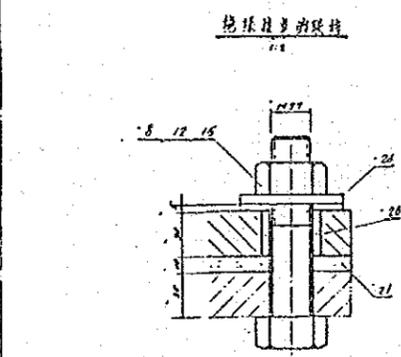
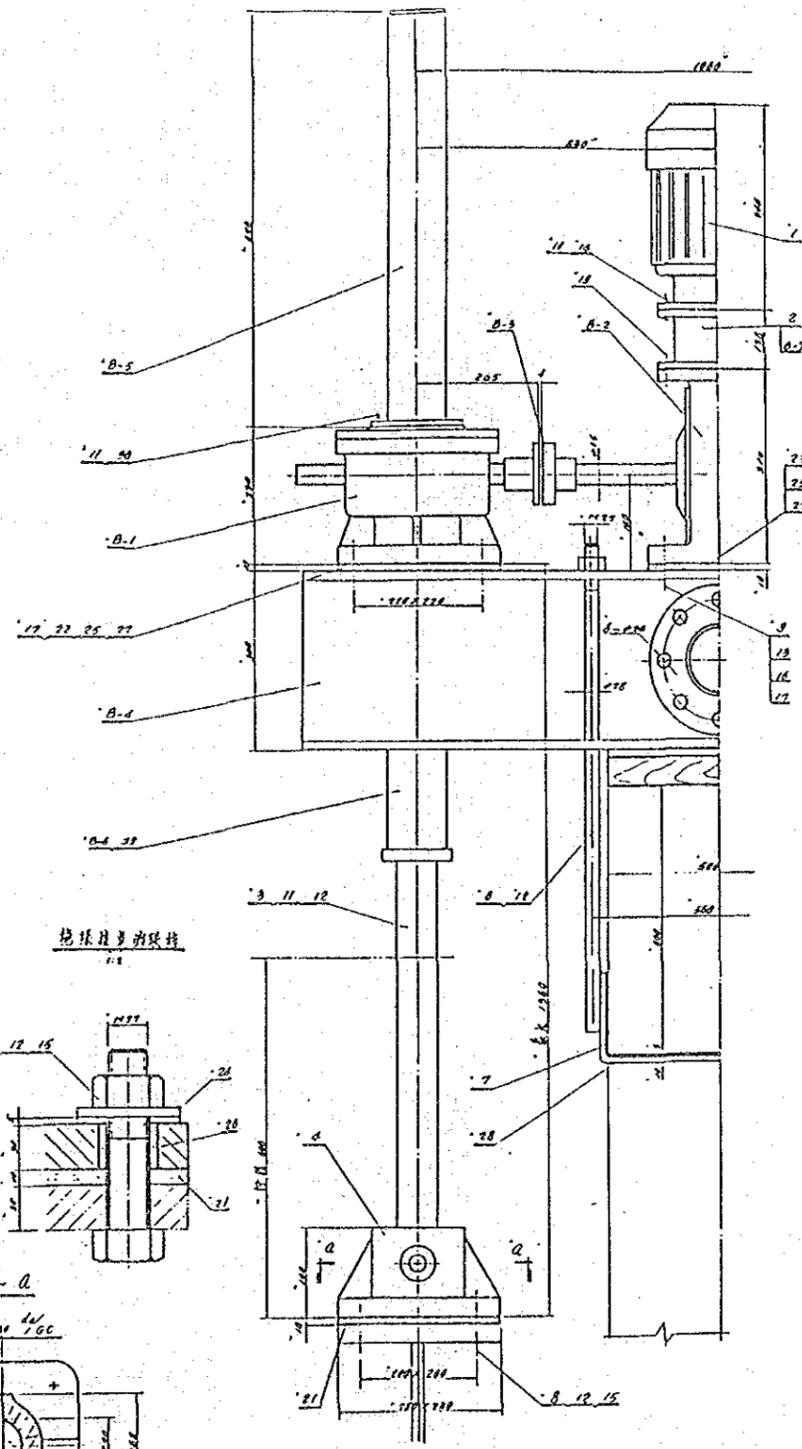
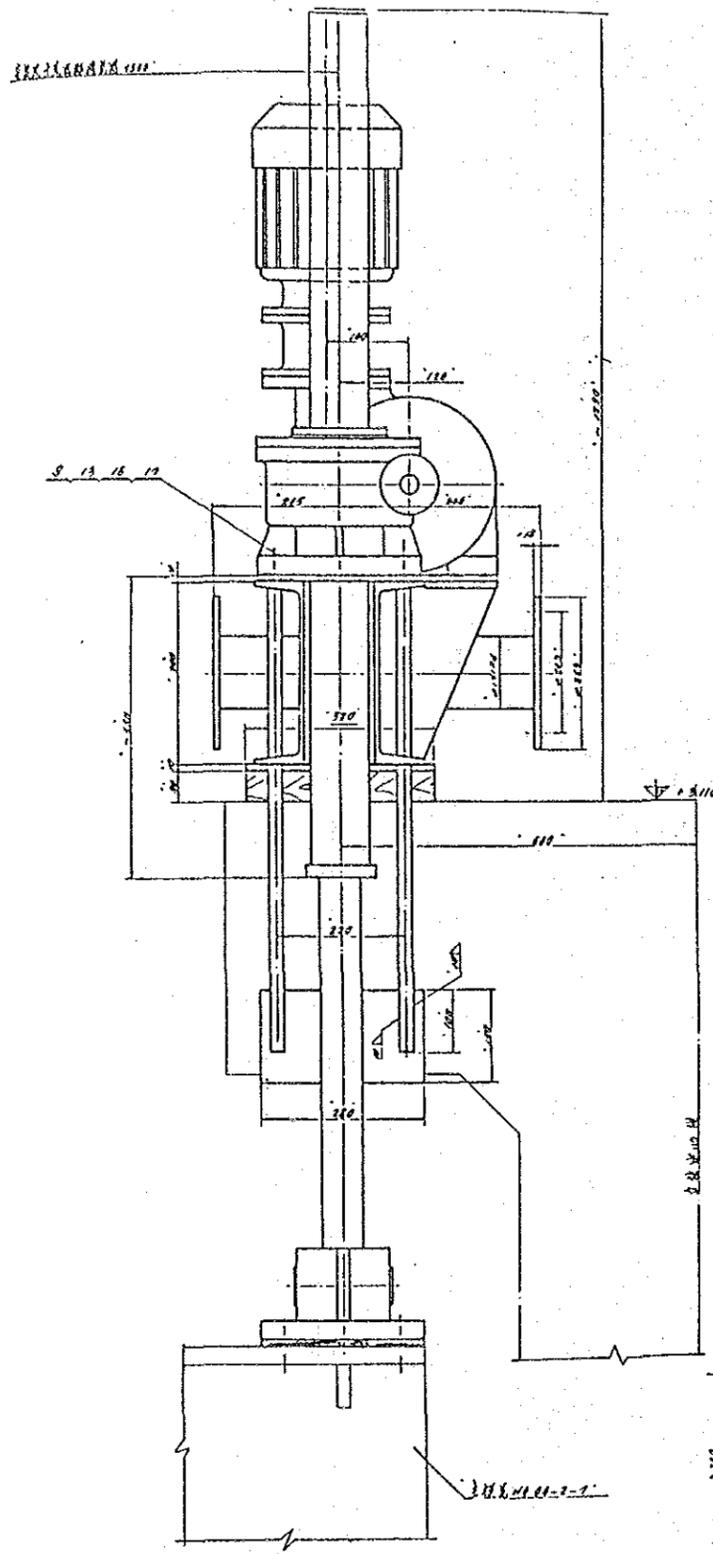


ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
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1. 旋床加工精度要求: 0.01mm/100mm
2. 旋床加工的公差要求: 0.01mm/100mm
3. 旋床加工精度: 0.01mm/100mm
4. 旋床加工精度: 0.01mm/100mm
5. 旋床加工精度: 0.01mm/100mm
6. 旋床加工精度: 0.01mm/100mm

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
29	轴	1	0.1	45#	
28	轴套	1	0.1	45#	
27	轴套	1	0.1	45#	
26	轴套	1	0.1	45#	
25	轴套	1	0.1	45#	
24	轴套	1	0.1	45#	
23	轴套	1	0.1	45#	
22	轴套	1	0.1	45#	
21	轴套	1	0.1	45#	
20	轴套	1	0.1	45#	
19	轴套	1	0.1	45#	
18	轴套	1	0.1	45#	
17	轴套	1	0.1	45#	
16	轴套	1	0.1	45#	
15	轴套	1	0.1	45#	
14	轴套	1	0.1	45#	
13	轴套	1	0.1	45#	
12	轴套	1	0.1	45#	
11	轴套	1	0.1	45#	
10	轴套	1	0.1	45#	
9	轴套	1	0.1	45#	
8	轴套	1	0.1	45#	
7	轴套	1	0.1	45#	
6	轴套	1	0.1	45#	
5	轴套	1	0.1	45#	
4	轴套	1	0.1	45#	
3	轴套	1	0.1	45#	
2	轴套	1	0.1	45#	
1	轴套	1	0.1	45#	
0-7	轴套	1	0.1	45#	
0-6	轴套	1	0.1	45#	
0-5	轴套	1	0.1	45#	
0-4	轴套	1	0.1	45#	
0-3	轴套	1	0.1	45#	
0-2	轴套	1	0.1	45#	
0-1	轴套	1	0.1	45#	



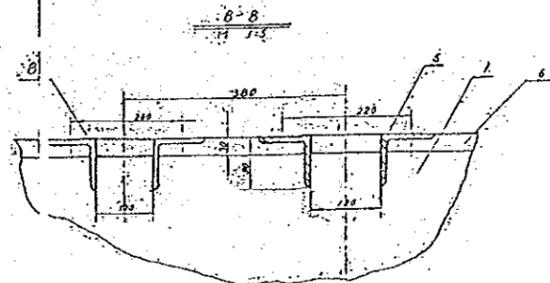
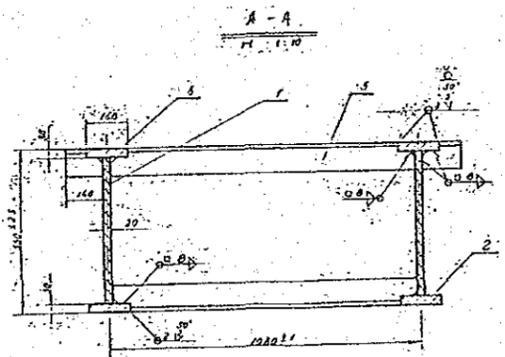
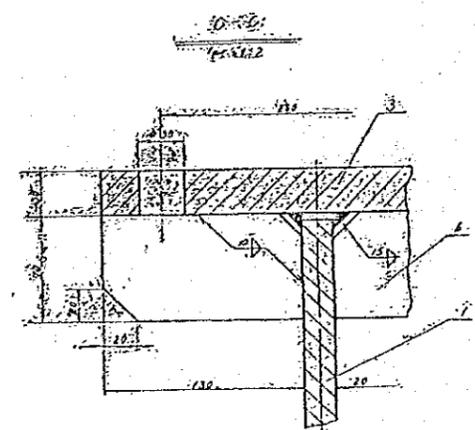
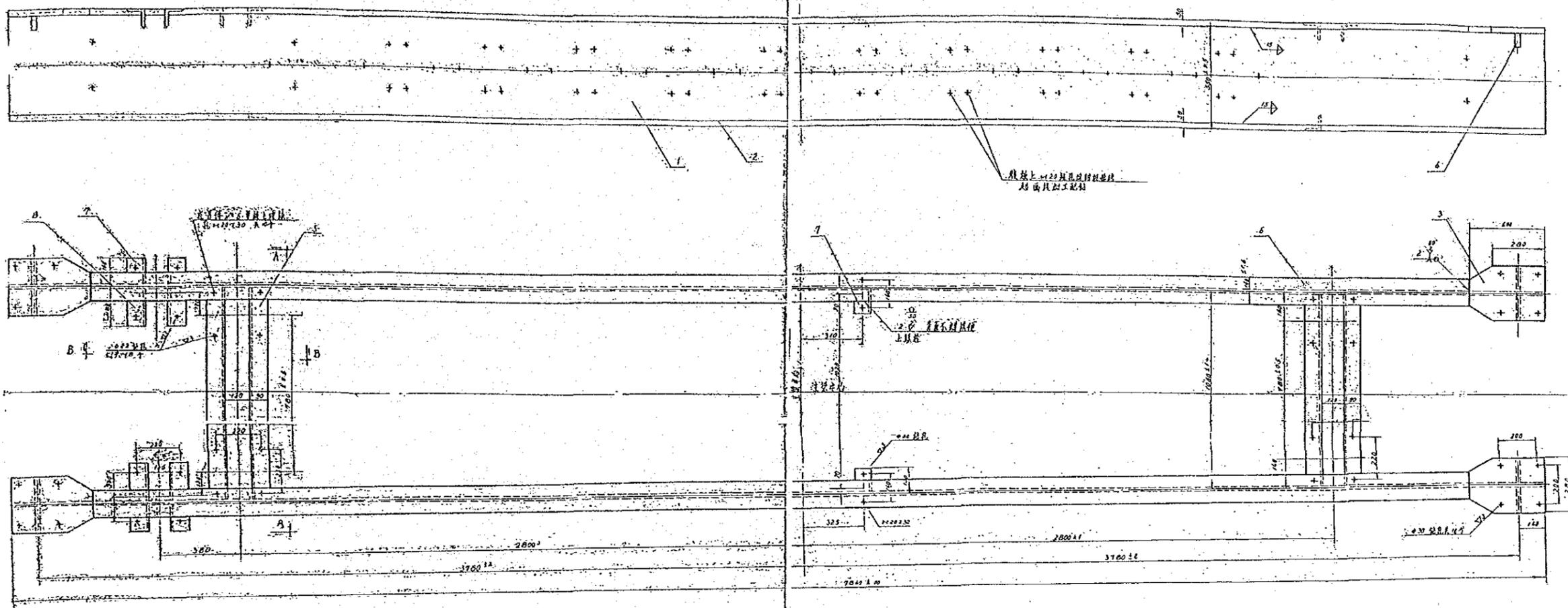
1. 旋床加工精度要求: 0.01mm/100mm
 2. 旋床加工的公差要求: 0.01mm/100mm
 3. 旋床加工精度: 0.01mm/100mm

DRAWN BY	
CHECKED BY	ビームジャッキ
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			

A-4-5(a)

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS



- 附註
1. 鋼管壁に地脚孔を付し埋込物を打設せよ
 2. 上取眼以上の100mm以内は必ず鋼管壁に鋼板を貼付し、地脚孔の位置は鋼管壁の中心線に一致せよ
 3. 鋼管壁の継ぎ目には必ず鋼板を貼付せよ
 4. 本圖は第二種電線厂高80mm電線押込機用のものである
 5. 鋼管壁の寸法は規格JIS S 5031に準じて製する

品名	規格	数量	単位	重量	備註
鋼管	φ100×4	4	m	17.60	
鋼板	φ100×4	6	m	12.32	
鋼板	φ100×4	2	m	2.66	
鋼板	φ100×4	6	m	11.64	
鋼板	φ100×4	8	m	11.16	
鋼板	φ100×4	6	m	24.36	
鋼板	φ100×4	2	m	250.516	
鋼板	φ100×4	2	m	570.116	

