

国家建委建筑科学研究院组织审查通过

建筑配件重复使用图集

上翻空腹钢木门

CJ 633

北京市建筑设计院 编制

北京 1975

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北京市建筑设计院 编制

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封面图
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说明

本图集在北京市北郊木材厂的协作配合下,组成三结合试制小组。经过制件、安装、使用、维护、检修、改造、推广等各个环节,共同编制出本图集。并由北郊木材厂组织加工生产。

一、设计选用

1. 本图集主要适用于车库或仓库、厂房等无特殊低温要求的建筑。未考虑防火、防腐、防锈等特殊情况。对已建成的建筑物门洞口与本图集不同时,如需更换门扇者亦适用。
2. 门的代号采用洞口的宽×高尺寸组成(不包括粉饰面)。例如 3636 即为 3600 宽 3600 高。
3. 开启形式分重锤拉杆及重锤折叠两种。立面形式分全板、带玻璃及有王小门等三种。可根据使用要求选用。
4. 为减轻重锤的重量,在导轨内设置了减重导向轮,但相应地加长了钢丝绳。考虑到重锤在不同室内高度的情况,图集设计以重锤入地为主。但也附有重锤不入地的辅助做法。如需选用后者做法时,在加工时必须向厂方明确提出。
5. 选用时应注意门洞上部距顶的高度及两边墙垛的宽度是否符合图集的安装尺寸要求。以免产生差错。

二、施工安装

1. 砌筑洞口时应根据附图要求,预埋附有钢板的预制混凝土块。安装前以洞口中从两边分出槽钢之间的宽度尺寸,并在两边墙上弹出垂直墨线,同时用水准仪找出两槽钢的水平高度,使两根槽钢上各点水平一致,确保门扇安装平整。然后沿墨线将角钢焊接于埋件上,再将槽钢与角钢块用螺栓拧紧,在拧紧前校正槽钢同墙面距离的平行垂直,以利开启。
2. 门扇安装,将减重导向轮放入槽钢轨道内后即应将门竖立起。起杆时将槽钢及门扇上的吊点支座用拉杆连接牢固。折叠式将上扇挂入挂槽钢内,再将上下扇的软绳用螺栓连接牢固。
3. 在安装门扇的同时,将钢丝绳一端系牢在轨道上端固定点上,向

下绕过减重导向轮,再绕过上部滑轮,将钢丝绳另一端联结重锤,门扇即可上下翻动开启。

4. 安装时使门侧各部位尺寸准确的關鍵在于垂直与水平,并严格控制钢丝绳,不得任意加大或减小,因此对上述问题安装时必须给予重视,以免造成开启失灵。

三、材料与制作

1. 门扇骨架全部采用 12 毫米厚冷轧带钢高频焊管,因限于管机的设备能力,目前门扇外骨架的断面刚度稍弱一些,因此附以 60×6 扁钢及大拉手等补强措施便于早日投产,待北郊木材厂改进设备能力后,再修改图集节点。
2. 面板采用双面纤维板,中间蜂窝纸热压板,门扇下部钉 500-600 高钢板,以防踢碰。
3. 轨道采用 L63 槽钢。
4. 管、钢材断料后,全部进行酸洗除锈,涂防锈漆一道,用二氯化碳气体保护焊接,焊缝磨平,校正平直后,安装蜂窝板,最后喷漆二道(颜色由设计人或使用单位选定)出厂。
5. 所有零部件均由厂方配套供应。

四、运输、保管、使用

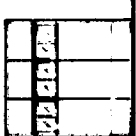
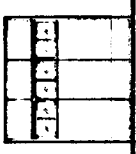
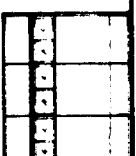
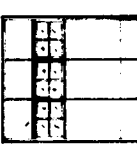
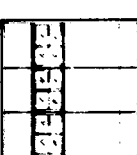
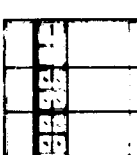
1. 门扇平放运输时顶四角垫平,上下扇之间也须衬垫四角,并用软绳绑扎结实。立放运输时应立架靠平,处之间要衬垫,并用软绳稳住。避免摔跌重压,特别是蜂窝板面,严禁硬物堆压及碰撞,以免损坏变形。
2. 制成品应贮存于干燥阴蔽之处,避免与水泥、石灰等有侵蚀性物质堆放在一起。
3. 使用过程中应经常注意检查钢丝绳及各联结点,发现钢丝绳有断股折丝现象,或联结点螺栓松动时,应及时修理或更换,避免使用时发生安全事故。
4. 为了延长使用年限,每隔 1-2 年应刷油漆一次,防止零件锈蚀及保护板面的防水性能。

图集使用图
1975

说明

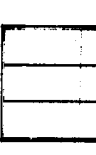
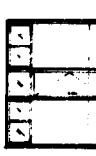
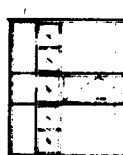
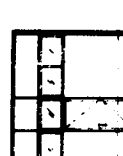
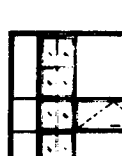
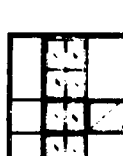
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2100	2400	2700	3000	3300	3600
 M11-2421	 M11-2721		 M11-3024		
 M11-2424	 M11-2724				
	 M21-2730	 M21-3030	 M21-3330	 M21-3630	
		 M21-3033	 M21-3333	 M21-3633	
			 M21-3636	 M21-3639	
				 M21-3639	

门分支号选用说明

门分号		门支号		门扇构造说明
代号	启动方式	代号	门扇构造形式	
1	拉杆式上翻	1	有玻璃	冷轧带钢高频焊矩形管骨架, 双面纤维增强板中嵌蜂窝纸热压板, 下部有钢板踢脚。
2	折叠式上翻	2	有玻璃和小门	
		3	全板	

