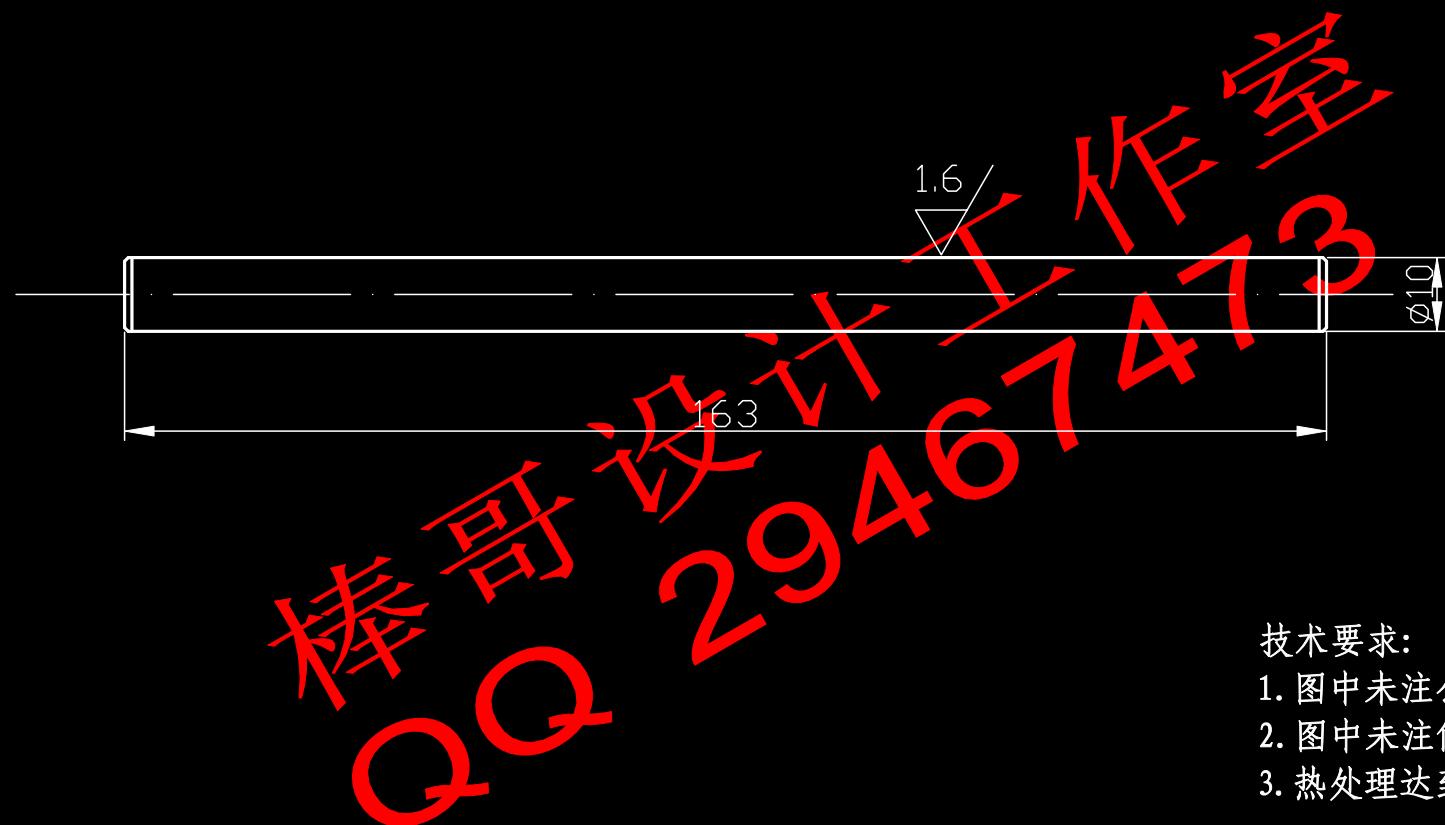
# A3-上模板



| 标记 | 处数 | 分区 | 更改文件号 | 签名 | 年月日 | 45 | 阶段标记 | 质量 | 比例   | 上模座 |
|----|----|----|-------|----|-----|----|------|----|------|-----|
| 设计 |    |    | 标准化   |    |     |    |      |    |      |     |
| 审核 |    |    |       |    |     |    |      |    |      |     |
| 工艺 |    |    |       | 批准 |     |    |      |    | 1: 1 |     |