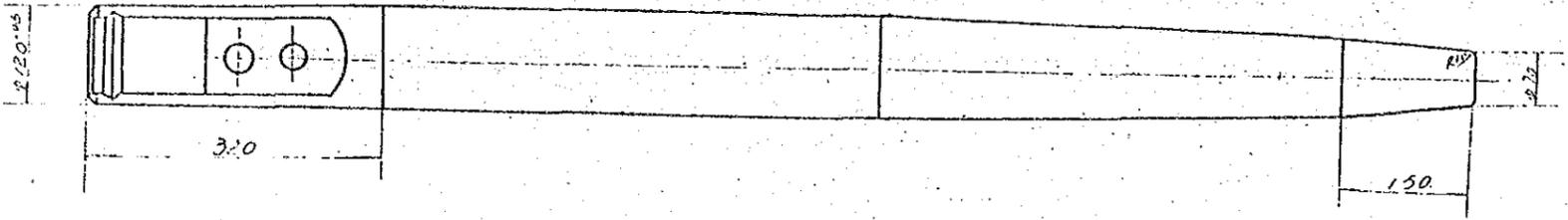
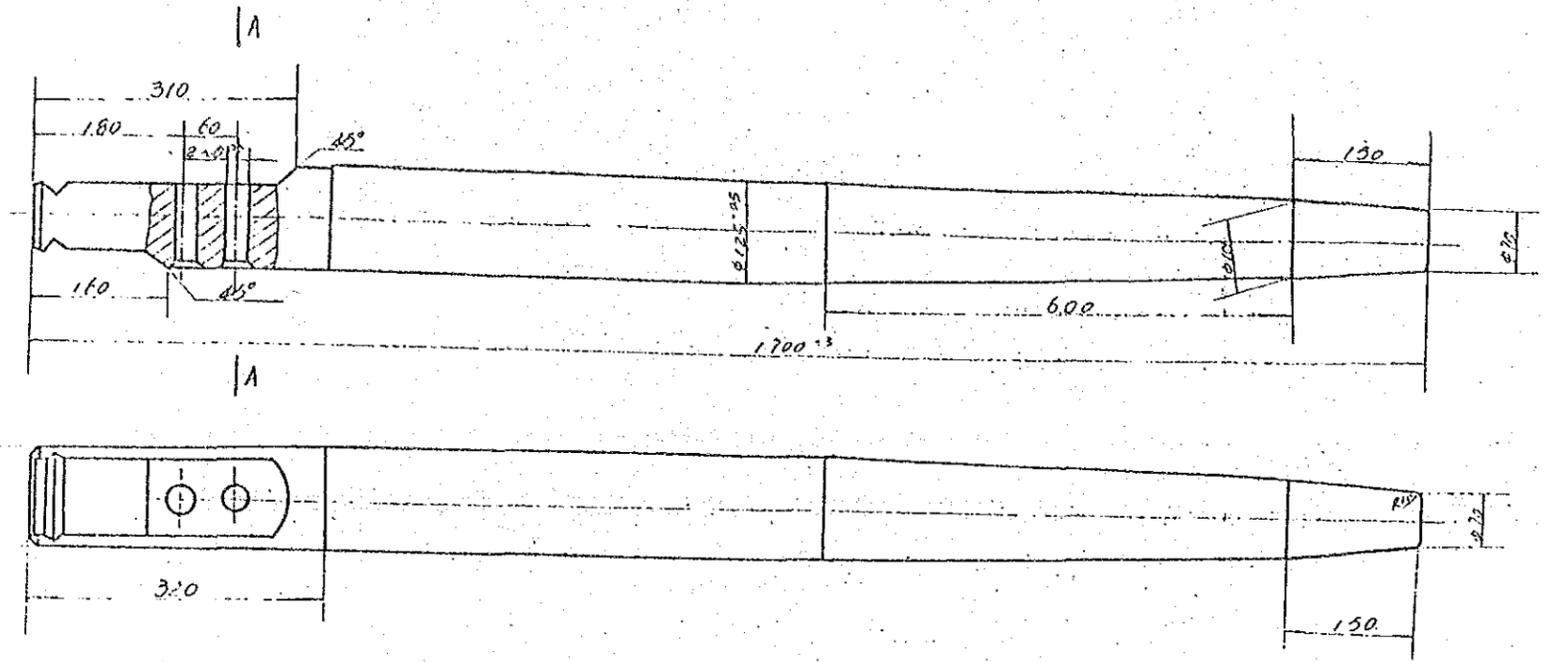
A-4-6

DRAWN BY	メインビーム
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

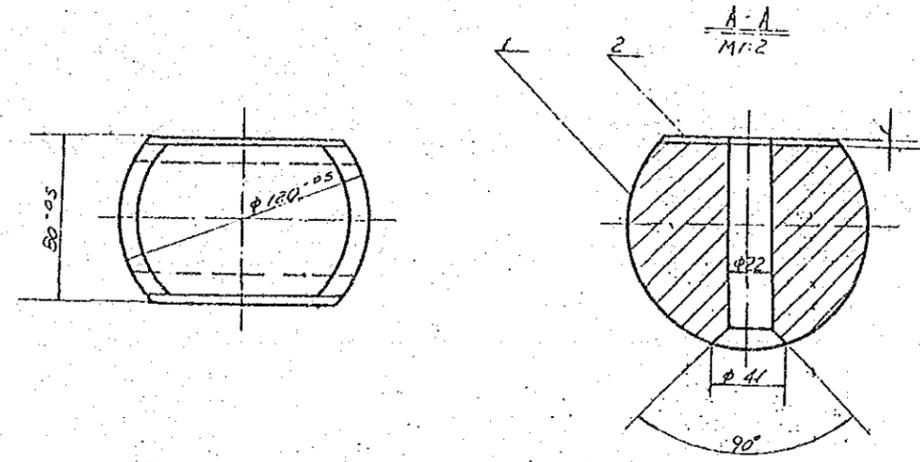
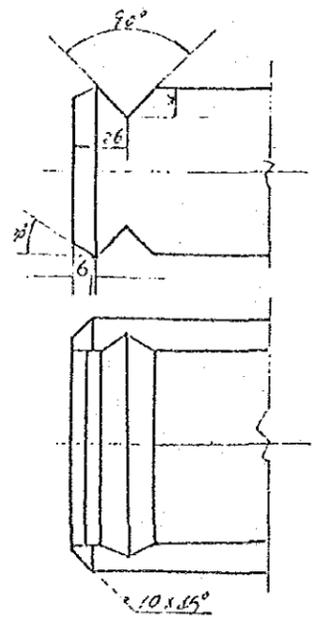
ITEM	DATE	REVISIONS	CHECKED
△			
△			

4		5			
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

全部▽



指定寸法前加工寸



2	添鉛層	δ=1	Ac		
1	鋁板棒	φ120x1700	A3		

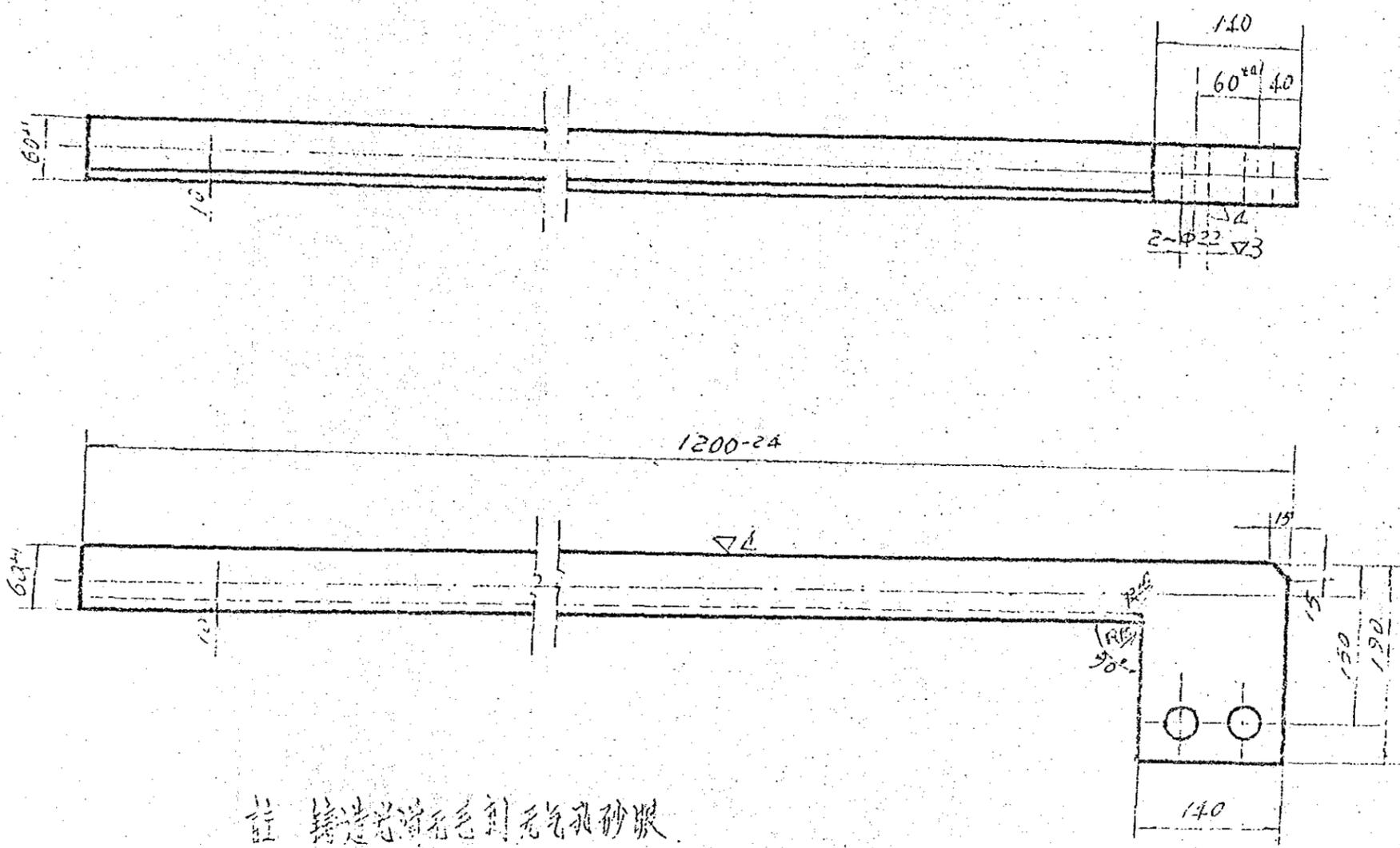
A-4-7(a)

DRAWN BY	スパイク	
CHECKED BY		
APPROVED BY		
DATE		
SCALE	DWG. NO.	REV
△		△

ITEM	DATE	REVISIONS	CHECKED

4				5	
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

其末ニ



註 鑄造時滑石粉を孔に砂眼

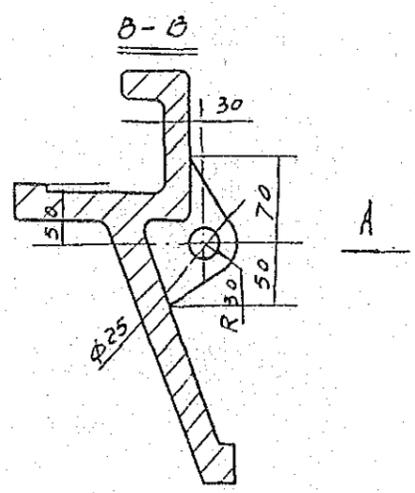
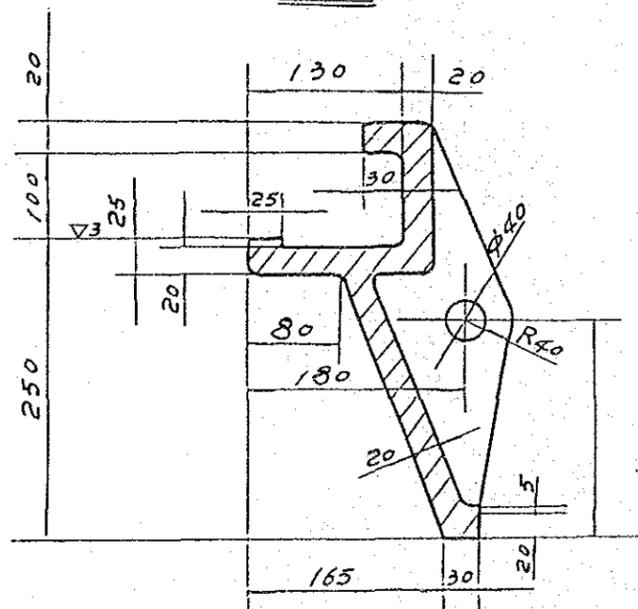
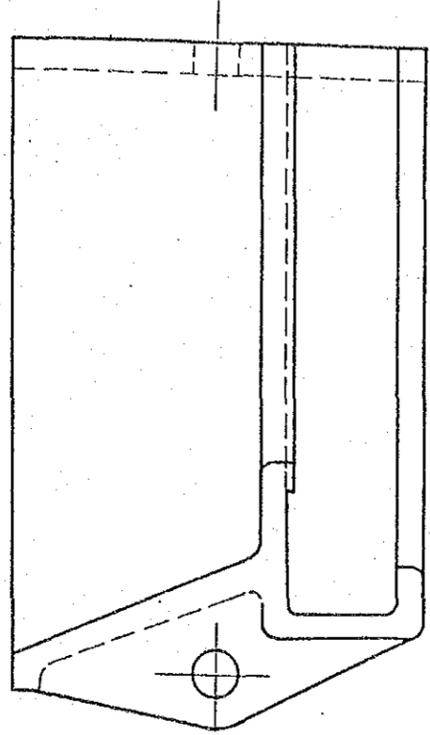
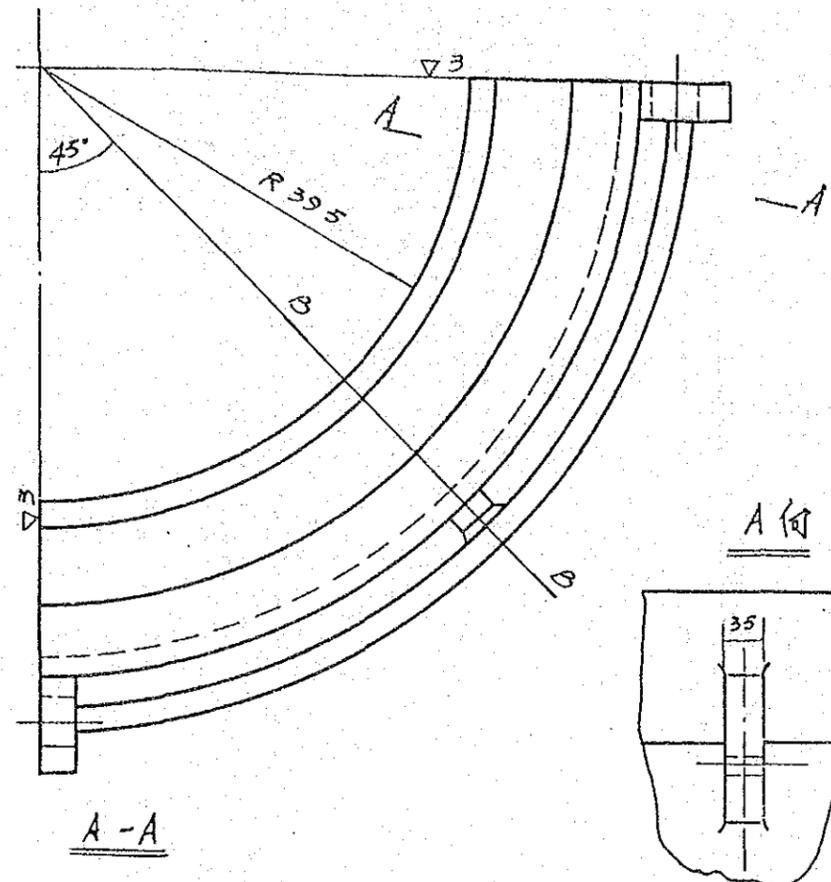
A-4-7 (b)

上掛	掛	190x60	鋁	145	02-2-259
		1200	A1		

DRAWN BY	スパイクハンガー
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

△	△	△
ITEM	DATE	REVISIONS

4		5			
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS



▽3之平面在保证铸件平直时
可不加工。
铸造圆角R10

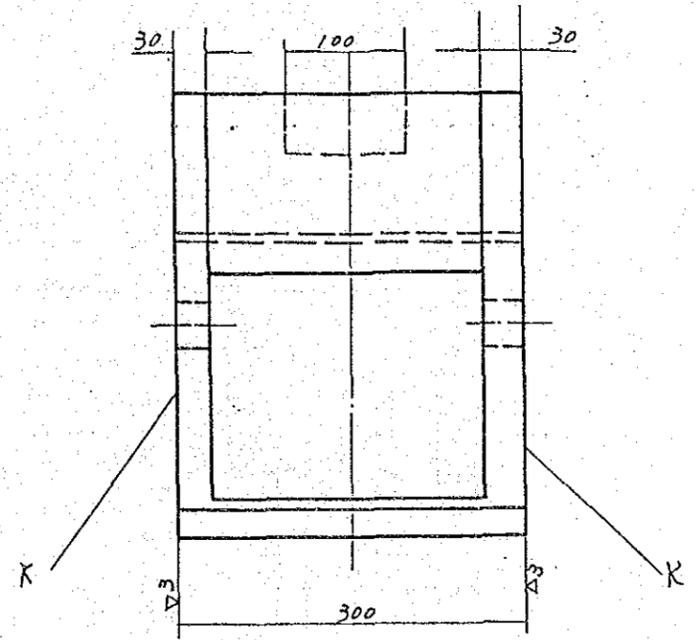
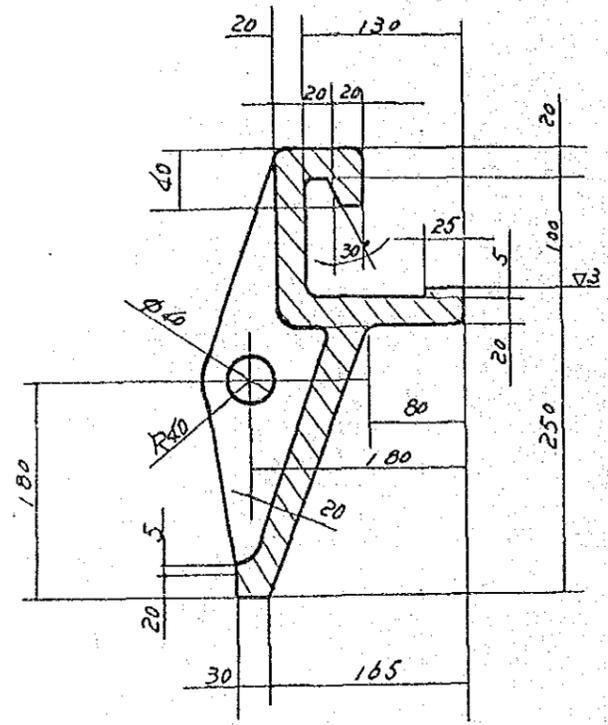
1:5 1 此件槽 集气罩 α=90° 母线 铸钢 80 | A-4-9(a)