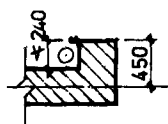
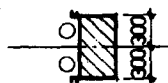
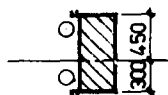
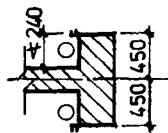
图例		2400	2700	3000	3300	3600
图例	图例	 M13-2421	 M13-2721	 M13-3024		
图例	图例	 M13-2424	 M13-2724	 M12-3024		
图例	图例		 M22-2730	 M22-3030	 M22-3330	 M22-3630
图例	图例			 M22-3033	 M22-3333	 M22-3633
图例	图例				 M22-3336	 M22-3636
图例	图例					 M22-3639
2100	2400	3000	3300	3600	3900	

编号说明见 4 页

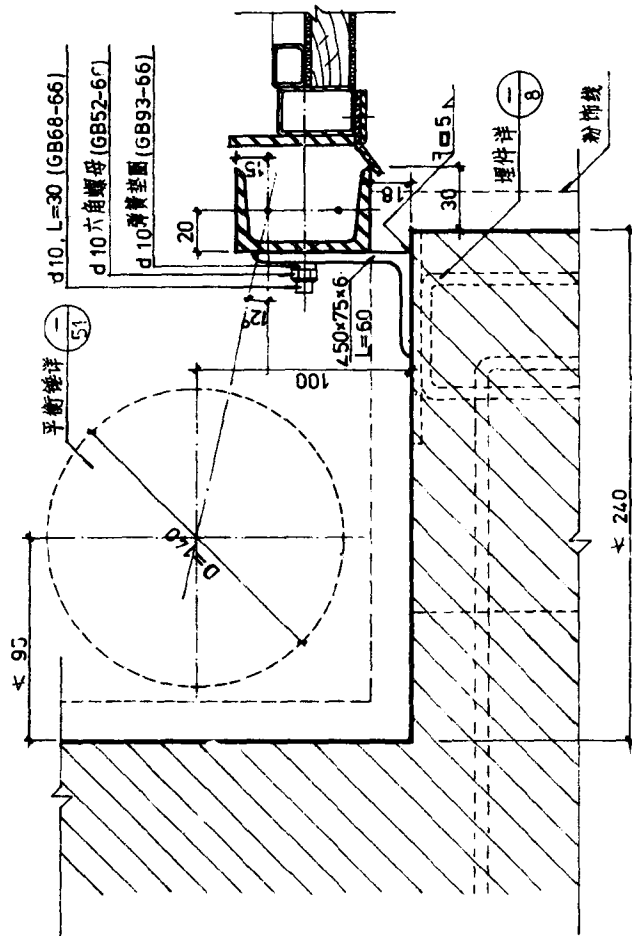
图集使用图
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选用表(二)

