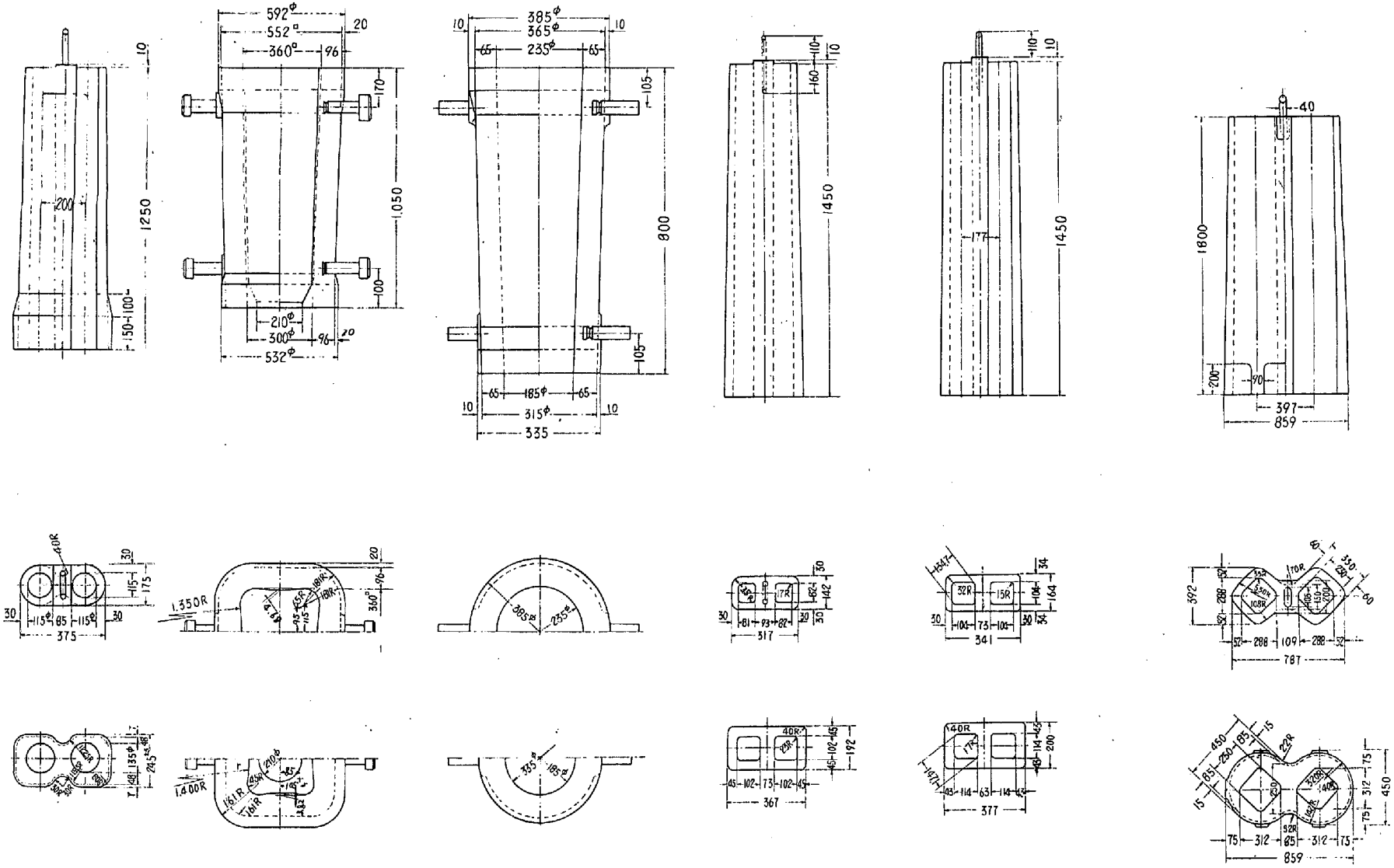
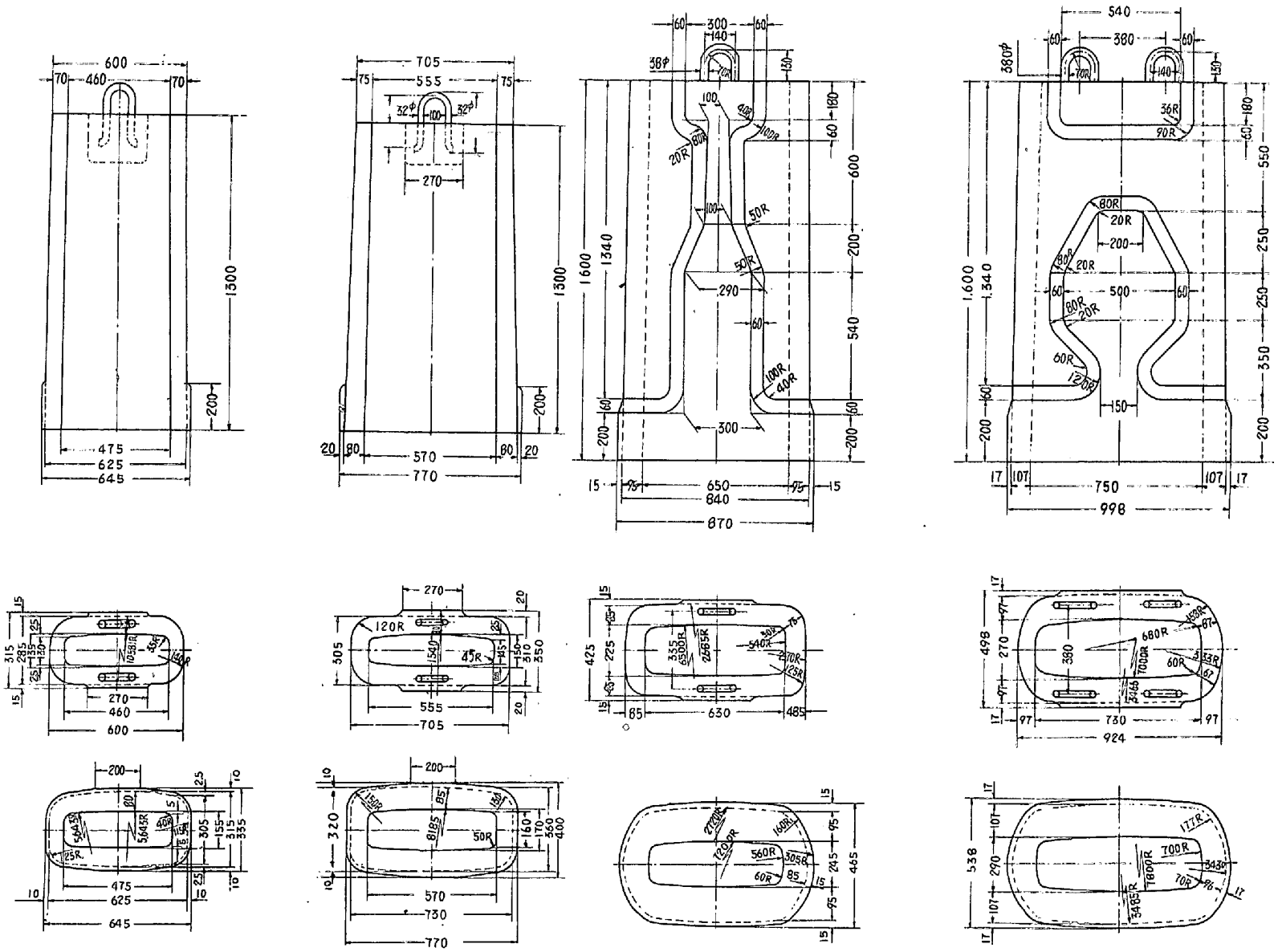
現 用 鋳 型

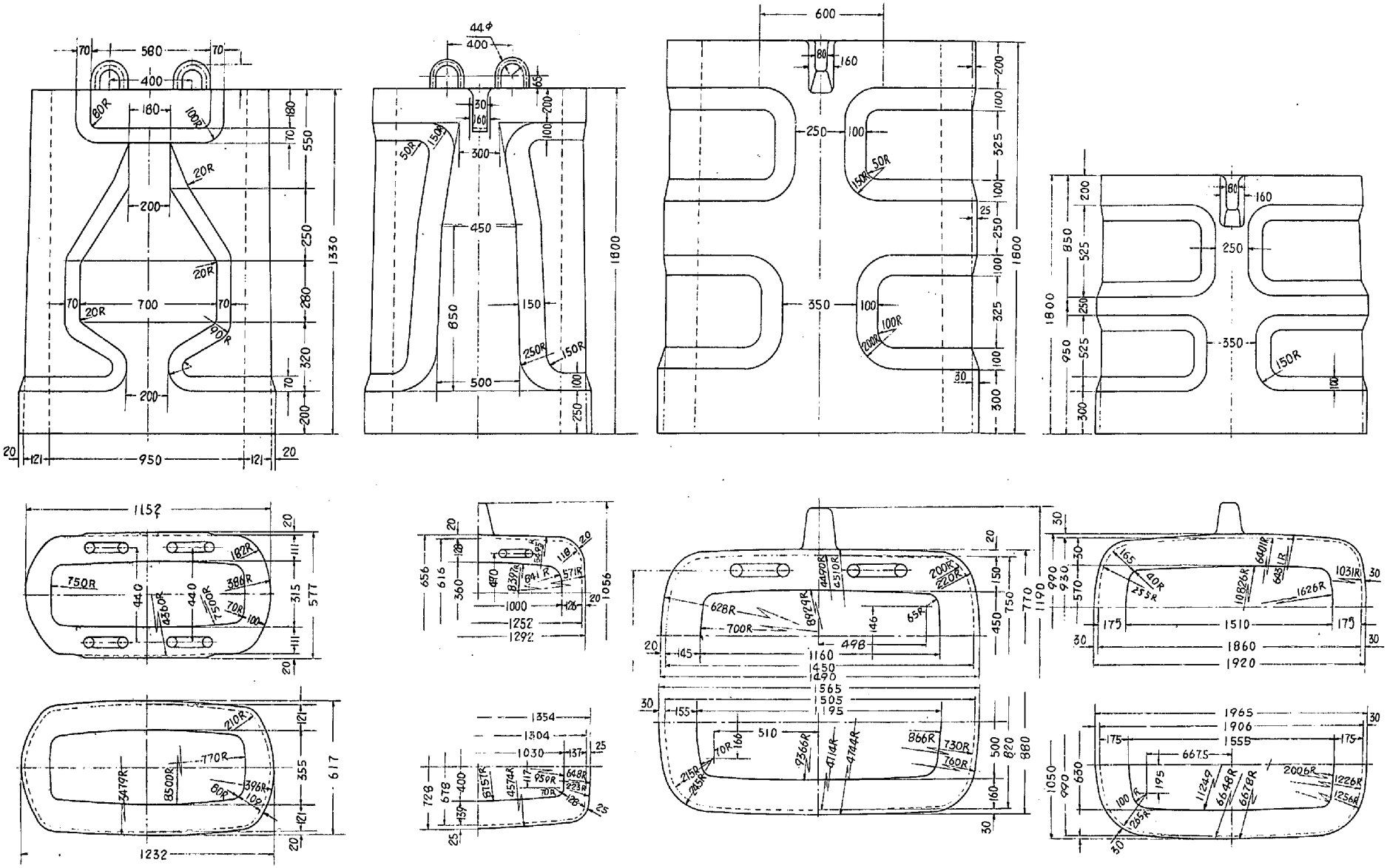


愛知製鋼	〃	〃	尼崎製鉄	〃	〃
H 110 kg	900 kg	250 kg	C-85	C-100	C-700



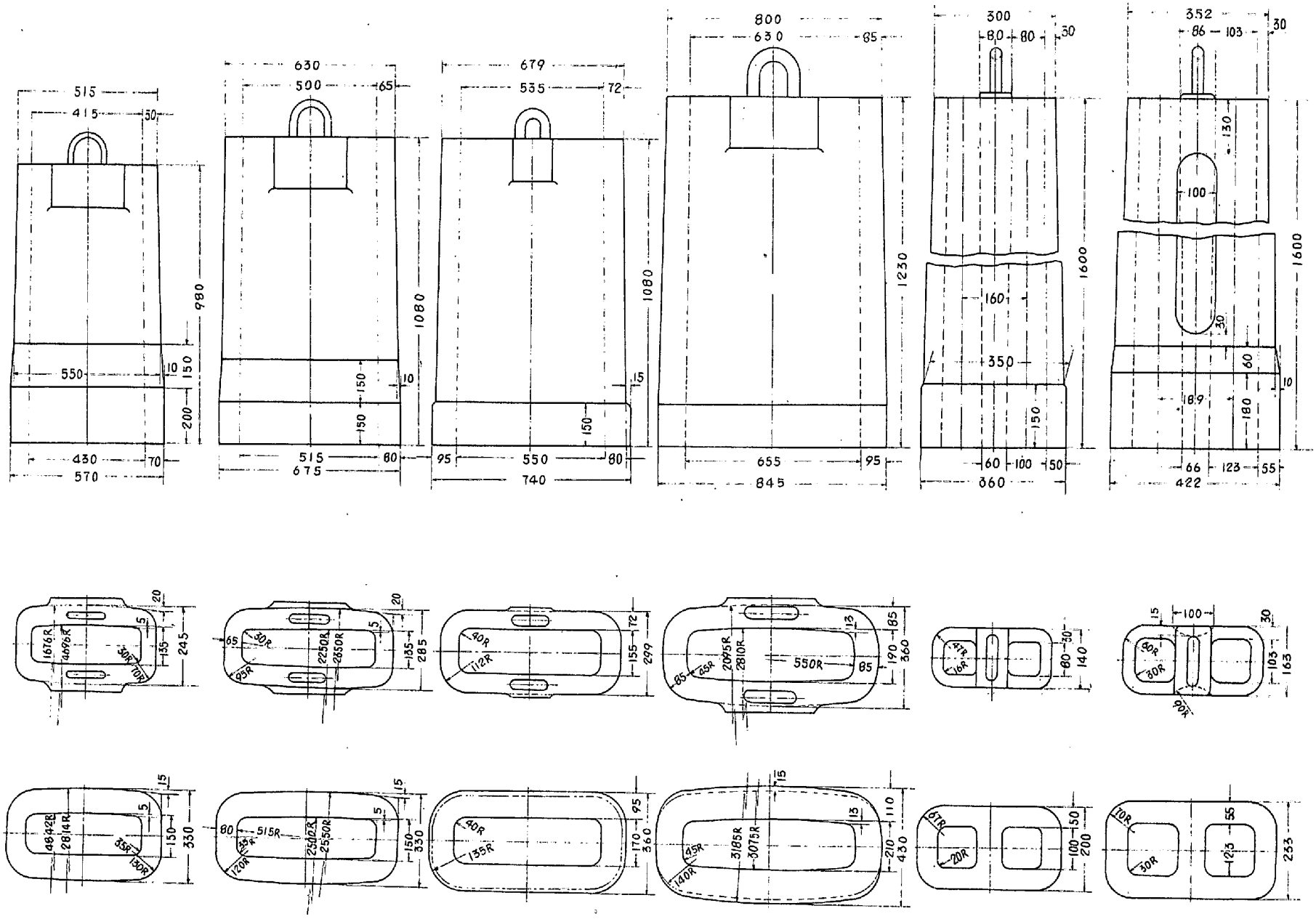
尼崎製鉄

B 400　　B 600　　B 1t　　B 2t



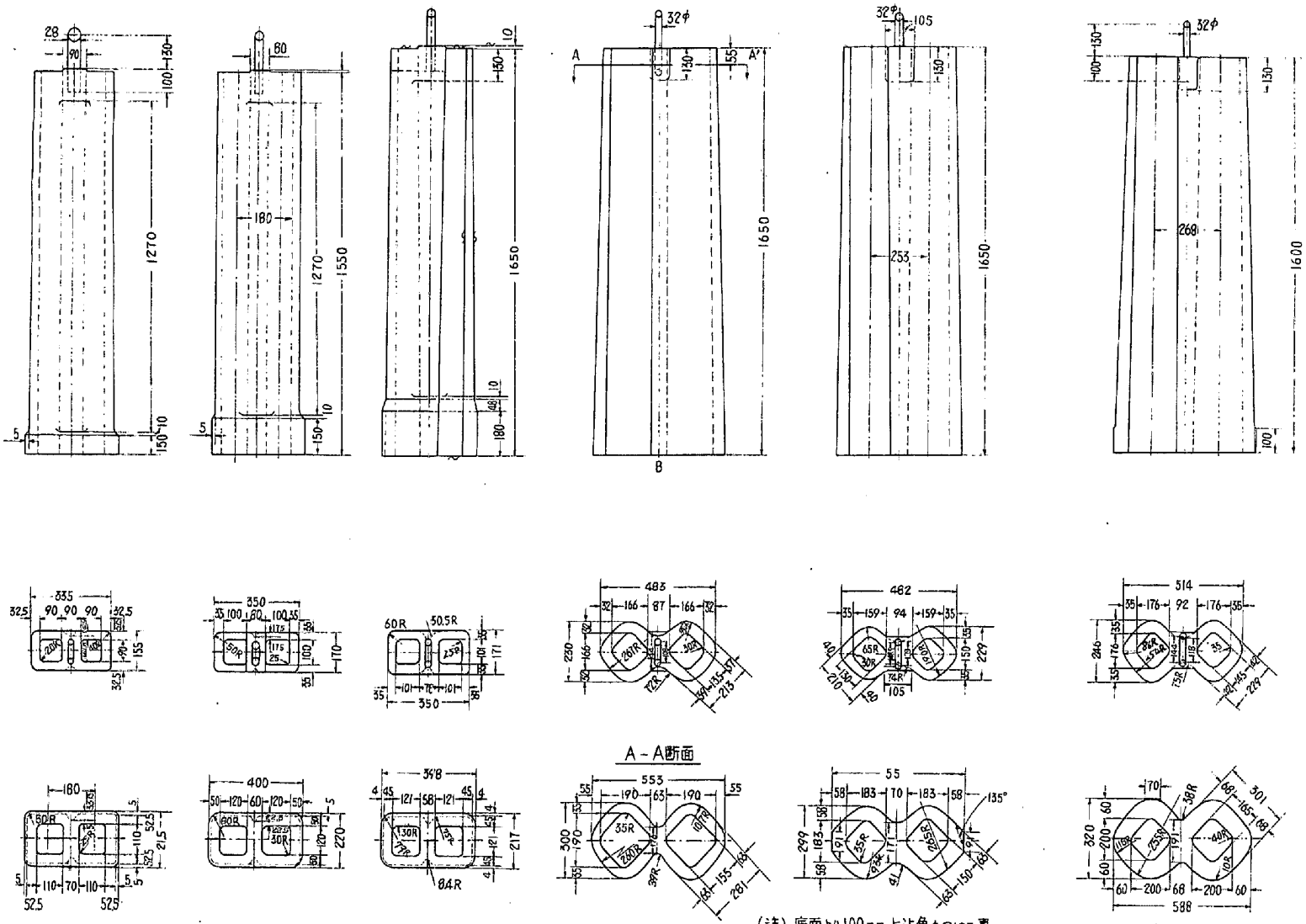
尼崎製鉄

B 3t　　B 4t　　B 6t　　B 10t



鋳鋼製

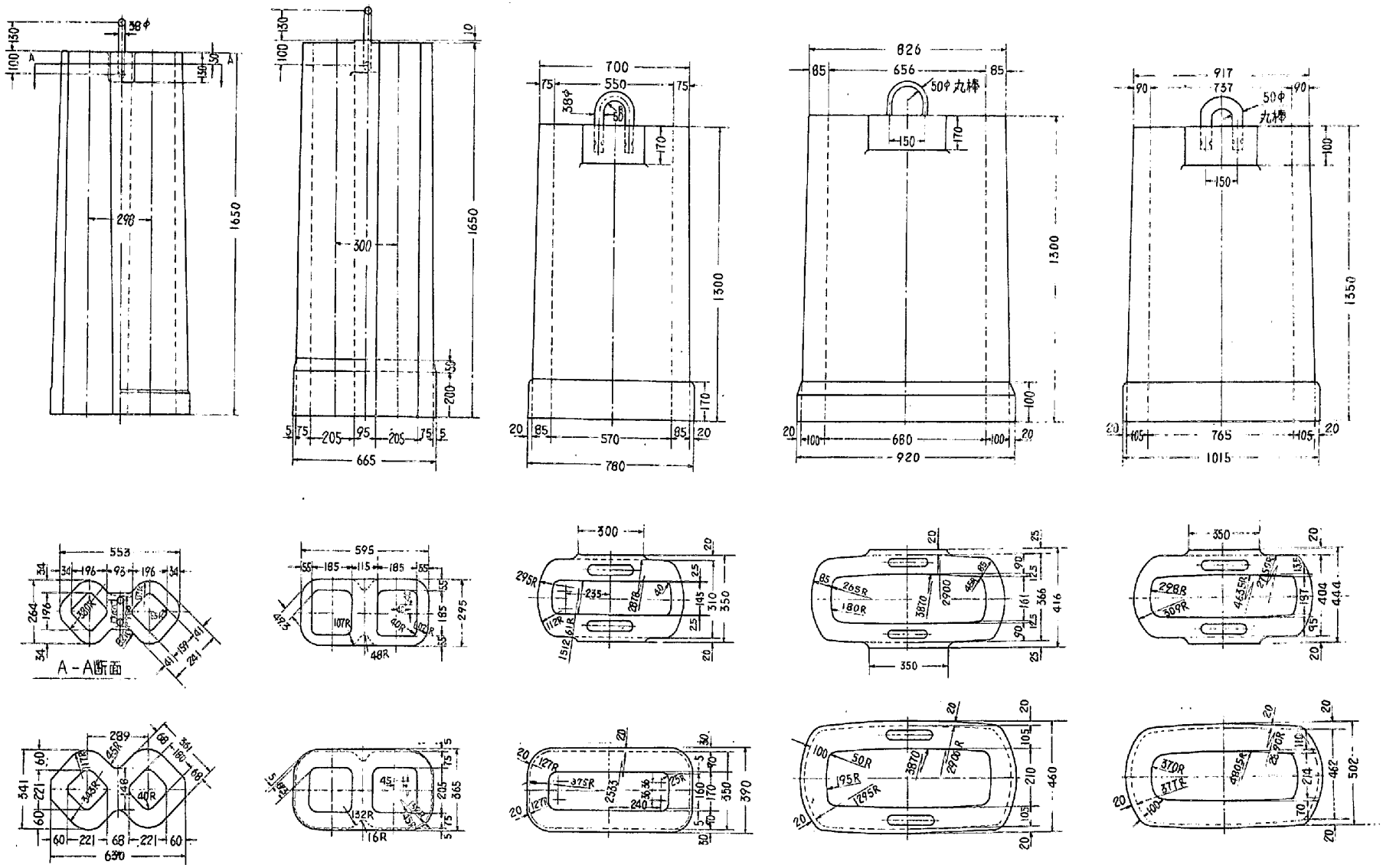
B03　　B045　　B06　　B09　　80 Kg　　130 Kg



(注) 底面より100mm上迫角をつける事

大阪製鋼

10型　12型　13型　20型(A)　20型(B)　25型



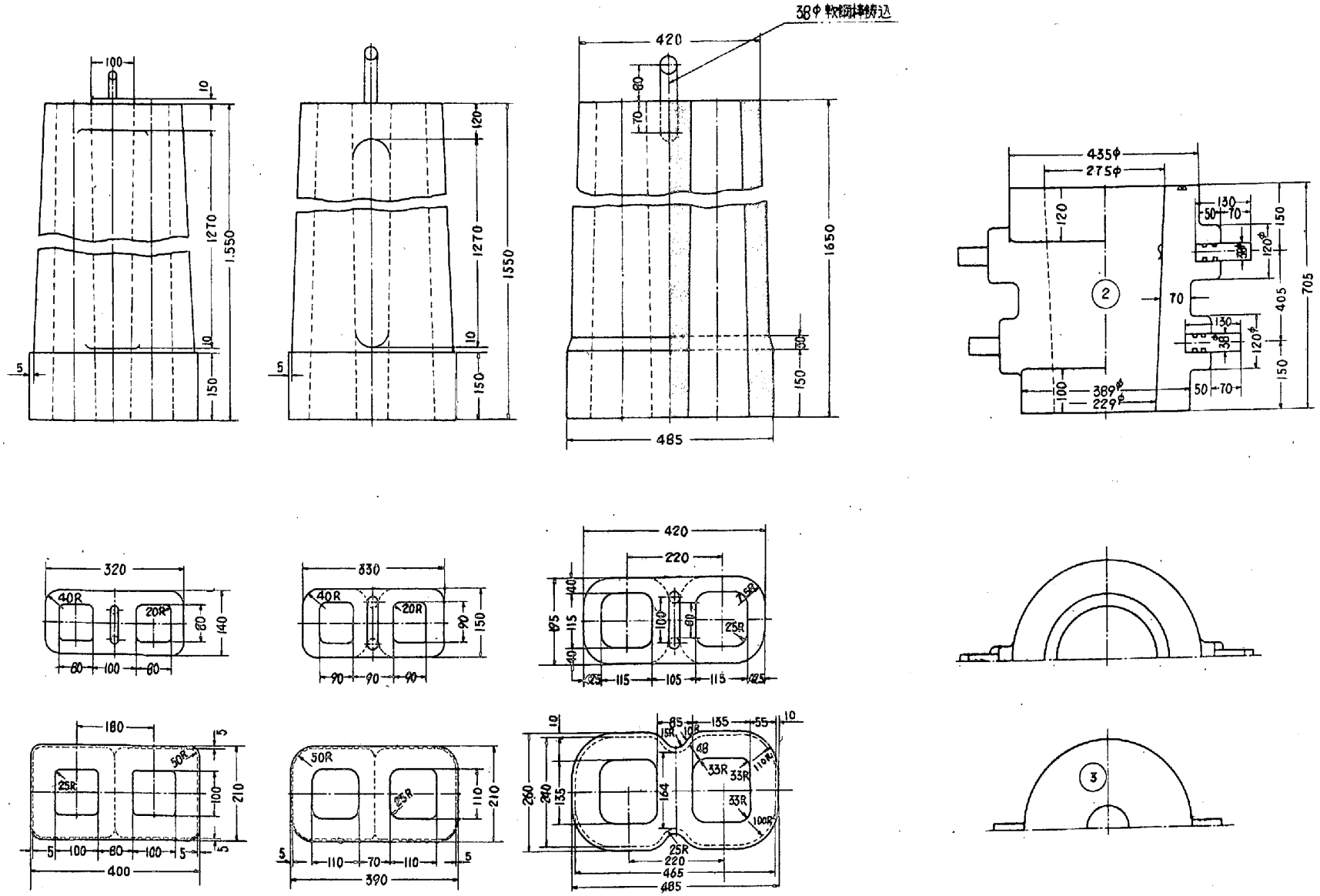
大阪製鋼　30型

〃　40型

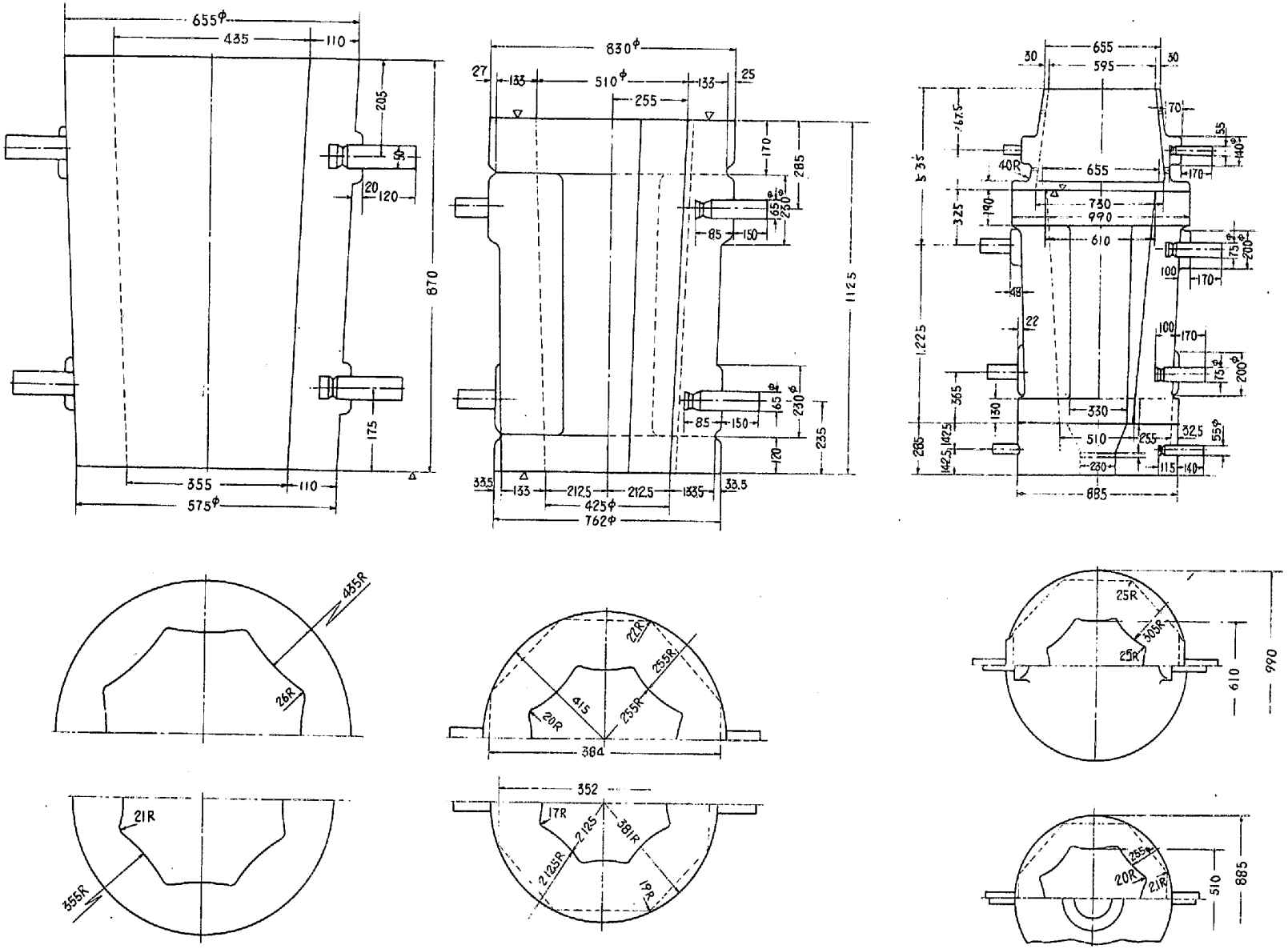
大谷重工　B 0.6

〃　B 1.2

〃　B 0.9



85 kg　　100 kg　　170 kg　　300 kg

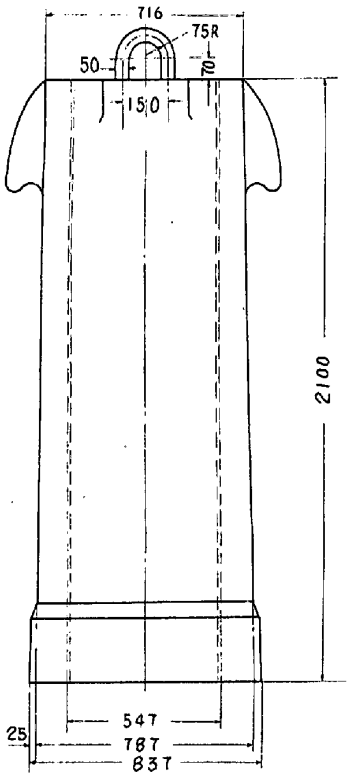

655φ
435
110
205
50
20
120
870
175
355
110
575φ
435R
26R
21R
355R
830φ
27
133
510φ
133
25
255
170
285
65φ
250φ
85
150
1125
65φ
230φ
85
150
235
120
33.5
133
212.5
212.5
133.5
33.5
425φ
762φ
22R
255R
415
20R
255R
384
352
17R
212.5
381R
212.5R
19R
655
30
595
30
70
55
140φ
67.5
535
40R
655
170
730
990
325
190
610
175φ
200φ
100
170
48
22
100
170
175φ
200φ
1,225
365
130
330
510
255
32.5
55φ
285
142.5
142.5
230
115
140
885
25R
305R
25R
610
990
255
20R
21R
510
885

