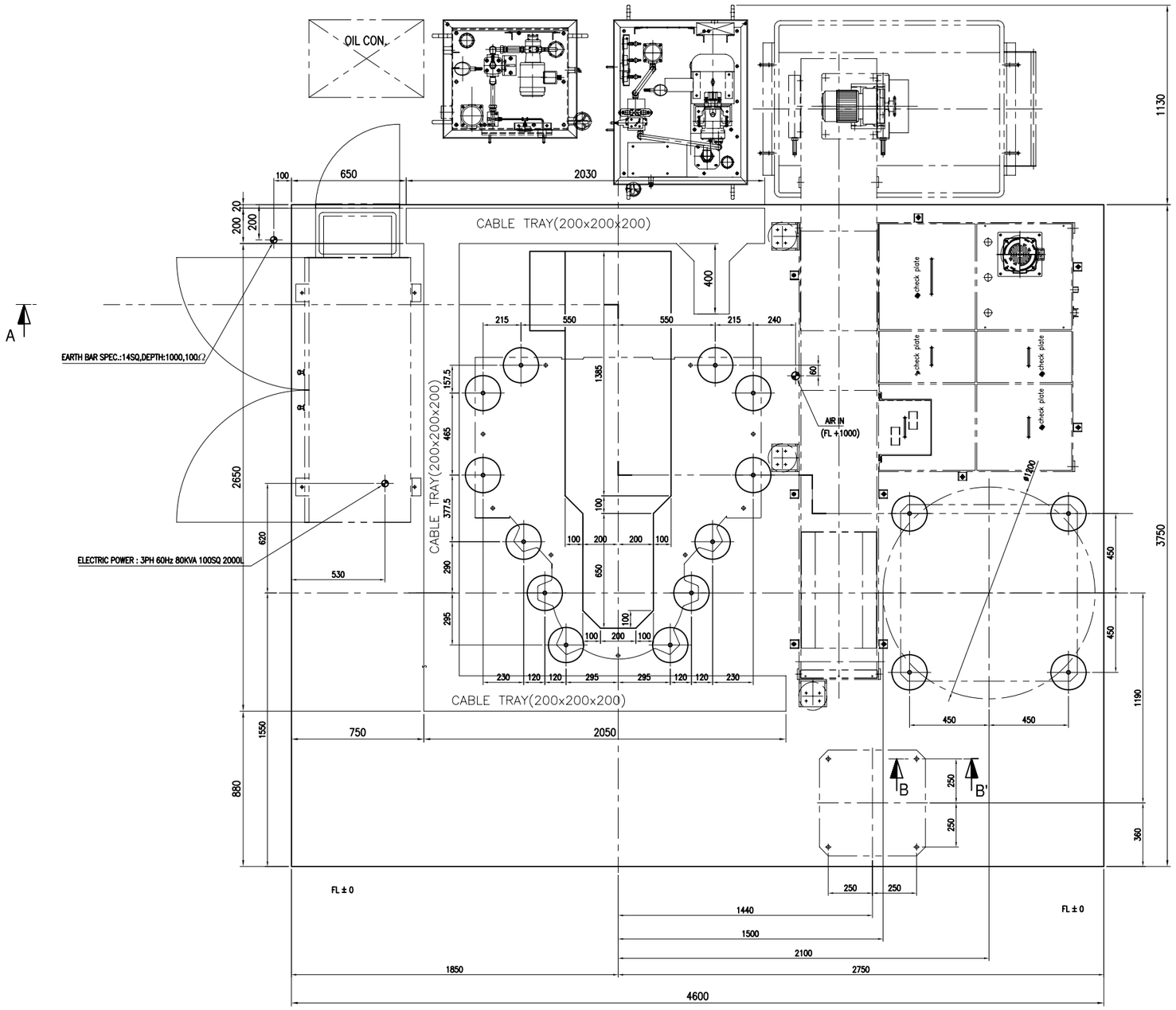
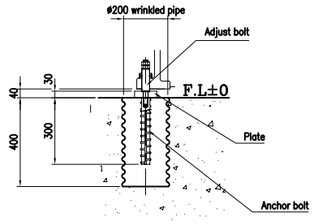
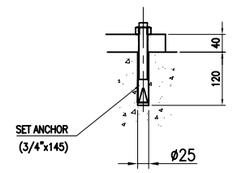
부 호	변경일자	변 경 내 용	담 당	확 인
1	08.11.10	LAYOUT 변경에 의한 기초변경	정 평호	