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各种墙垛设计尺寸参考

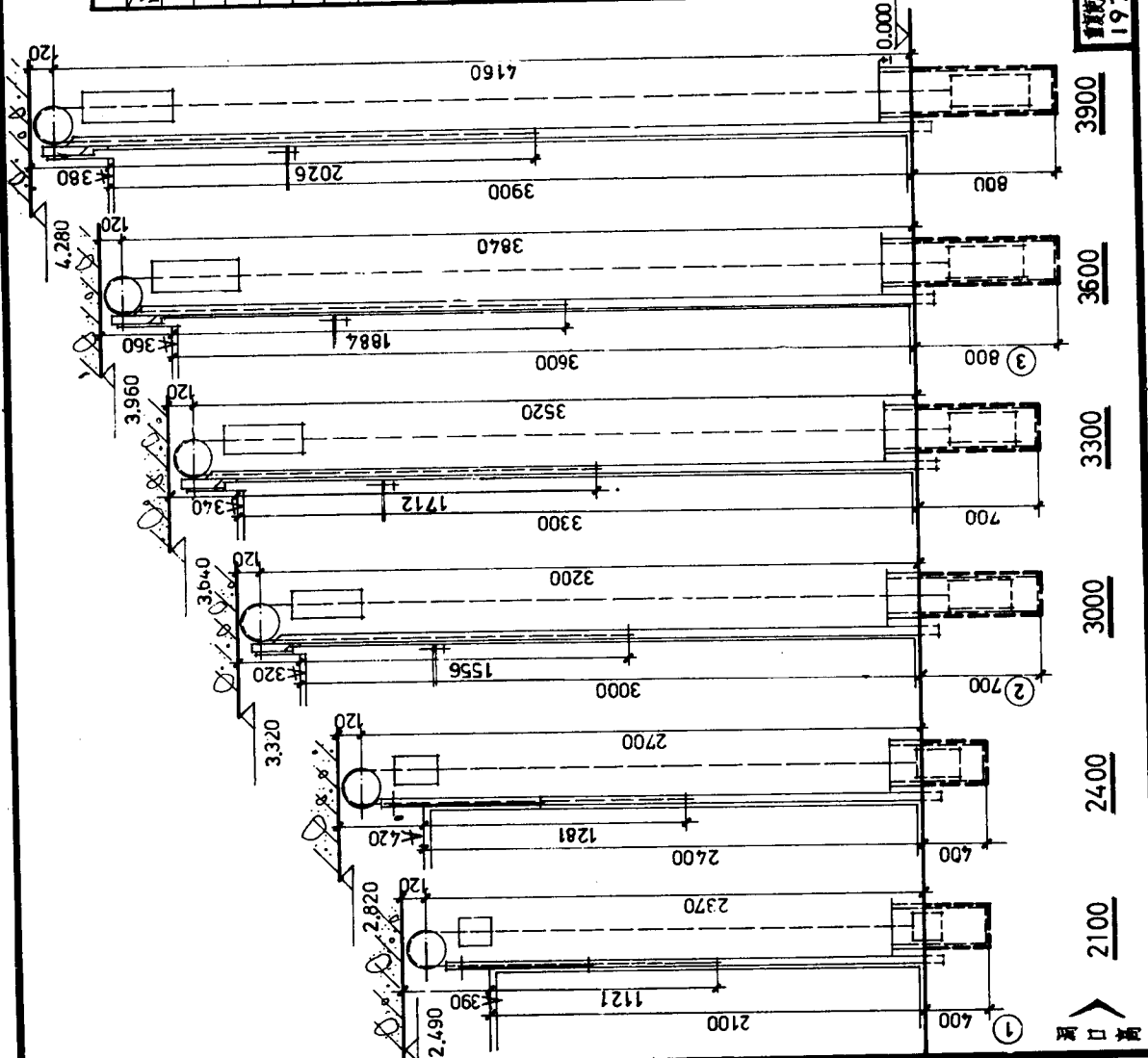


施工说明

1. 预制混凝土埋件位置及数量详见 8 页。
2. 以洞口中从两边分槽钢之间的宽度尺寸，并在两边墙上弹出垂直墨线，将角钢块沿墨线焊于埋件中心，然后安装槽钢需保证各点高低水平一致，距墙尺寸平行垂直一致。
3. 槽钢安装完后，即可挂门扇及安装钢丝绳等。
4. 墙垛参考尺寸供设计参考，也可根据具体设计另定，但不得小于详图所示距墙 240 的距离。

槽钢安装平面

图例	说明
1	平街锤入地坑
2	平街锤入地坑
3	平街锤入地坑



门洞上口到顶板底最小距离	单位: mm
2400	3900
2700	3300
3000	3000
3300	3600
3600	3300
3900	3600

注: 以上尺寸根据门洞装置所需最小净高如土质另有要求, 高度可增不可减。

平街锤入地坑编号	高度	长度	重量
1	2100	1121	0.51
2	2400	1281	0.55
3	3000	1556	0.55
4	3300	1712	0.55
5	3600	1884	0.55
6	3900	2026	0.55

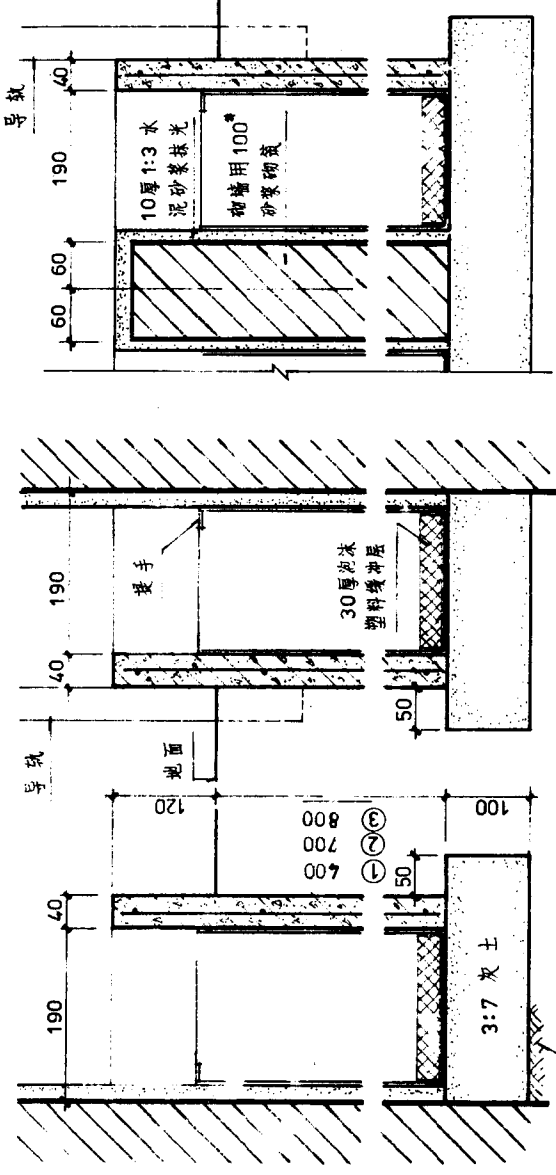
混凝土构件, 铁桶构造见 9 页

各门所需钢丝绳用量	长度 M	重量 kg
2100	2400	3.43
2400	2700	3.80
3000	3300	4.11
3300	3600	4.40
3600	3900	4.75

注: 采用 D 型钢丝绳 GB3655-64
直径 D=3.4 不得大于 4.4
重量 3.4≈4.1kg/100M, 4.4≈6.65kg/100M
表内按 3.4-4.4 之平均重量 5.38kg/100M 计算。

每桶用 门洞高	混凝土构件 编号	铁桶 个
2100	①	2
2400	①	2
3000	②	2
3300	②	2
3600	③	2
3900	③	2

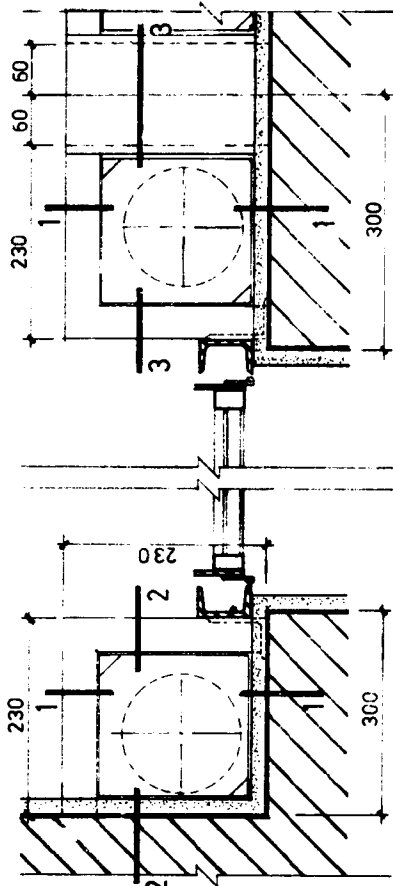
注：
1. 混凝土构件采用 200[#] 细石混凝土捣制，要求表面平整，现场制作。
2. 铁桶用 0.5 厚薄钢板制作，一种规格，三坑通用。
3. 铁桶系备取土时取出桶之用。