DRAWN BY	ガススカート (コーナー用)
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			

4				5	
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

其余



铸造圆角 R10mm.
 K面欠不平行度 不大于 1mm.
 ▽3 平面在保证铸件平直时
 允许不加工。

A-4-9 (b)

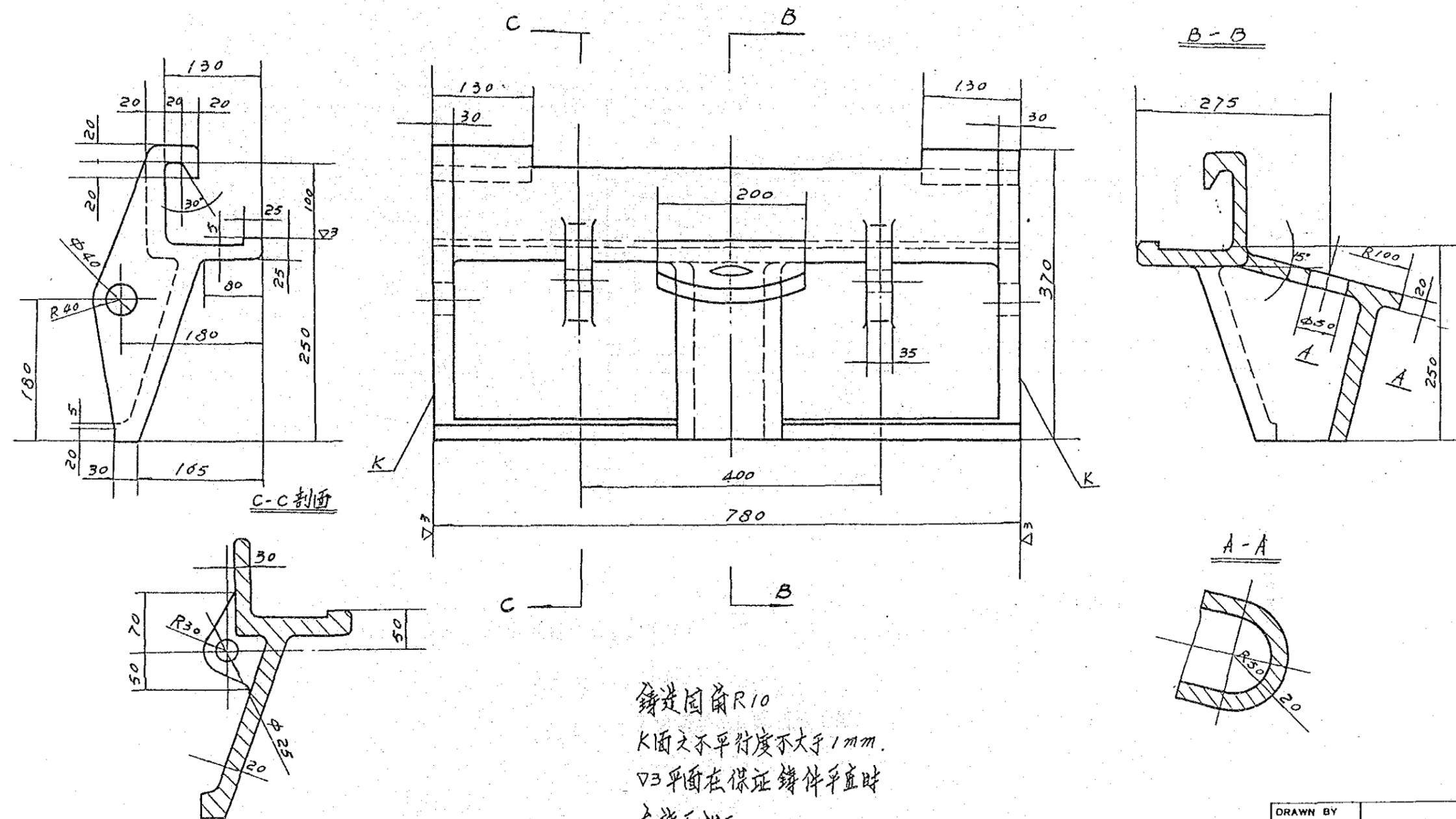
1.5.4 电解槽 集气罩 l=300 雨棚 铸钢 26

DRAWN BY	ガススカート (コーナー補助用)
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

△	△	REVISIONS	CHECKED

4		5			
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

其余~



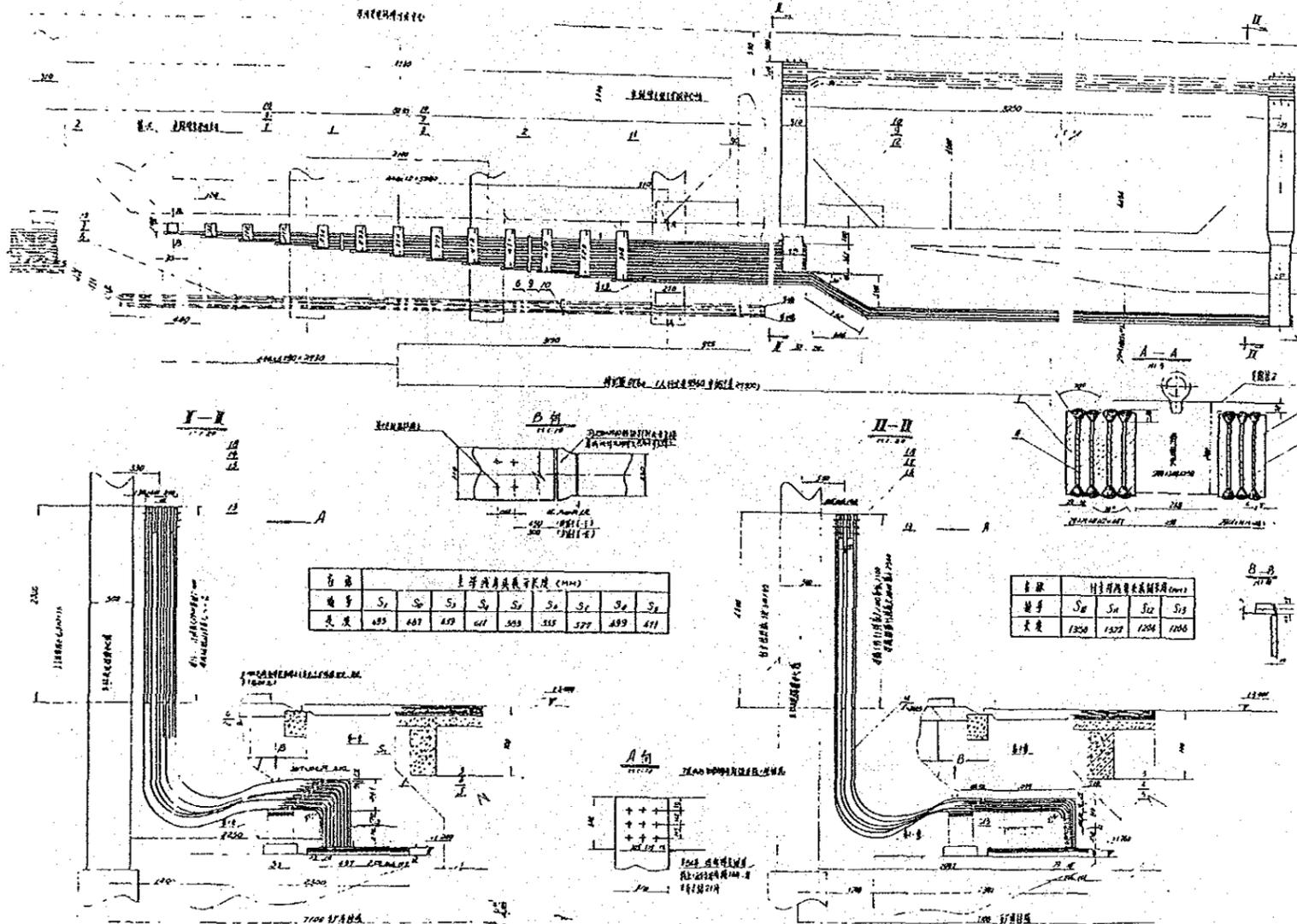
铸造圆角R10
 K面之平行度不大于1mm.
 ∇3平面在保证铸件平直时
 允许不加工

2.5 电焊槽 集气罩 材料 铁板 83

A-4-9(c)

DRAWN BY	ガススカート (短側用)
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

ITEM	DATE	REVISIONS	CHECKED



管号	S ₁	S ₂	S ₃	S ₄	S ₅	S ₆	S ₇	S ₈	S ₉
長さ	485	487	479	467	503	515	527	489	471

管号	S ₁₀	S ₁₁	S ₁₂	S ₁₃
長さ	1250	1320	1200	1200

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

図説

1. 炉内管束の配置は、燃焼効率を向上させるためである。
2. 各部の寸法は、設計図面に準じて製作される。
3. 各部の材質は、設計図面に準じて指定される。
4. 各部の組立順序は、設計図面に準じて行われる。
5. 各部の検査方法は、設計図面に準じて行われる。

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
12	炉内管束	12	1200	1200	
13	炉内管束	13	1300	1300	
14	炉内管束	14	1400	1400	
15	炉内管束	15	1500	1500	
16	炉内管束	16	1600	1600	
17	炉内管束	17	1700	1700	
18	炉内管束	18	1800	1800	
19	炉内管束	19	1900	1900	
20	炉内管束	20	2000	2000	

管号	S ₁₄	S ₁₅	S ₁₆	S ₁₇
長さ	1250	1320	1200	1200

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
21	炉内管束	21	2100	2100	
22	炉内管束	22	2200	2200	
23	炉内管束	23	2300	2300	
24	炉内管束	24	2400	2400	
25	炉内管束	25	2500	2500	
26	炉内管束	26	2600	2600	
27	炉内管束	27	2700	2700	
28	炉内管束	28	2800	2800	
29	炉内管束	29	2900	2900	
30	炉内管束	30	3000	3000	

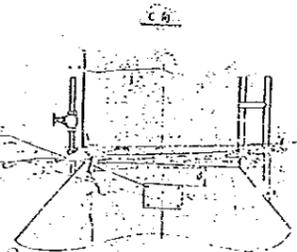
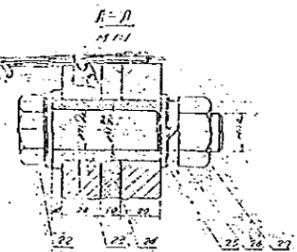
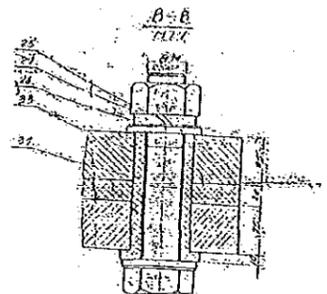
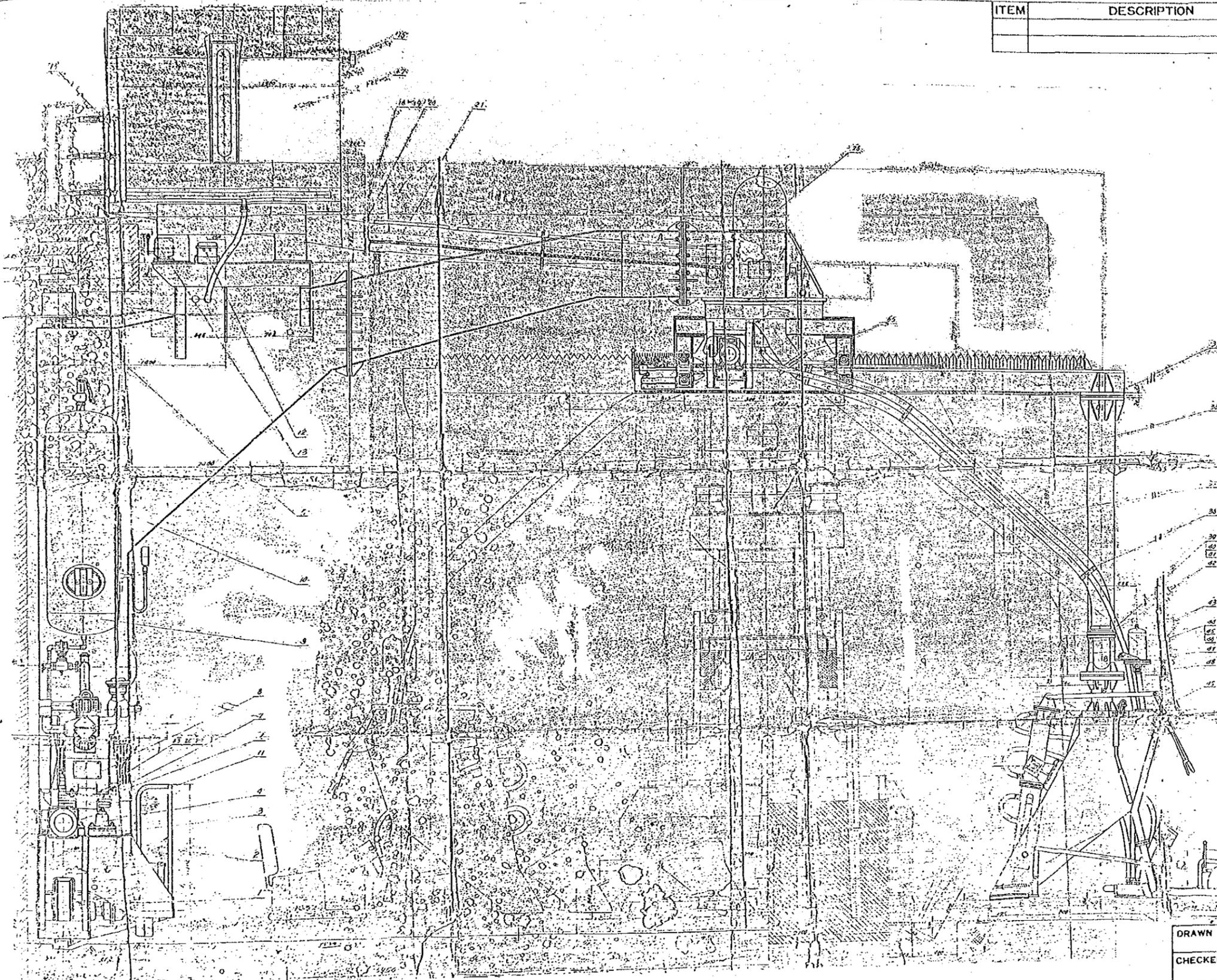
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
31	炉内管束	31	3100	3100	
32	炉内管束	32	3200	3200	
33	炉内管束	33	3300	3300	
34	炉内管束	34	3400	3400	
35	炉内管束	35	3500	3500	
36	炉内管束	36	3600	3600	
37	炉内管束	37	3700	3700	
38	炉内管束	38	3800	3800	
39	炉内管束	39	3900	3900	
40	炉内管束	40	4000	4000	

A-4-11

DRAWN BY	炉回りブス組立図
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS



A-4-12(b)

DRAWN BY	ウォールクレーン側面図
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO.
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			