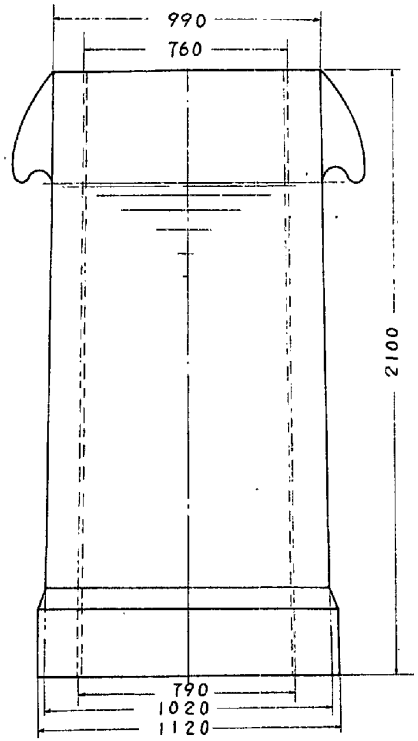
大谷重工

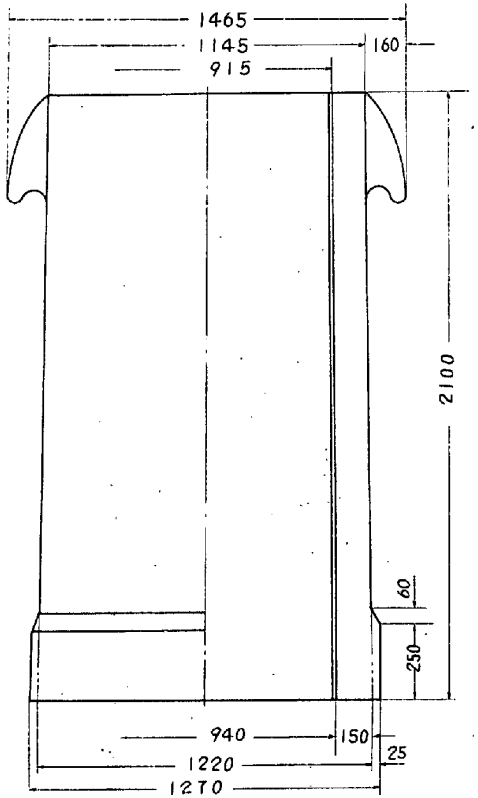
1t

2t

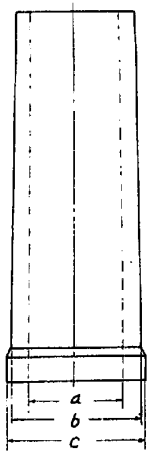
3t



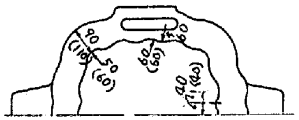




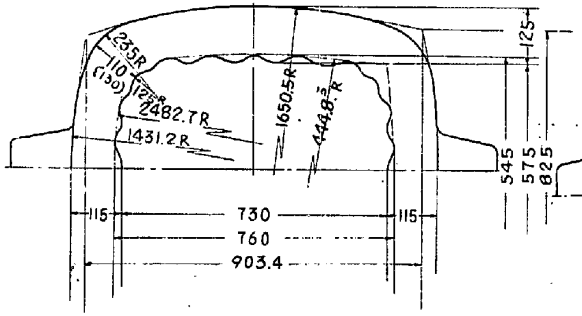
短辺下部寸法

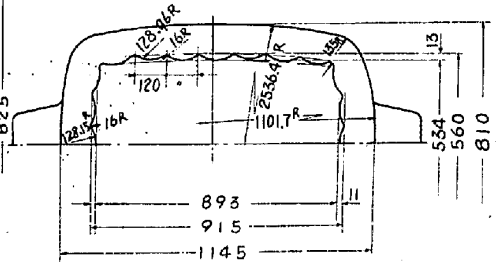


鋳型名	a	b	c
C-5 C 改3	605	895	945
C-6 F	595	885	935
C-8FR -1.0	622	942	992
C-10FR -1.3改	610	950	1010
C-13FR -1.5	692	1032	1092
C-10CR -1.5改	593	933	993
KC-10-C 改3	793	1133	1193
KC-15CR 1.3	885	1265	1325
KC-15CR 1.5改	755	1135	1195



(カッコ内は底部寸法)



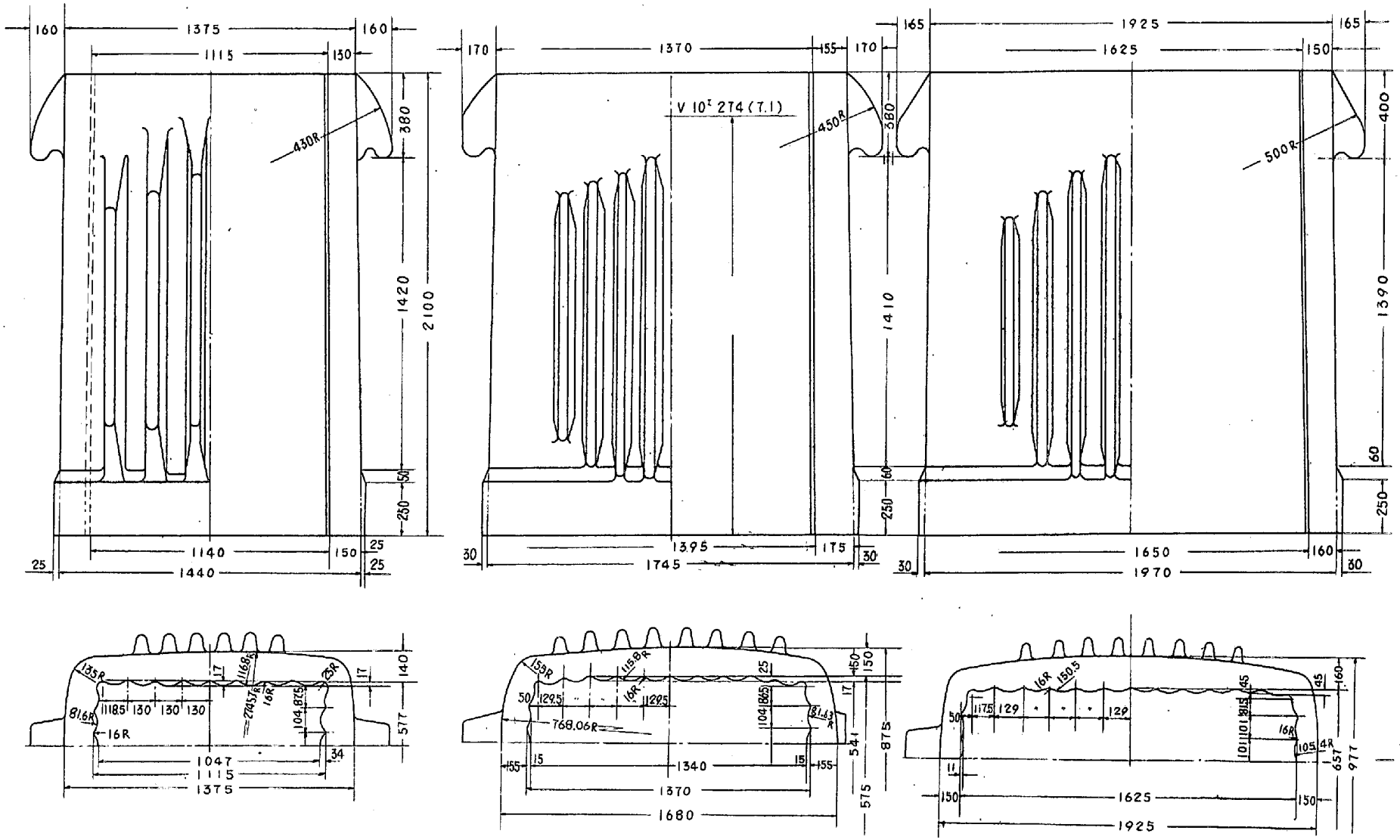


川鉄・千葉

H3改

C-5-C改3

C-6F



川 鉄 ・ 千 葉

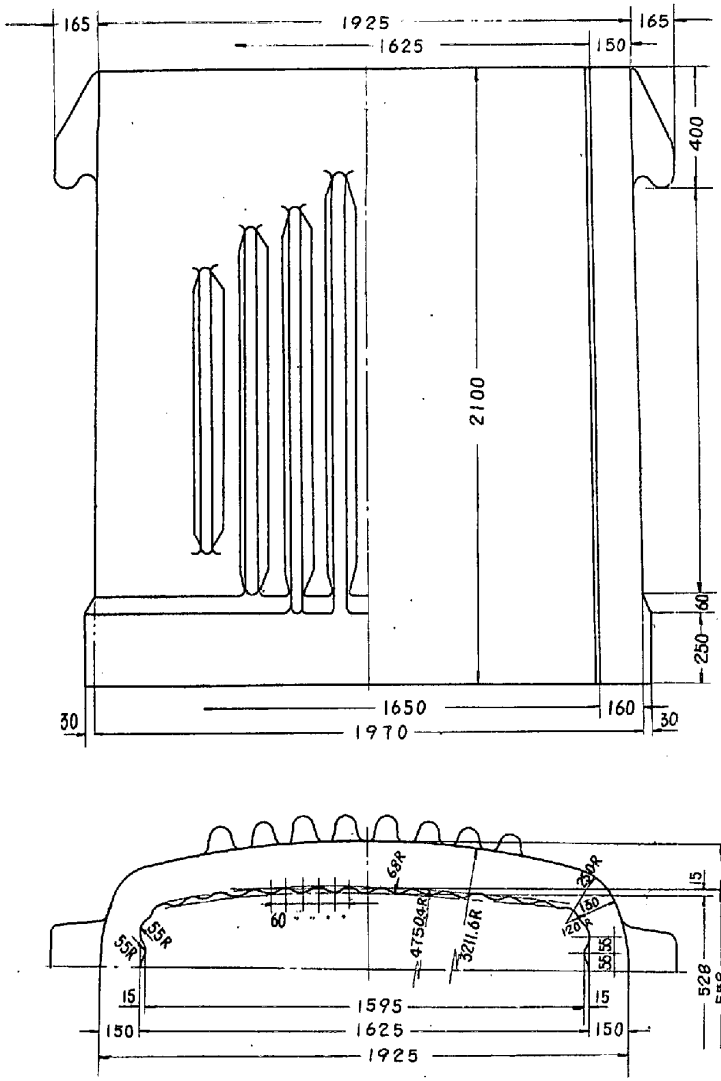
C－8FR－1.0

・

C－10FR－1.3改

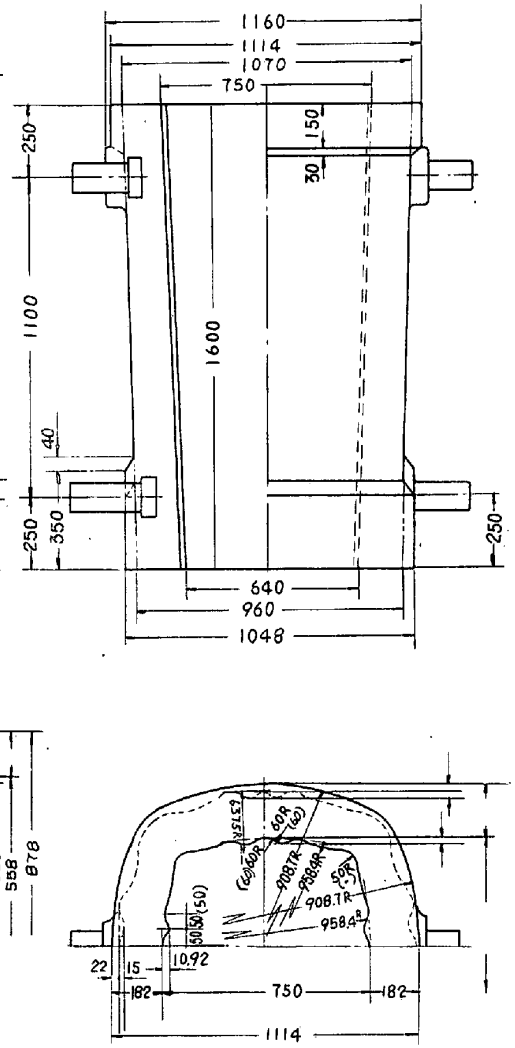
・

C－13FR－1.5

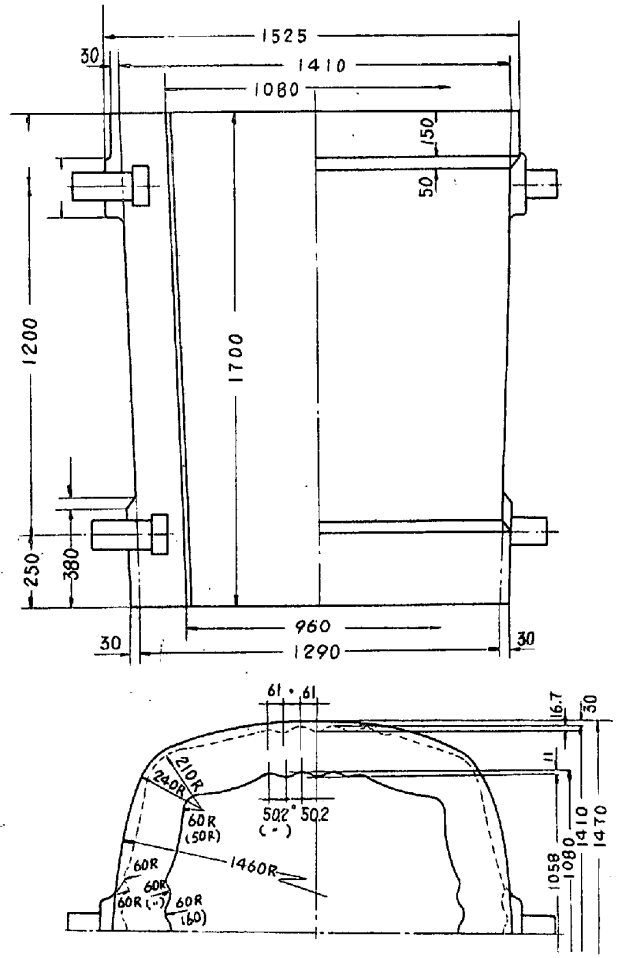


川 鉄 ・ 千 葉

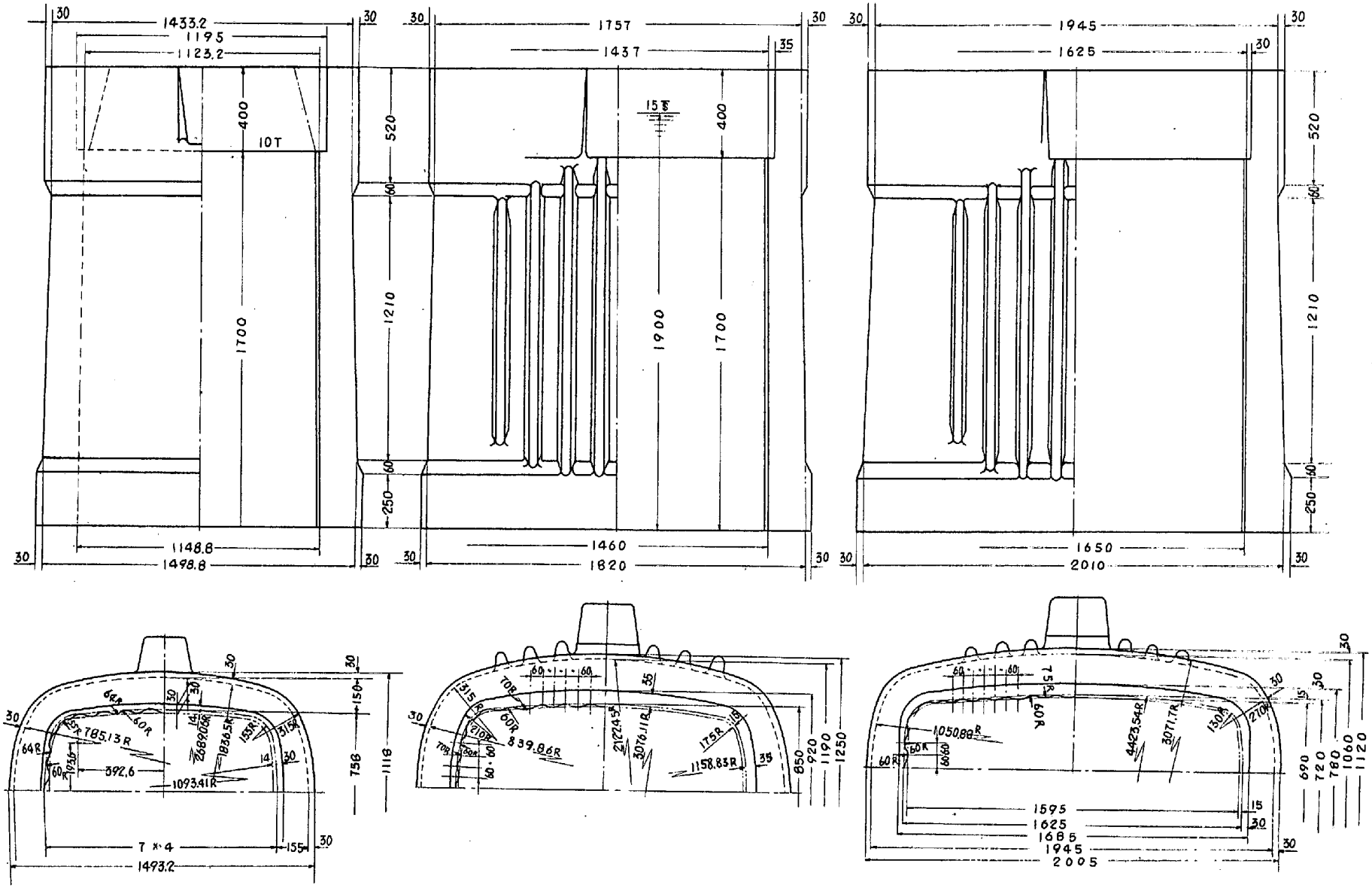
C-10 CR-1.5 改



KVH 5



KVH 10

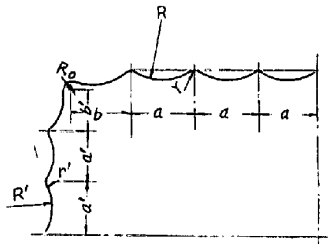


川鉄・千葉

KC-10,-C 改3

KC-15CR 1.3

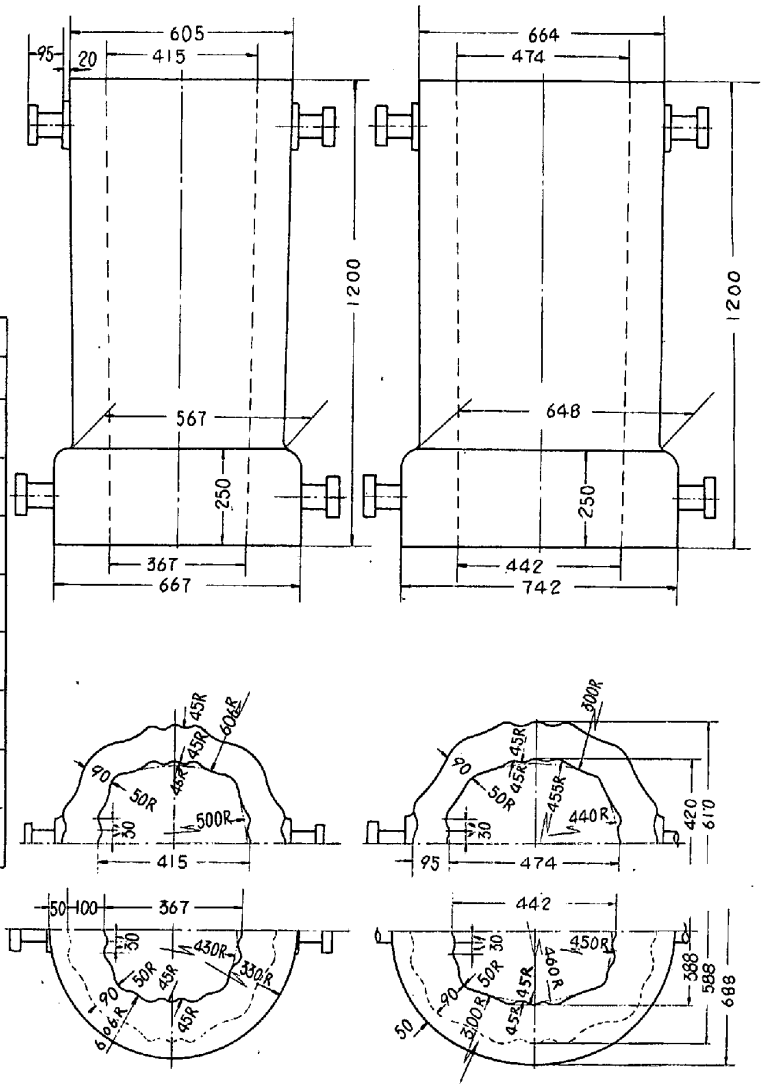
KC-15CR 1.5



コルゲートまたはフリュート寸法

鋳型名	長辺部					短辺部					隅角半径
	山数*	a	b	R	r	山数	a'	b'	R'	r'	Ro
C-6F	6	120		128.96	16	4	101		128.15	16	25
C-8FR -1.0	7	130	118.5	116.8	16	4	104	87.5	81.6	16	25
C-10FR -1.3改	9	129.5	129.5	115.81	16	4	104	86.5	81.6	16	25
C-13FR -1.5	11	129	117.5	150.5	16	5	101	81.5	105.4	16	25
C-10CR 1.5改	12	120		68	60	3	110		55	55	55
KC-10C 改3	8	94		64	60	5	94		64	60	55
KC-15CR 1.3	10	120		70	60	6	120		70	60	60
KC-15CR 1.5	12	120		75	60	4	120		60	60	55