素土夯实 / 1—1

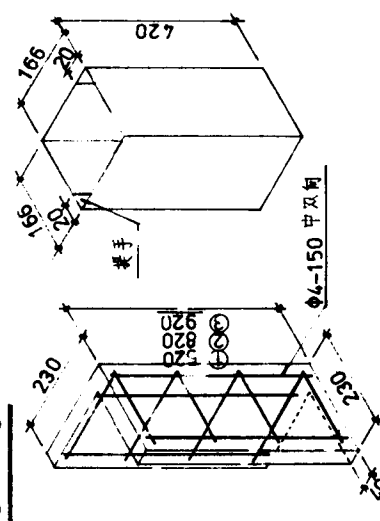
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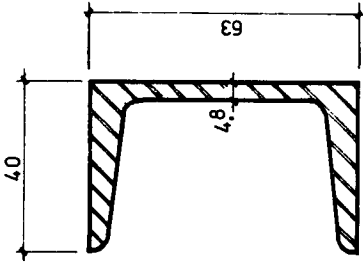
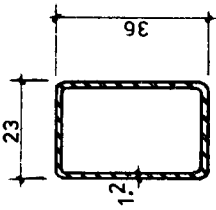
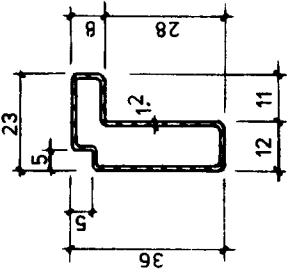
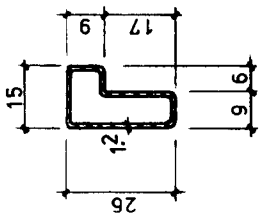
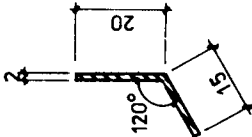
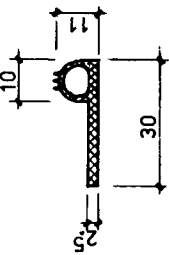
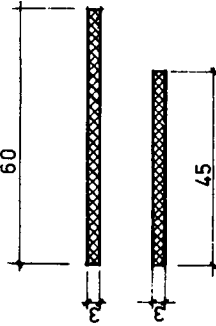
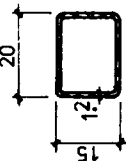
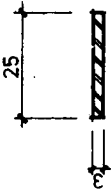
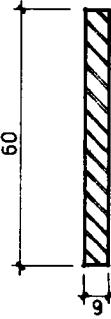
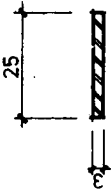
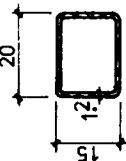
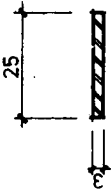
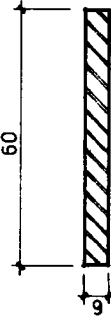
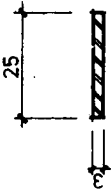
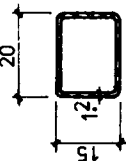
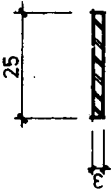
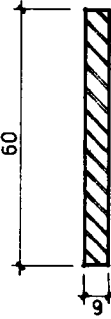
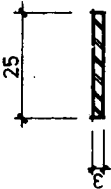
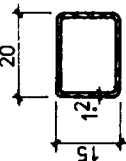
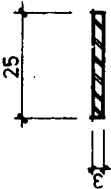
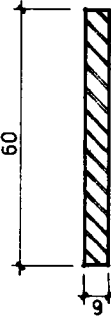
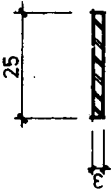
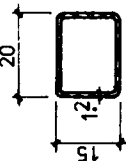
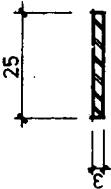
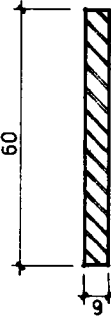
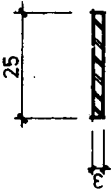
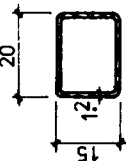
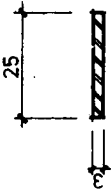
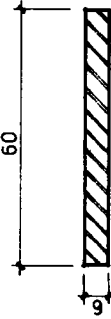
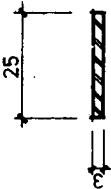
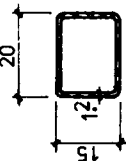
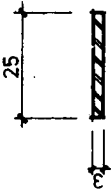
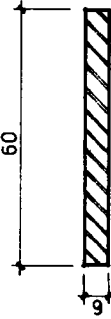
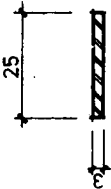
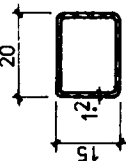
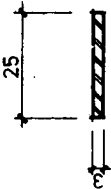
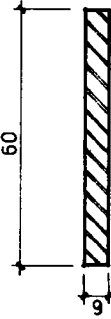
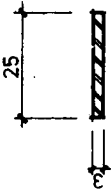
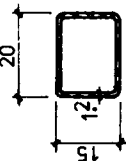
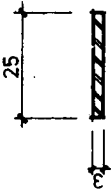
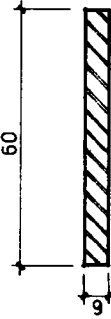
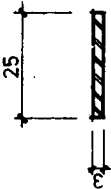
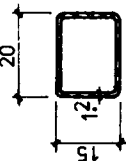
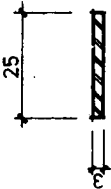
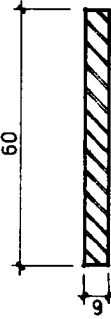
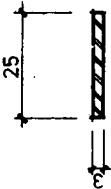
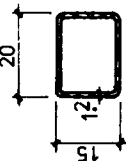
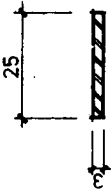
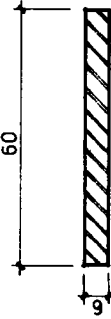
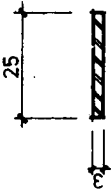
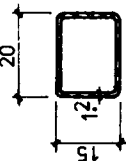
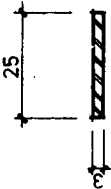
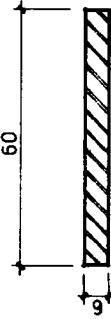
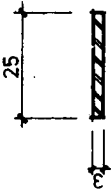
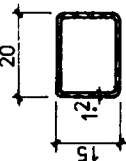
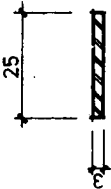