# A4-打杆

其余 3.2 /



## 技术要求:

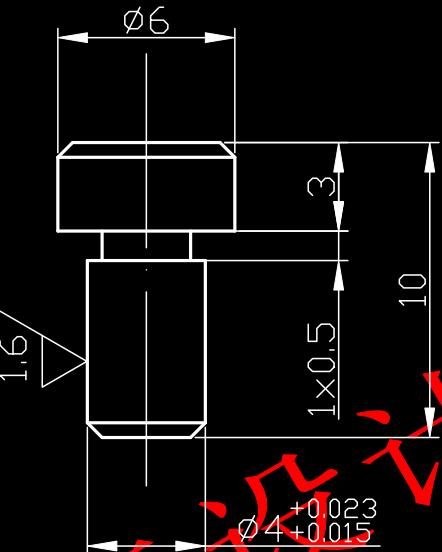
- 图中未注公差为 IT12
- 图中未注倒角为 1
- 热处理达到 43--48HRC

| 打 杆 |  |  | 比例   | 数量 | 材料 | 编号 | 共 页 |
|-----|--|--|------|----|----|----|-----|
| 制图  |  |  | 1: 1 | 1  | 45 |    | 第 页 |
| 审核  |  |  |      |    |    |    |     |

# A4-挡料销

其余

3.2



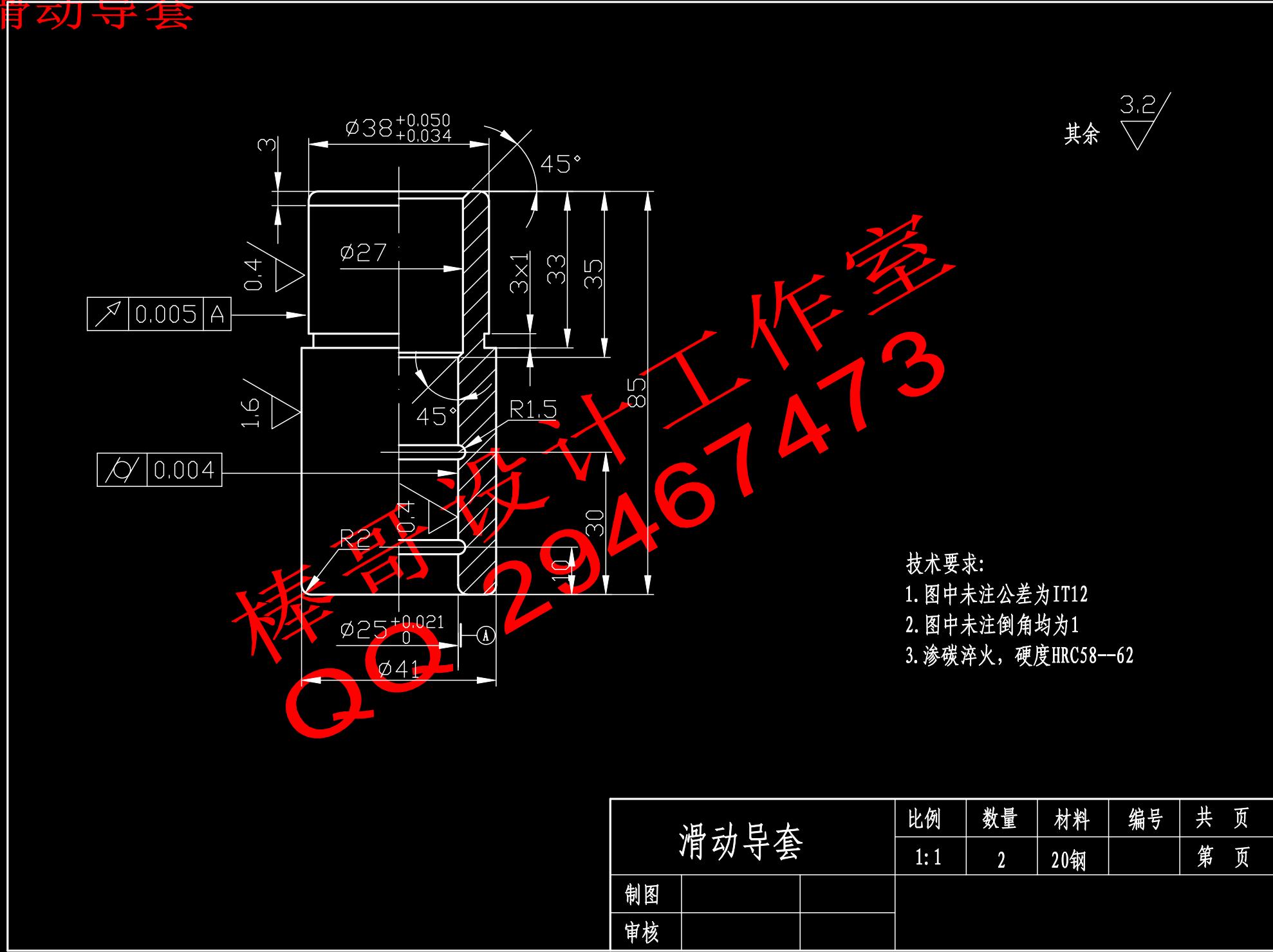
## 技术要求:

- 热处理硬度达42—46HRC
- 未注倒角为0.5

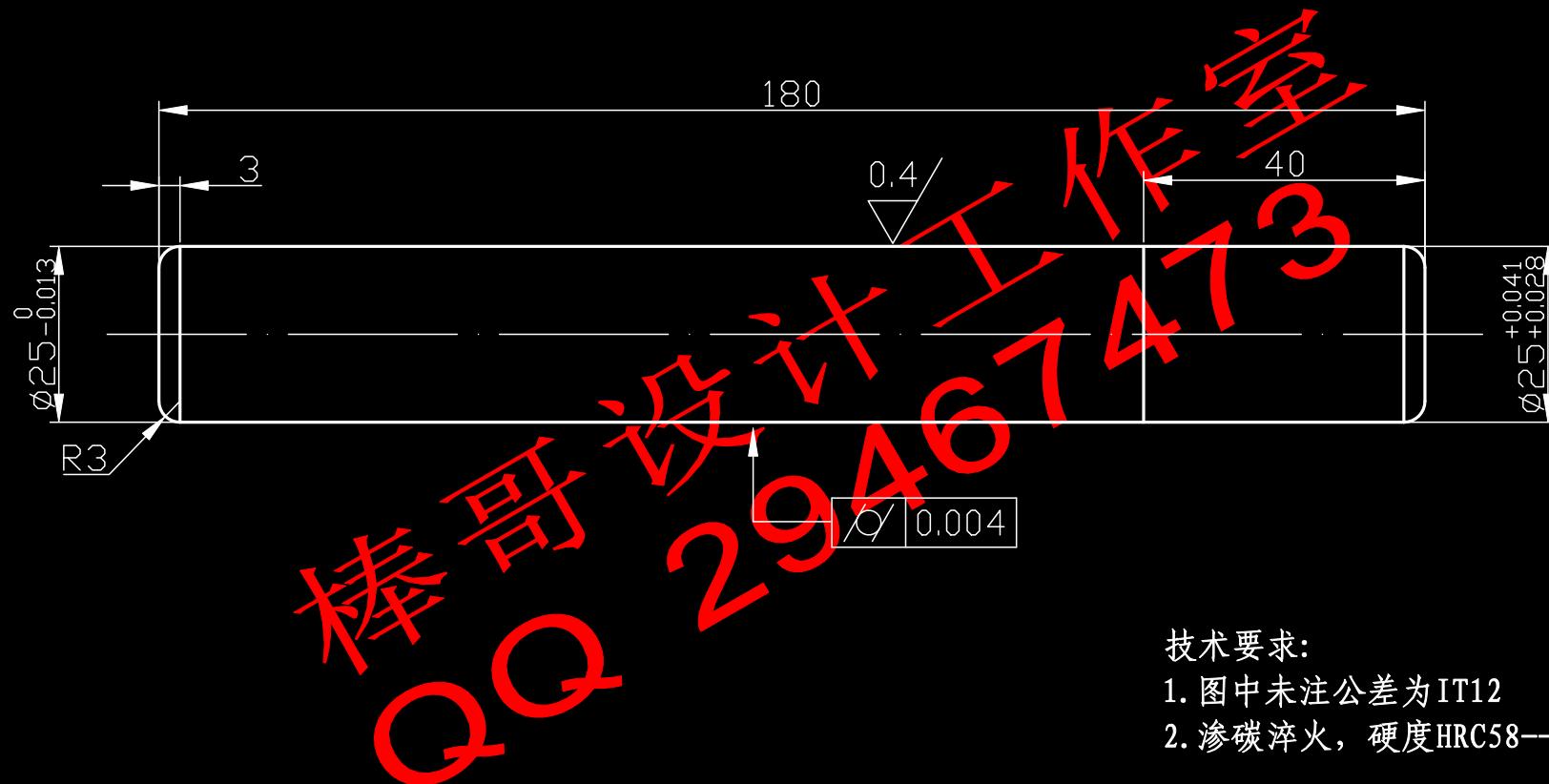
挡料销

| 挡料销 |  |  | 比例   | 数量 | 材料  | 编号 | 共 页 |
|-----|--|--|------|----|-----|----|-----|
| 制图  |  |  | 4: 1 | 1  | 45钢 |    | 第 页 |
| 审核  |  |  |      |    |     |    |     |

# A4-滑动导套



# A4-滑动导柱



技术要求:

1. 图中未注公差为IT12
2. 渗碳淬火, 硬度HRC58--62

| 滑动导柱 |  | 比例   | 数量 | 材料  | 编号  | 共 页 |
|------|--|------|----|-----|-----|-----|
| 制图   |  | 1: 1 | 2  | 20钢 | 第 页 |     |
| 审核   |  |      |    |     |     |     |