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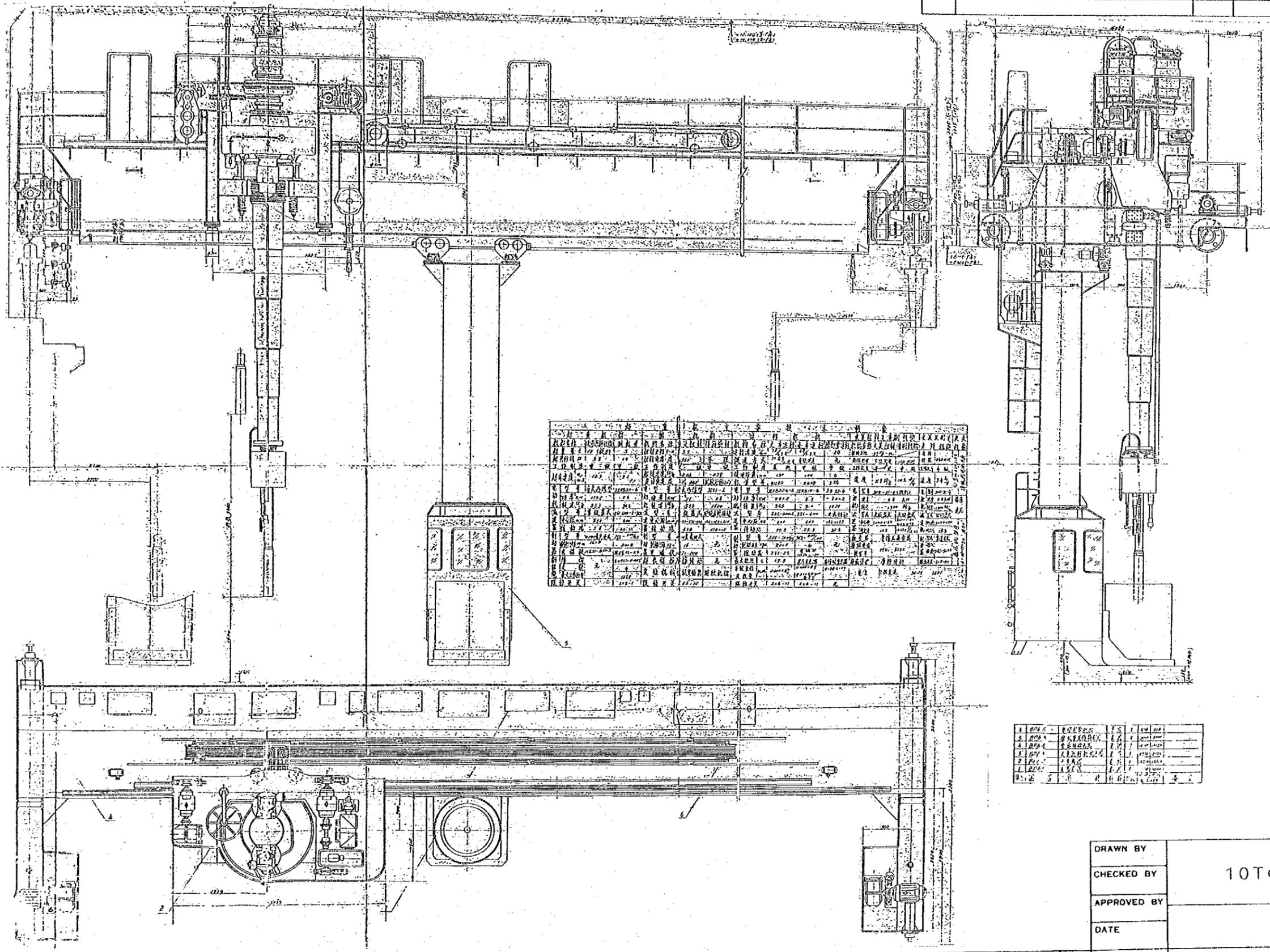
2

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4

5

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS



ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
1
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REV	DATE	DESCRIPTION	BY	CHKD
1
2
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4
5

A-4-13

DRAWN BY	
CHECKED BY	10Tonスパイクプラー
APPROVED BY	
DATE	
SCALE	
DWG. NO.	
REV	△

△	ITEM	DATE	REVISIONS	CHECKED

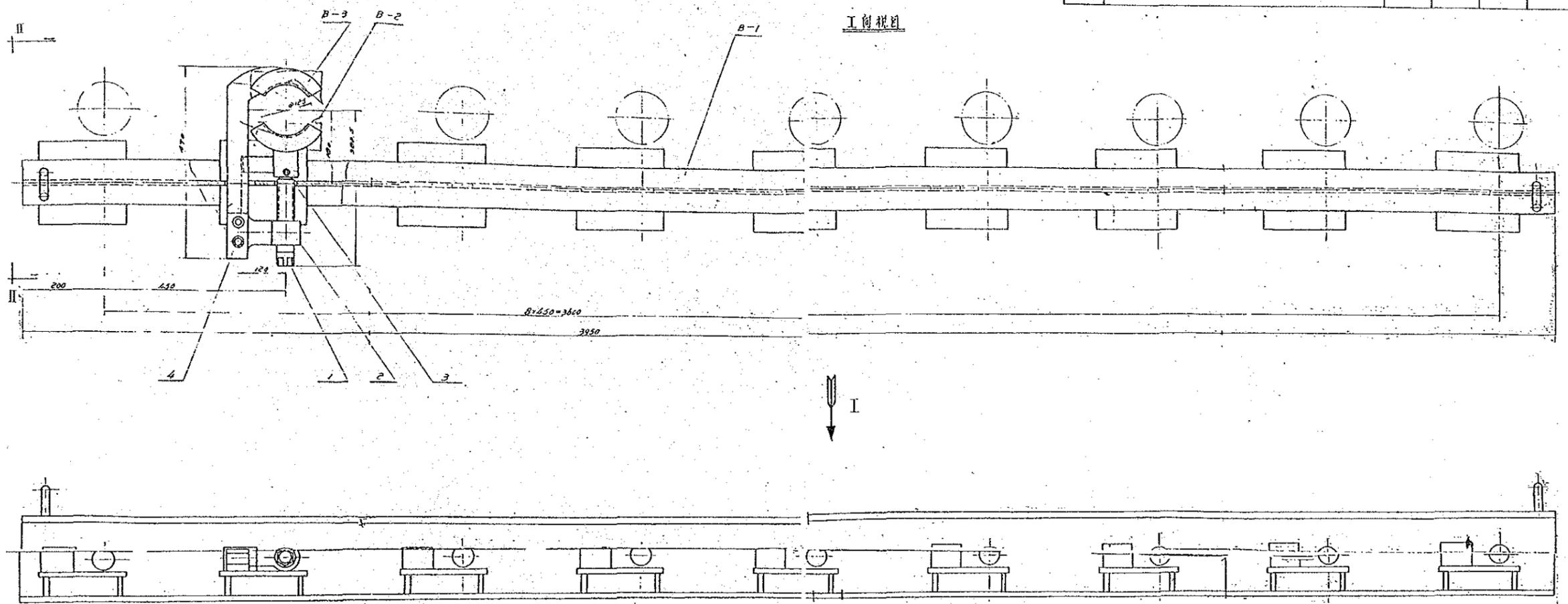
2

3

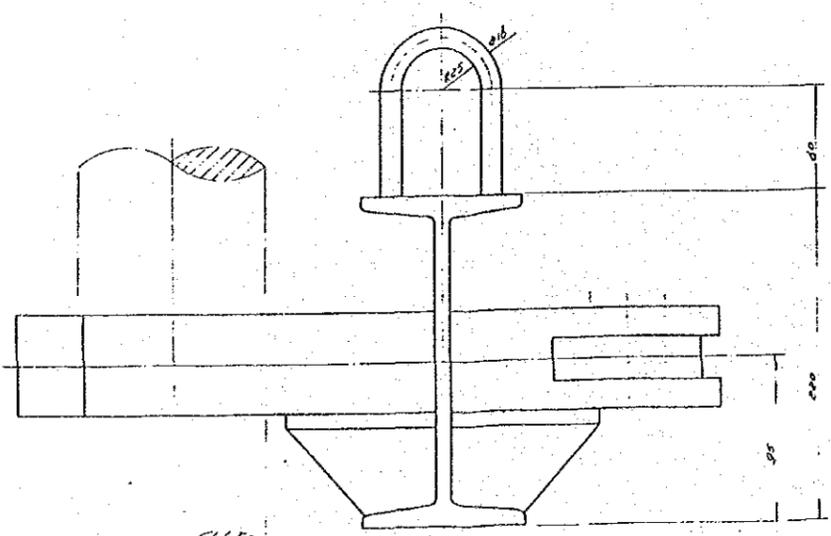
4

5

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS
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II-III 视图
比例 1:2



重量 402 公斤

1	GB487-50	圆 柱 销	25 ϕ x70	10	85	0.20	5
3	GB75-50	圆 钢 螺 丝 钉	M12x20	18	13	0.08	0.3
2	16-2-19	螺 丝	T60x6	9	13	2.5	31.5
1	16-2-18	螺 丝	T60x6	9	85	2.7	26.3
B-3-06-2-27		外 卡 箍		9	15.3	15.3	0.77
B-2-06-2-06		内 卡 箍		9	1.6	6.0	
B-1-06-2-05		工 字 钢 吊 钩		1			1.93

说 明

1. 本吊具要求重量为10吨,每一卡头卡2吨。
2. 在正式制造以前必须先制造一卡头卡一段工字钢进行试验。卡头能卡至2吨即符合标准,然后方允许成批制造。
3. 试验压力与扭矩关系列表如下:

压力	扭矩	压力	扭矩	压力	扭矩
4000 公斤	1250 公斤公分	5000 公斤	1570 公斤公分	6000 公斤	1887 公斤公分
7000 公斤	2102 公斤公分	8000 公斤	2516 公斤公分	8500 公斤	2673 公斤公分

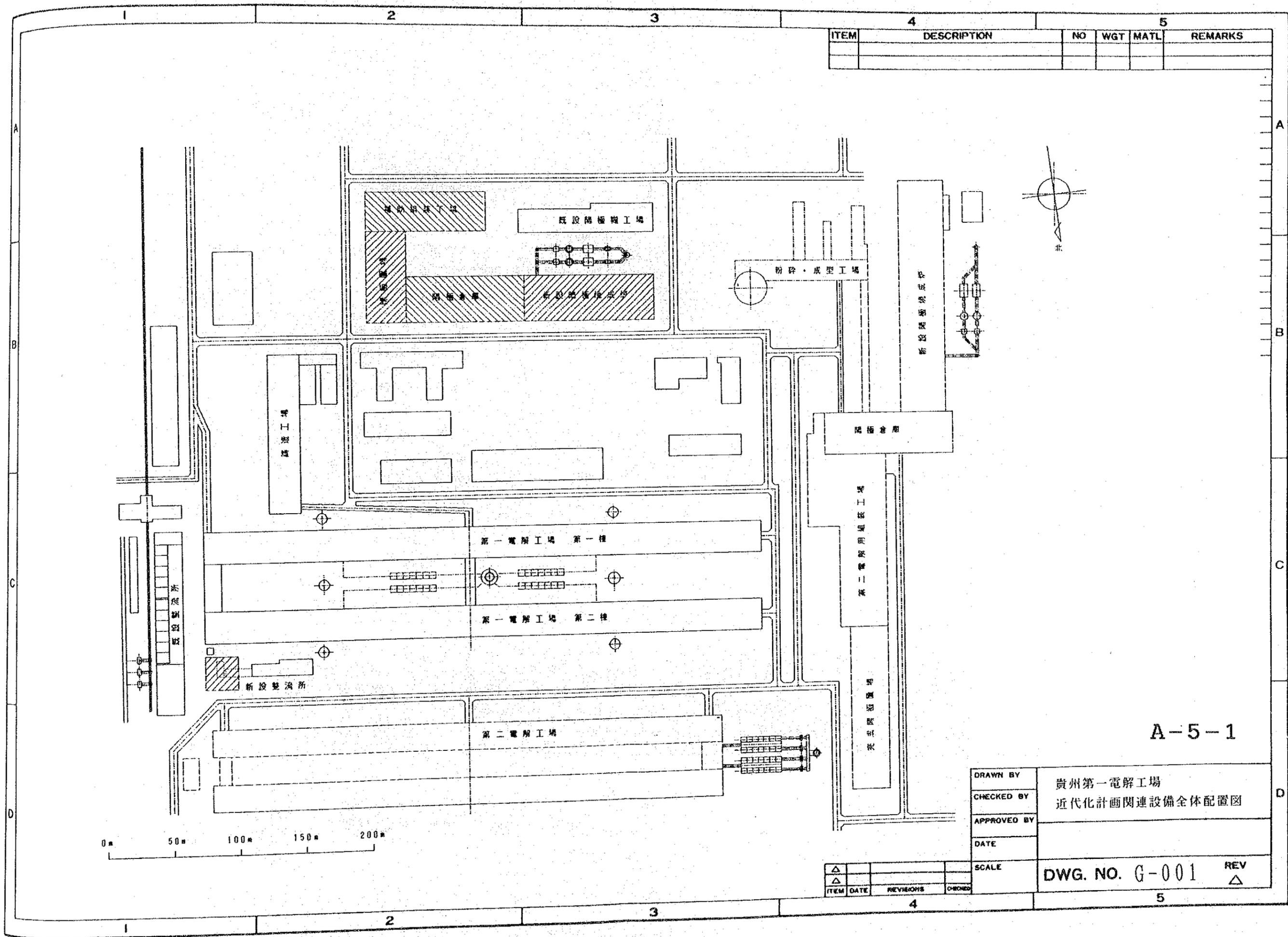
A-4-14

DRAWN BY	上 昇 用 補 助 梁 組 立 圖	
CHECKED BY		
APPROVED BY		
DATE		
SCALE	DWG. NO.	REV
△		△

ITEM	DATE	REVISIONS	CHECKED
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添付資料 A-5

貴州アルミニウム工場 第一電解工場
近代化計画関連設備図面類



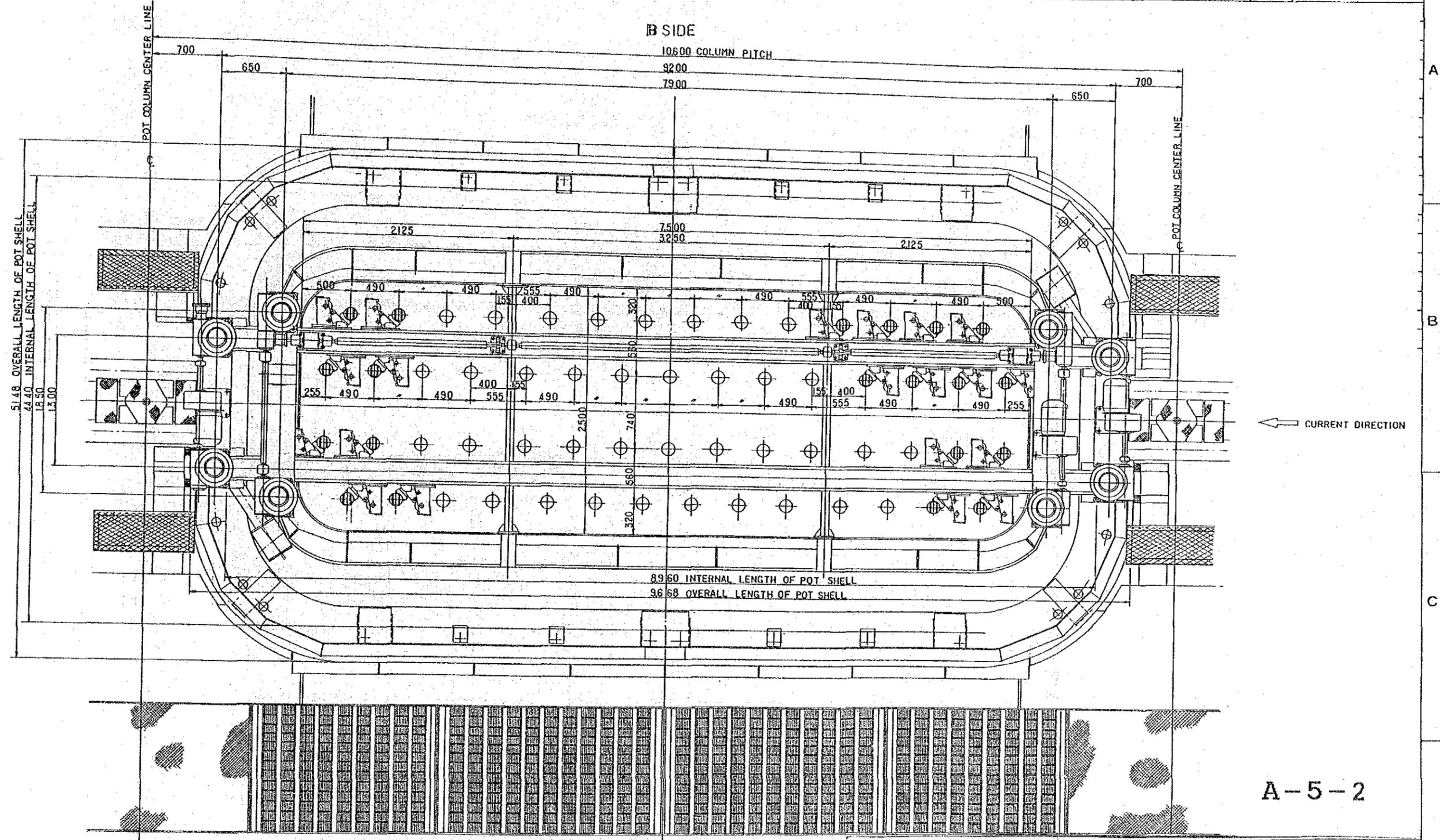
4		5			
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

A-5-1

DRAWN BY	貴州第一電解工場
CHECKED BY	近代化計画関連設備全体配置図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-001
REV	△