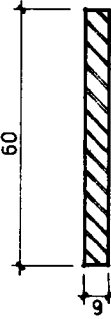
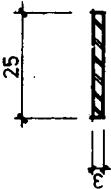
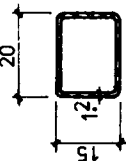
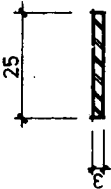
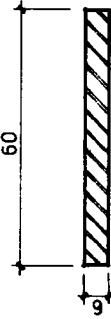
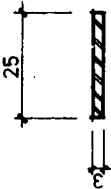
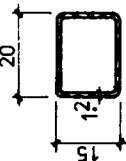
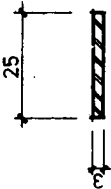
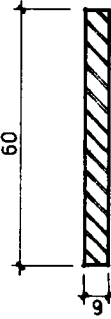
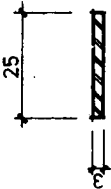
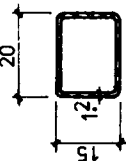
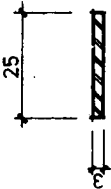
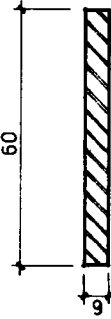
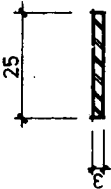
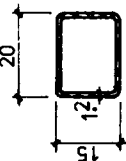
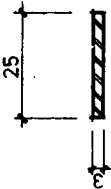
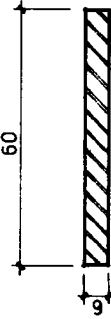
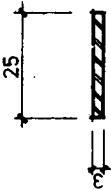
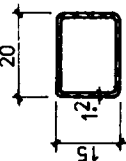
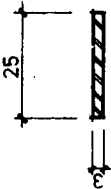
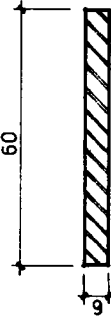
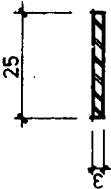
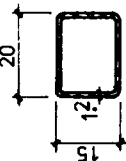
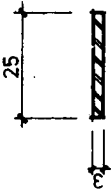
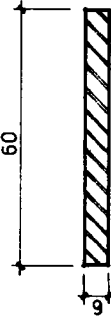
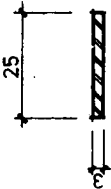
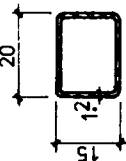
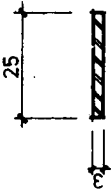
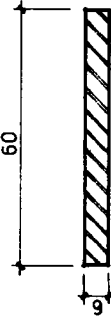
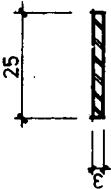
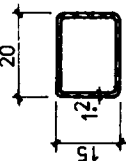
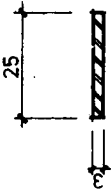
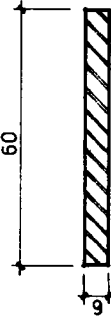
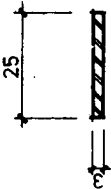
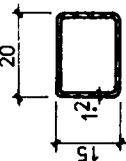
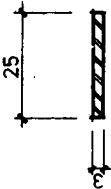
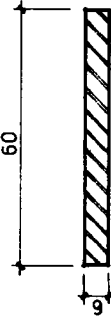
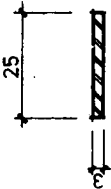
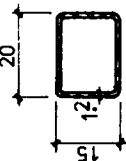
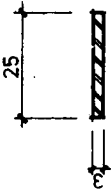
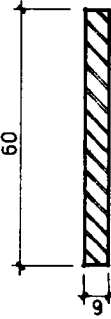
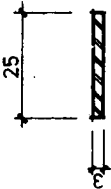
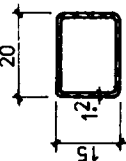
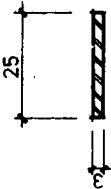
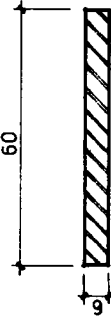
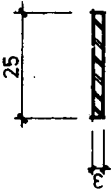
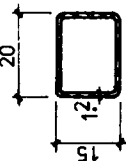
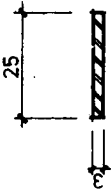
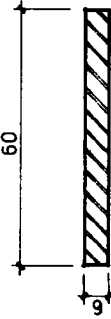
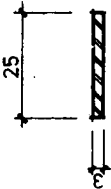
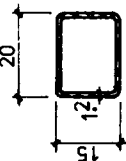
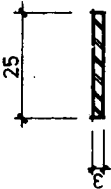
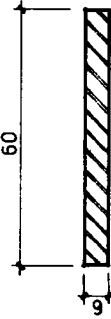
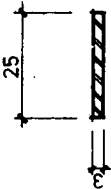
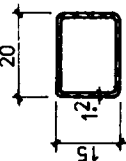
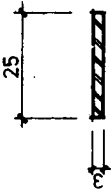
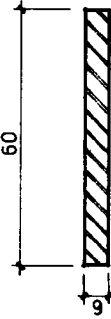
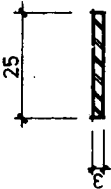
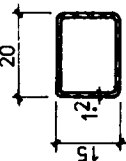