※ 鋼塊の一辺についての山数
b, b' 以外は頭部,底部とも同一寸法

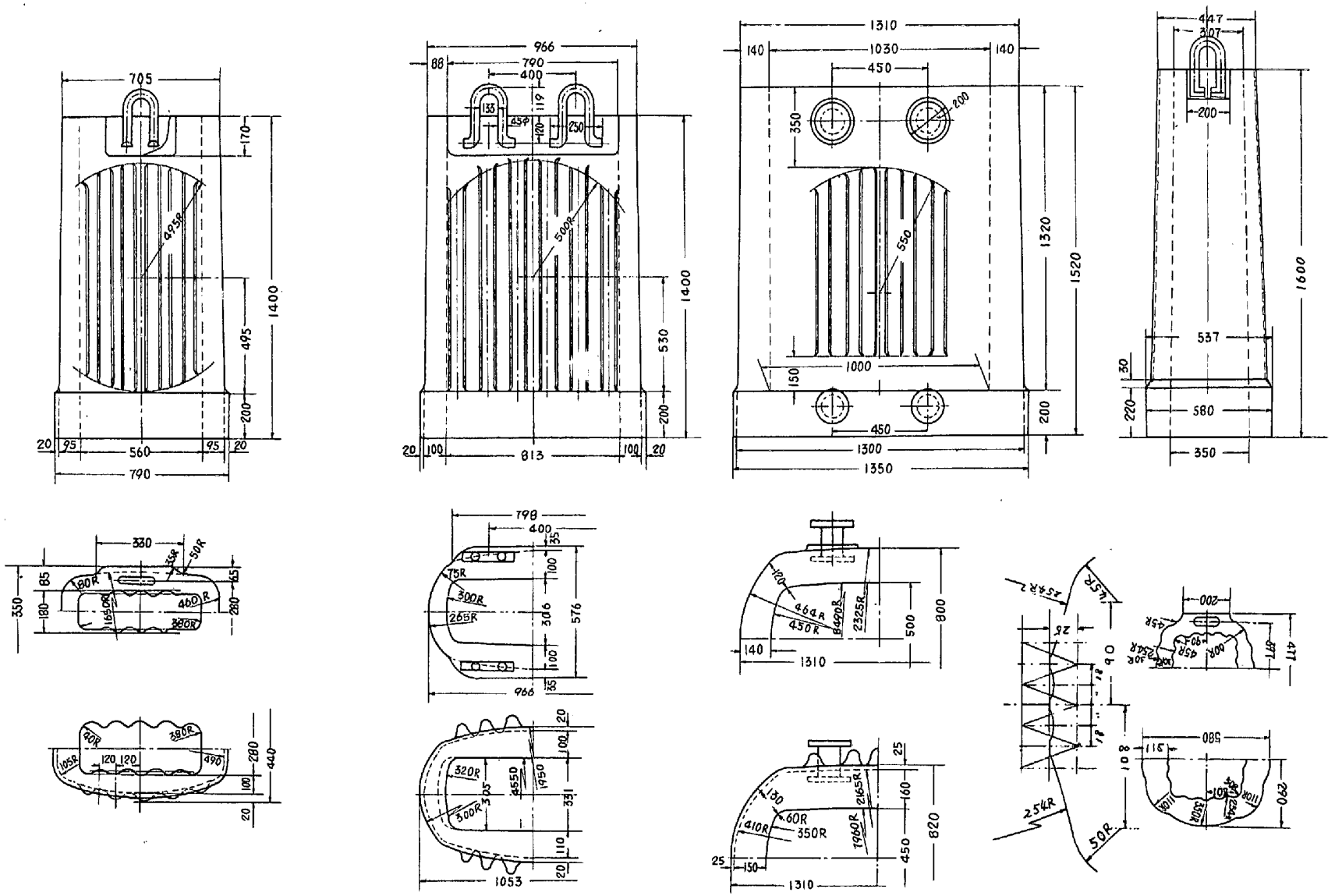


川鉄・千葉

川鉄・西宮

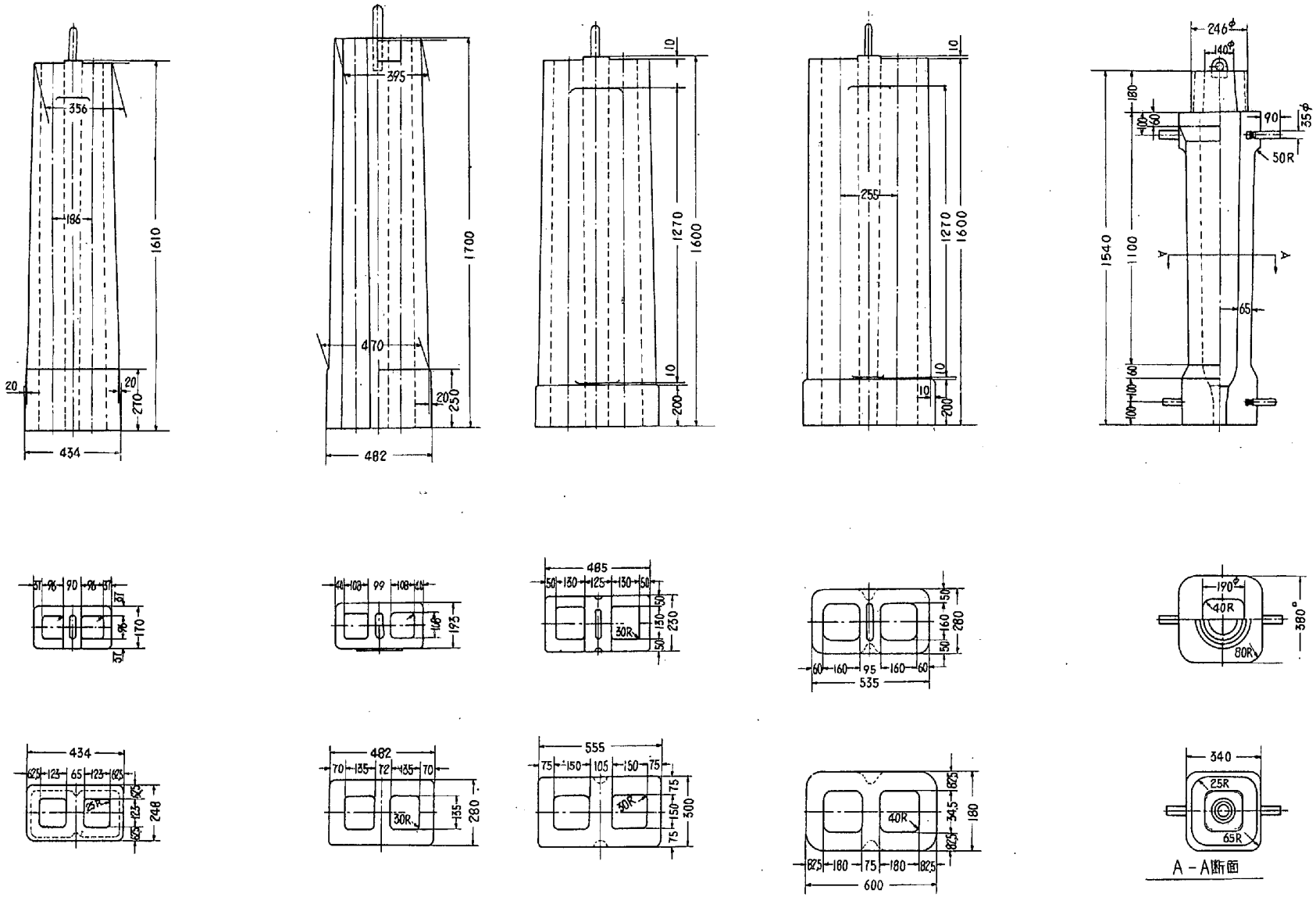
H1.2V

H1.4V



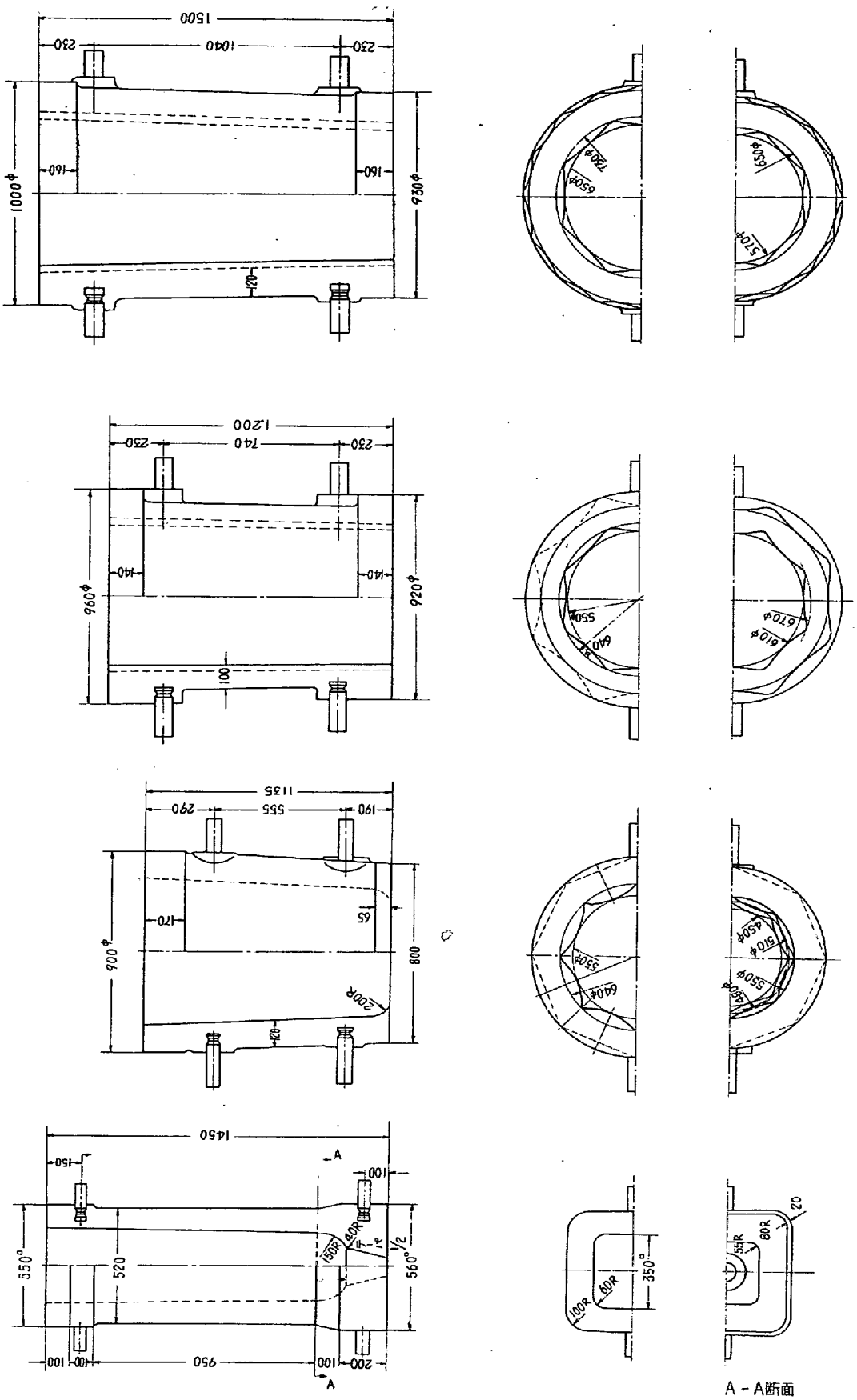
川鉄・葺合

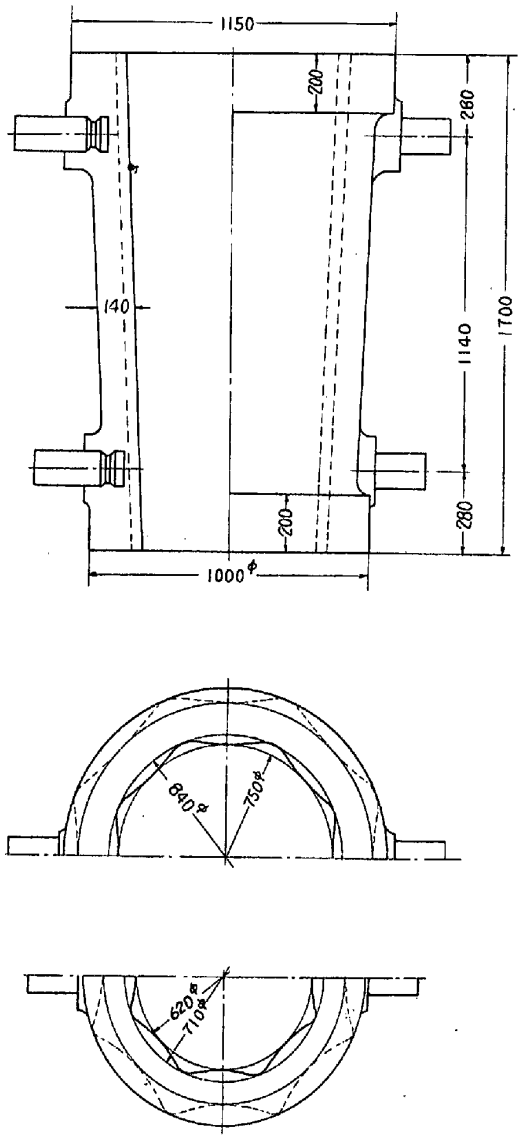
A 0.8R　　B 2R　　KBV 5R　　H



川鉄・兵庫

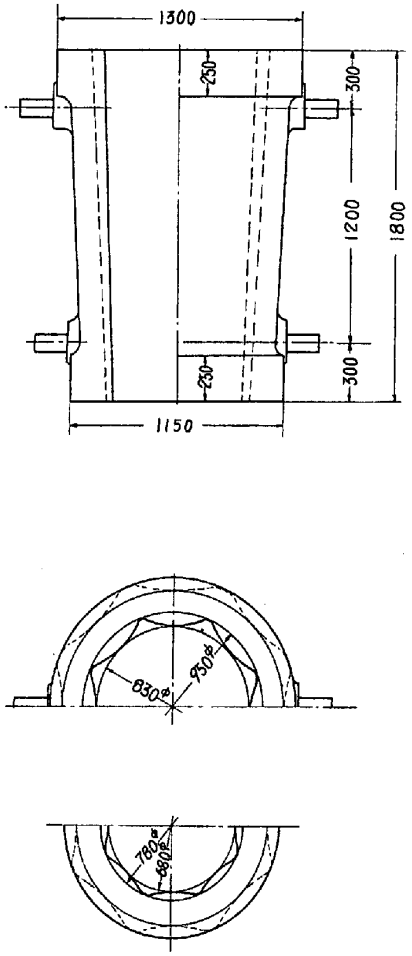
100 kg　　160 kg　　200 kg　　300 kg　　250 kg


1500
1040
230
230
160
160
1000φ
930φ
120
730φ
650φ
570φ
650φ
4000kg
1200
740
230
230
140
140
960φ
920φ
100
550φ
640φ
610φ
670φ
3000kg
1135
555
290
190
170
65
900φ
800
200R
120
550φ
640φ
450φ
510φ
550φ
450φ
2000 kg
1450
150
100
A
550°
520
150R
40R
1/2
560°
100
100
950
100
200
A
100R
60R
350°
55R
80R
20
A－A断面
川鉄・兵庫
1000 kg

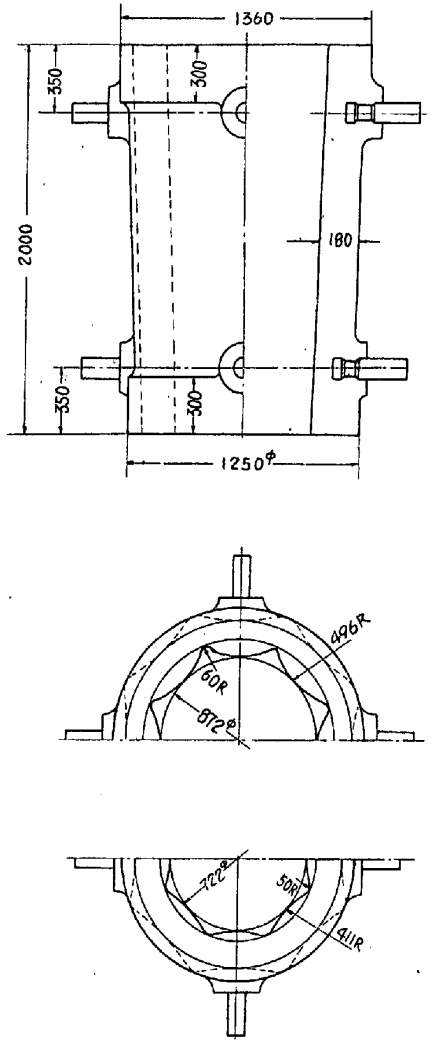


川鉄・兵庫

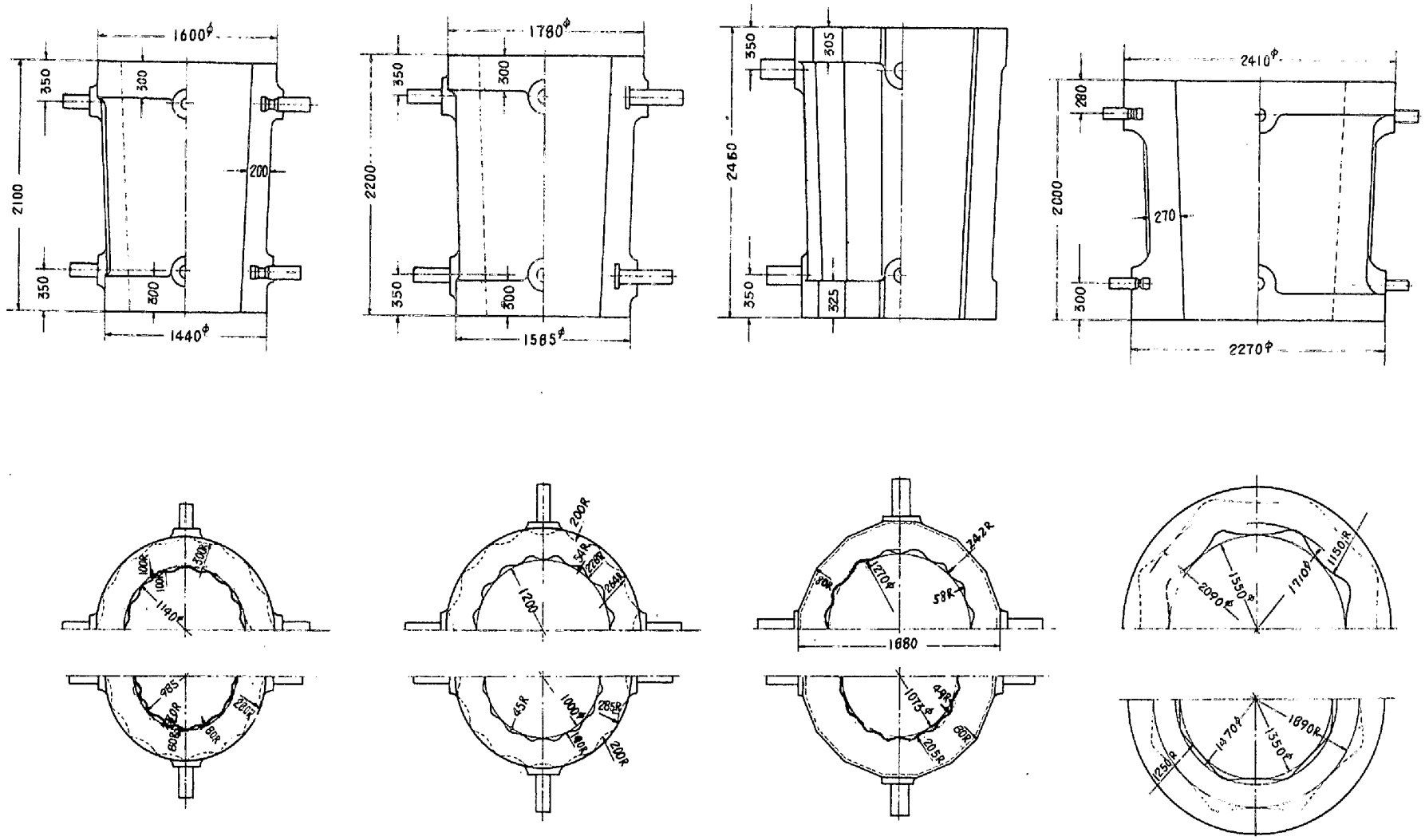
6000 kg



8000 kg

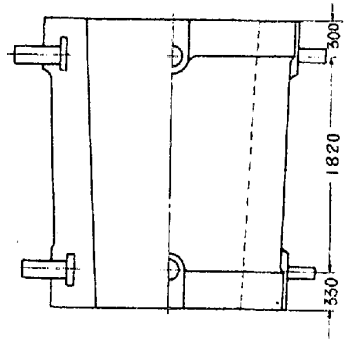


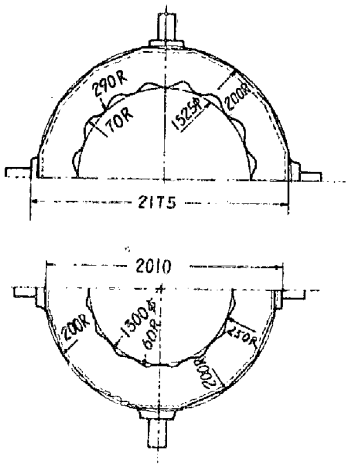
10,000 kg



川鉄・兵庫　　〃　　〃　　〃

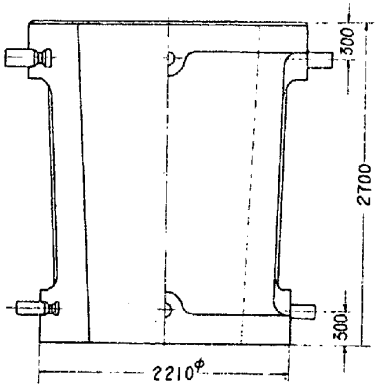
15,000 kg　　20t　　25 t　　30 t

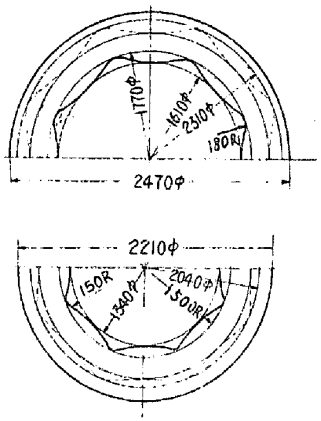




川鉄・兵庫

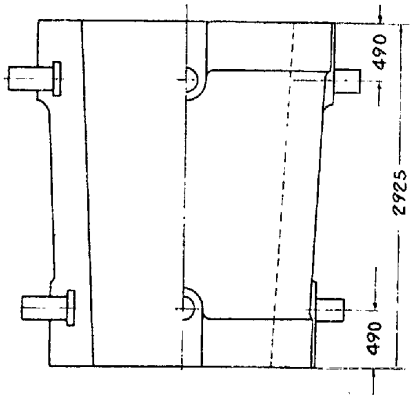
35 t

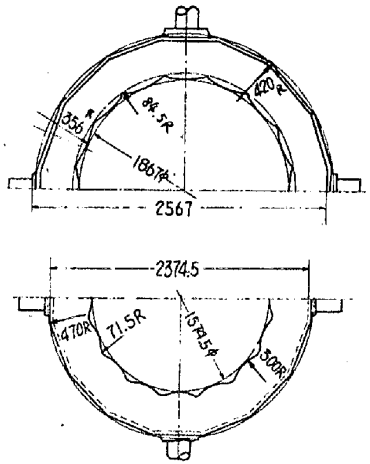




〃

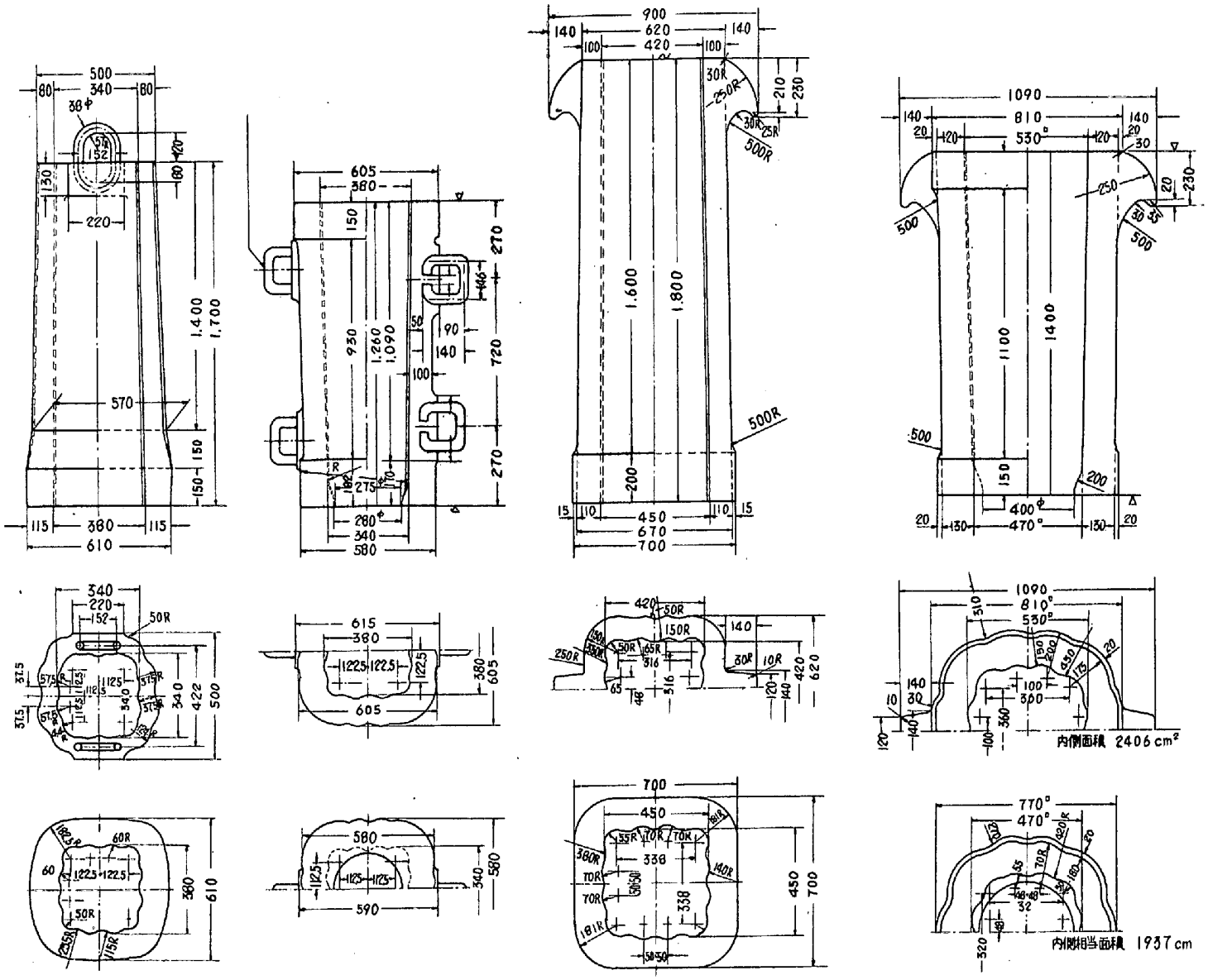
43 t





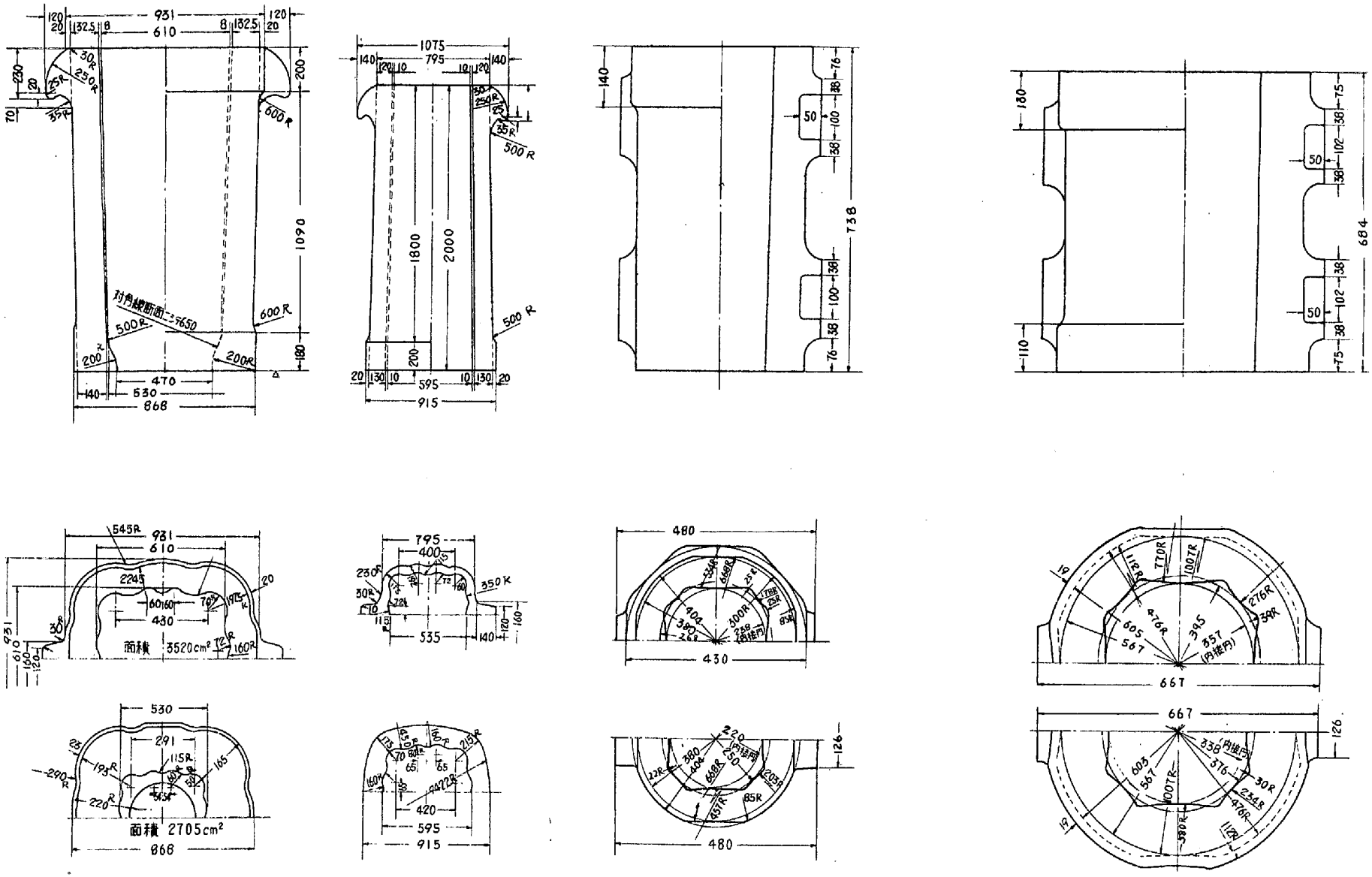
〃

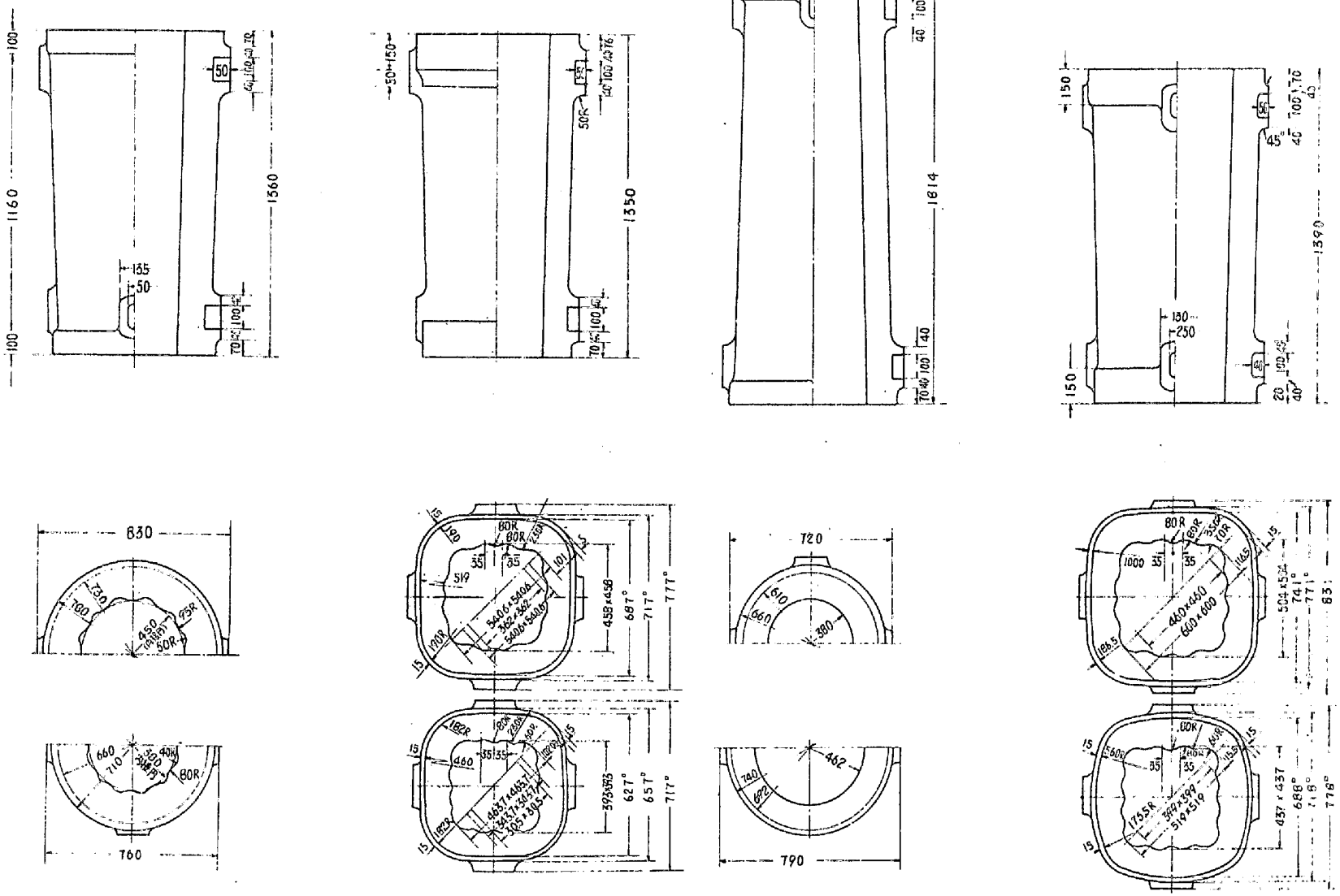
65 t



神戸製鋼

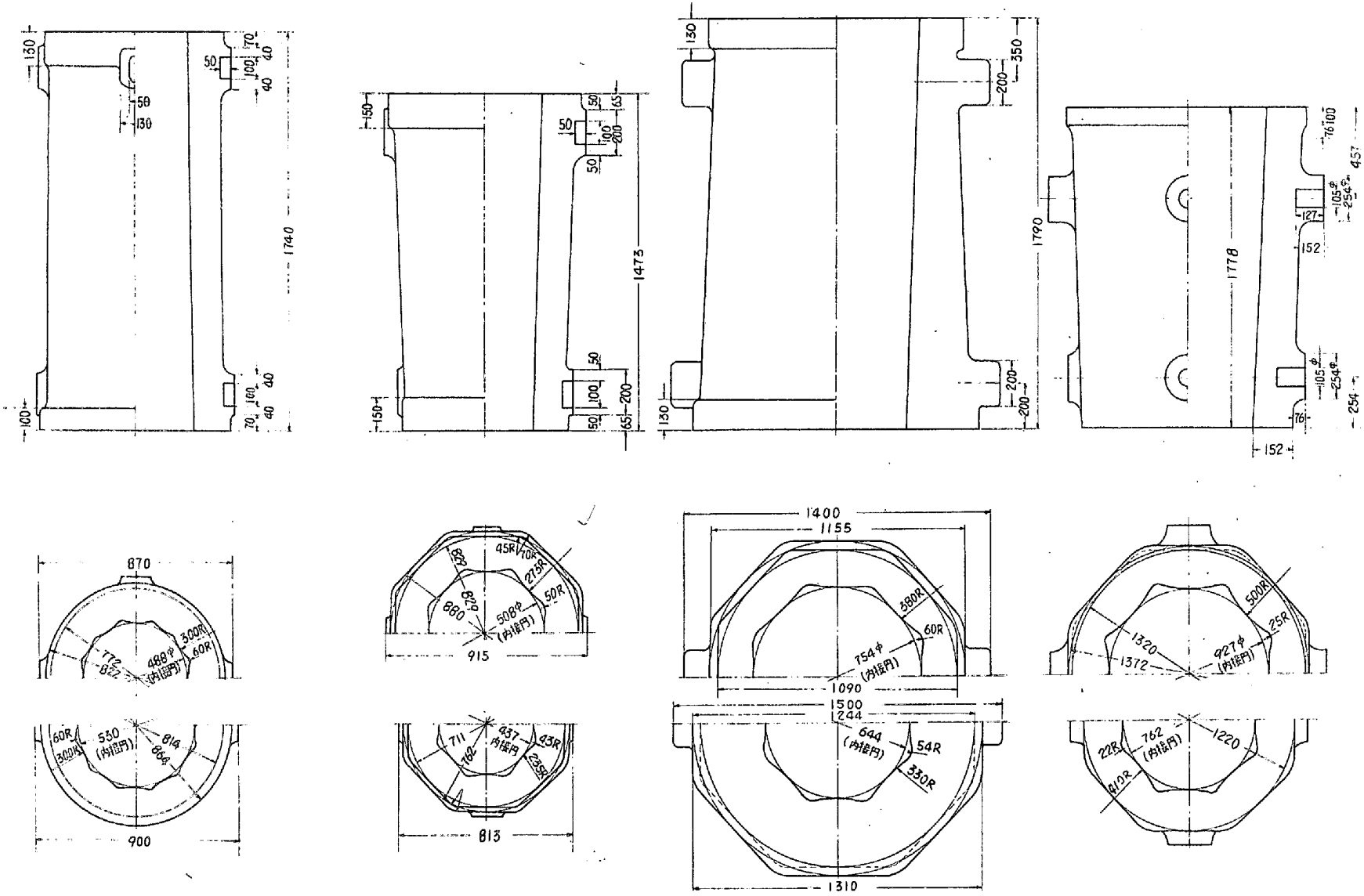
N 1t　　1.2t　　N 2t　　K 2t


931
610
1090
1800
2000
868
530
470
595
915
738
684
面積 3520cm²
面積 2705cm²
480
430
667
666
神戸製鋼
K 3TH
4 TH
住金・製鋼
300 kg
675 kg