△	△	△	△
ITEM	DATE	REVISIONS	CHECKED

ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS



A-5-2

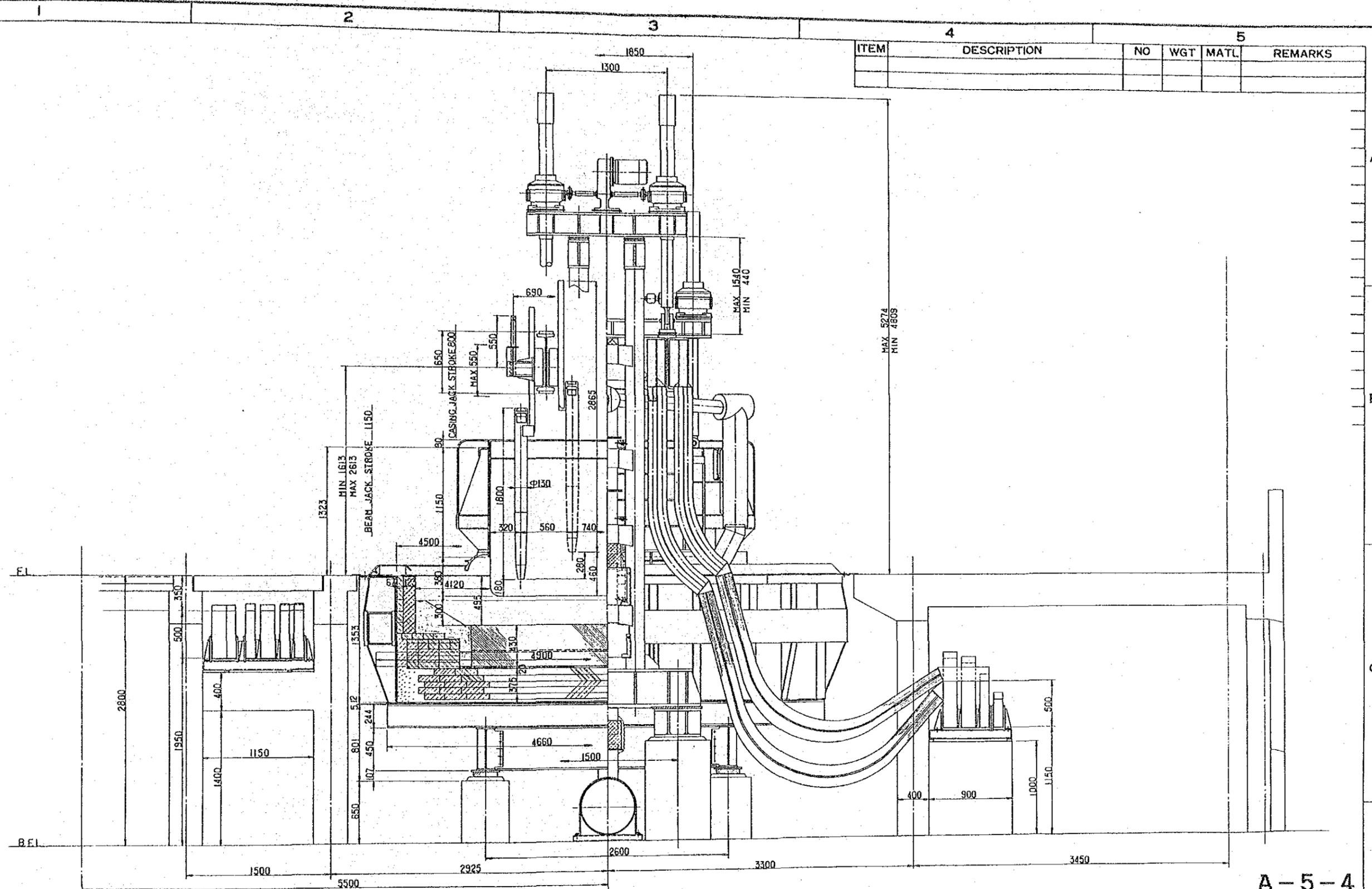
SPECIFICATION
 CURRENT 120,000A
 ANODE AREA 185,350 cm² (7,500 x 2,500 x 500^R)
 CURRENT DENSITY 0.65 A/cm²
 STUD 1,800 x 130 x 58 PIECES 7,695 cm²
 CURRENT DENSITY 15.6 A/cm² 2,069 A/PIECE

CATHODE CARBON BLOCK 450 x 430 x 3,135 x 16 PIECES
 COLLECTOR BAR 65 x 150 x 4,900 x 32 PIECES
 CURRENT DENSITY 39 A/cm² 3,750 A/PIECE
 SHELL (INSIDE) 4,440 x 1,320 x 8,960

A SIDE

DRAWN BY	120KA縦型電解炉平面図 (参考図)
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO. G-002
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			



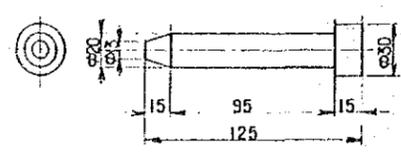
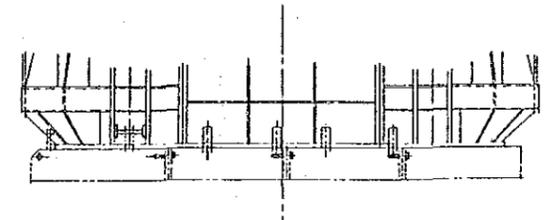
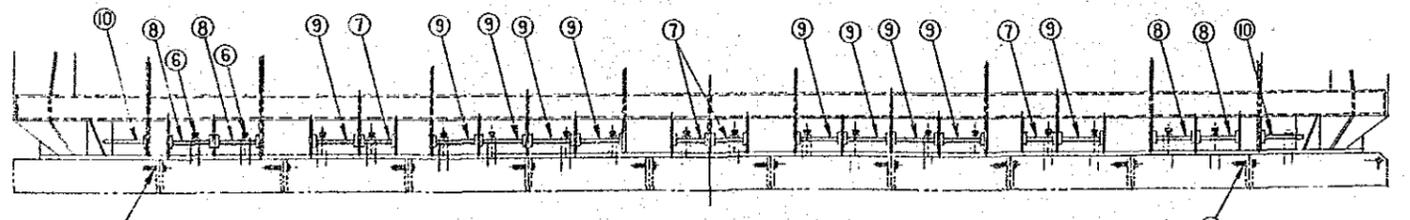
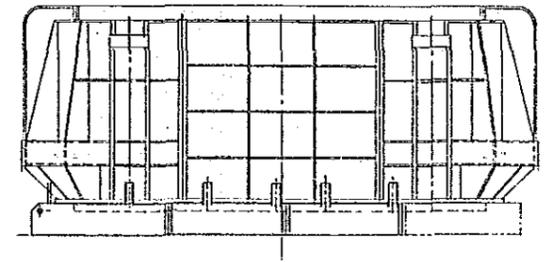
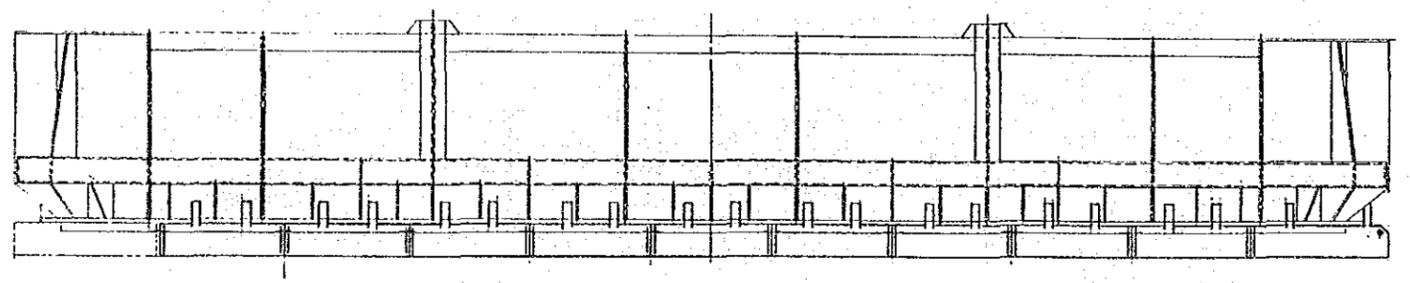
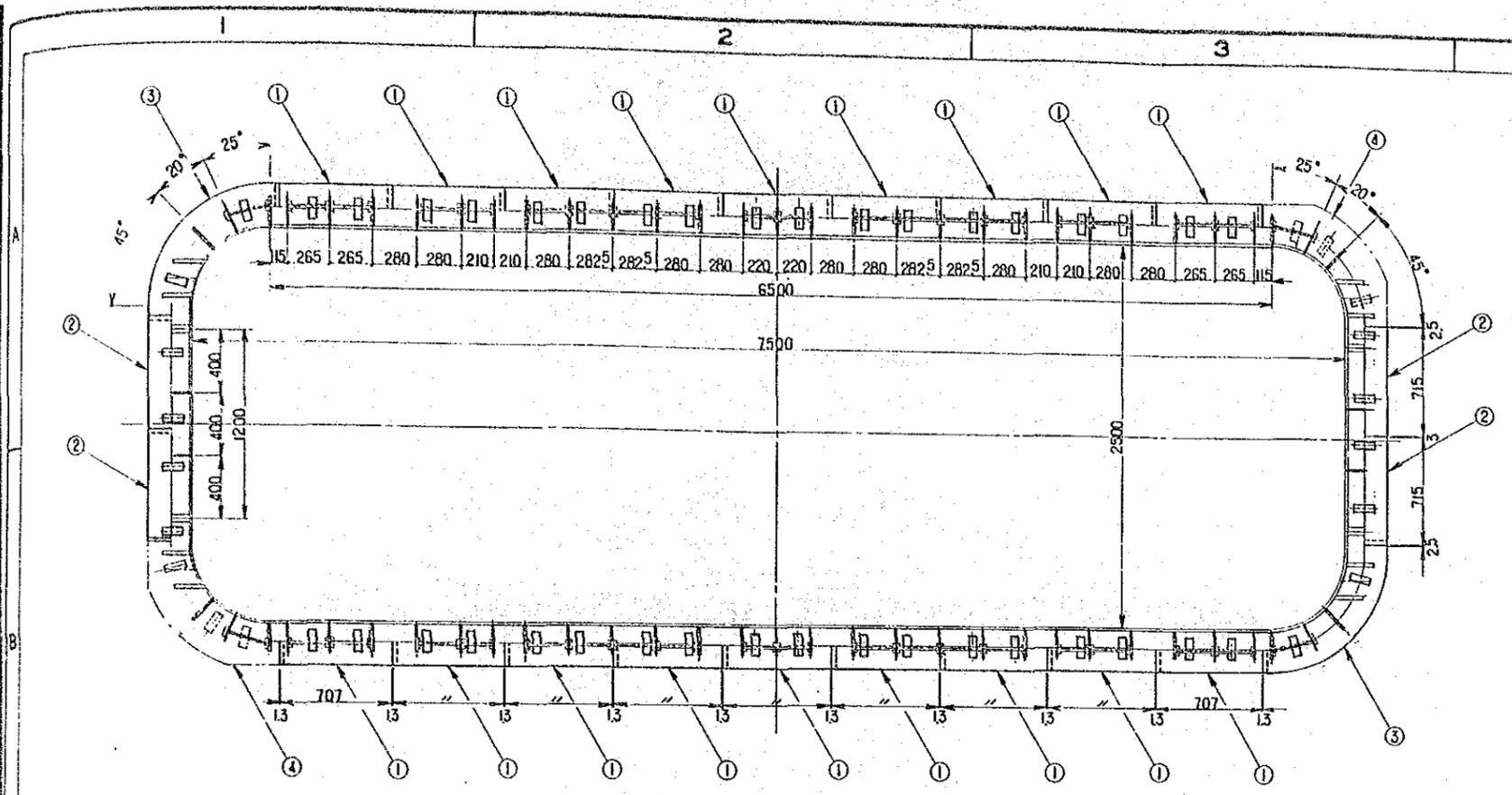
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

A-5-4

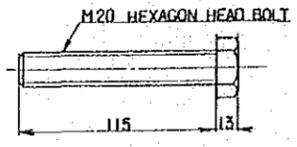
DRAWN BY	120KA縦型電解炉断面図 (参考図)
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO. G-004
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			

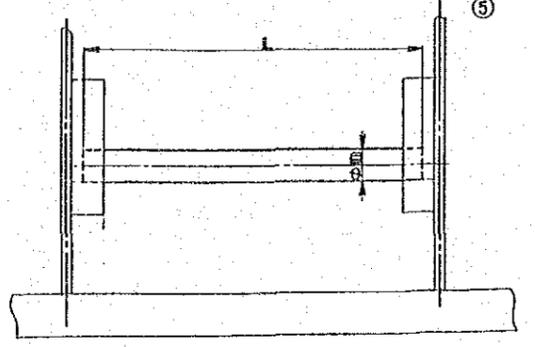
4		5			
ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS



DETAIL OF ⑤



DETAIL OF ⑥



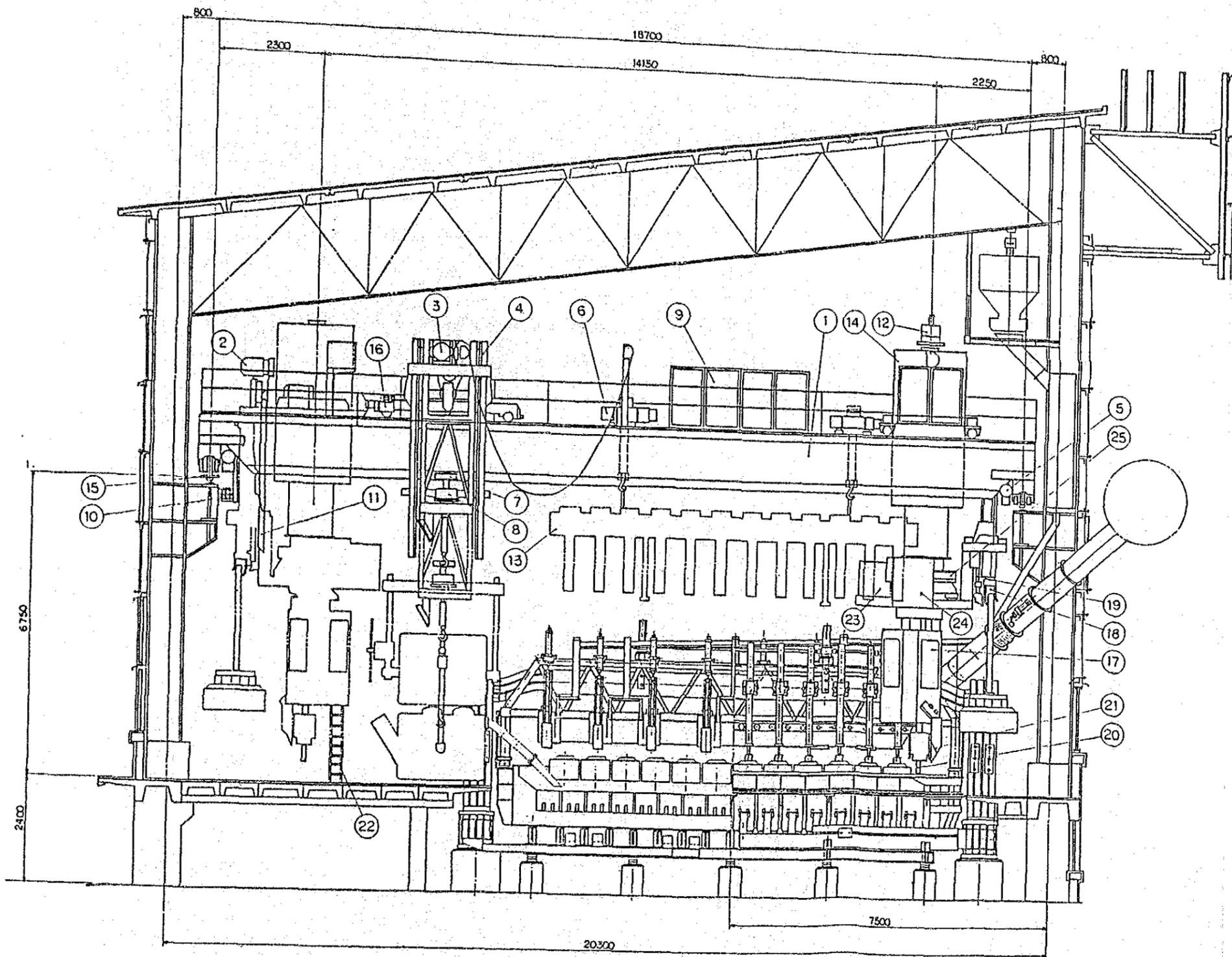
DETAIL OF ⑦⑧⑨

	φD	L
⑦	19	200
⑧	19	250
⑨	19	264
⑩	19	280

△	△	△	△
ITEM	DATE	REVISIONS	CHECKED

DRAWN BY	120KA 縦型電解炉	D
CHECKED BY	ガスカート配置参考図	
APPROVED BY		
DATE		
SCALE	DWG. NO. G-006	REV
		△