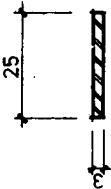
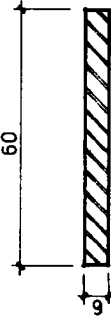
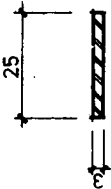
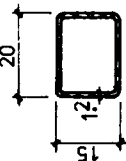
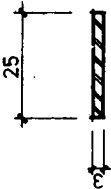
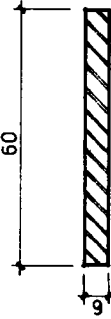
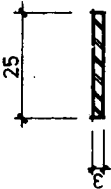
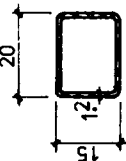
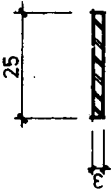
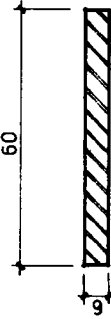
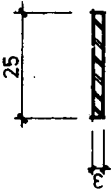
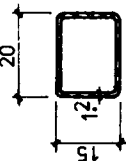
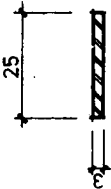
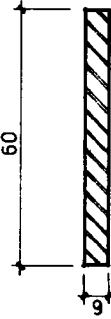
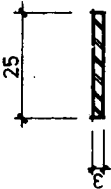
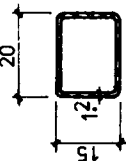
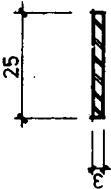
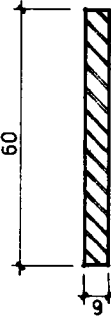
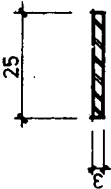
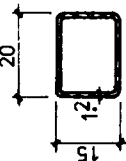
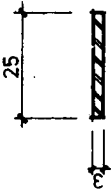
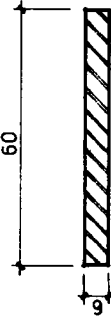
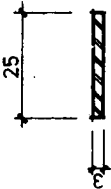
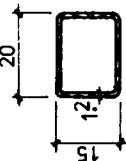
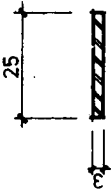
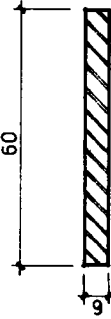
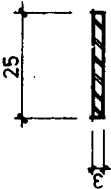
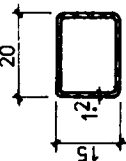
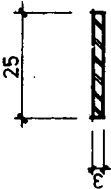
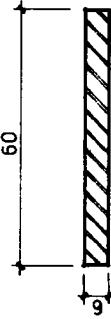
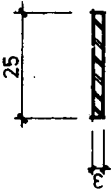
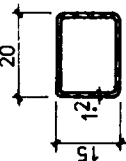
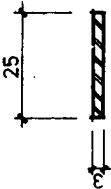
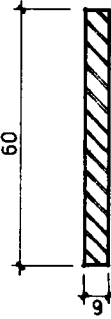
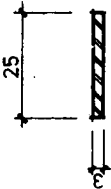
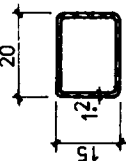
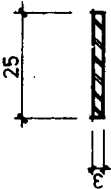
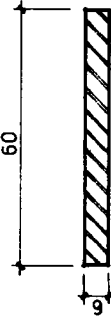
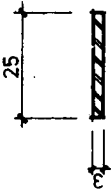
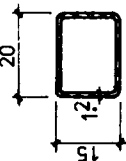
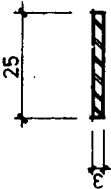
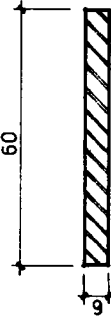
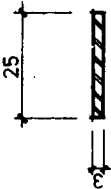
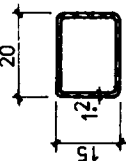
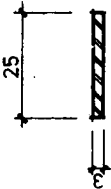
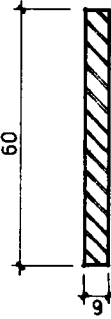
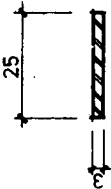
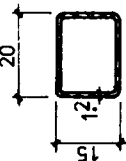
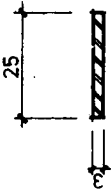
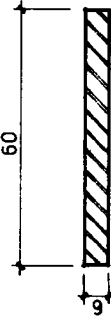
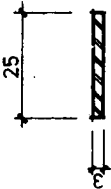
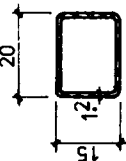
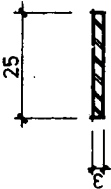
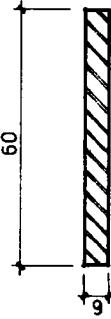
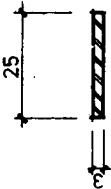
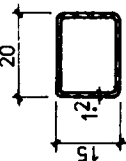
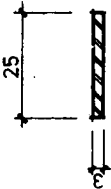
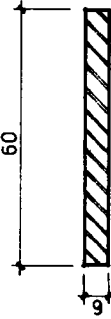
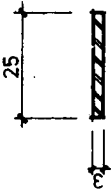
3—3