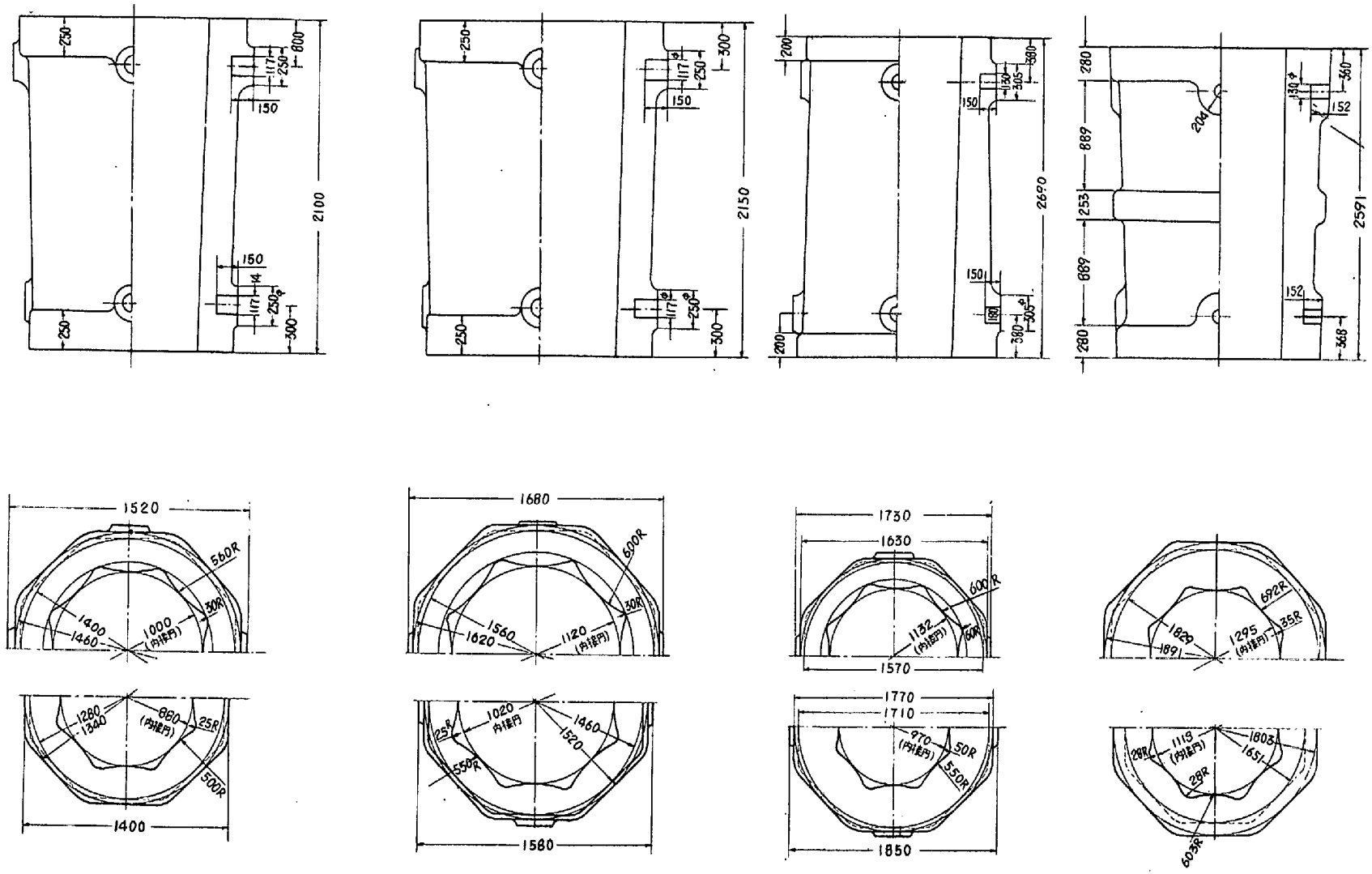
住金・製鋼

1T 700kg　　1T 900kg　　2T　　2.4t



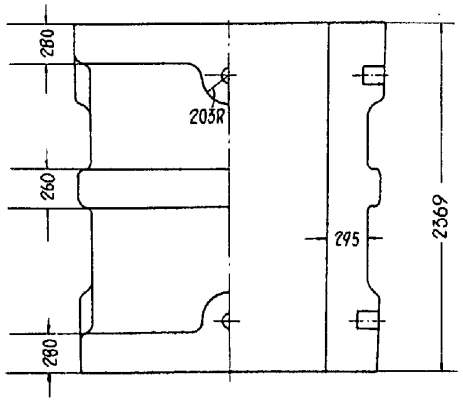
住金・製鋼

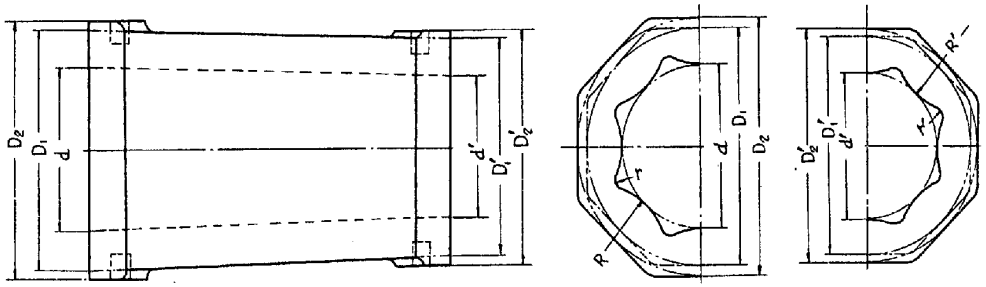
2.9 T　　2.6 T　　6.5 T　　10 T



住金・製鋼

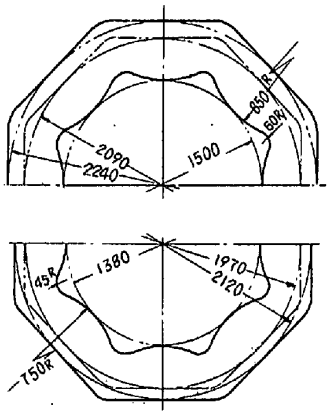
15 T　　20 T　　22.5 T　　30 T





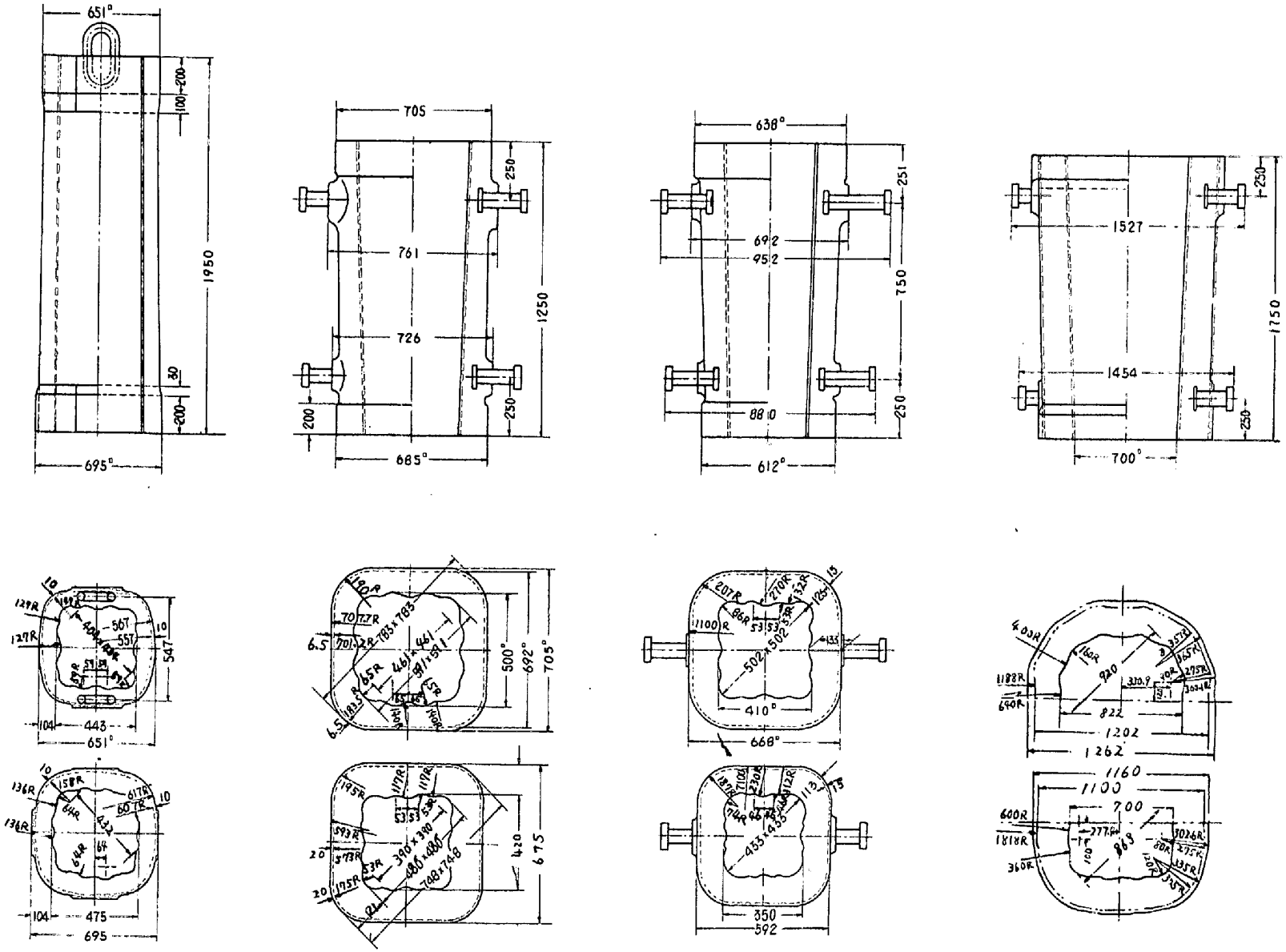
入角鋳型寸法詳細

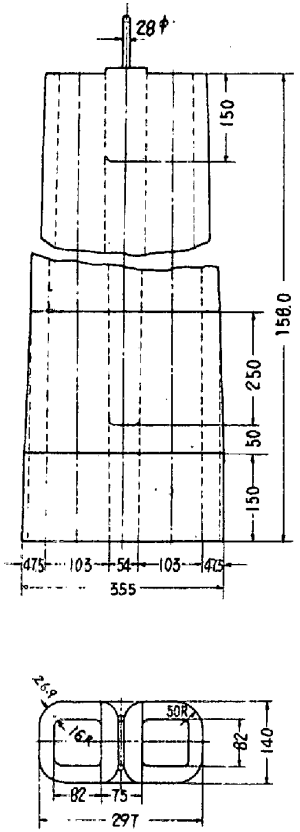
鋳型名	頭部					底部				
	d	D_1	D_2	r	R	d'	D_1'	D_2'	r'	R'
2T 600	508	829	880	50	273	437	711	762	43	235
6T 500	754	1090	1155	60	380	644	1244	1310	54	330
10T 000	927	1320	1372	25	500	762	1220	—	22	410
15T 000	1000	1400	1460	30	560	880	1280	1340	25	500
20T 000	1120	1560	1620	30	600	1020	1460	1520	25	550
22T 500	1132	1570	1630	60	600	970	1710	1770	50	550
30T 000	1295	1829	1981	35	692	1118	1651	1803	28	603
42T 000	1500	2090	2240	50	850	1380	1970	2120	45	750



仕金・製鋼

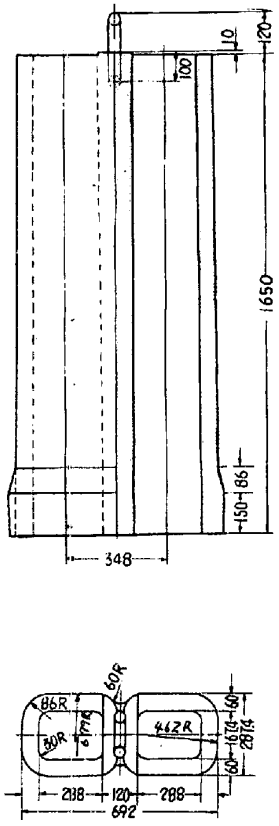
42t 000 kg


651°
200
100
1950
30
200
695°
705
250
761
726
1250
200
250
685°
638°
251
692
952
750
880
250
612°
250
1527
1750
1454
250
700°
10
129R
127R
567
557
10
547
104
443
651°
10
136R
136R
104
475
695
500°
692°
705°
420
675
390×390
486×486
748×748
20
20
638
692
952
750
880
250
612
350
592
668°
410°
502×502
1100R
1160
1100
700
600R
1818R
360R
920
822
1202
1262
1188R
690R
403R
160R
277R
1026R
335R
813
住金・鋼管
A 型
C 型
S T
F 9 B

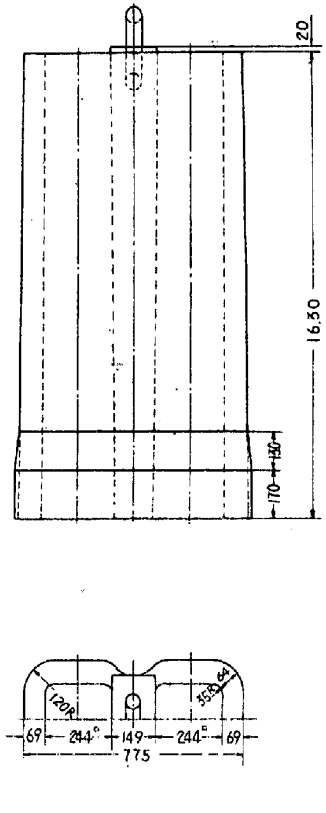


住金・小倉

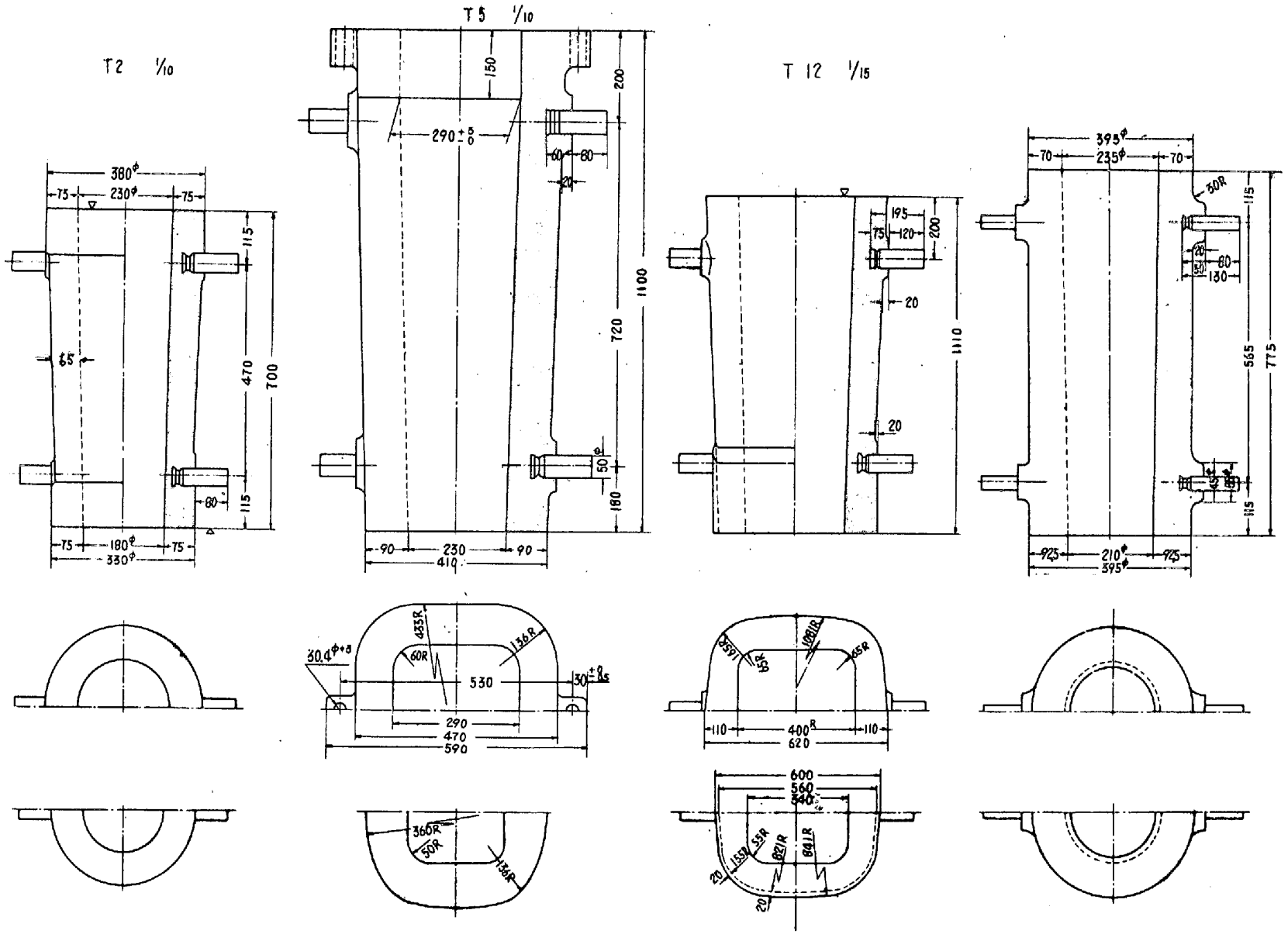
90 kg



450 kg

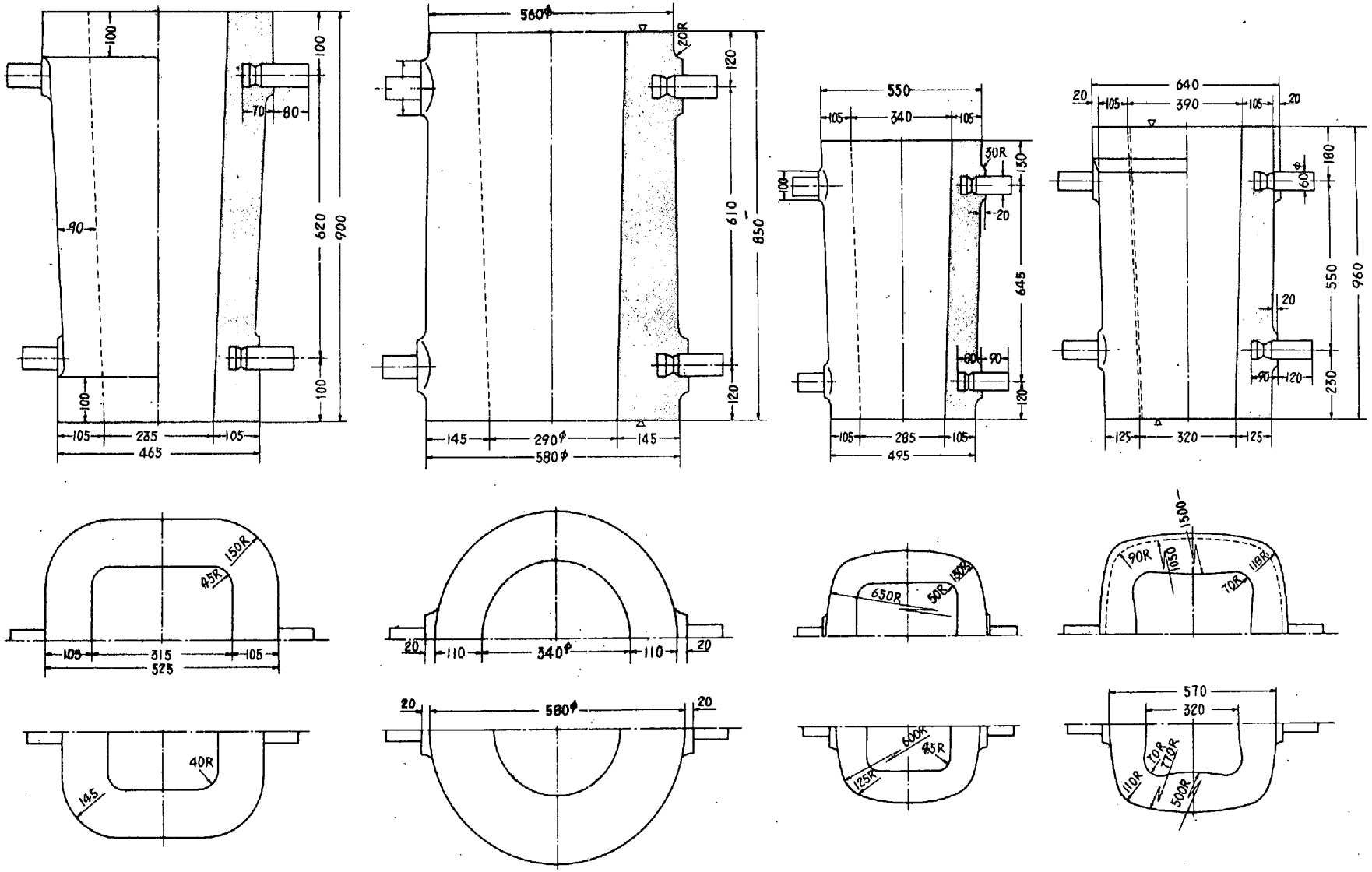


600 kg



大同製鋼

T 2　　T 5　　T 12　　300 kg



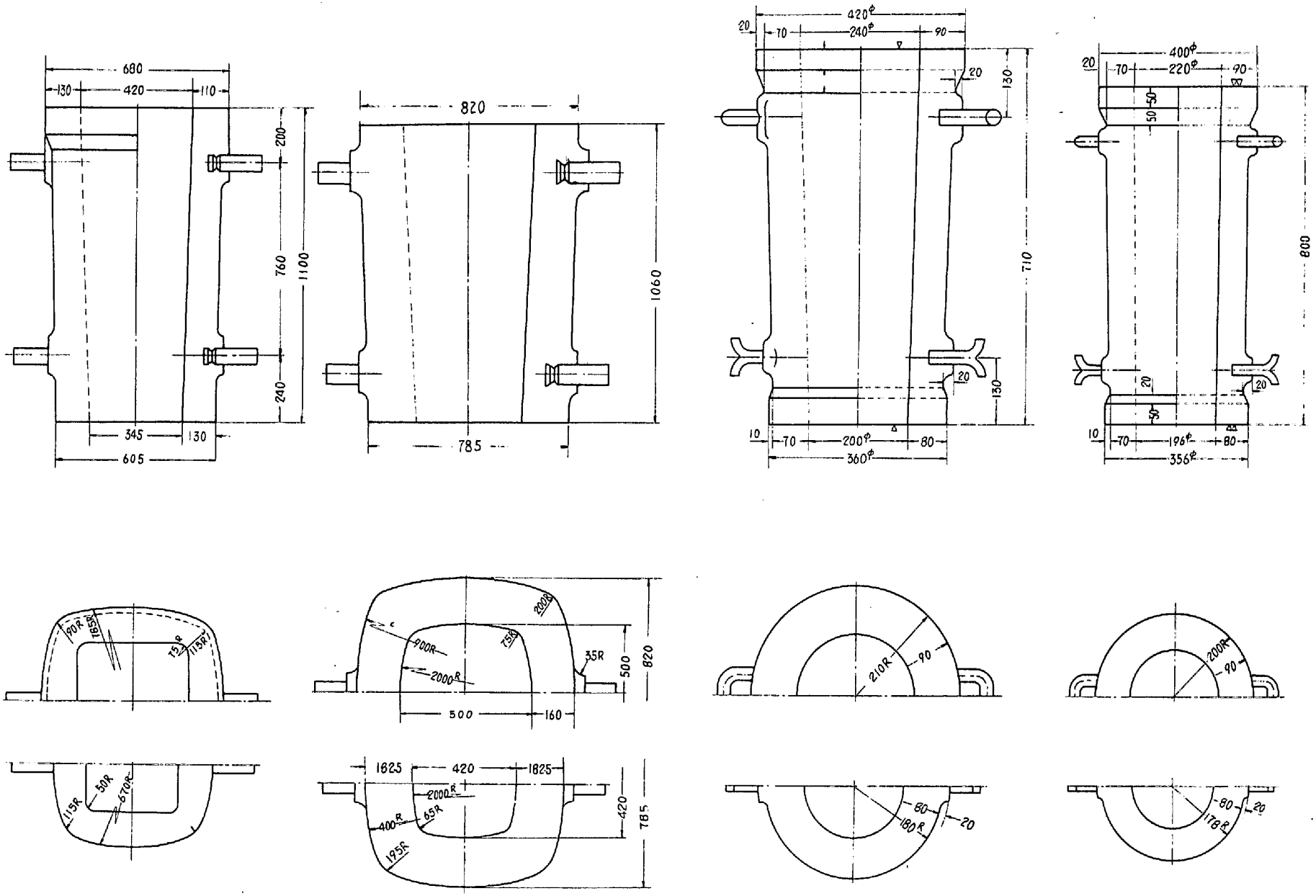
大同製鋼

500 kg

500 kg

600 kg

1000 kg



大 同 製 鋼

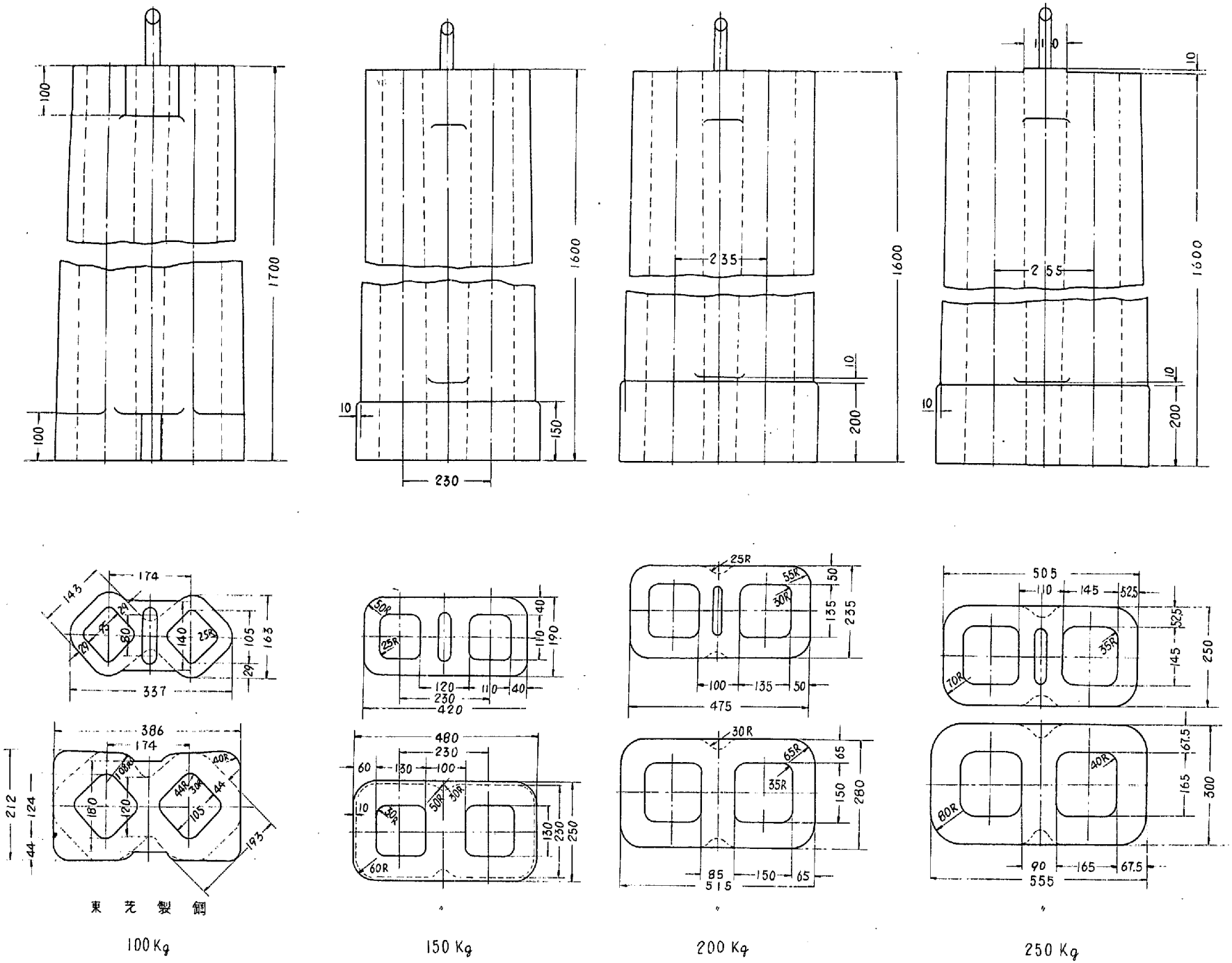
1200

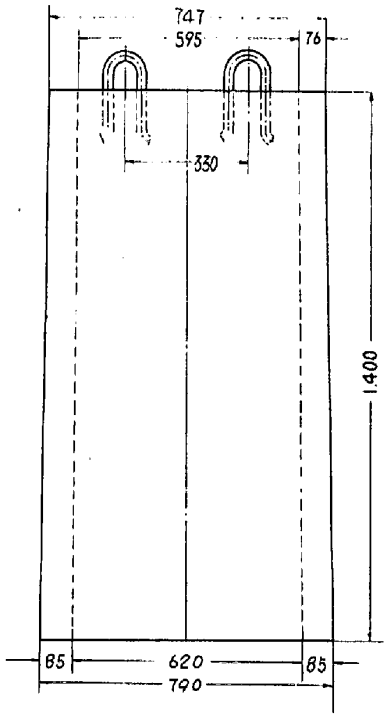
2000

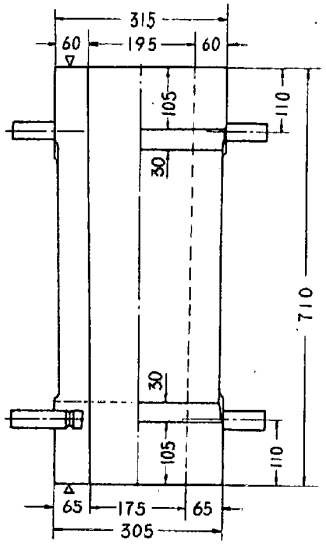
(平井)