A-5-6

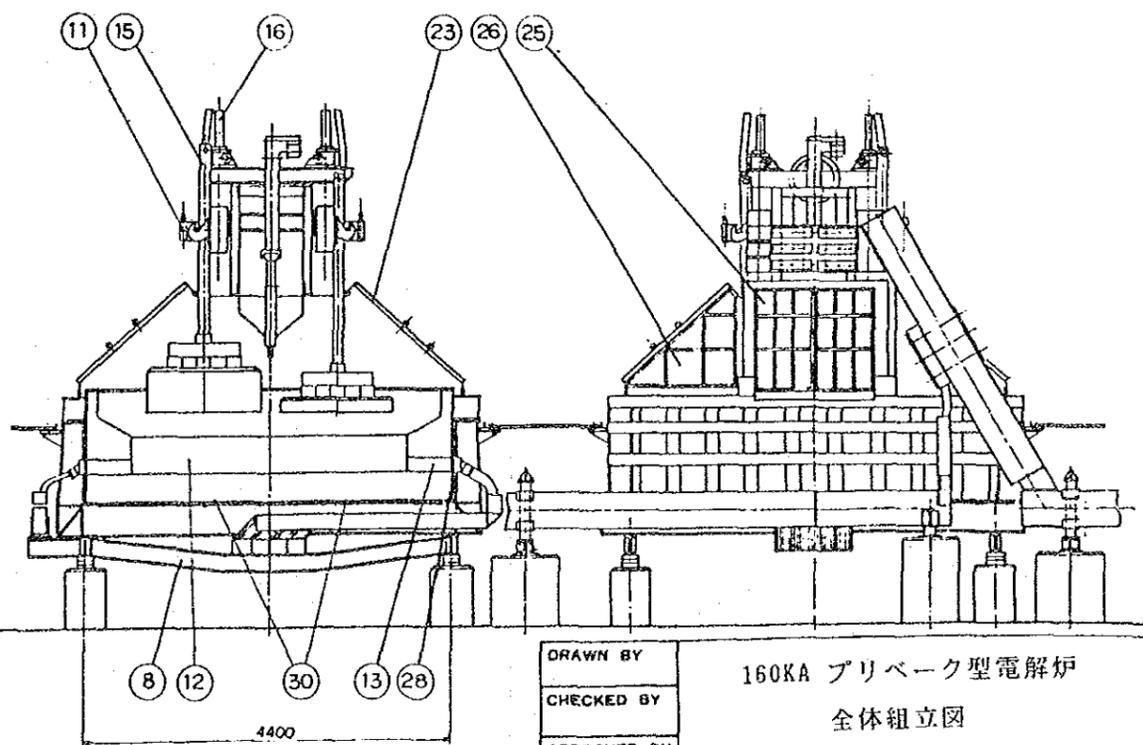
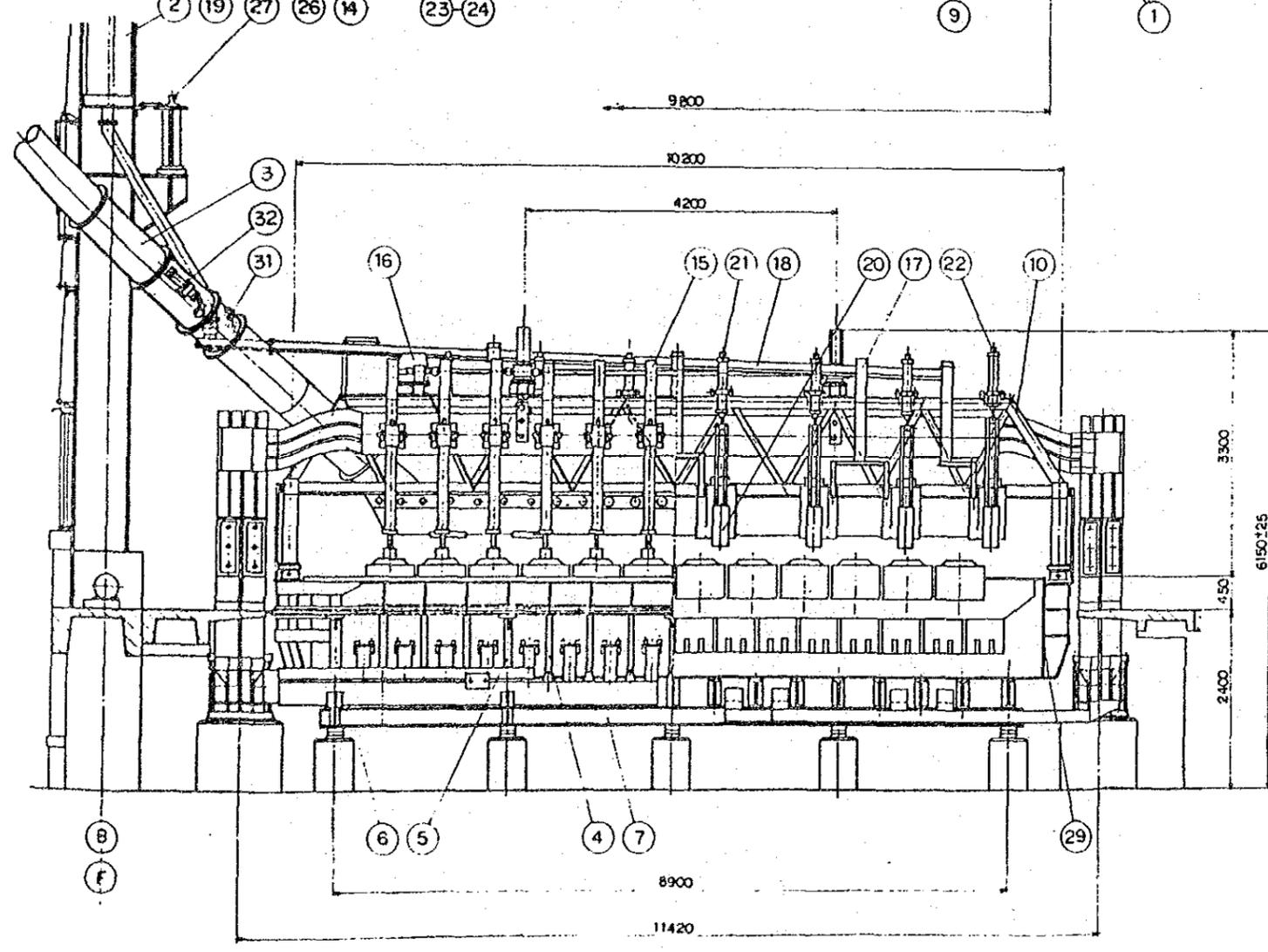
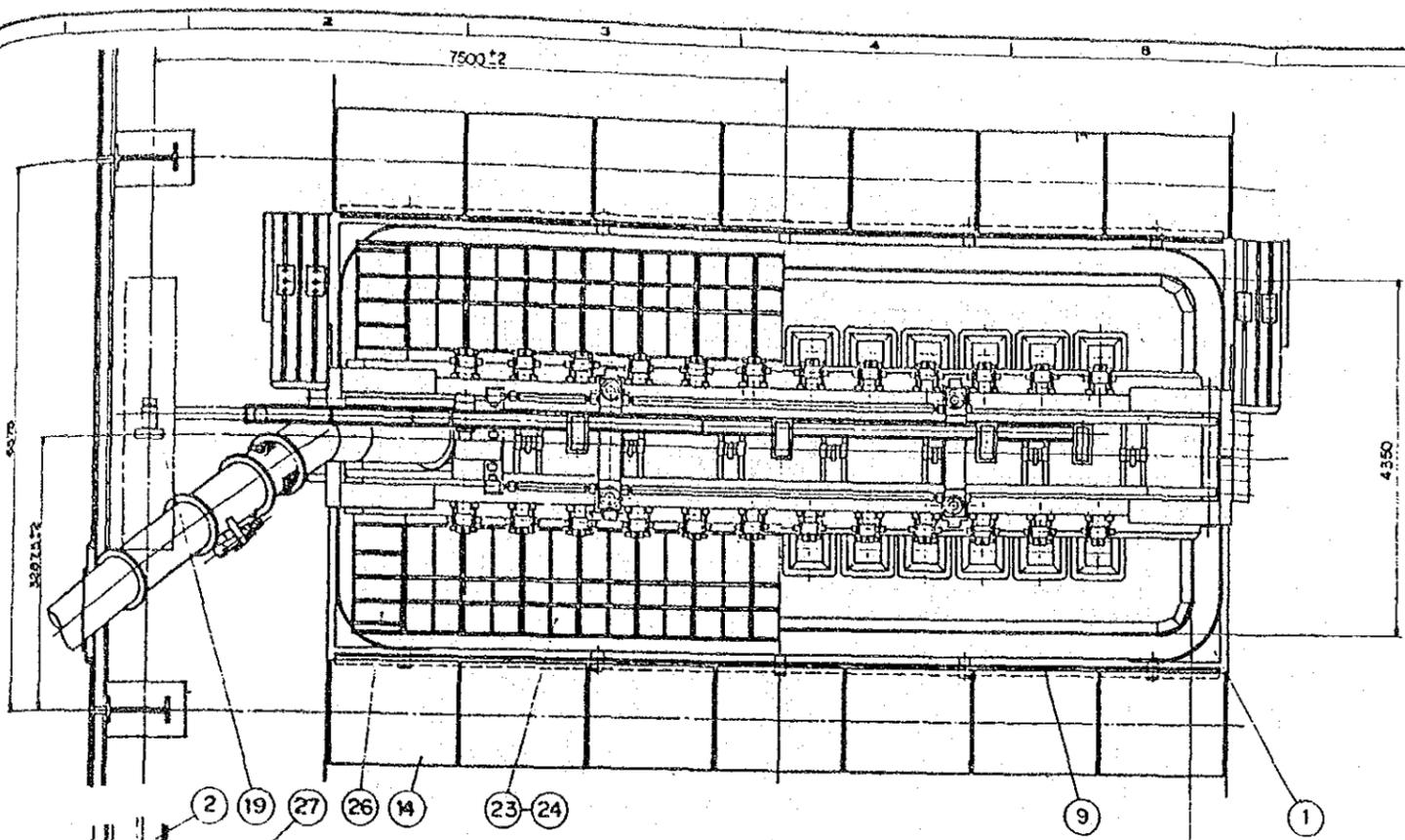


ITEM	DESCRIPTION	NO.	WGT	MATL.
1	CRANE GIRDER			
2	COMPRESSOR	2		
3	HOIST	1		
4	TAPPING TROLLEY LOAD 12T	1		
5	LONG TRAVEL DRIVE	1		
6	RACK RAISER HOIST	2		
7	COMPRESSION LOAD CELL	2		
8	HOOK ROTATION DEVICE	1		
9	ELECTRICAL CABINET NO.1	1		
10	MAIN POWER SUPPLY	1		
11	AIR COMPRESSOR INLET PIPE	1		
12	ALUMINA FILLING SPOUT	1		
13	RACK RAISER	1		
14	HOOPER	1		
15	GUIDE ROLLER	1		
16	ELECTRICAL CABINET NO.2	4		
17	CABIN	1		
18	ANODE EXTRACTION	1		
19	ANODE CLAMP TIGHTENING	1		
20	CRUST BREAKER	1		
21	ALUMINA RETRACTABLE SPOUT	1		
22	RETRACTABLE WOOD LADDER	1		
23	HYDRAULIC UNIT	1		
24	AIR CONDITIONED	1		
25	CABIN TURRET	1		

A-5-9

DRAWN BY	160KA プリベーク型電解工場
CHECKED BY	建屋断面図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-009 REV △

△	△	△	△
ITEM	DATE	REVISIONS	CHECKED

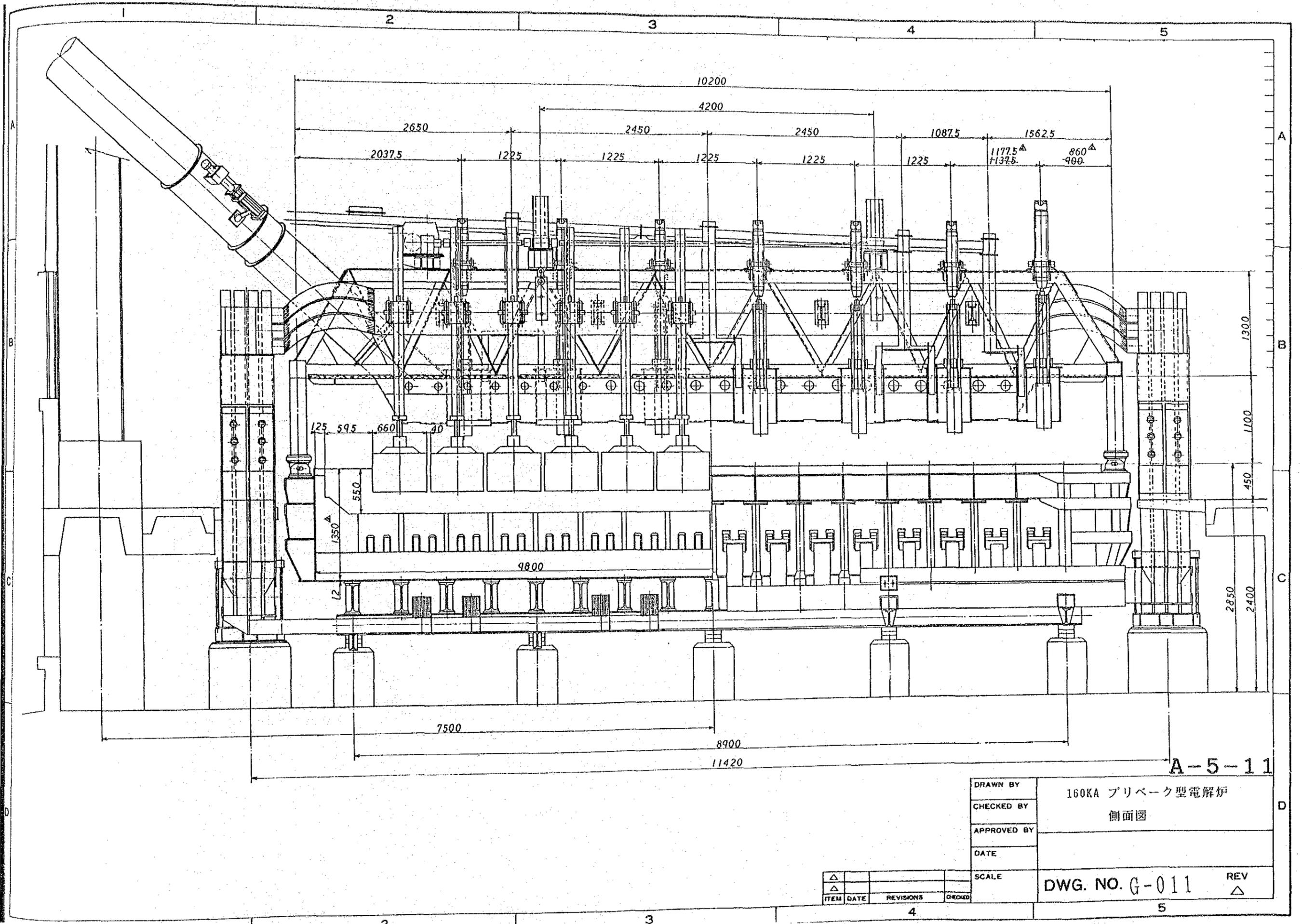


ITEM	DESCRIPTION	NO.	WGT	MATL	REMARKS
1	CORNER PLATE	416			
2	ORE HOPPER	104			
3	POT BRANCH DUCT	104			
4	CRADLE 1 (STANDARD)	1248			
5	2 (WITH BRACKET)	312			
6	END CRADLE	208			
7	SUPPORT BEAM A (CRADLE SUPPORT)	208			
8	B (BUS SUPPORT)	416			
9	GRATING SUPPORT	208			
10	POT SUPERSTRUCTURE	104			
11	CLAMP	2496			
12	CATHODE CARBON	1664			
13	COLLECTOR BAR	3328			
14	GRATING	714			
15	ANODE ROD ASSEMBLY	2496			
16	JACKING SYSTEM 32THA	104SH			
17	ORE FEEDER	104SH			
18	AIRSLIDE	104SH			
19	BLOWER	104			
20	BREAKER CHISEL	104SH			
21	AIR CYLINDER (FOR BREAKER)	621			
22	(FOR TAPPING HOLE)	104			
23	SIDE COVER (STANDARD)	2704			
24	(WITH STEP)	416			
25	END COVER	416			
26	CORNER COVER	416			
27	CRANE RAIL (73KG RAIL)				
28	SIDE PANEL	208			
29	END PANEL	208			
30	BOTTOM PLATE	208			
31	EXPANSION JOINT	104			
32	SWITCH DAMPER	104			

A-5-10

DRAWN BY	160KA プリバーク型電解炉
CHECKED BY	全体組立図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-010
REV	△