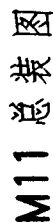
平衡锤坑平面

混凝土构件透视 铁桶透视

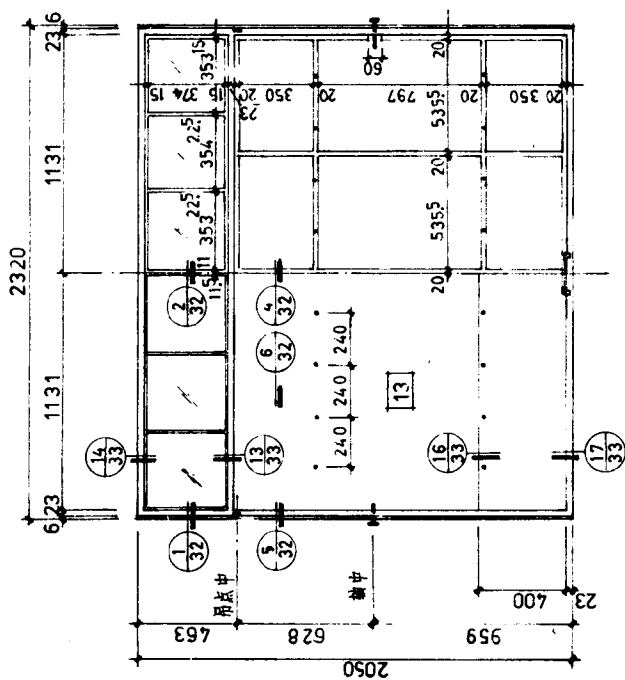


	槽钢(导轨) 6.63kg/M		23x36矩形管 1.07 kg / M		1# 异形管 1.07 kg / M		2# 异形管 0.77 kg/M
	钢板(拨水条) 0.55kg/M		盖缝 6字橡胶条		盖缝平板橡胶条		15x20 矩形管 0.66 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
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	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M		钢带(盖缝板) 0.59 kg / M		钢带(盖缝板) 0.59 kg / M
	钢带(加强板) 2.83 kg / M		钢带(加强板) 2.83 kg / M				

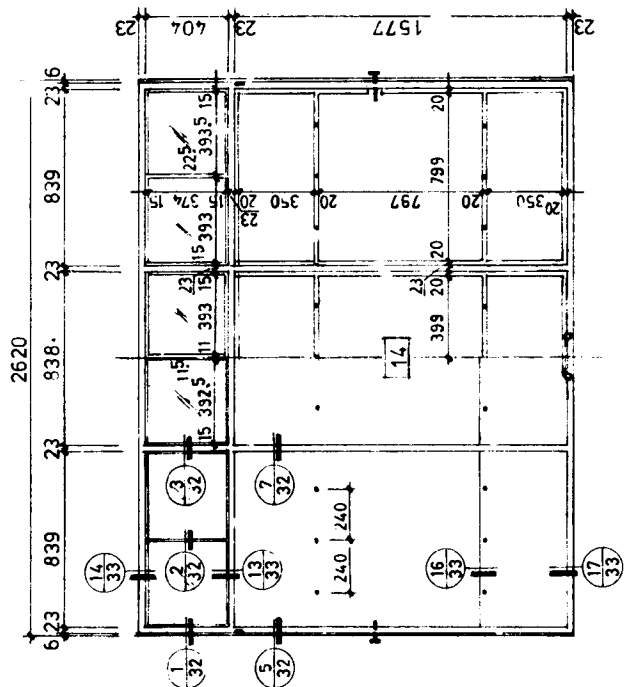
料号	页次	名	称	单	量	材	料
1	44	滑轮			2		
2	40	拉杆			2		
3	39	上吊点			2		
4	39	下吊点			2		
5	45	减重导向滑轮组			2		
6	50	滑轮			2		
7	51	平衡锤			2		灰口铸铁
8	9	平衡锤入地坑			2		
9	7	钢丝绳			2		钢丝绳绳径 φD=34-44
10	49	碰头①			2		
11	49	碰头②			2		
12	36	拉手④	3000重吊 (④①)		2		
13	—	δ=1 踢脚板			—		薄钢板
14	37	侧边导轨			2		
15	—	玻璃			—		3mm
16	34	面板			—		24mm厚
17	10	橡胶条			—		3mm厚
18	10	6字形橡胶条			—		



注: 管路及零部件全部采用二氧化碳气体保护焊; M12有小门(小门零件同17页), M13为全板。



M11-2421
骨架图

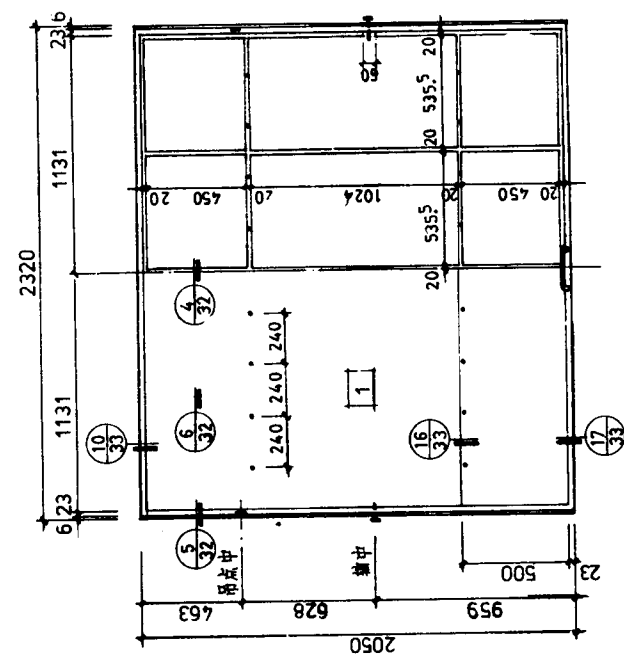


M11-2721
骨架图

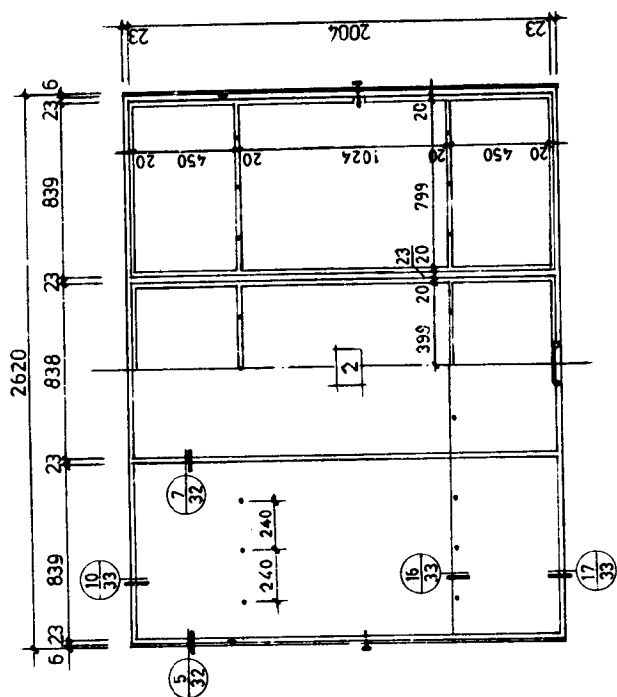
门号	每樘门用蜂窝板(块)		
	板号	规格(宽×高)	数量
M11-2421	[13]	1136×1577	2
M11-2721	[14]	839×1577	3