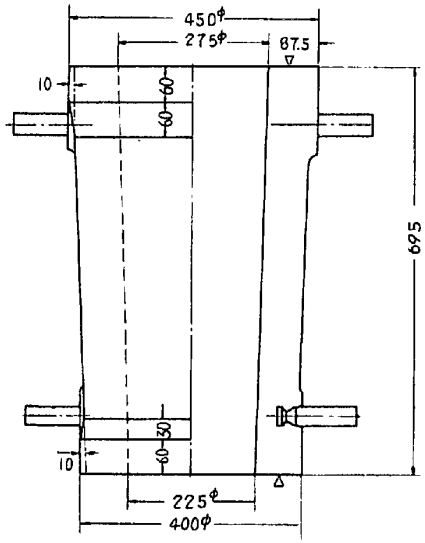
210 Kg 丸 型

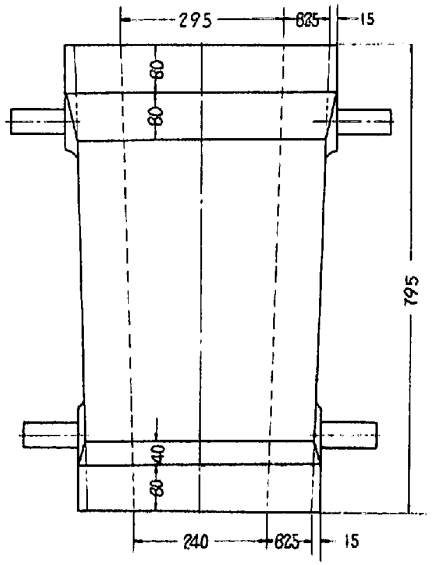
220 Kg 丸 型

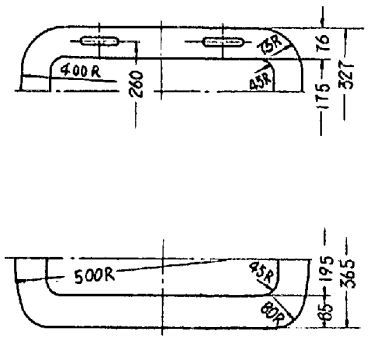

東 芝 製 鋼
100 Kg
150 Kg
200 Kg
250 Kg

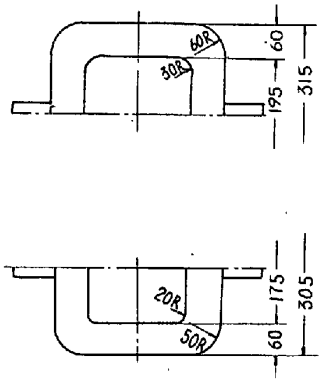


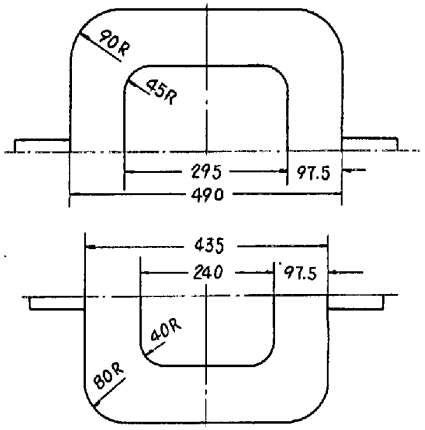












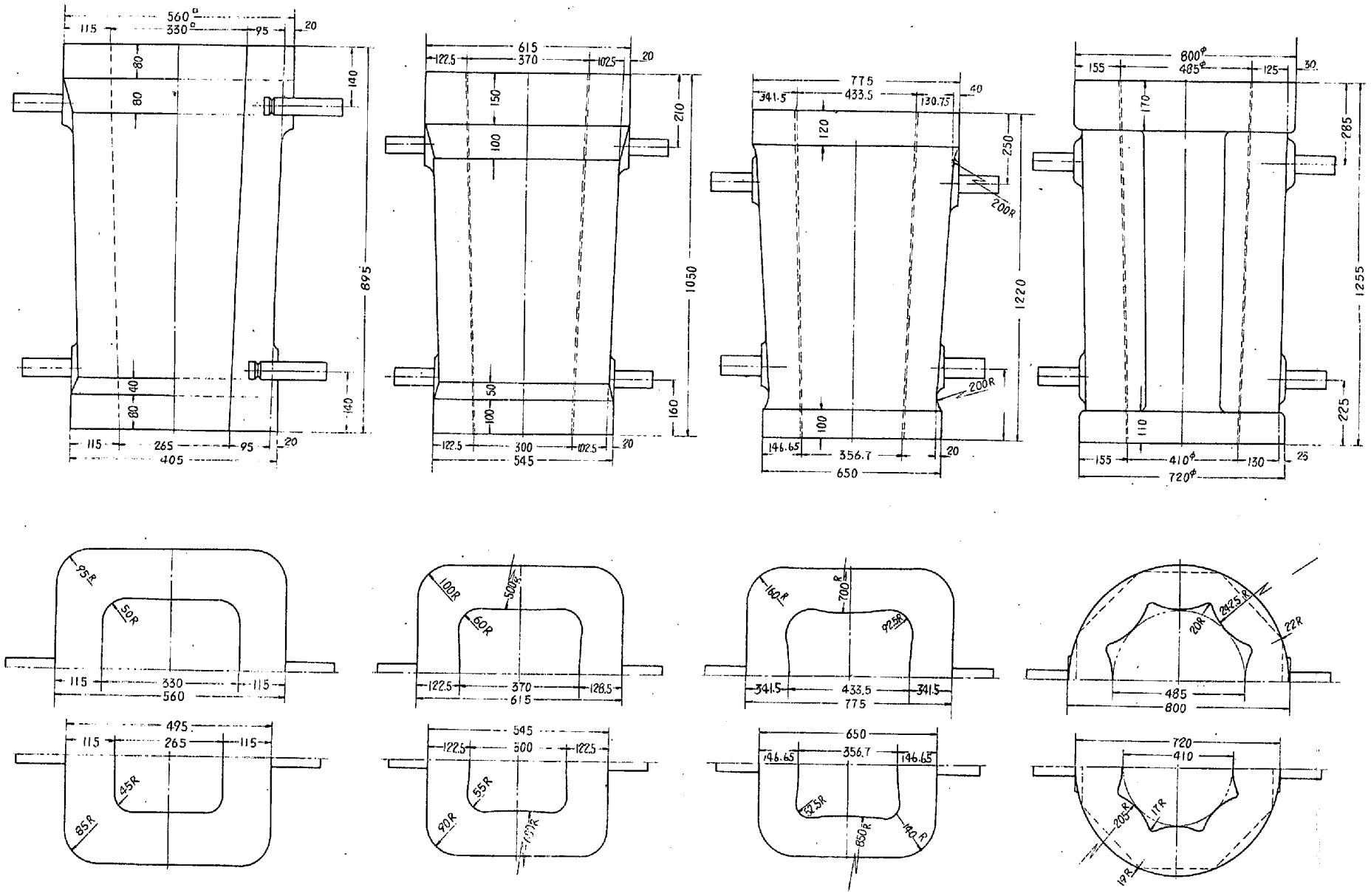
東 芝 製 鋼

B 0.8

200 Kg

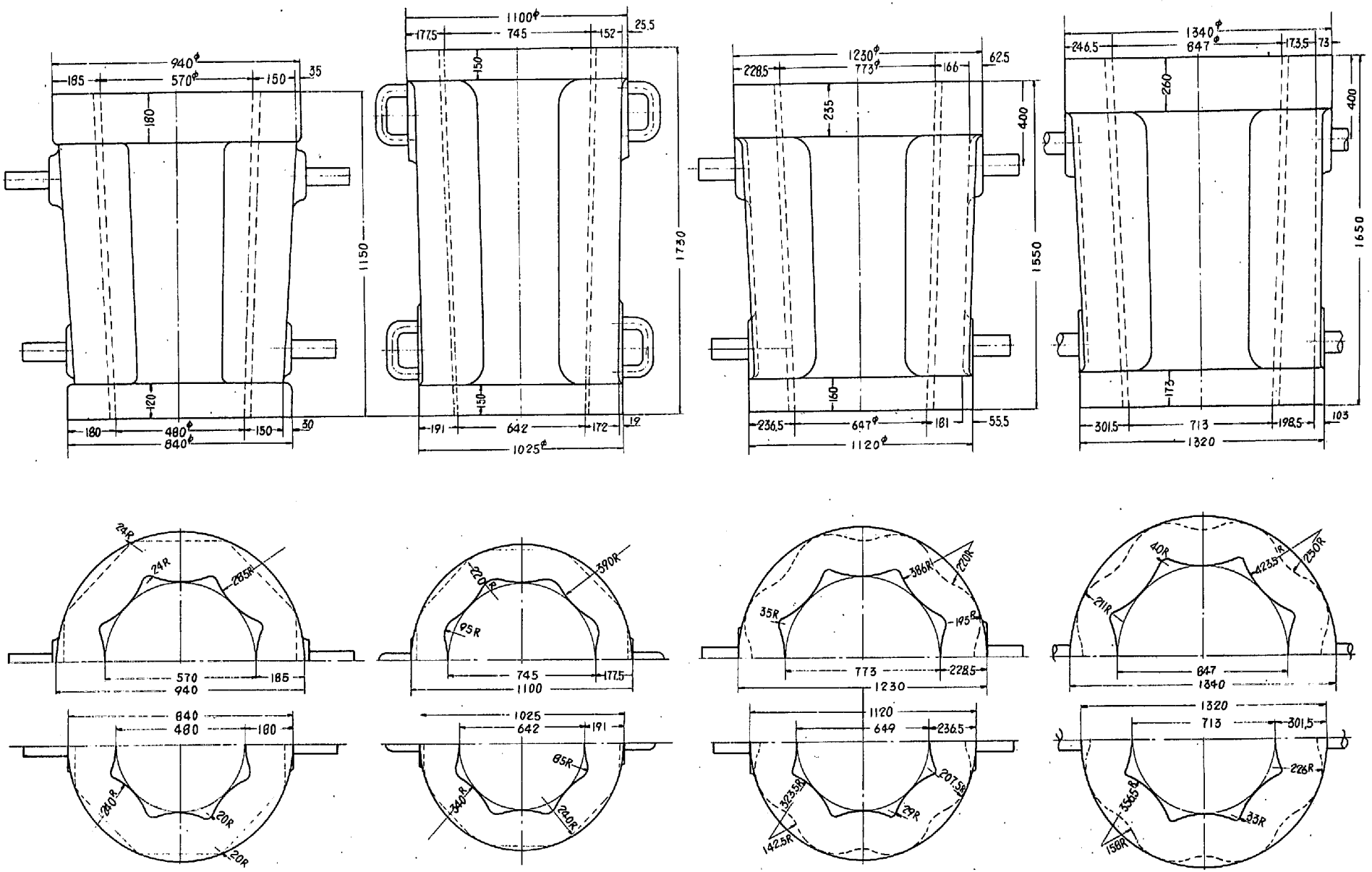
300 Kg

500 Kg 角



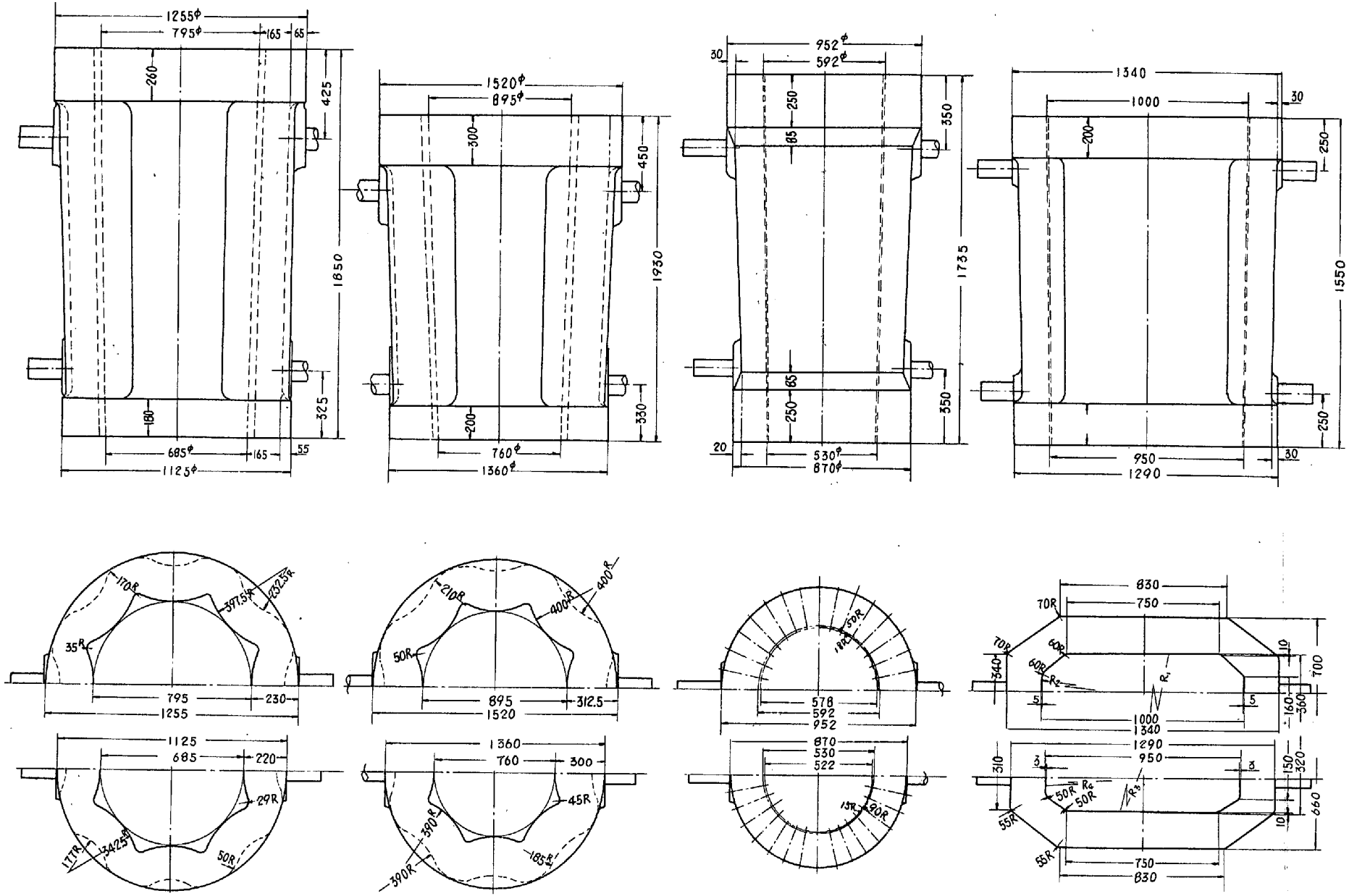
東 芝 製 鋼

700 Kg　　1 T　　1.8 T　　2 T



東 芝 製 鋼

2.5 T　　6.0　　6.0 T　　8.0 T



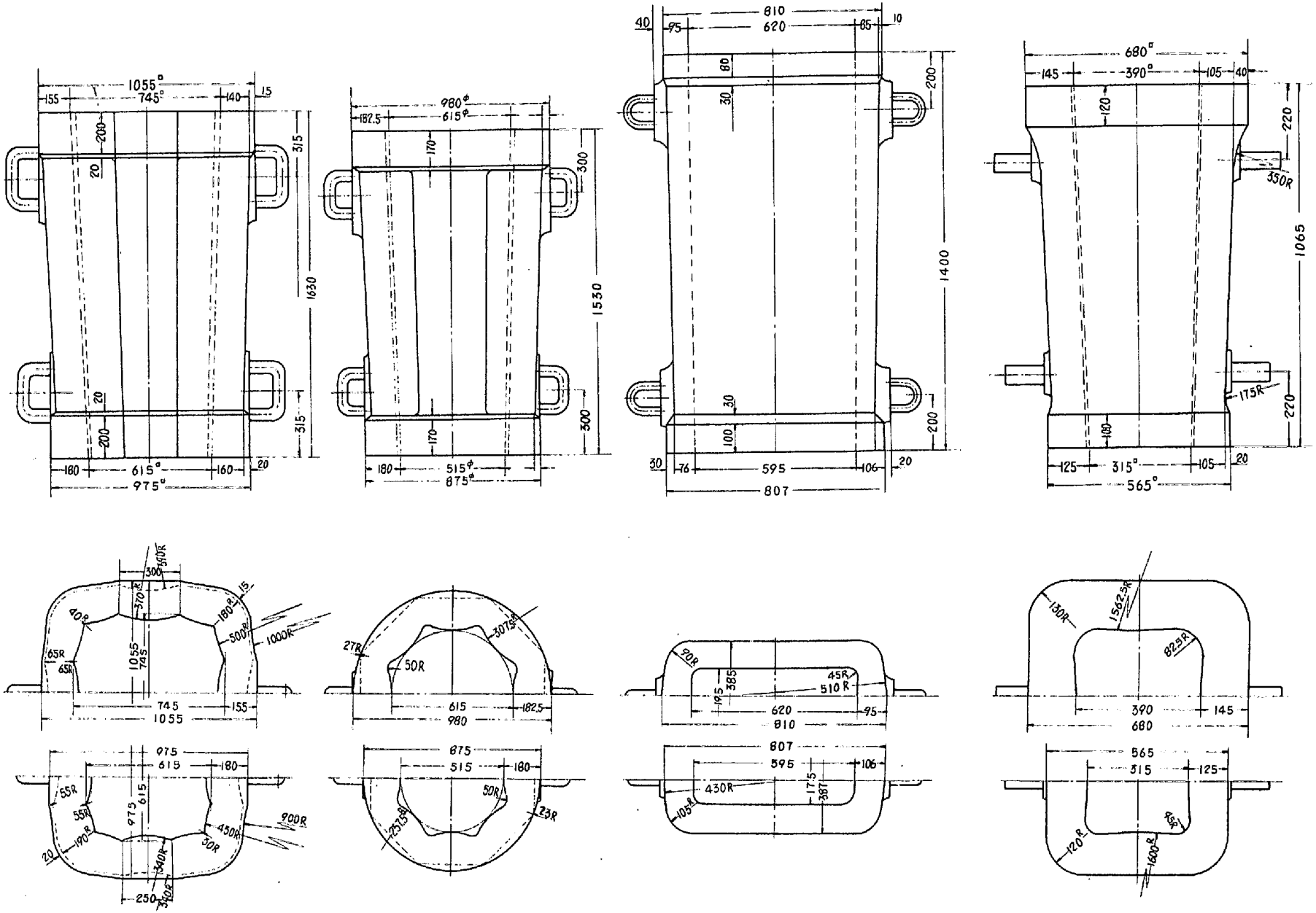
東芝製鋼

8 T II

10 T

C. 3.5

改 3 T



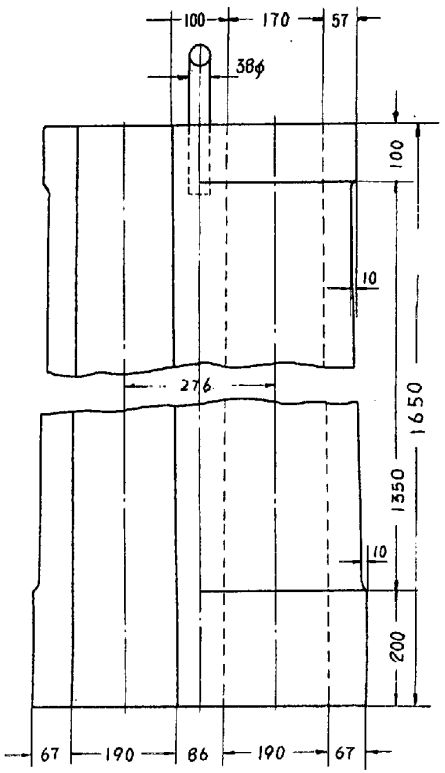
東芝製鋼

KH 50

0-3

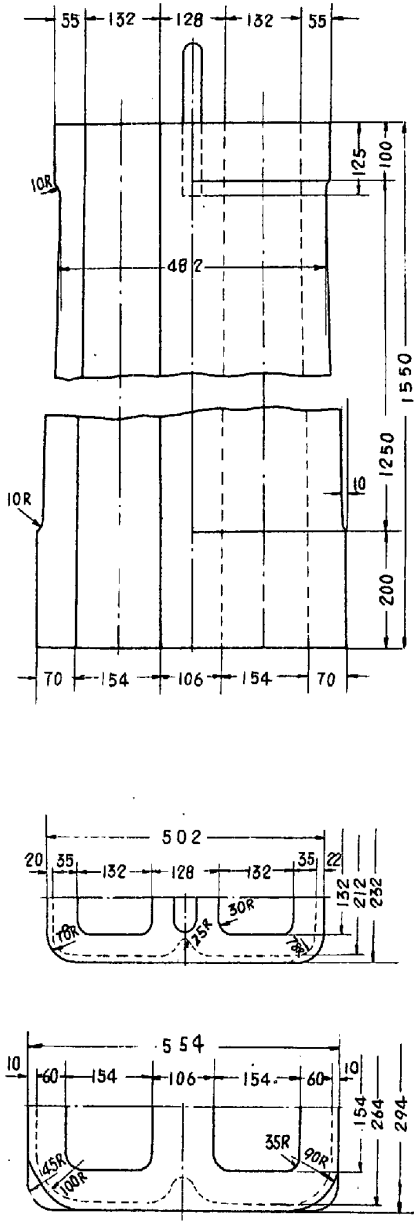
0.8 改

1.2

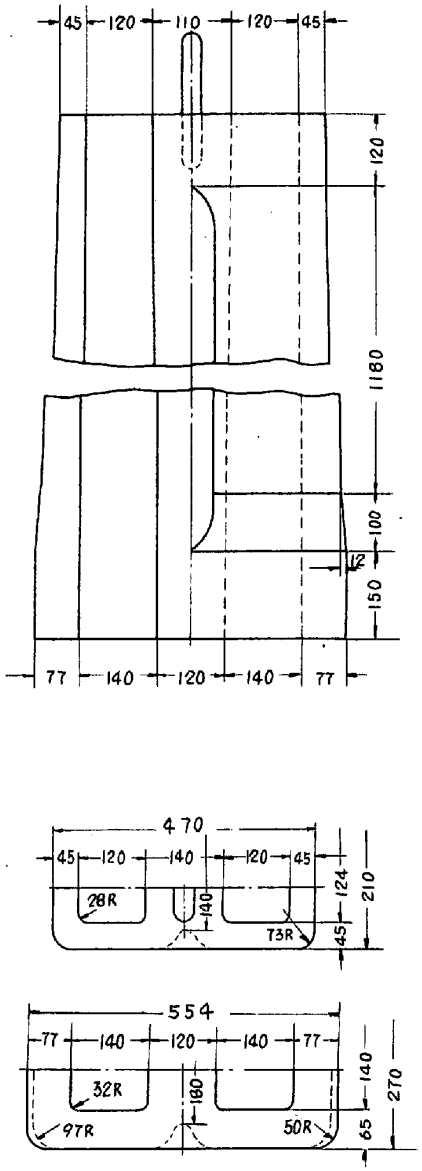


東 都 製 鋼

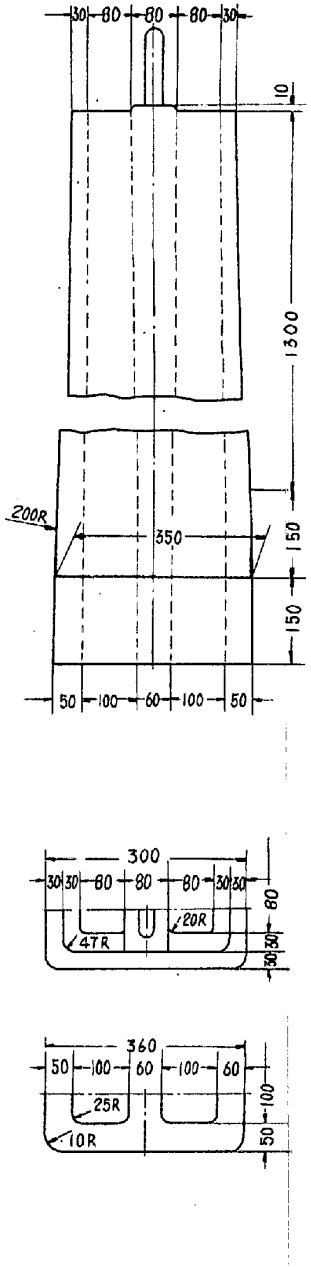
350K 複 型



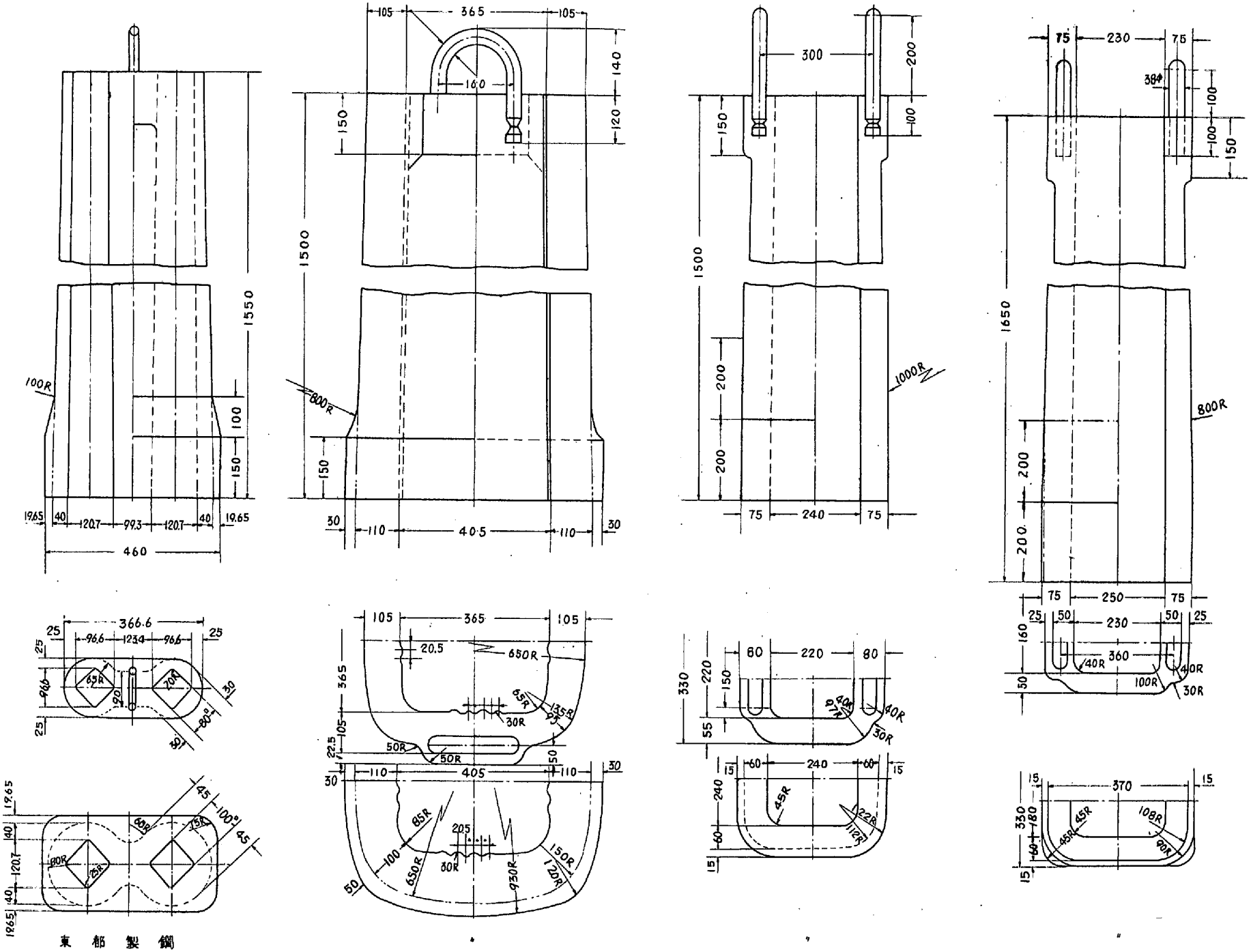
200K 複 型



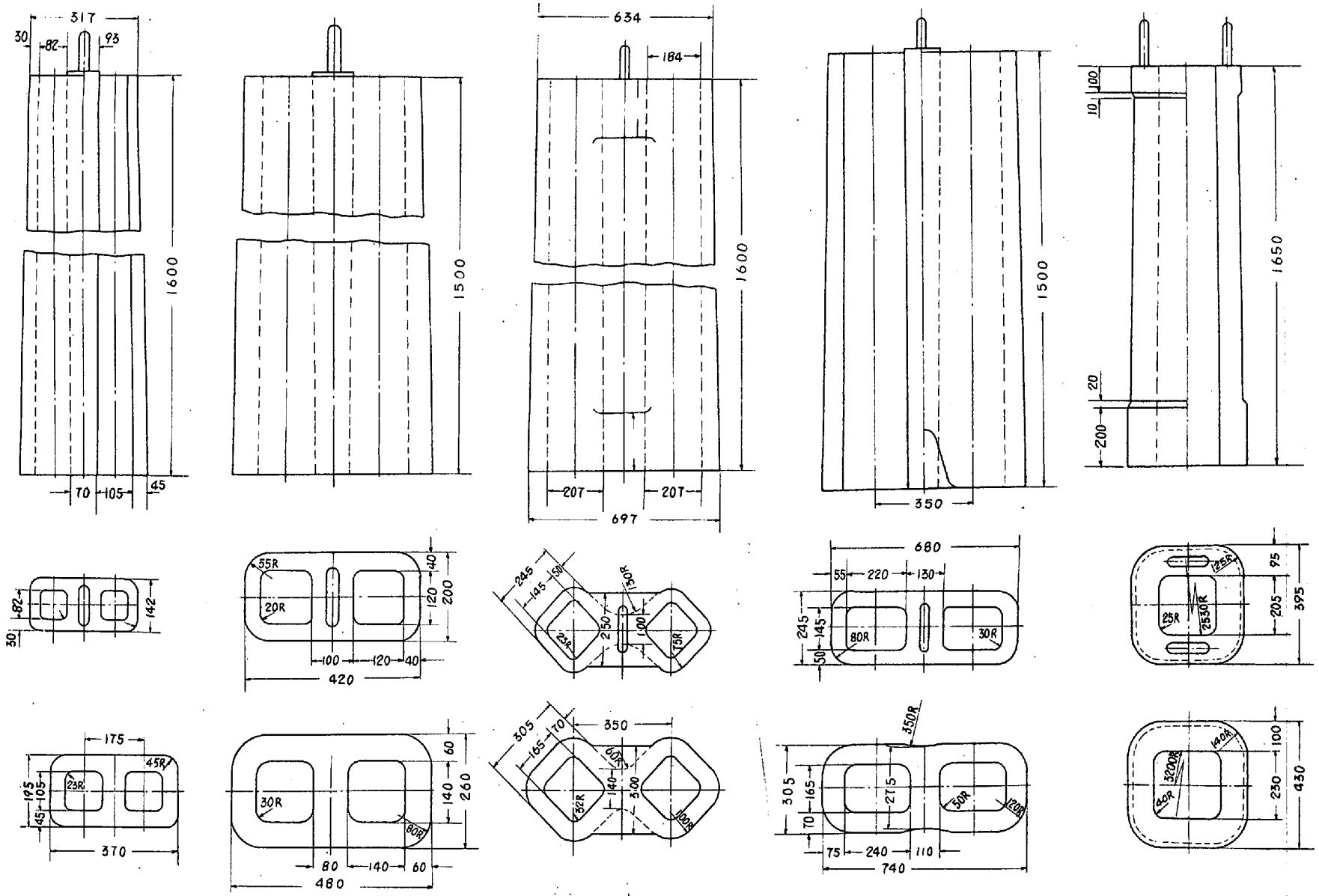
170K 複 型



80K 複 型

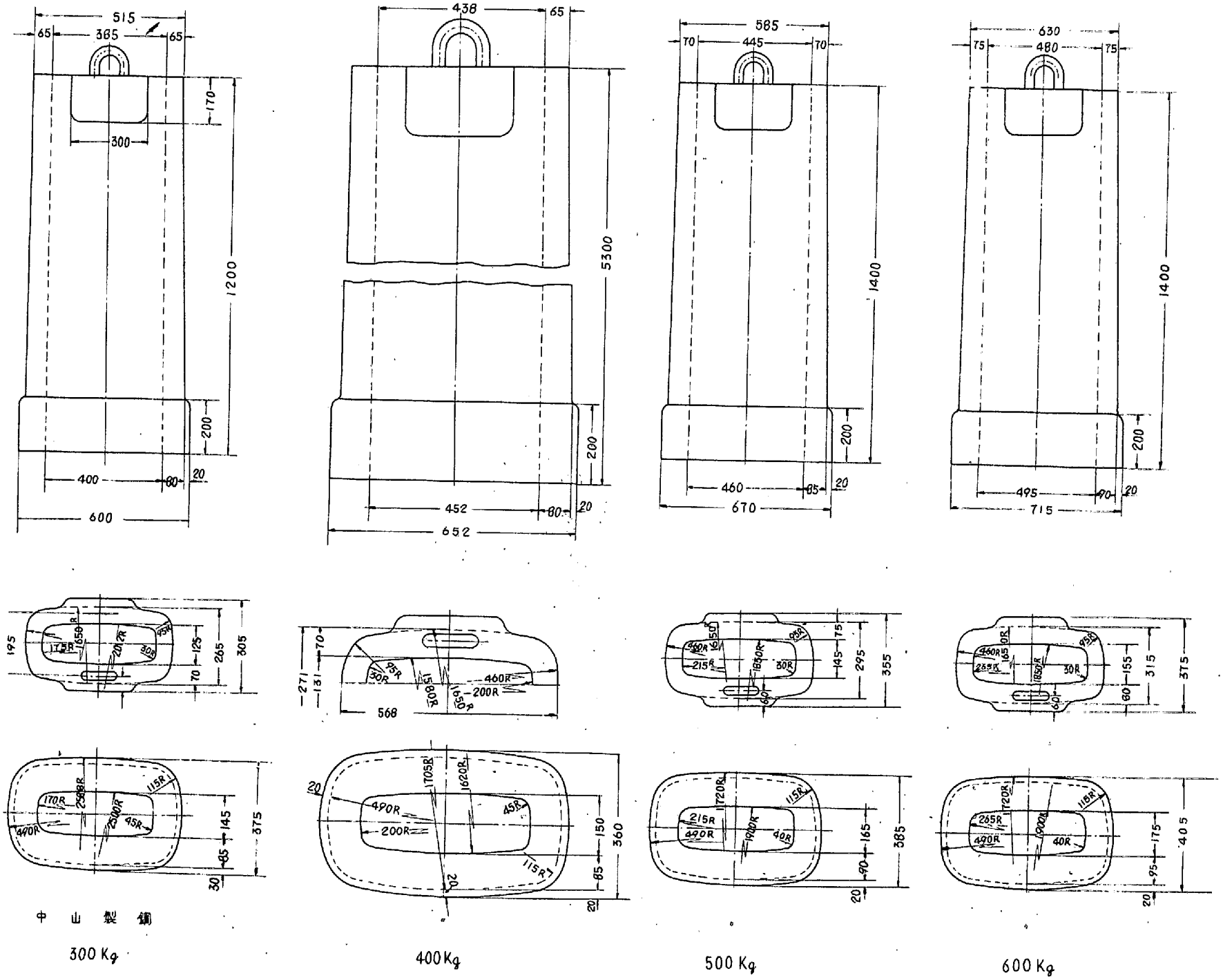