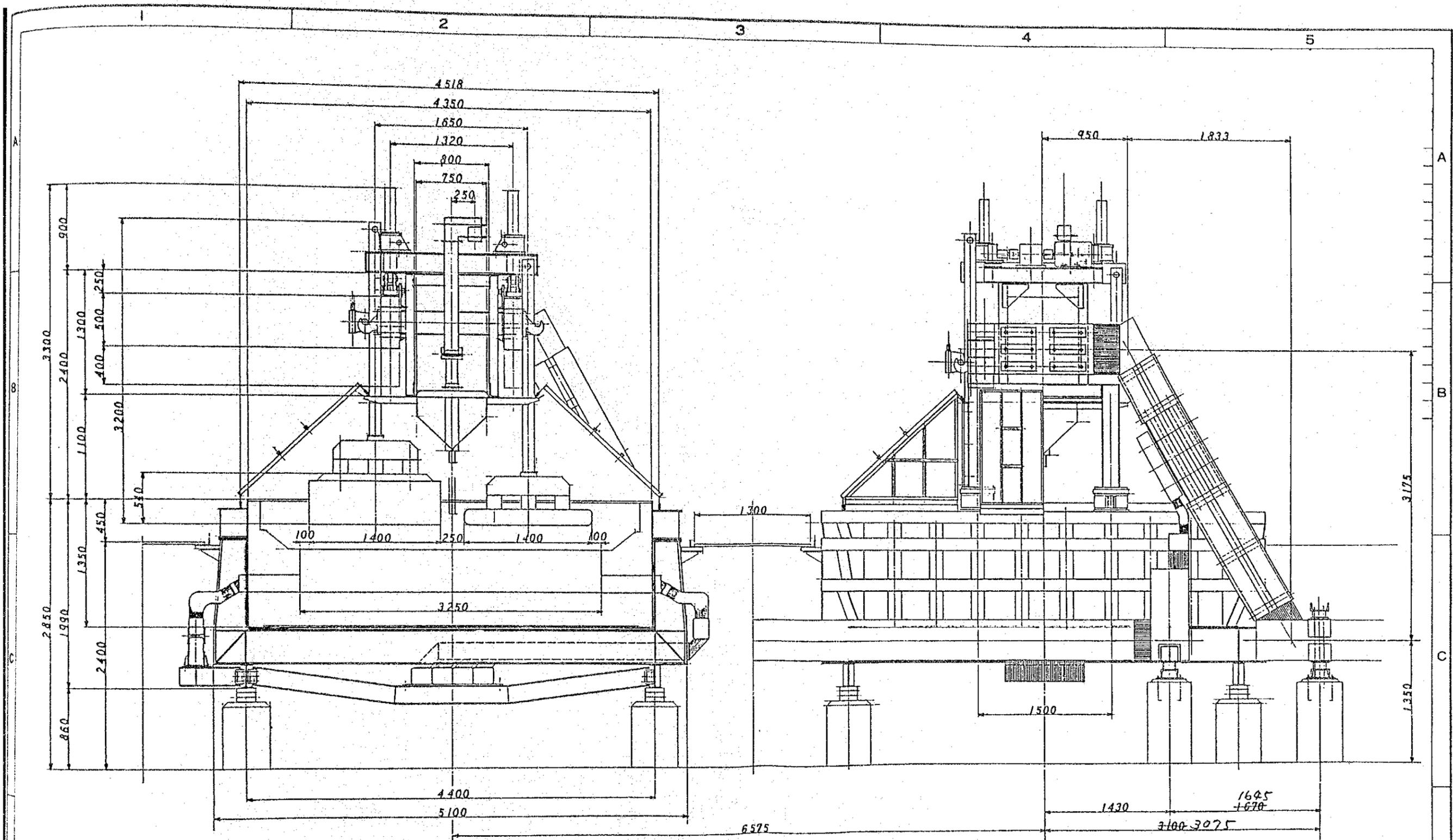
REV	DATE	REVISIONS	BY
△			



DRAWN BY	160KA プリベーク型電解炉
CHECKED BY	側面図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-011
	REV

△			
ITEM	DATE	REVISIONS	CHECKED

A-5-11



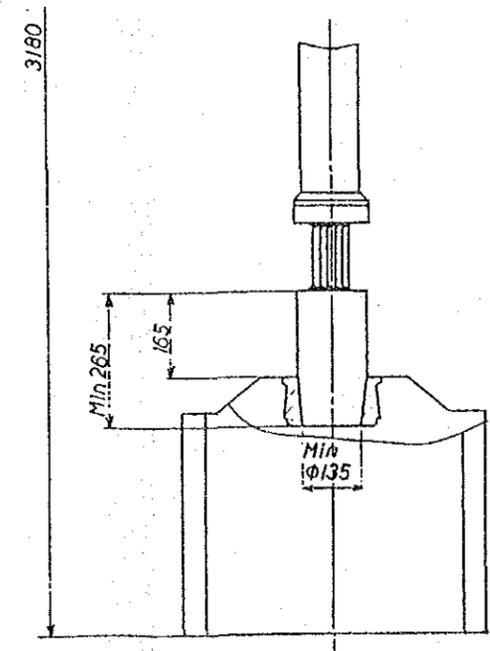
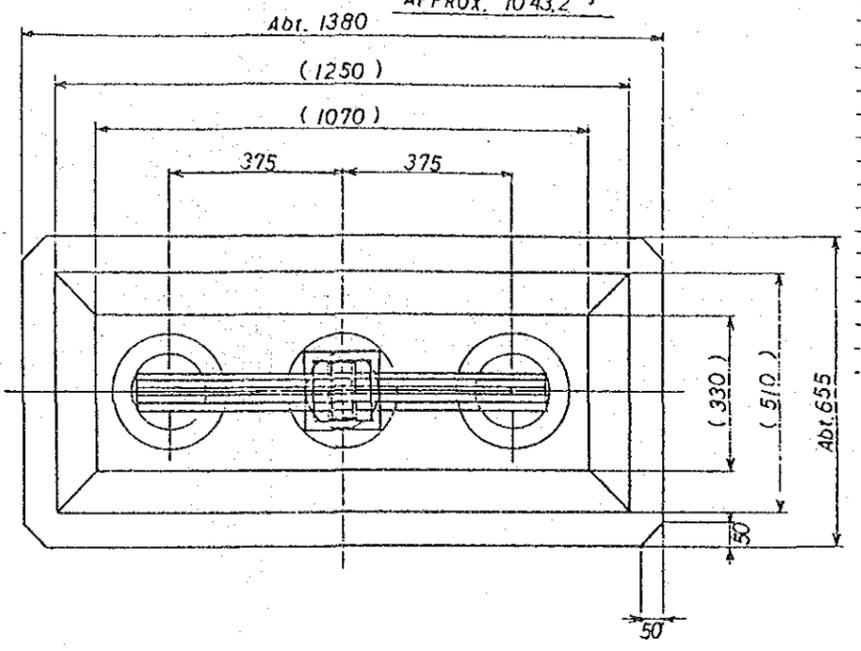
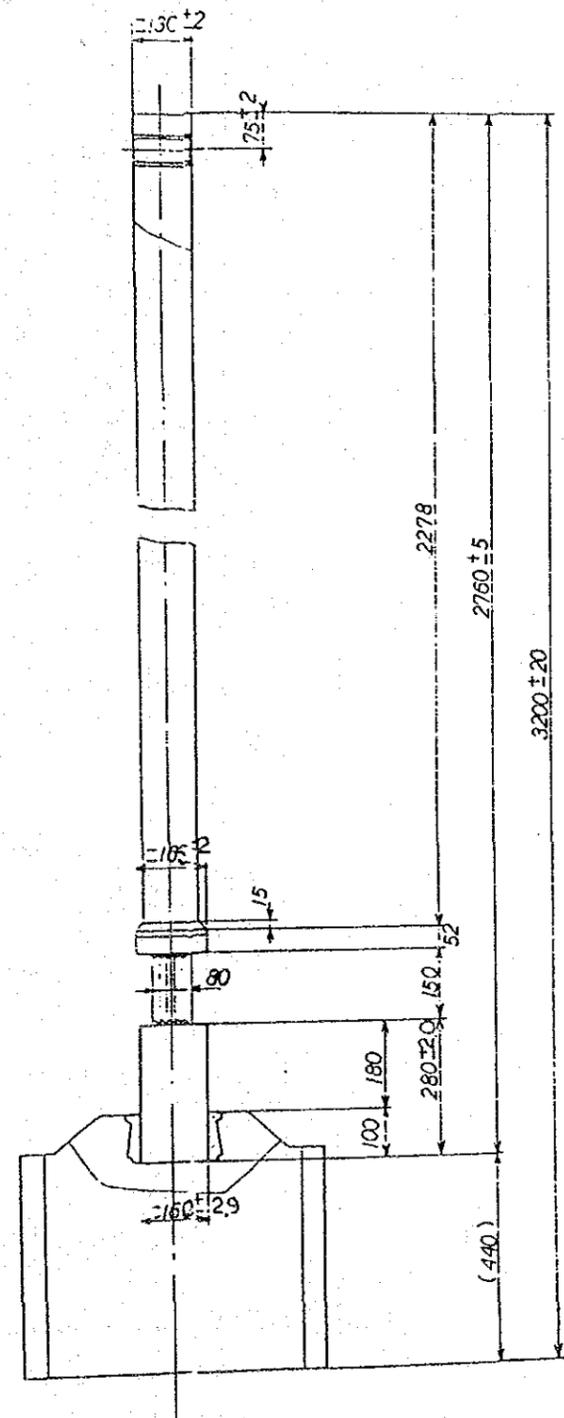
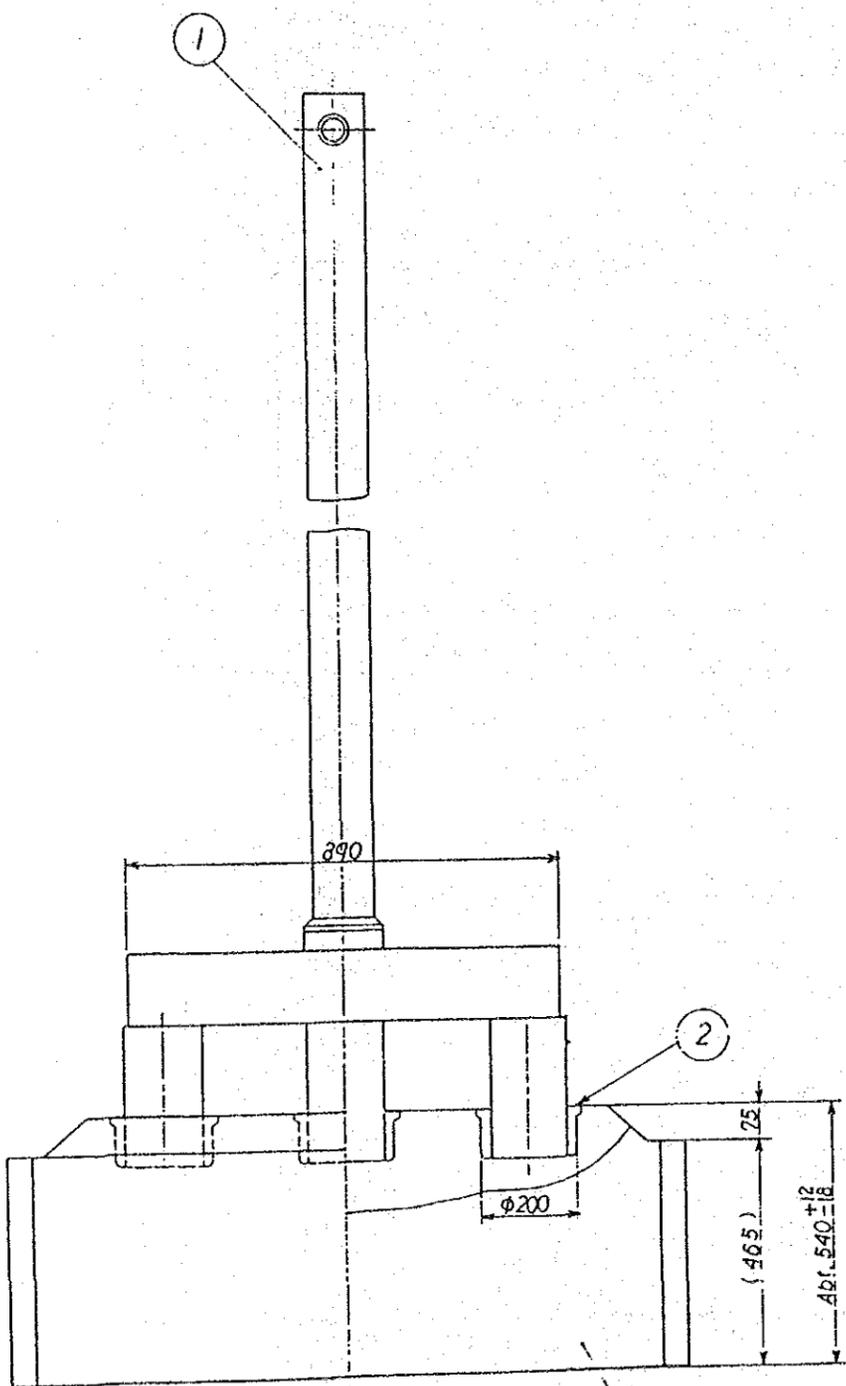
A-5-12

DRAWN BY	160KA プリベーク型電解炉
CHECKED BY	断面図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-012
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			

1	ALUMINIUM ROD	1	3332 AL-SS	CO05-01-01
2	CAST IRON	3	Abr. 30	FC
3	BAKED CARBON	1	Abr. 680	

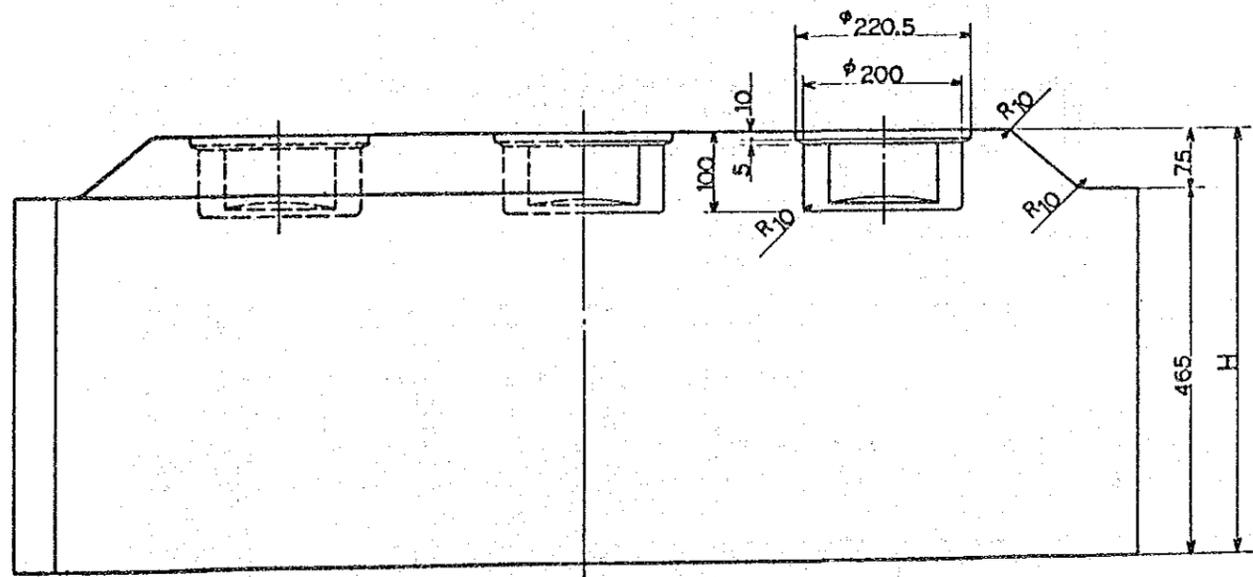
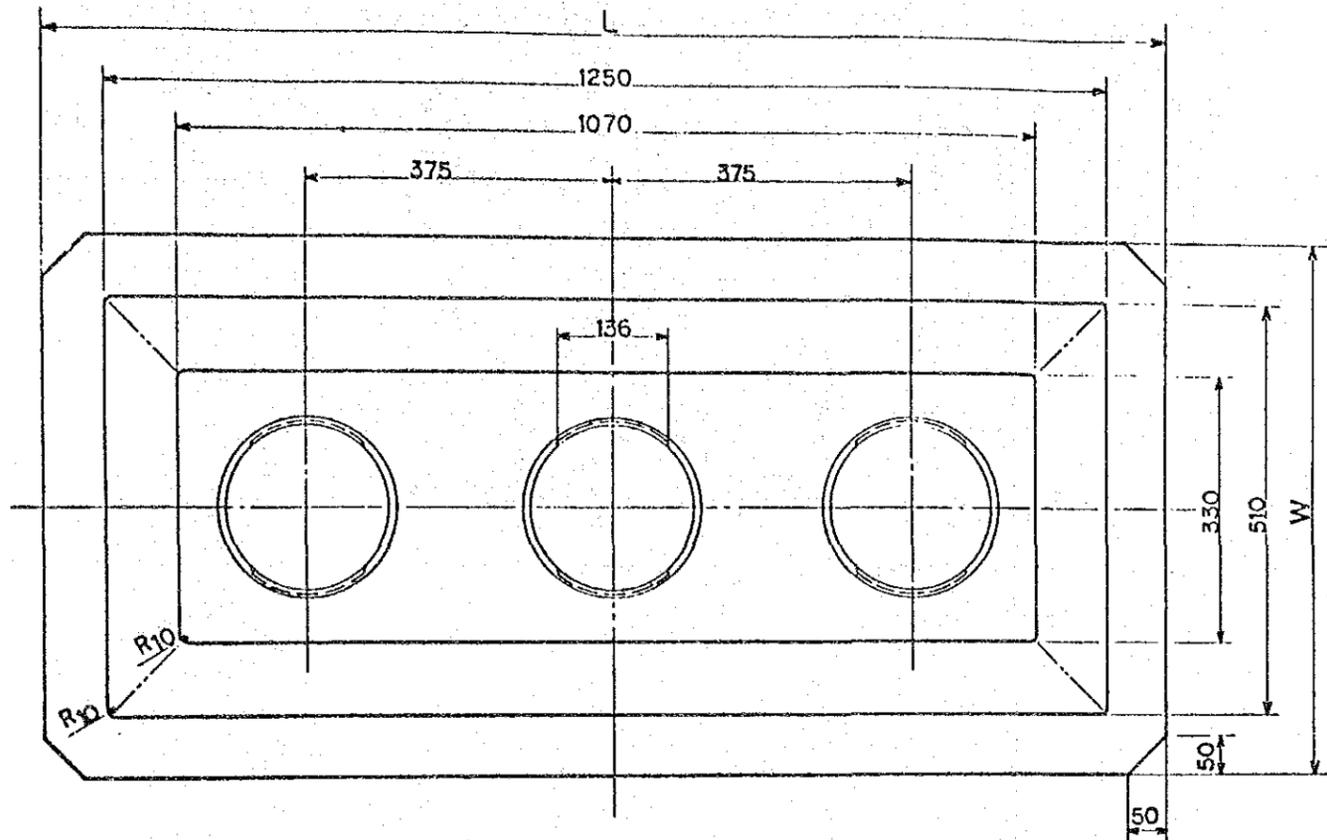
APPROX. 1043.2 Kg