门 号	每樘门用钢量(公斤)		
	带 钢	型 钢	铸 铁 共 重
M11-2421	29.77	58.11	144.46
M11-2721	38.67	58.97	158.58

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	505	506	507	508	509	510	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	526	527	528	529	530	531	532	533	534	535	536	537	538	539	540	541	542	543	544	545	546	547	548	549	550	551	552	553	554	555	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	571	572	573	574	575	576	577	578	579	580	581	582	583	584	585	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	601	602	603	604	605	606	607	608	609	610	611	612	613	614	615	616	617	618	619	620	621	622	623	624	625	626	627	628	629	630	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	646	647	648	649	650	651	652	653	654	655	656	657	658	659	660	661	662	663	664	665	666	667	668	669	670	671	672	673	674	675	676	677	678	679	680	681	682	683	684	685	686	687	688	689	690	691	692	693	694	695	696	697	698	699	700	701	702	703	704	705	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	721	722	723	724	725	726	727	728	729	730	731	732	733	734	735	736	737	738	739	740	741	742	743	744	745	746	747	748	749	750	751	752	753	754	755	756	757	758	759	760	761	762	763	764	765	766	767	768	769	770	771	772	773	774	775	776	777	778	779	780	781	782	783	784	785	786	787	788	789	790	791	792	793	794	795	796	797	798	799	800	801	802	803	804	805	806	807	808	809	810	811	812	813	814	815	816	817	818	819	820	821	822	823	824	825	826	827	828	829	830	831	832	833	834	835	836	837	838	839	840	841	842	843	844	845	846	847	848	849	850	851	852	853	854	855	856	857	858	859	860	861	862	863	864	865	866	867	868	869	870	871	872	873	874	875	876	877	878	879	880	881	882	883	884	885	886	887	888	889	890	891	892	893	894	895	896	897	898	899	900	901	902	903	904	905	906	907	908	909	910	911	912	913	914	915	916	917	918	919	920	921	922	923	924	925	926	927	928	929	930	931	932	933	934	935	936	937	938	939	940	941	942	943	944	945	946	947	948	949	950	951	952	953	954	955	956	957	958	959	960	961	962	963	964	965	966	967	968	969	970	971	972	973	974	975	976	977	978	979	980	981	982	983	984	985	986	987	988	989	990	991	992	993	994	995	996	997	998	999	1000	1001	1002	1003	1004	1005	1006	1007	1008	1009	1010	1011	1012	1013	1014	1015	1016	1017	1018	1019	1020	1021	1022	1023	1024	1025	1026	1027	1028	1029	1030	1031	1032	1033	1034	1035	1036	1037	1038	1039	1040	1041	1042	1043	1044	1045	1046	1047	1048	1049	1050	1051	1052	1053	1054	1055	1056	1057	1058	1059	1060	1061	1062	1063	1064	1065	1066	1067	1068	1069	1070	1071	1072	1073	1074	1075	1076	1077	1078	1079	1080	1081	1082	1083	1084	1085	1086	1087	1088	1089	1090	1091	1092	1093	1094	1095	1096	1097	1098	1099	1100	1101	1102	1103	1104	1105	1106	1107	1108	1109	1110	1111	1112	1113	1114	1115	1116	1117	1118	1119	1120	1121	1122	1123	1124	1125	1126	1127	1128	1129	1130	1131	1132	1133	1134	1135	1136	1137	1138	1139	1140	1141	1142	1143	1144	1145	1146	1147	1148	1149	1150	1151	1152	1153	1154	1155	1156	1157	1158	1159	1160	1161	1162	1163	1164	1165	1166	1167	1168	1169	1170	1171	1172	1173	1174	1175	1176	1177	1178	1179	1180	1181	1182	1183	1184	1185	1186	1187	1188	1189	1190	1191	1192	1193	1194	1195	1196	1197	1198	1199	1200	1201	1202	1203	1204	1205	1206	1207	1208	1209	1210	1211	1212	1213	1214	1215	1216	1217	1218	1219	1220	1221	12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M13—2421 骨架图



M13-2721
图 5

门号	每罐门用峰窝板(块)		
	板号	规格(宽×高)	数量
M13-2421	1	1136×2004	2
M13-2721	2	839×2004	3

门 号	每座门用钢量(公斤)			
	带 钢	型 钢	铆 铁	共 重
M13-2421	25.18	59.96	52.22	137.36
M13-2721	30.62	60.98	56.58	148.18

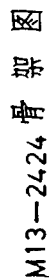


图 架 骨

① = M13-2724

② = M13-3024

注: 3000 宽门下焊 ① ② 拉手各 1 个

代号	门 号	每樘门用蜂窝板(块)		
		板 号	规 格 (宽×高)	数 量
	M13-2424	115	1136×1157	4
①	M13-2724	117	839×1157	6
②	M13-3024	116	939×1157	6

代号	门 号	每座门用钢量(公斤)			
		带 钢	型 钢	铸 铁	共 重
	M13-2424	29.91	69.39	56.58	155.88
①	M13-2724	36.65	70.56	65.30	172.51
②	M13-3024	39.58	71.93	69.66	181.17