80K 複型　　1300角單型　　500K 單型　　450K 單型



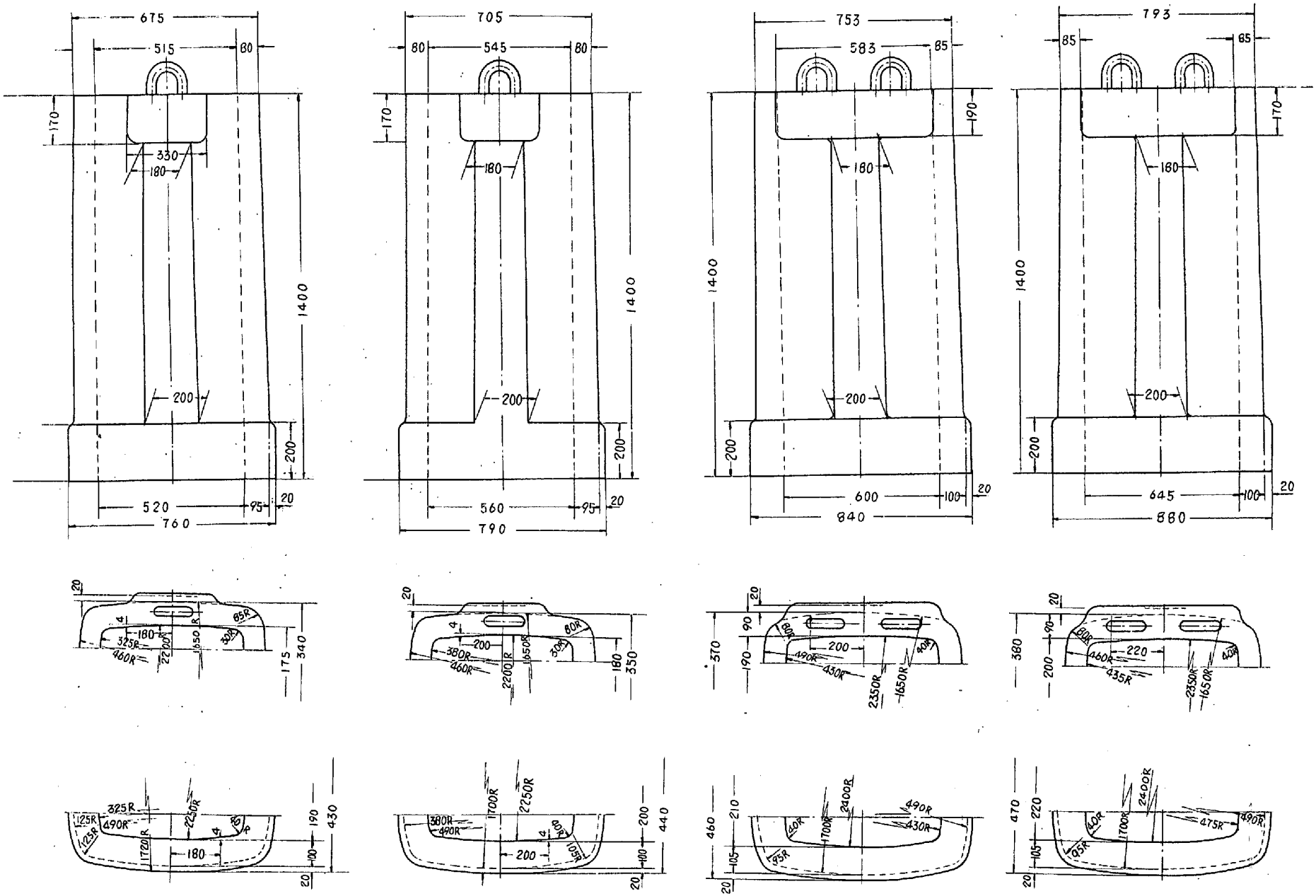
中 山 製 鋼

100 Kg　　180 Kg　　250 Kg　　350 Kg　　500 Kg



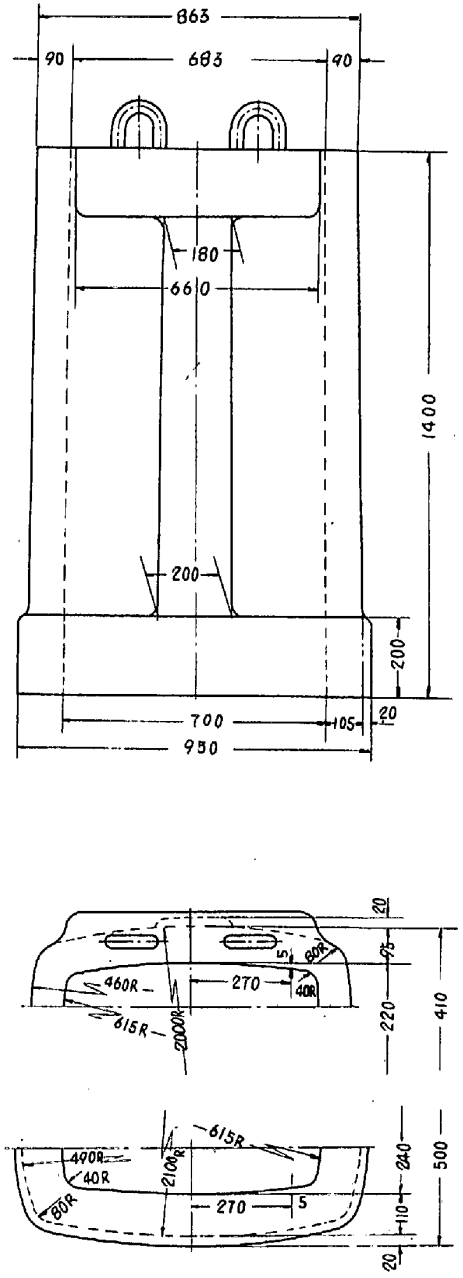
中山製鋼

300 Kg　400 Kg　500 Kg　600 Kg



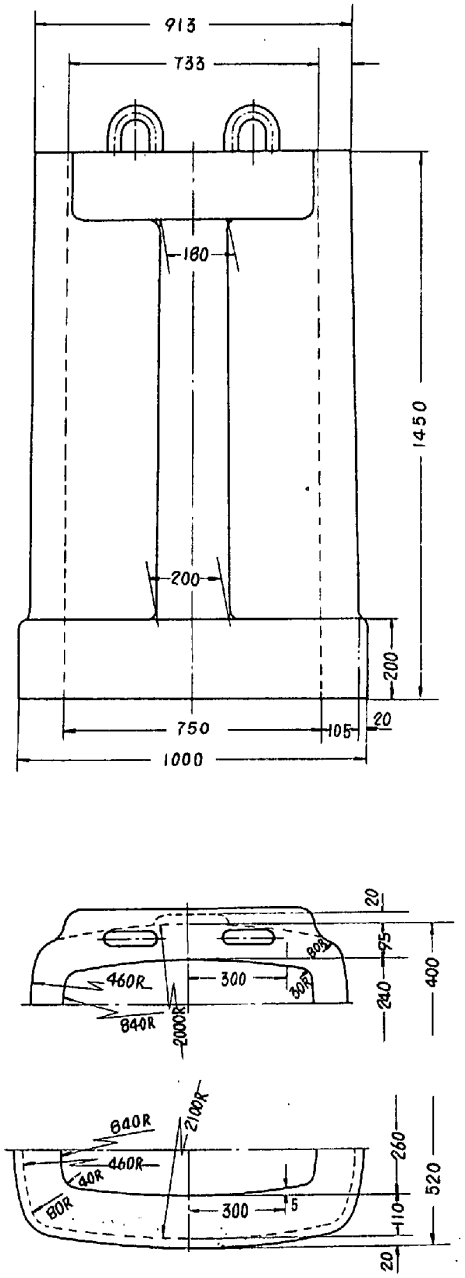
中 山 製 鋼

700 Kg　　800 Kg　　900 Kg　　1000 Kg

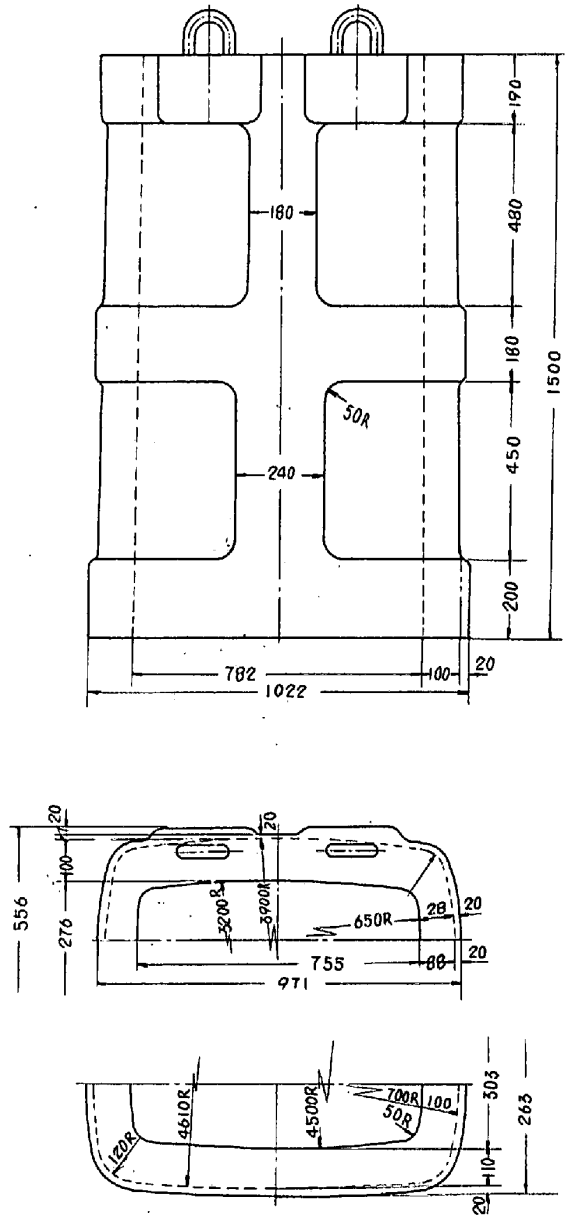


中　山　製　鋼

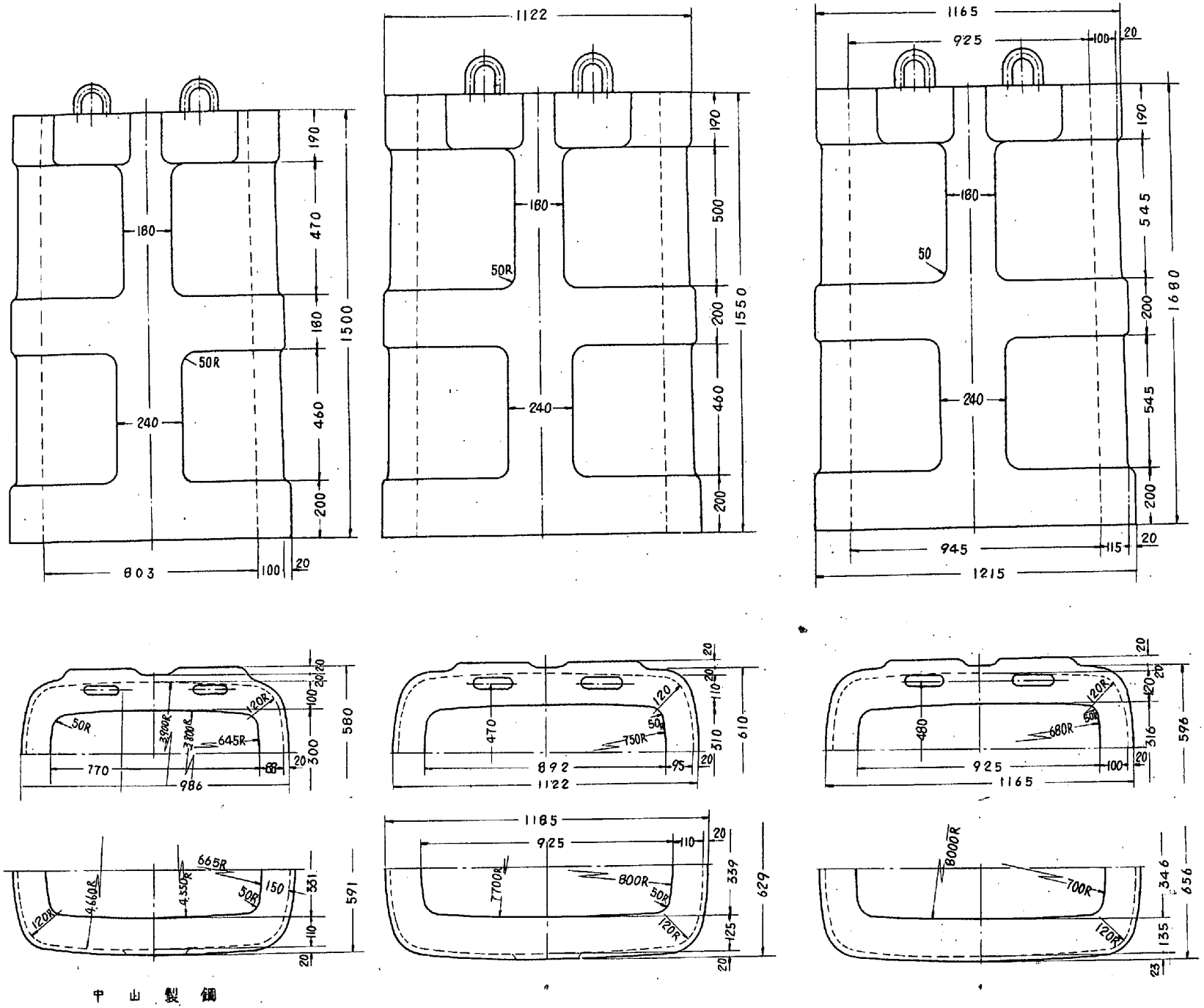
1,200 Kg



1,500 Kg



1,800 Kg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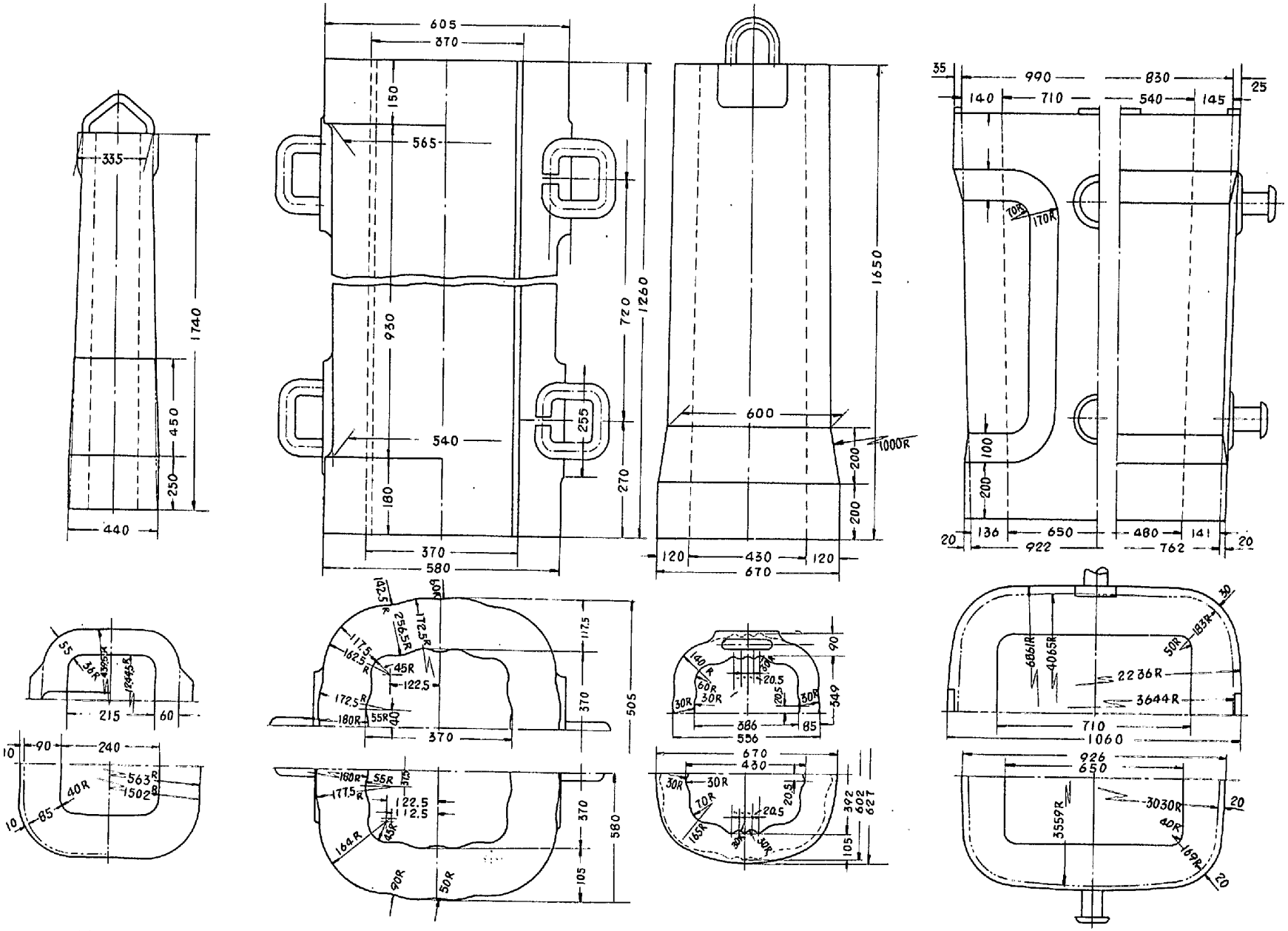
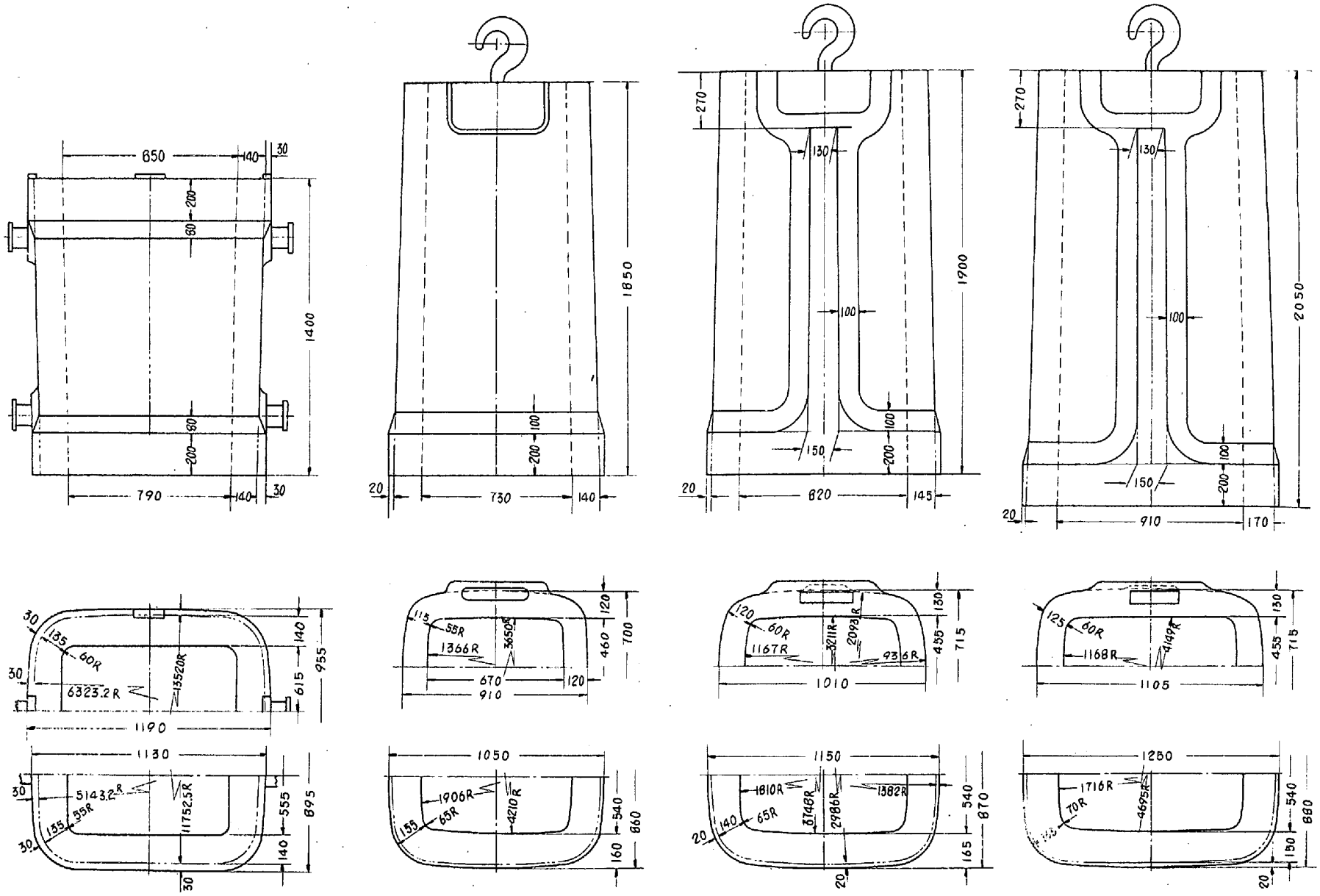
1165
925
100
20
190
470
180
500
545
1500
1550
1680
50R
50
240
460
200
803
115
945
1215
580
610
576
770
986
892
1122
925
1165
645R
750R
680R
120R
3900R
3800R
665R
4350R
4660R
150
351
591
629
346
656
800R
700R
6000R
135
23
中 山 製 鋼
2,000 Kg
2,500 Kg
3,000 Kg



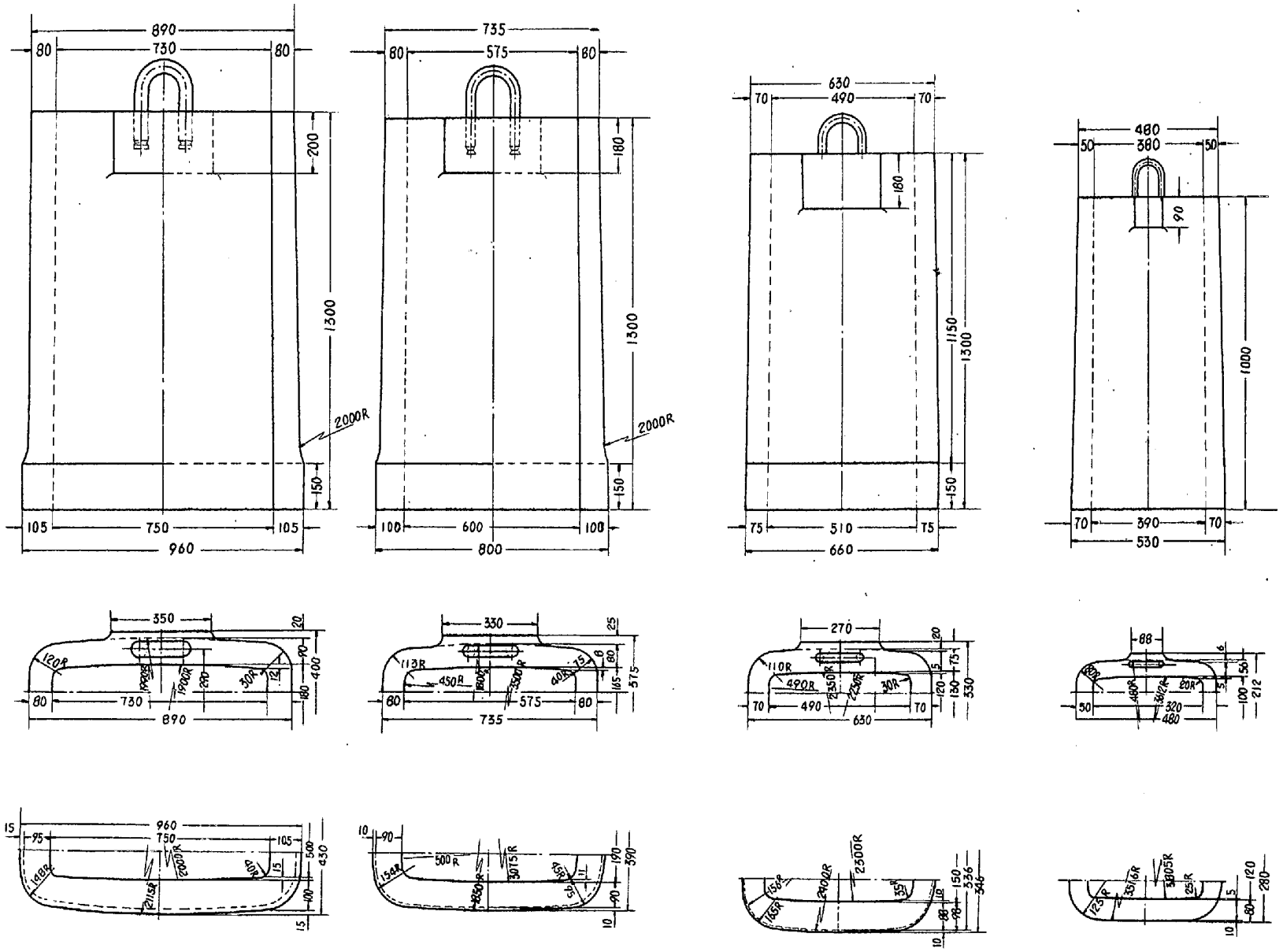
日新製鋼（尼崎）　　（呉）

角 600 Kg　　1200 Kg　　1350 Kg　　上広 3.5



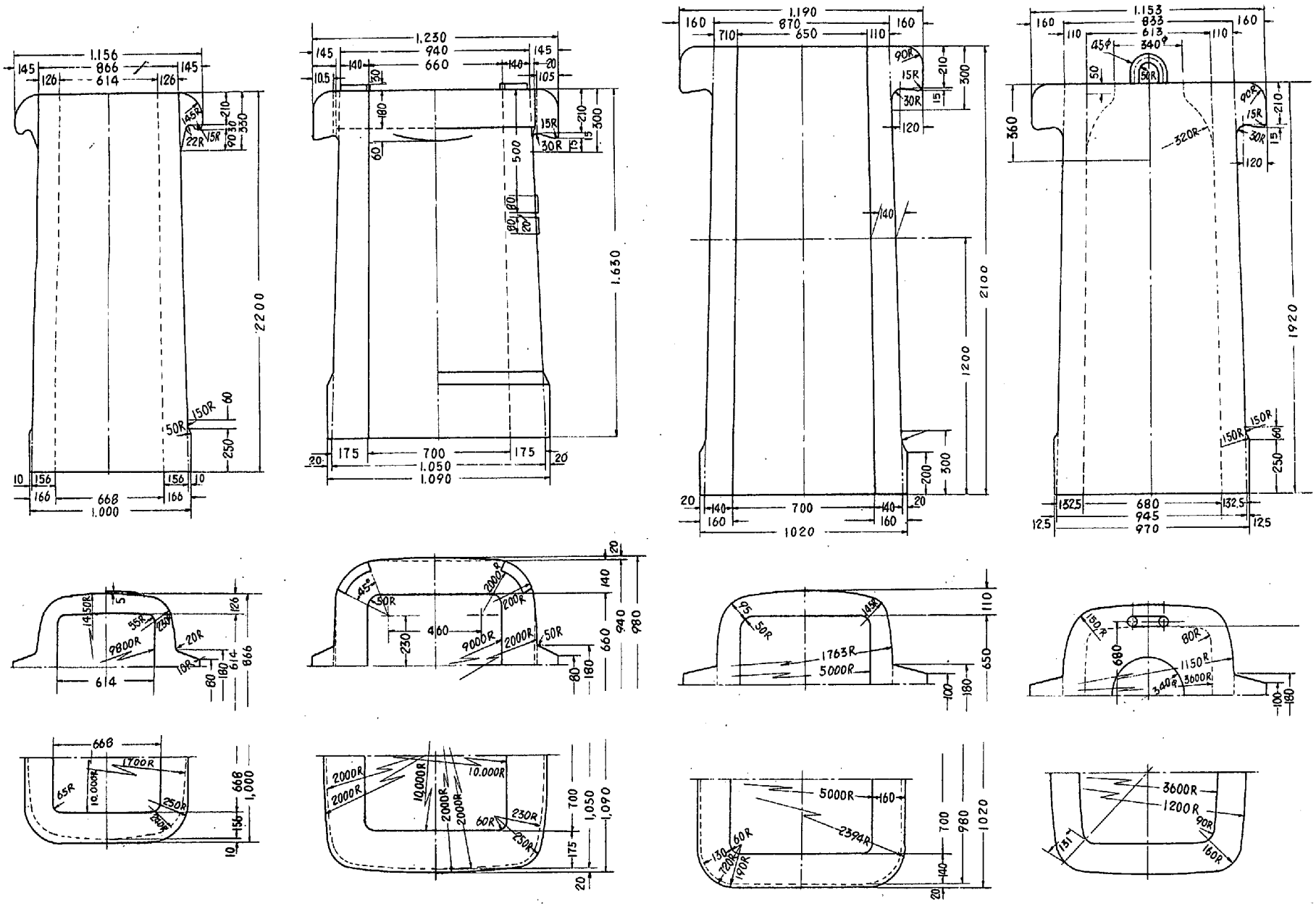
日新製鋼(株)