A-5-13

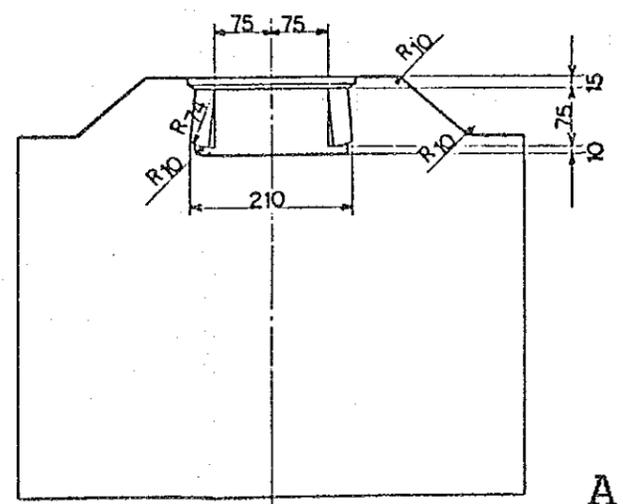
DRAWN BY	160KA プリベーク型電解炉 陽極組立図
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO. G-013
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			



ITEM	DESCRIPTION	NO	WGT	MATL	REMARKS

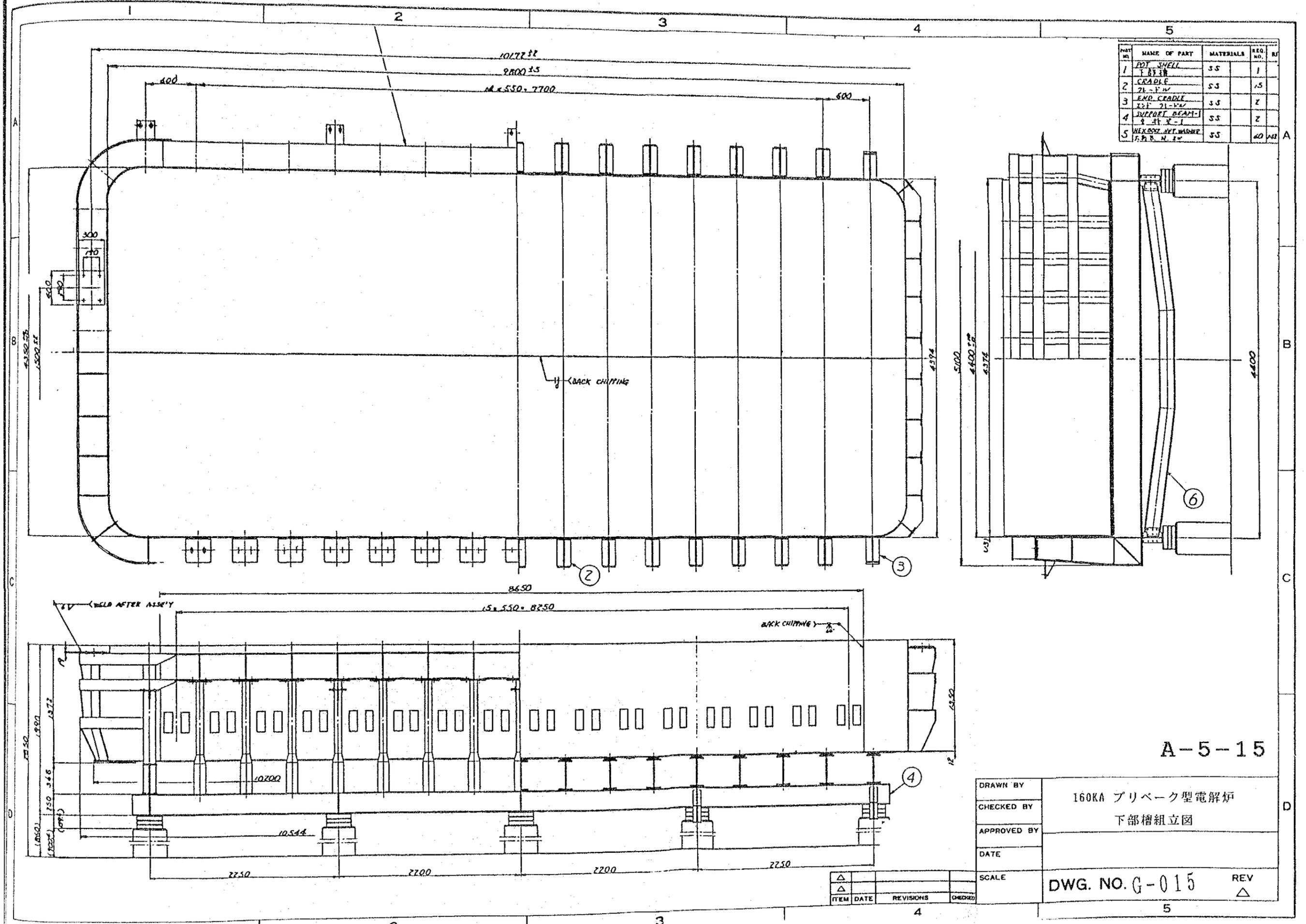
SPECIFICATIONS		
	GREEN ANODE CARBON BLOCK	BAKED ANODE CARBON BLOCK
WEIGHT	730 kg/BLOCK	Abt. 680 kg/BLOCK
LENGTH	L = 1400mm	L = Abt. 1380 mm
WIDTH	W = 660mm	W = Abt. 655 mm
HEIGHT	H = 540 ± 15mm	H = Abt. 537 ± 15mm
VOLUME	0.45 m ³	



A-5-14

DRAWN BY	160KA プリバーク型電解炉 陽極寸法図
CHECKED BY	
APPROVED BY	
DATE	
SCALE	DWG. NO. G-014
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			



PART NO.	NAME OF PART	MATERIALS	REQ. NO.	REV.
1	POY SHELL	S.S	1	
2	CRADLE	S.S	1.5	
3	END CRADLE	S.S	2	
4	SUPPORT BEAM- 2x1 21-1/2"	S.S	2	
5	HEXBOG NUT W/ WDR F. P. B. N. 1"	S.S	40	

A-5-15

DRAWN BY	160KA プリバーク型電解炉
CHECKED BY	下部槽組立図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-015
REV	△

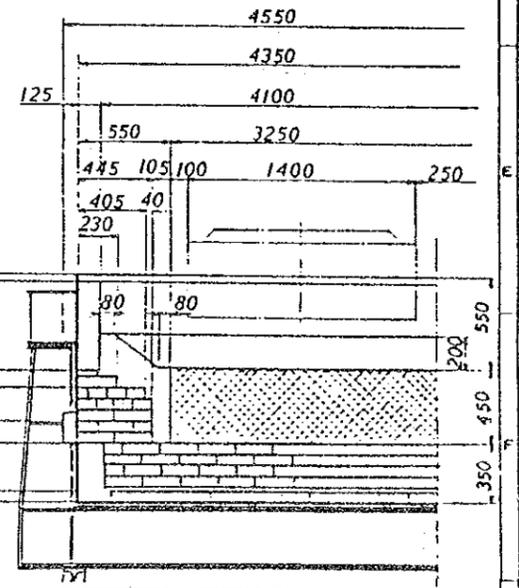
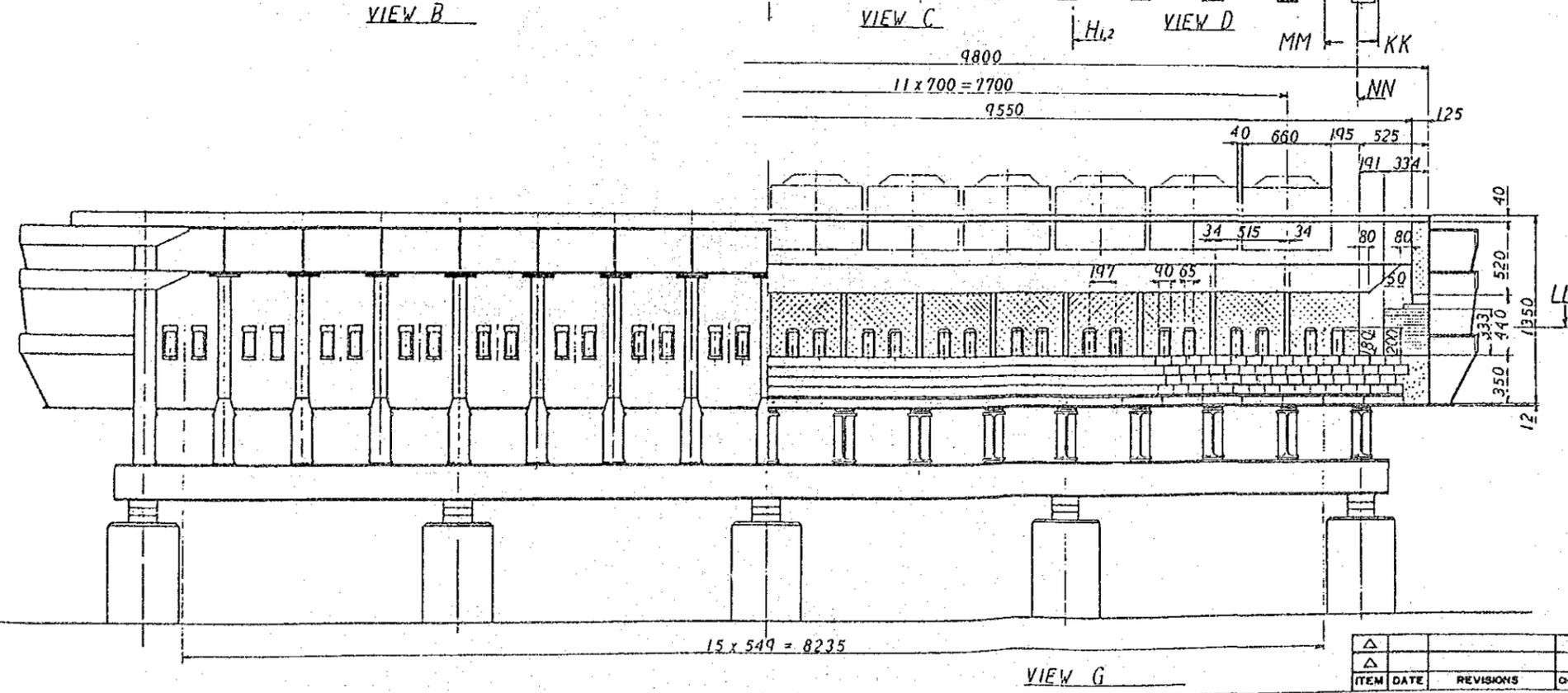
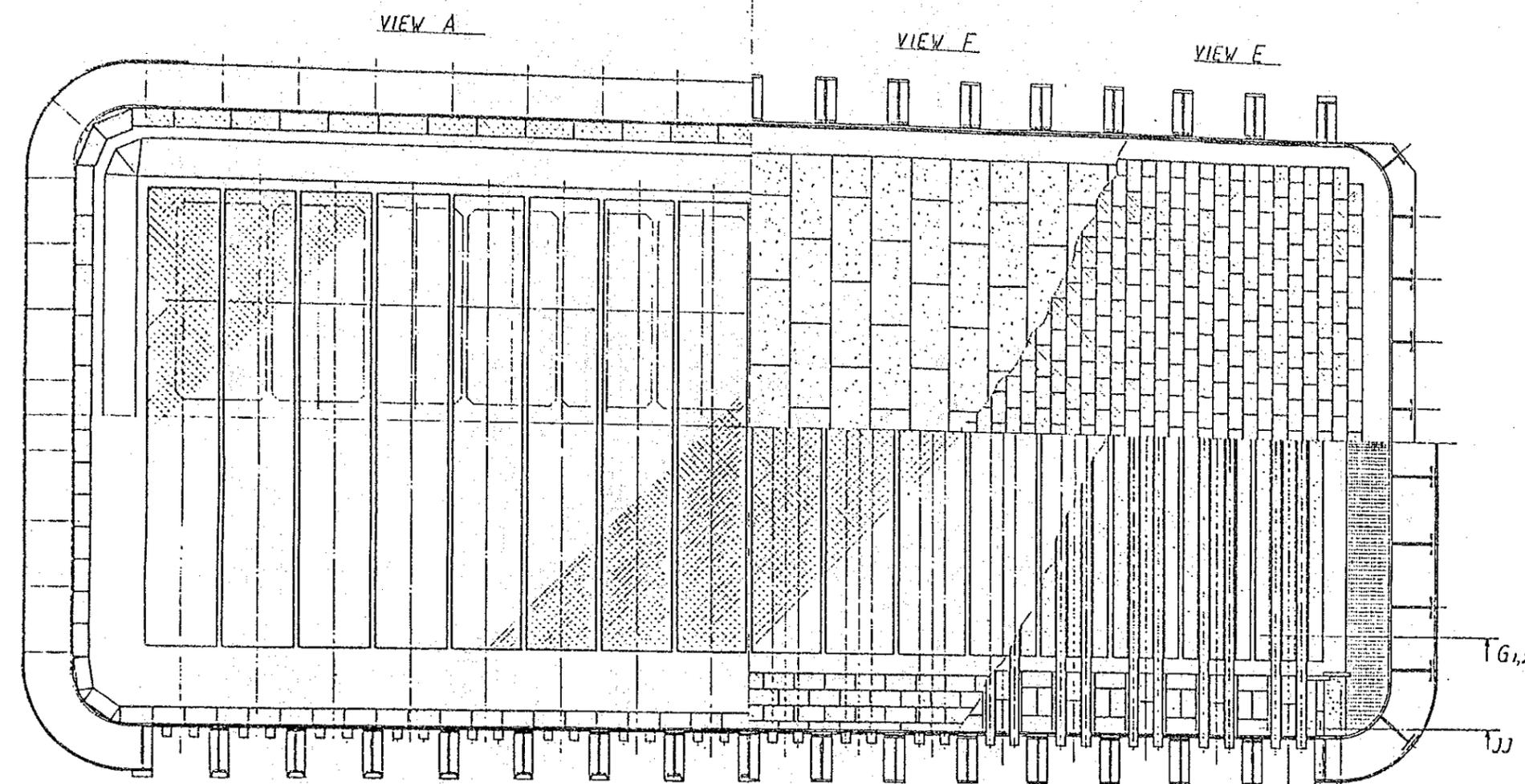
ITEM	DATE	REVISIONS	CHECKED
△			
△			

ITEM	DESCRIPTION	NO.	WGT	MATL.	REMARKS
1	CATHODE CARBON BLOCK	994 1MA	16	15906	
2	SIDE PREBAKED CARBON BLOCK	-1	70.41	2492	
3		-2	8.1	203	
4	TAMPING MIXTURE			18100	
5	COLLECTOR BAR	418	32	13376	
6	REFRACTORY MORTAR			13200	
7	CHAMOTTE POWDER			4200	
8	CASTABLE CEMENT			1100	
9	THERMAL INSULATING BOARD	2.3B	204	486	
10	INSULATING BRICK	NO. 5	17	3213	13524
11		NO. 6		328	
12	REFRACTORY BRICK	NO. 7		3658	
13		NO. 8		14	
14		NO. 9		42	
15		NO. 10		104	

A-5-16

-  PREBAKED CARBON
-  TAMPING MIXTURE
-  CHAMOTTE POWDER
-  REFRACTORY BRICK
-  INSULATING BRICK
-  THERMAL INSULATING BOARD
-  CASTABLE CEMENT

NOTE
 THIS DRAWING IS PREPARED FOR THE ACTUAL
 POTLINING WORKS. THEREFORE, SOME DETAILED
 DIMENSIONS HAVE BEEN REVISED FROM THE
 ORIGINAL DRAWING.



DRAWN BY	160KA プリバーク型電解炉
CHECKED BY	築炉図
APPROVED BY	
DATE	
SCALE	DWG. NO. G-016
REV	△

ITEM	DATE	REVISIONS	CHECKED
△			
△			