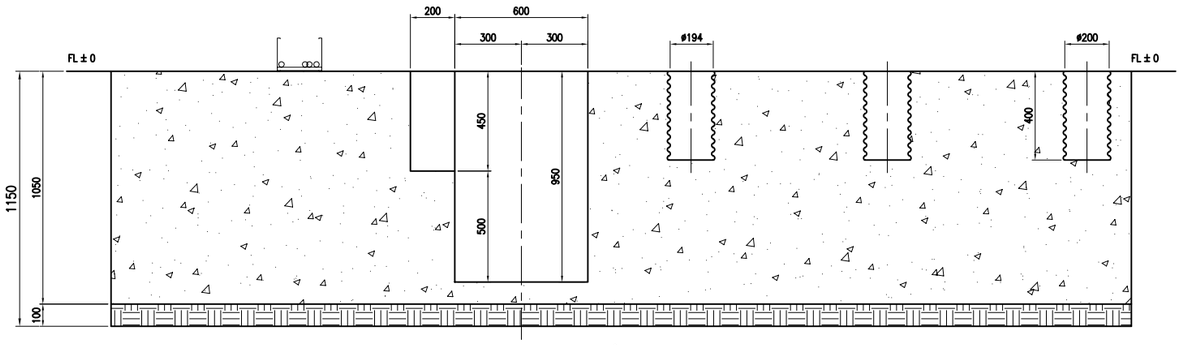
LEVELING BLOCK ASS'Y



SECTION B–B'

※NOTE

1. Mortar for machine installation, use a nonshrink grout mortar.
   (Recomend motar: MASTER FLOW 870–GK)
   Customer has to pour mortar into anchor holes.
2. Ground condition of foundation is to maintain over 10 ton/m² ground bearing for precision machine.
3. The nachine installation on FL–0 does not reguire the PIT COVER work.
5. Customer provide the Utility line, Air line,
   Electric power and Water line by the machine.
   Compressed air ;
   Volume: 500 liter/min, PT 1/2" pipe line, pressure: over 5Kg/cm².
   Electric power: 3PH 60Hz 80kVA 100SQ (projection length:2000 mm).
   Incomimg power specification to the machine : 220V, 250A
6. Dimension of anchor hole keep with in ±5 mm.
   Each hole is less than ±10 mm in total deviation.
7. Customer provide the flexible tube (wrinkled pipe) and cable tray etc. shown on foundation drawing.
8. For the machine instalation 10Ton lifting crane, lifting height 7m.
9. This is our standard foundation drawing .
   So, this drawing can be used on condition of a local exper's approval.
   He has to review the drawing in the light of the actual factory conditon.



SECTION A–A'

LOAD ANALYSIS

PART	WEIGHT	NO. of LEVELING BLOCK	
MACHINE BODY + WORKPIECE	15+4.5=19.5 TON	12 EA	1.63t/EA
A.T.C	1.5 TON	4 EA	0.38t/EA

절삭가공 허용차 (±)		지시없는 모서리 : C –	재질	–	수량	1SET
0.5이상 6이하	0.05	지시없는 라운딩 : R –				
6초과 30이하	0.1	승인	열처리	–	처도	N / S
30초과 120이하	0.15					
120초과 315이하	0.2	검도			중량	
315초과 1000이하	0.3					
1000초과 2000이하	0.5	설계 정 평호 20 07. 11. 15	표면처리	–		
탭 (볼트 구멍) 중심거리	0.2					

한 국 정 밀 기 계 (주)

기계명 NT–10/12F

CNC VERTICAL TURNING LATHE

품 명 FOUNDATION DRAWING

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품 번 T18F–F0–001A