4.8T　　K40　　K45　　K50



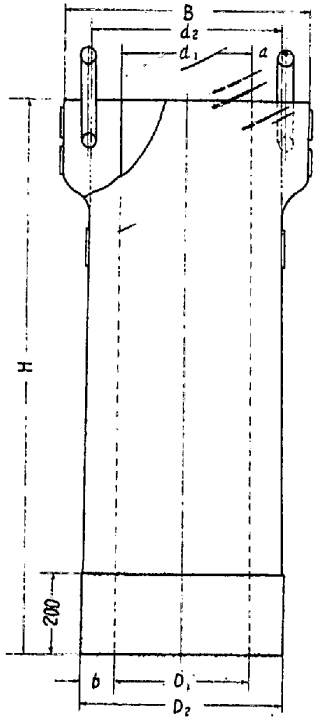
日 曹 製 鋼

B 10　　B 08　　B 05　　B027

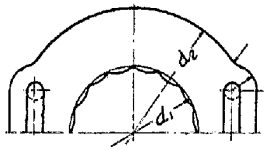


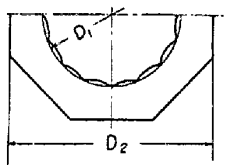
鋼管・川崎

K 62　　KH 60 C　　K 70　　KS 68

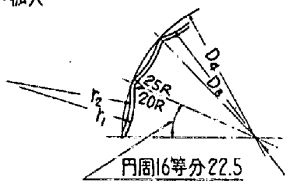


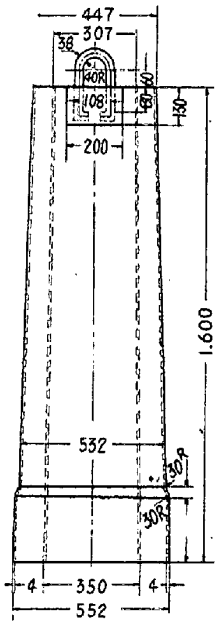
型別		NO 3-CH	NO 4-CH	NO 6-CH	NO 8-CH	NO 9-CH	NO 10-CH
底部内径	D_1	320φ	362	410φ	471φ	501	527
〃 外径	D_2	490	538	630	730φ	765	820
〃 肉厚	b	85	88	110	129.5	132	146.5
頭部内径	d_1	308	349φ	396φ	457φ	487	513
〃 外径	d_2	465	508φ	602φ	681φ	725	776
〃 肉厚	a	78.5	79.5	103	112	119	131.5
	B	614	654	721	785	765	816
高さ	H	1250	1400	1400	1450	1350	1400
	D_3	308φ	349φ	396φ	457φ	487φ	513φ
	D_4	320φ	362φ	419φ	471φ	501φ	527φ
	r_1	308_R	349_R	396_R	457_R	487_R	513_R
	r_2	320_R	362_R	410_R	471_R	501_R	527_R

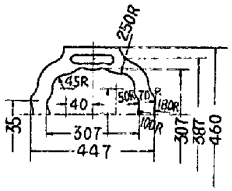


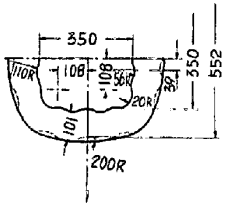


コルゲート拡大



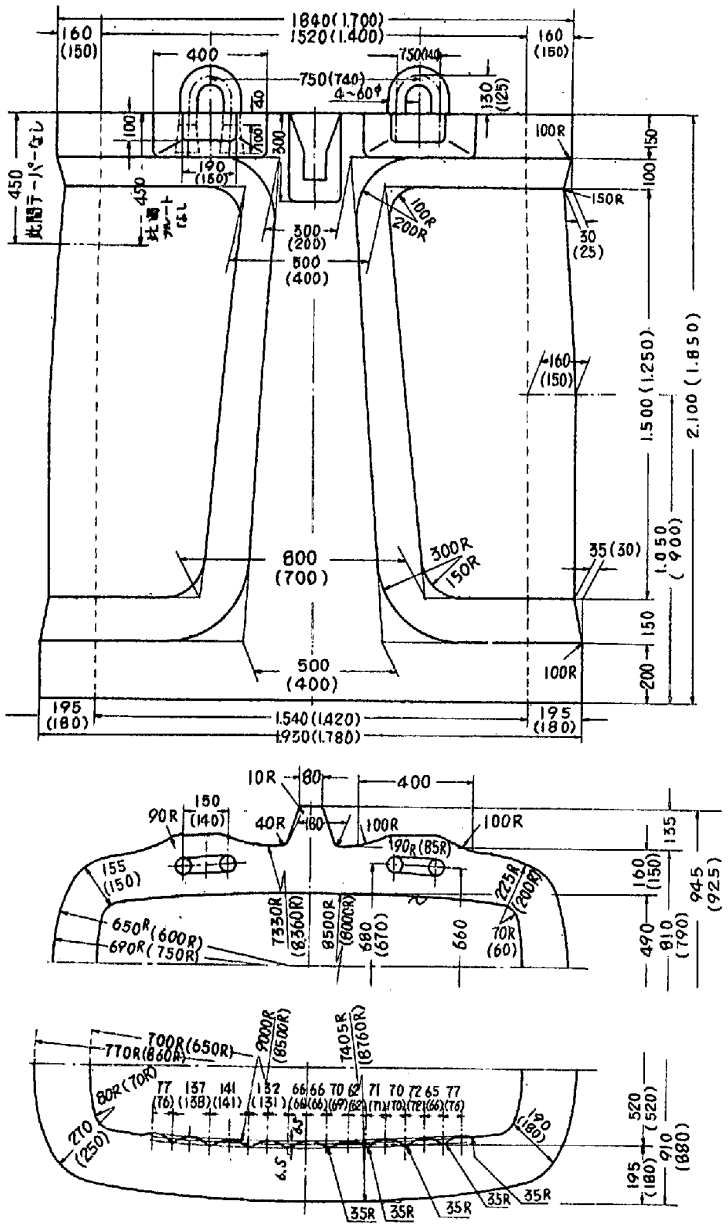






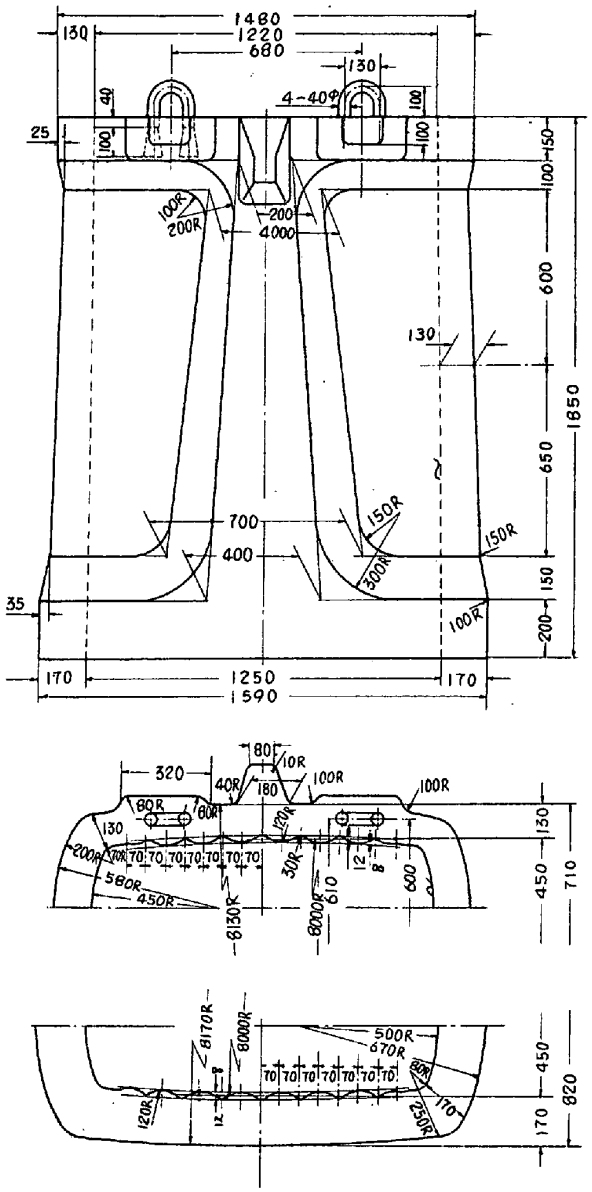
鋼管・川崎

NO 3-CH, 4-CH, 6-CH, 8-CH, 9-CH, 10-CH

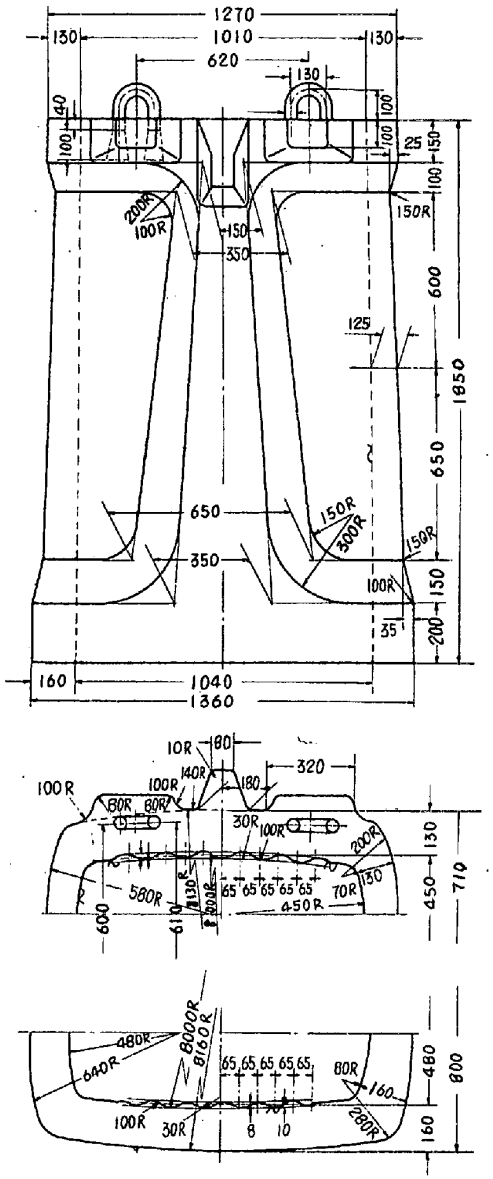


個管・鶴見

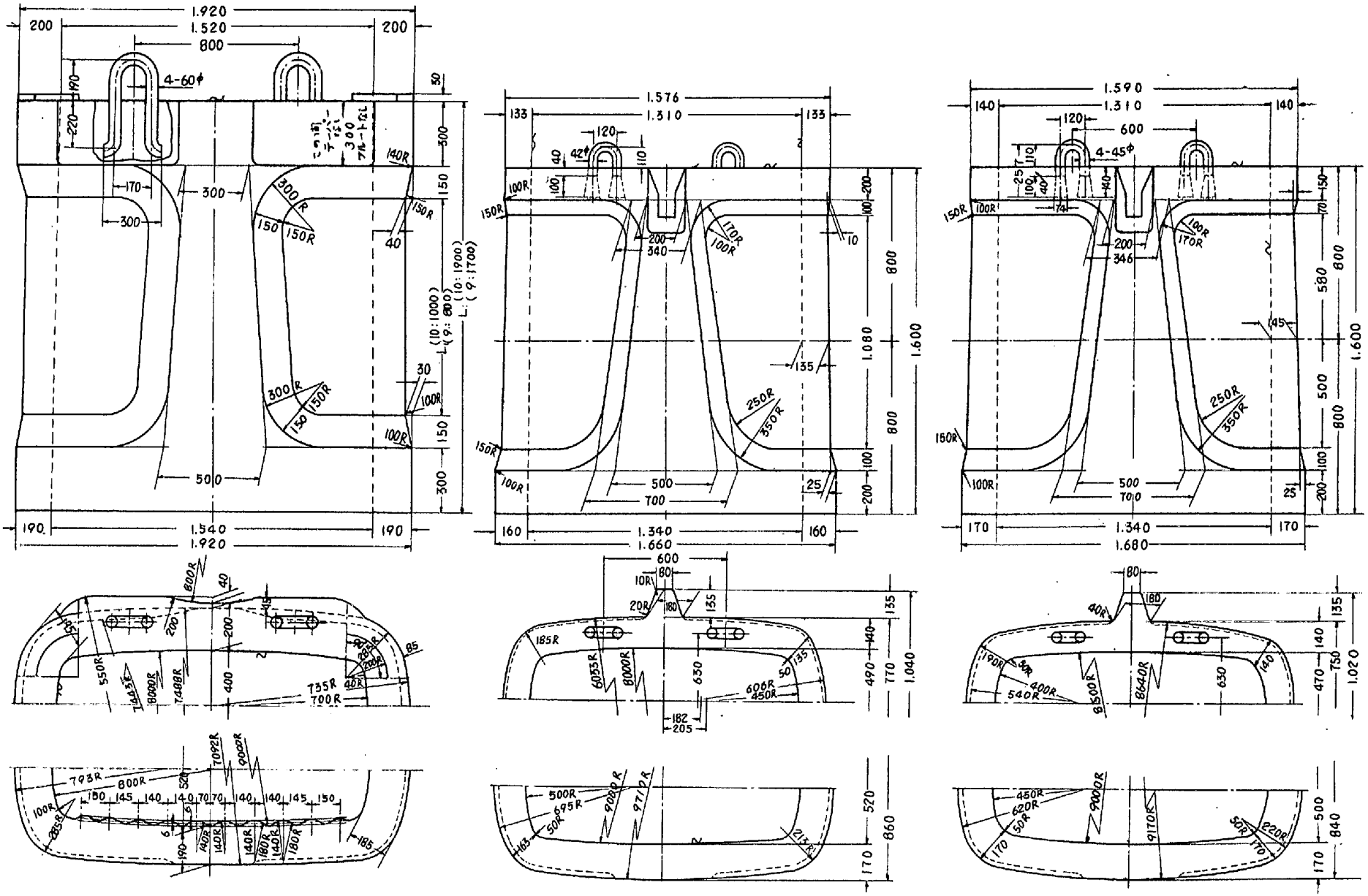
K10, K6（カッコ内の寸法）



KB6



KB5

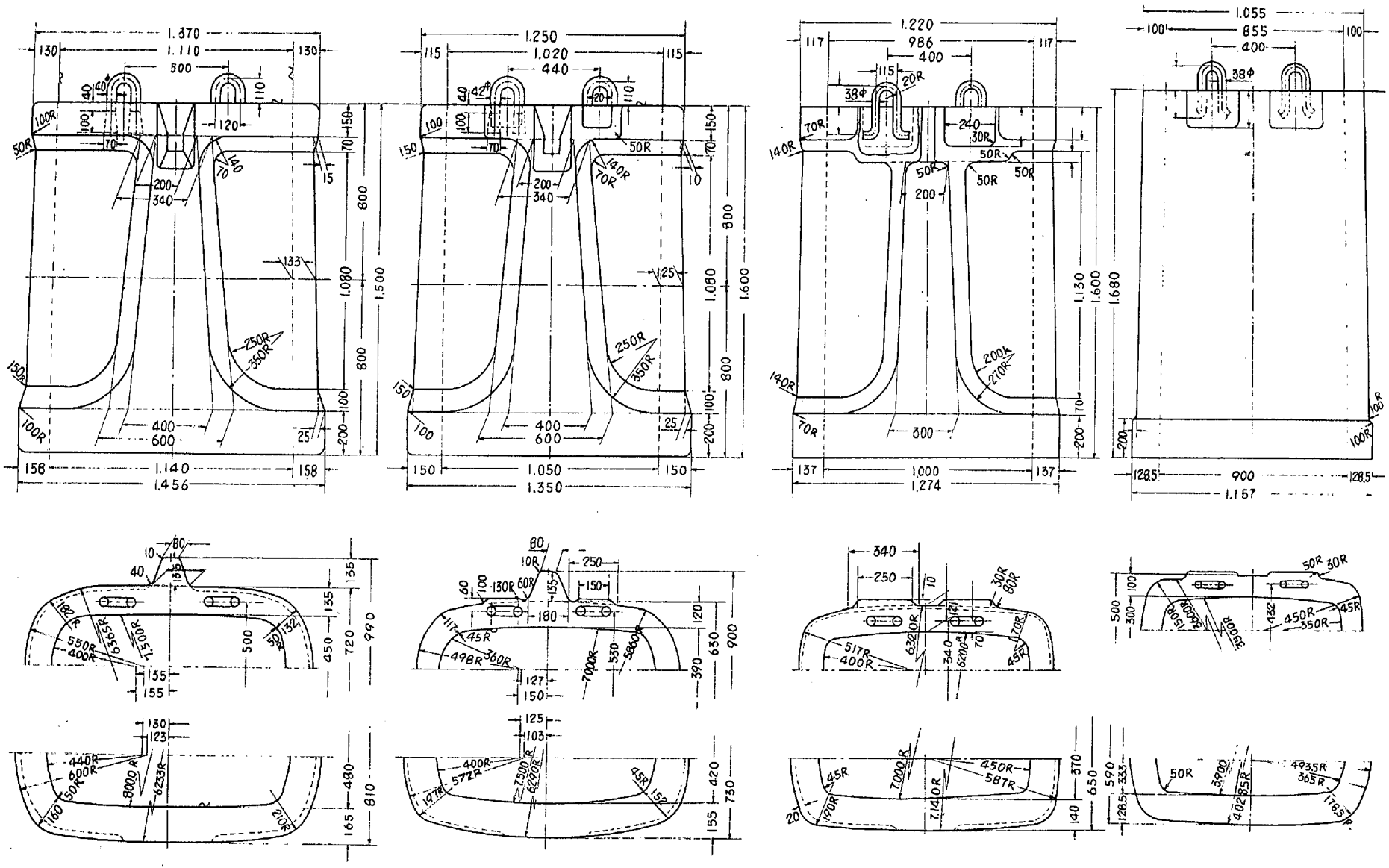


鋼管・鶴見

KB 10.9

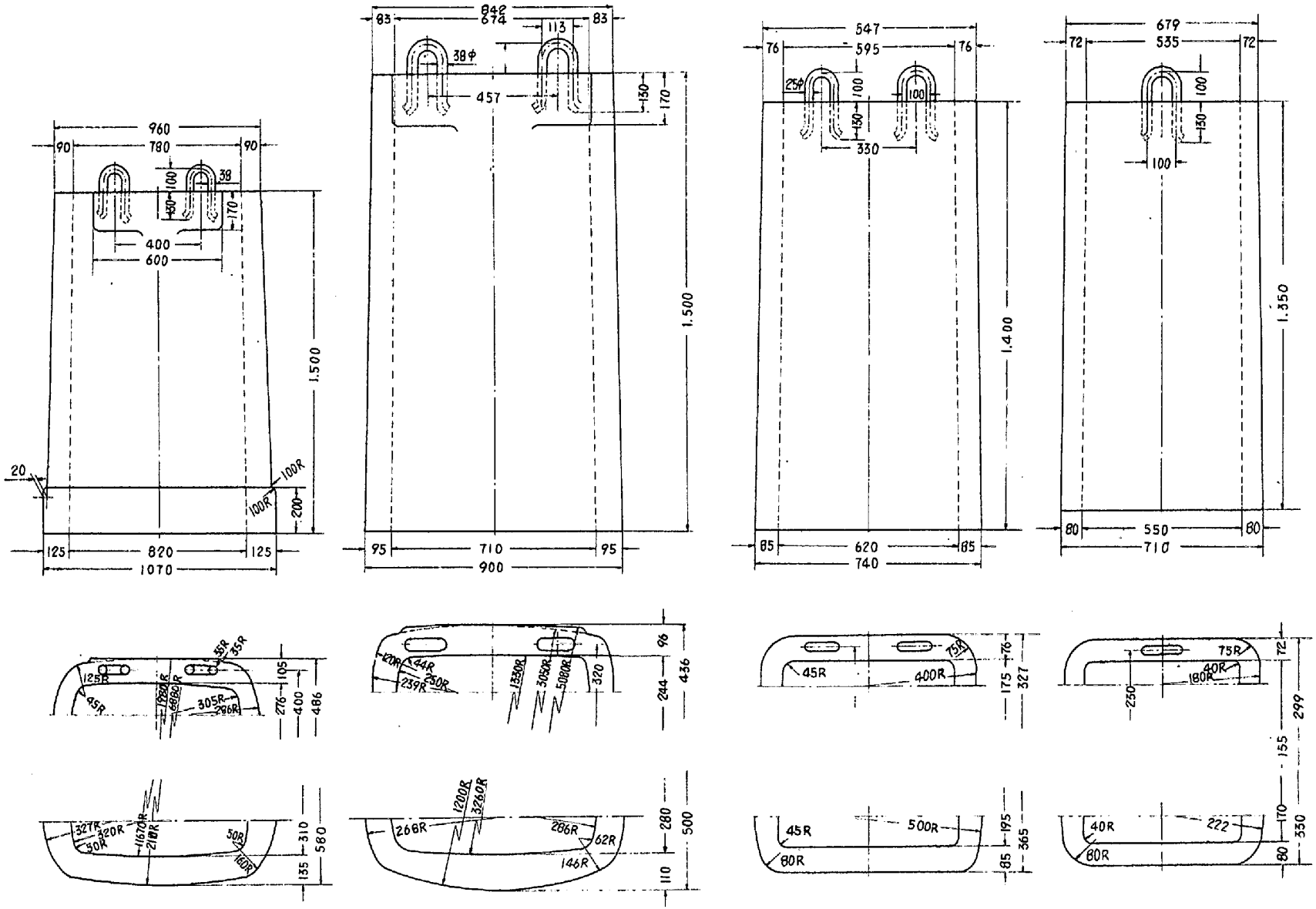
HB 6

HB 5.5



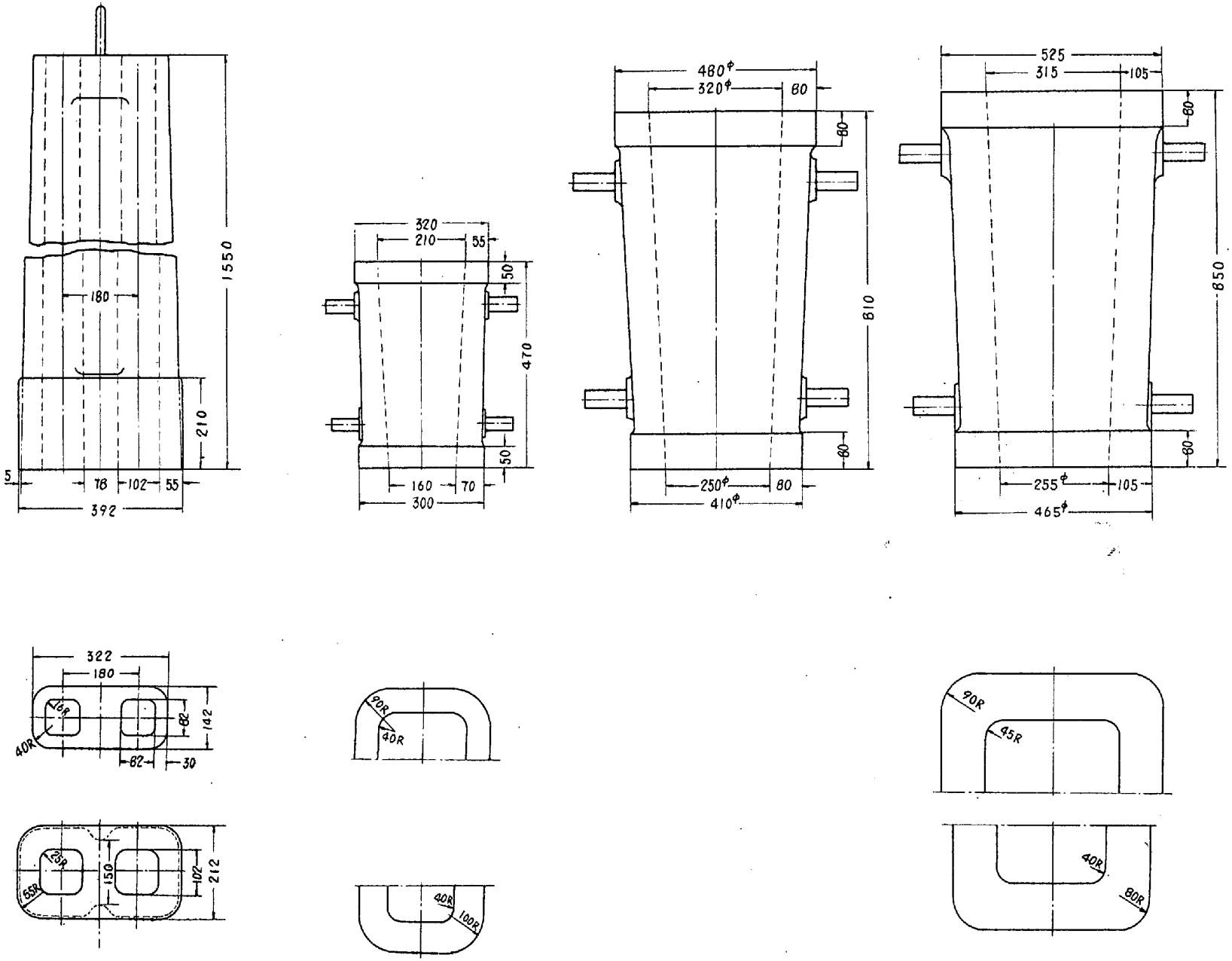
鋼管・鶴見

HB 5　　HB 4　　B3.5　　B3.0



鋼管・鶴見

B 2.0　　B 1.6　　B 0.8　　B 0.6



日本鋳造

80 Kg

日本特殊鋼

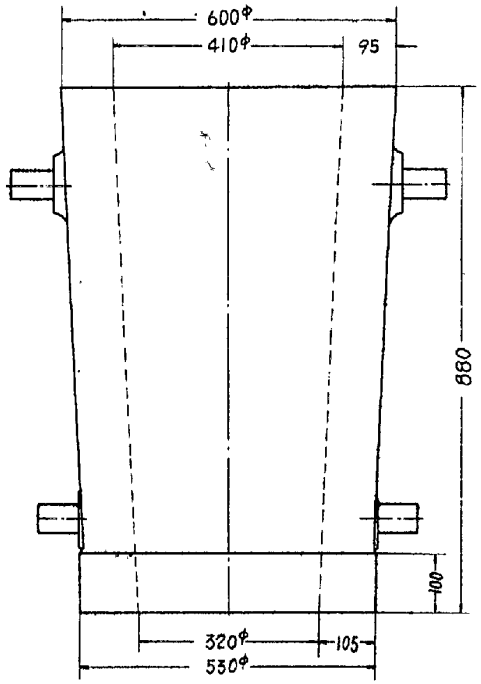
角 130 Kg

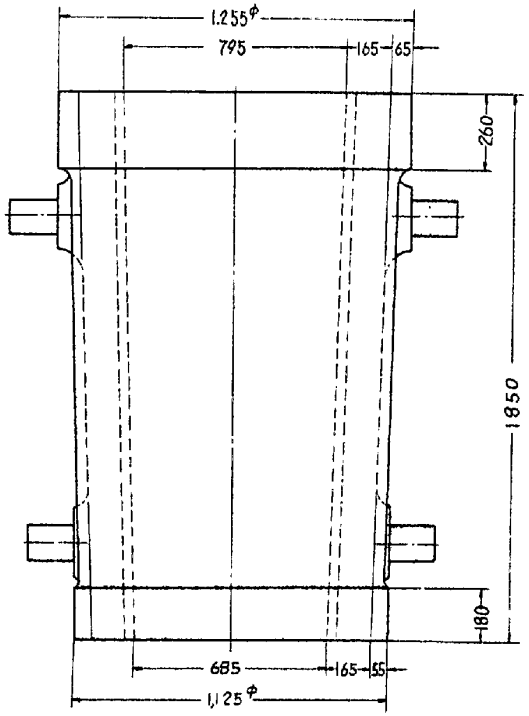
〃

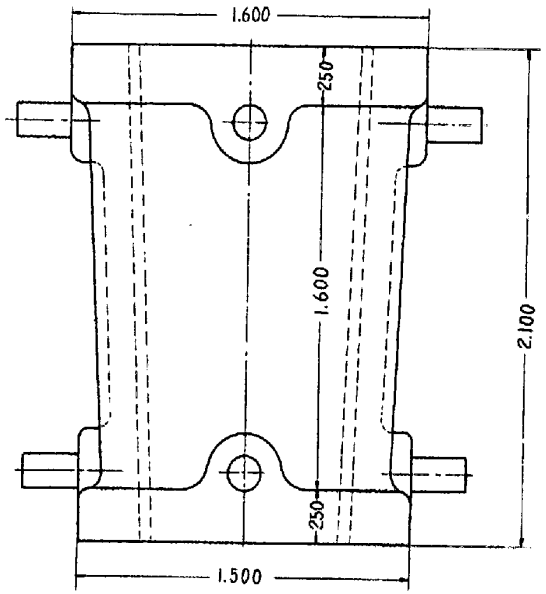
R 400 Kg

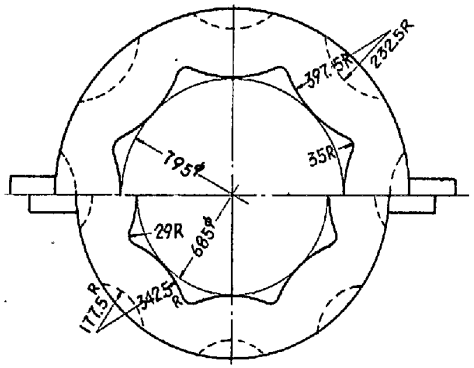
〃

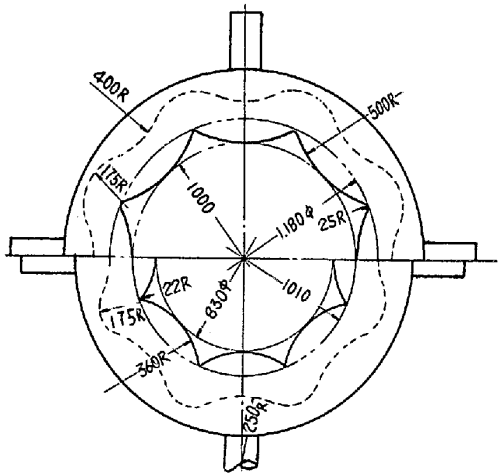
角 600 Kg









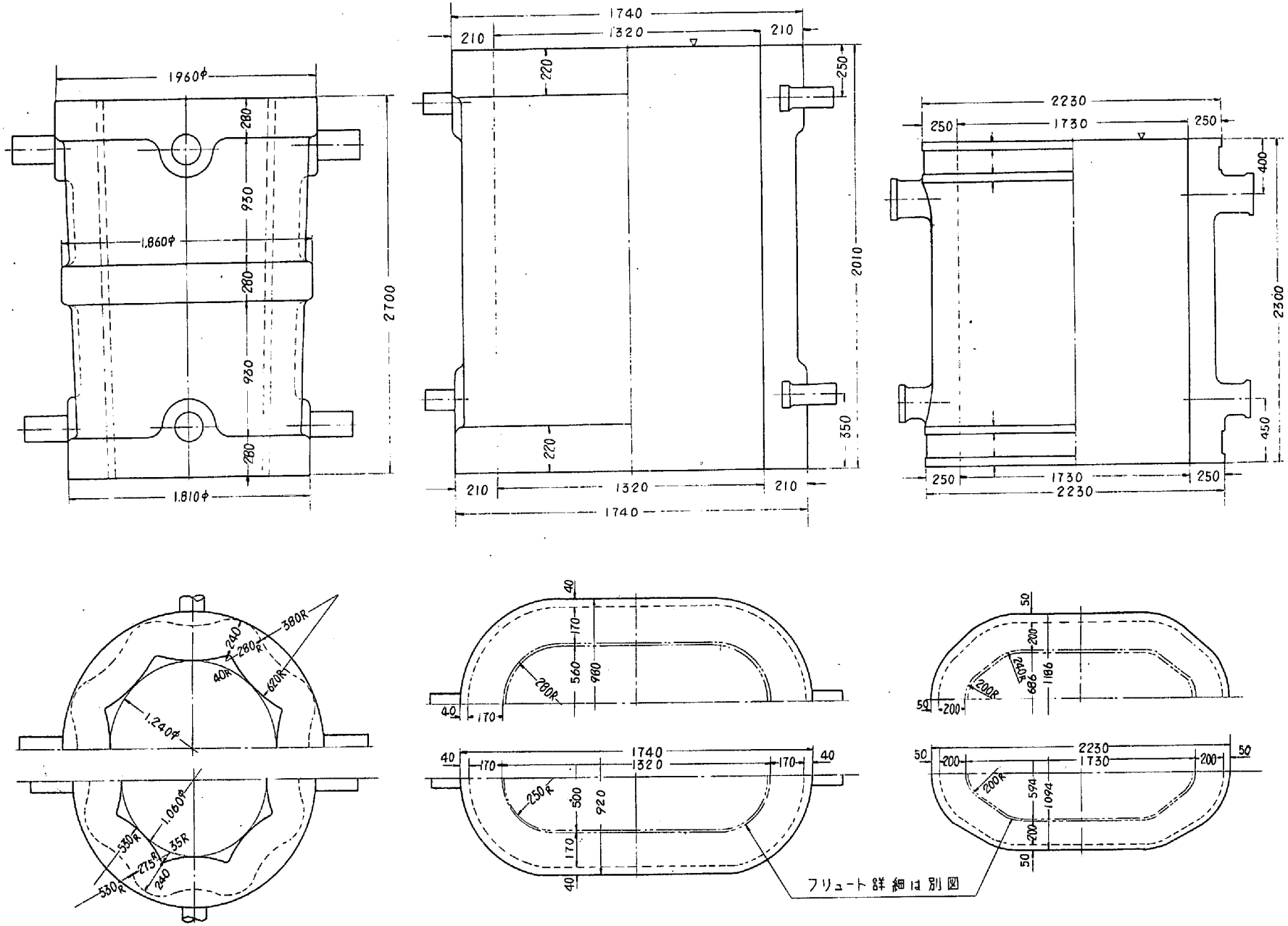


日 本 特 殊 鋼

R 800Kg

八 角 8 t

八 角 15 t



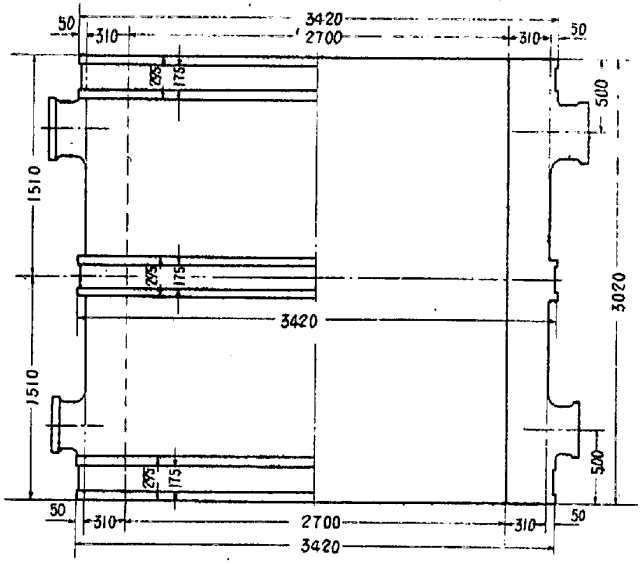
日本特殊鋼

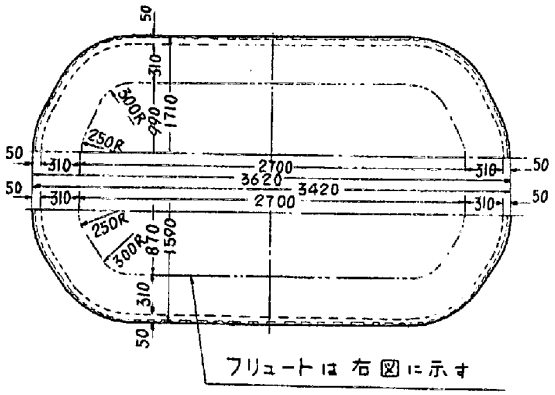
八角 25 t

日本製鋼

9 Ⓚ

16 Ⓚ

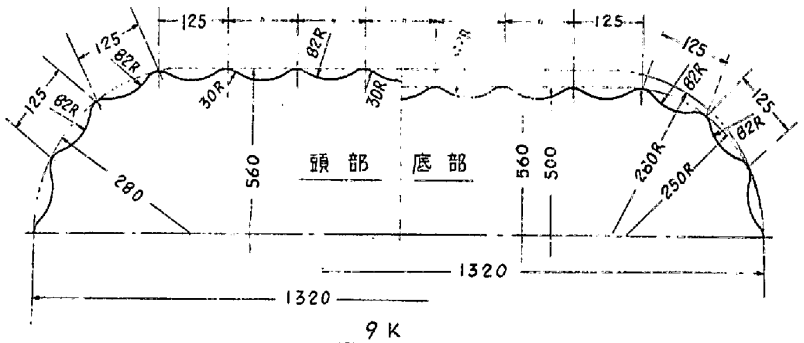




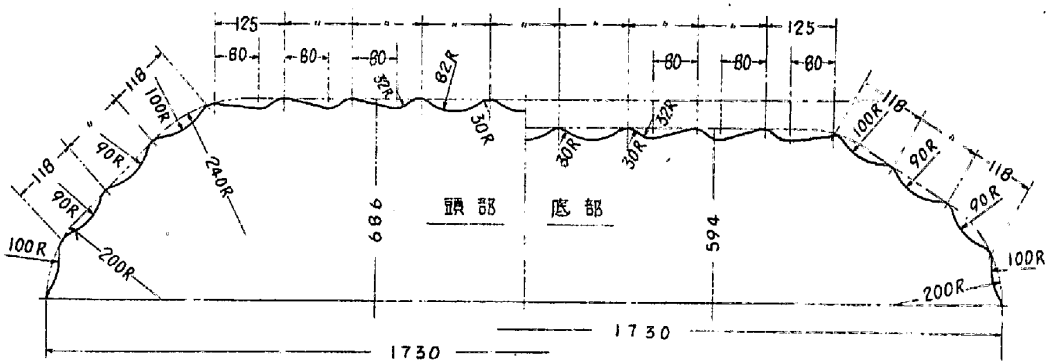
日本製鋼

48 K₁

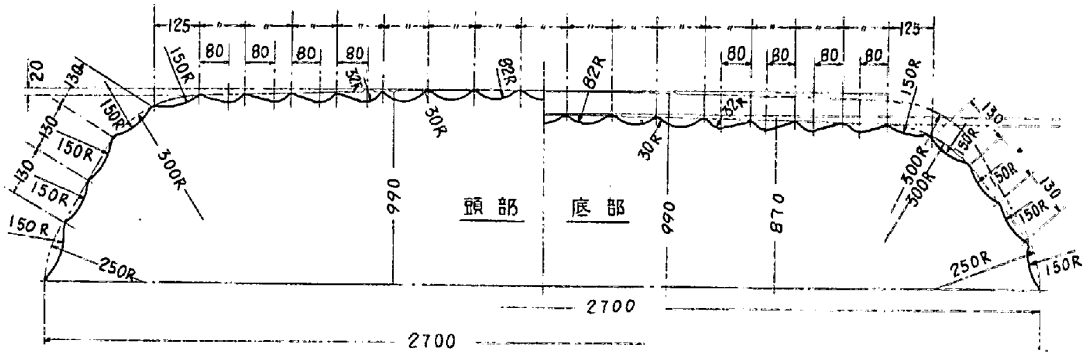
フリュート詳細図



9 K

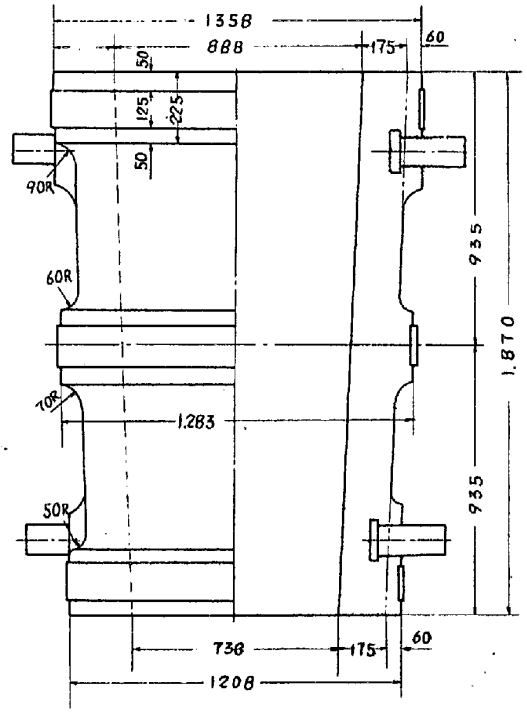


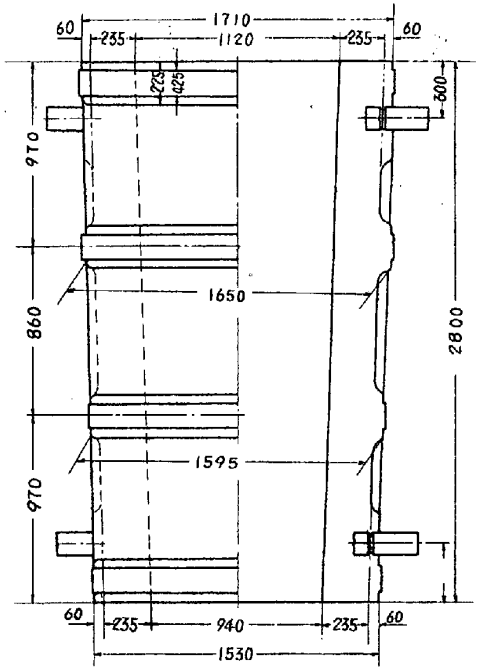
16 K₁

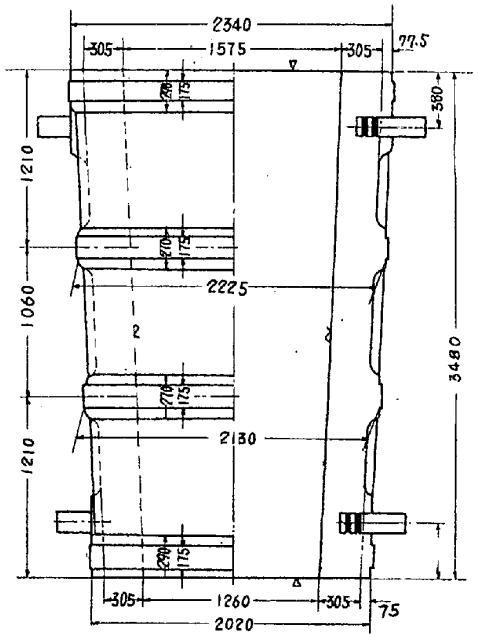


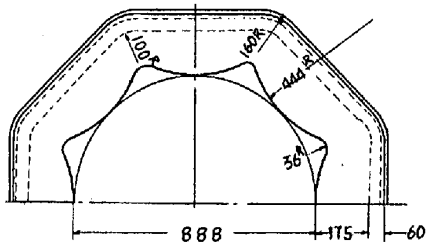
48 K₁

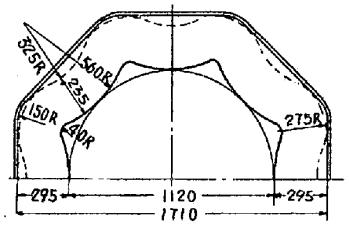
9 K. 16 K₁ 48 K₁

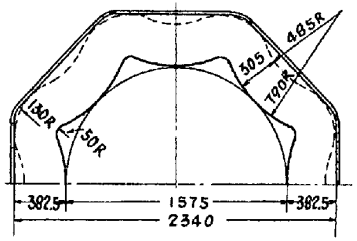


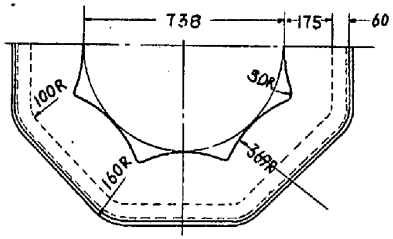


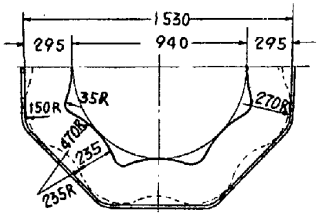


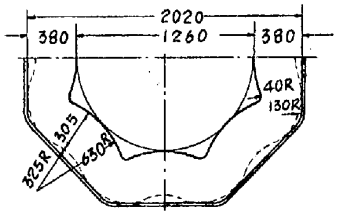










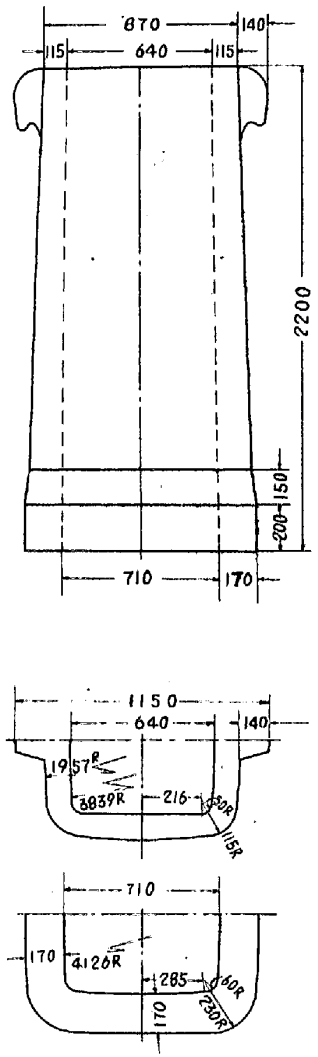


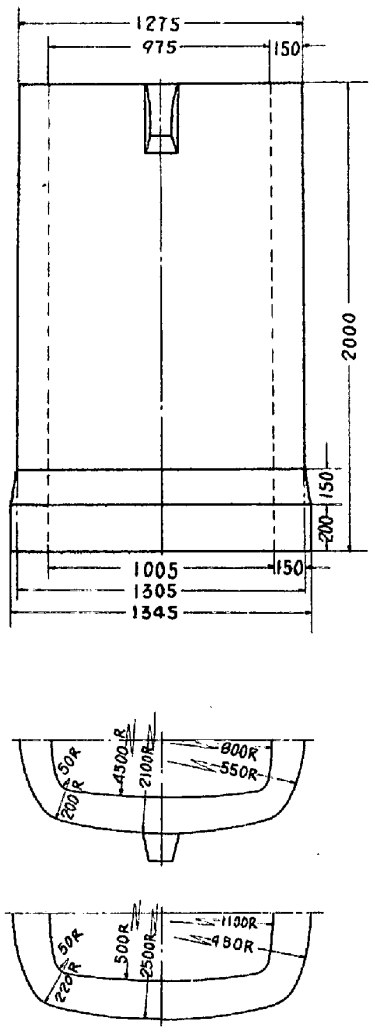
日 本 製 鋼

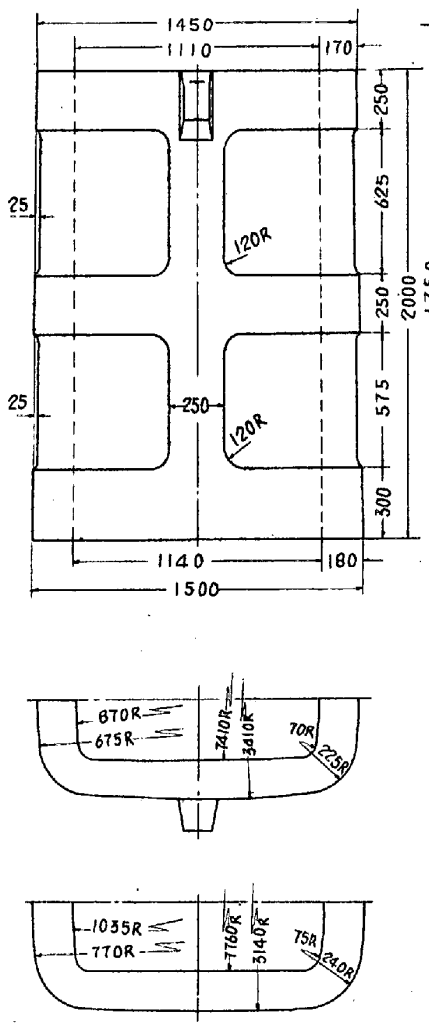
10 B

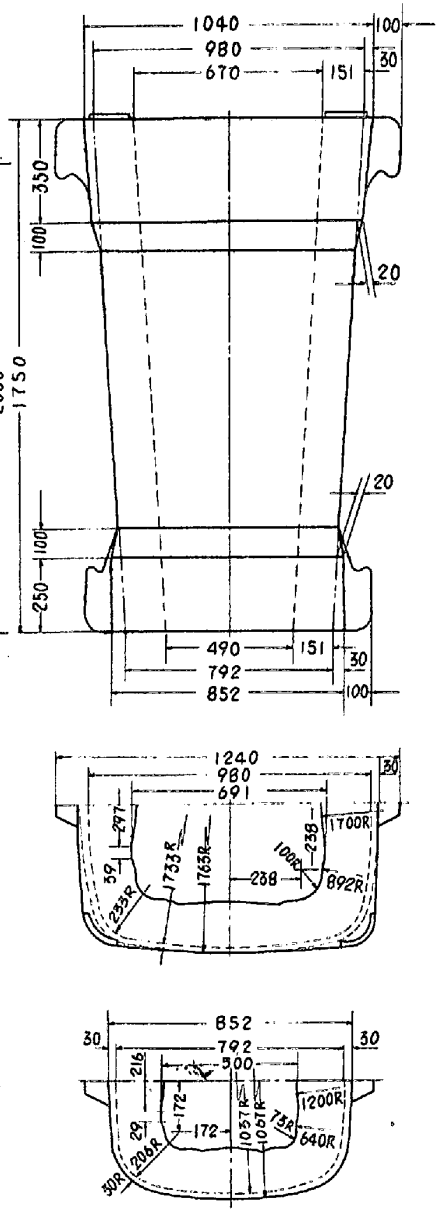
25 A

60 B



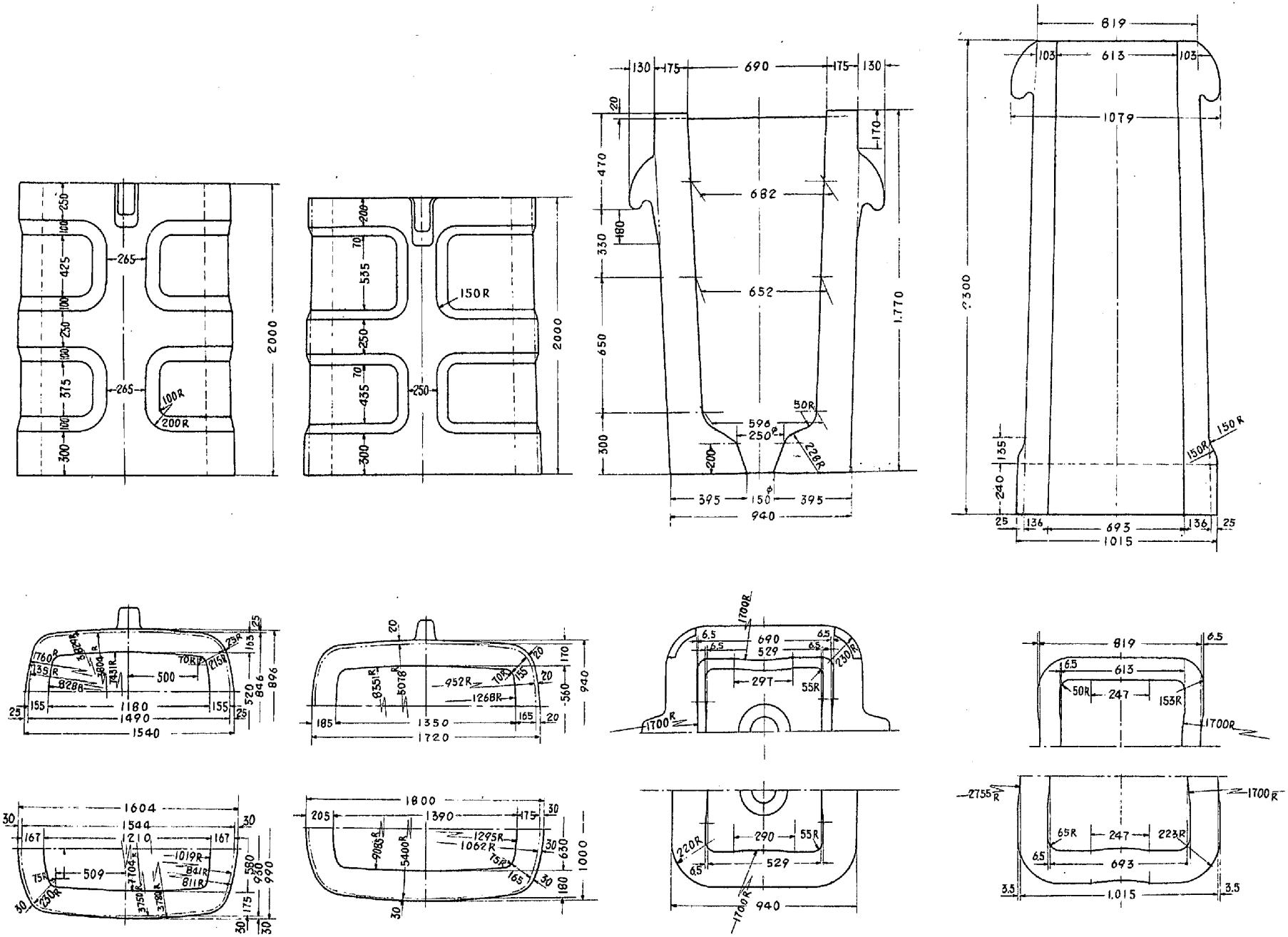






富士鉄・室蘭

MS 6　　MB 6　　MB 6.5　　MU 50



富士鉄・室蘭

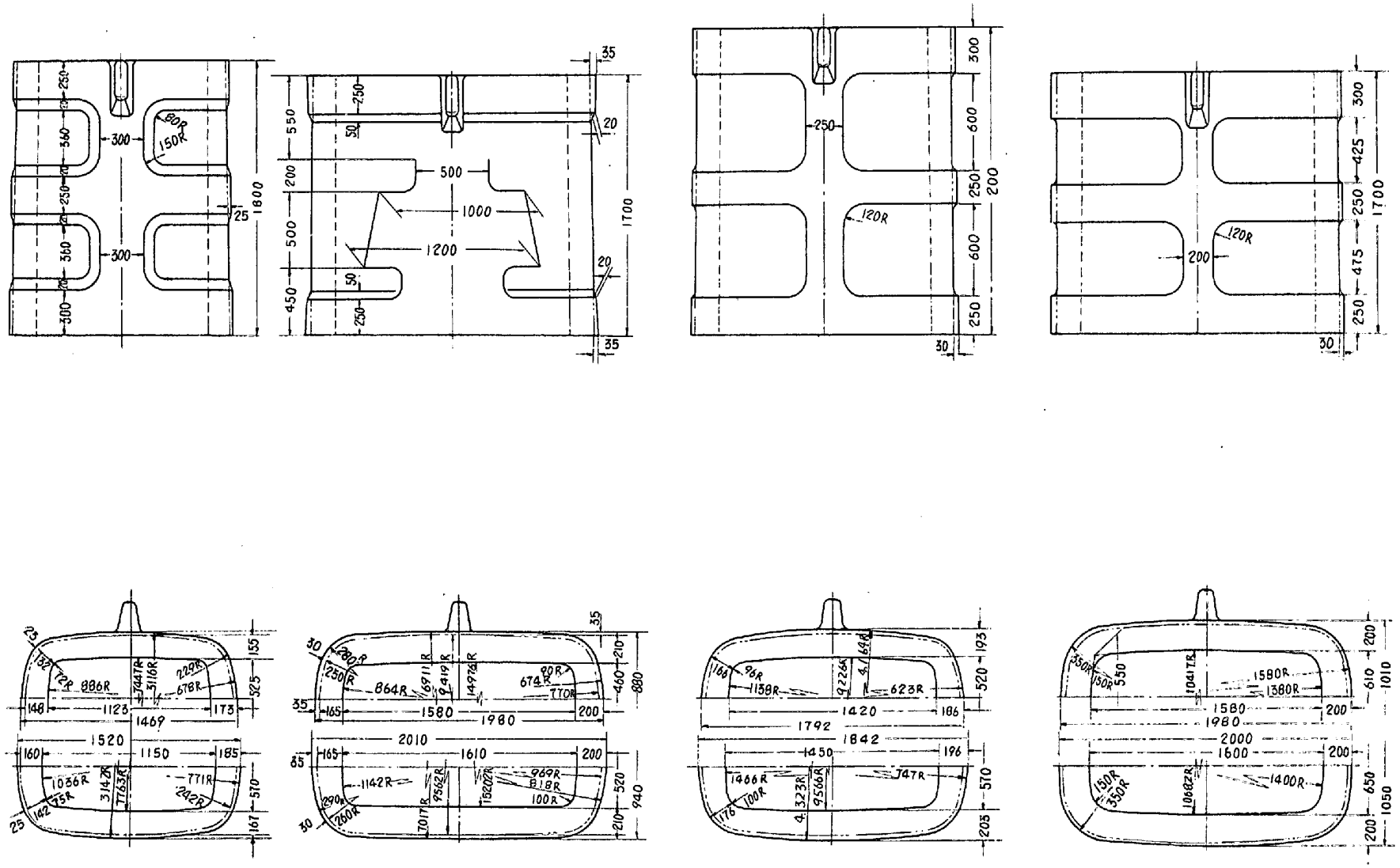
MB 8

MB 10

富士鉄・釜石

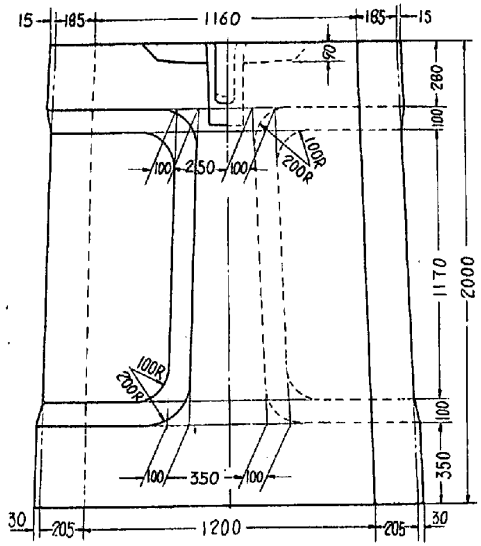
KU 2C

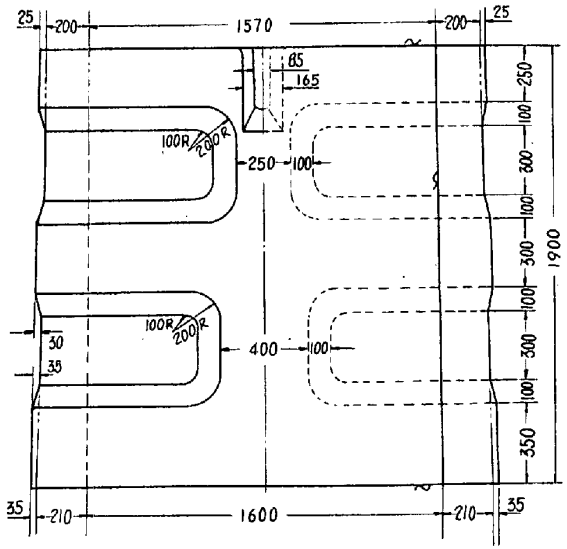
K 69

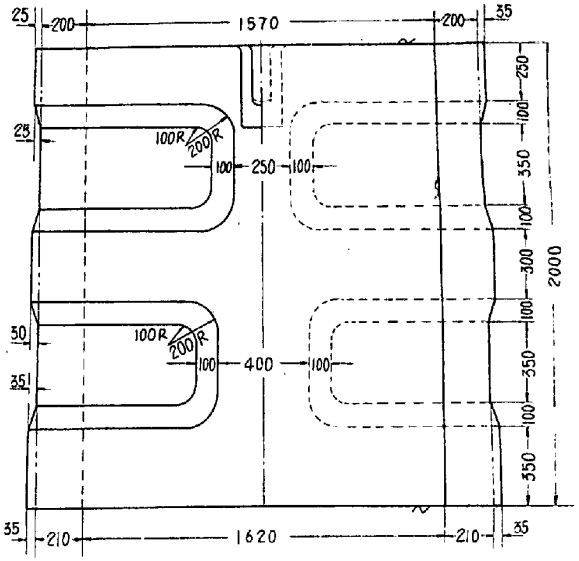


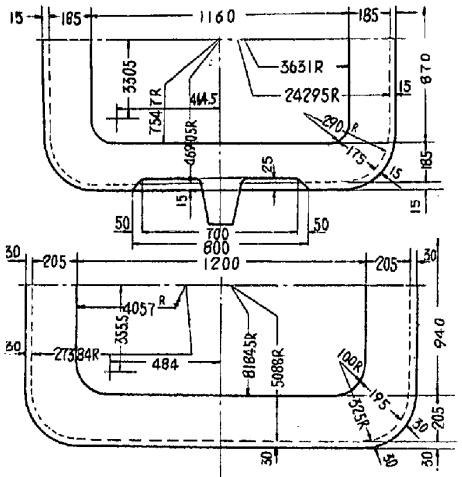
富士鉄・広畑

HB 6.5　　HB 8　　HB 8.5　　HB 10



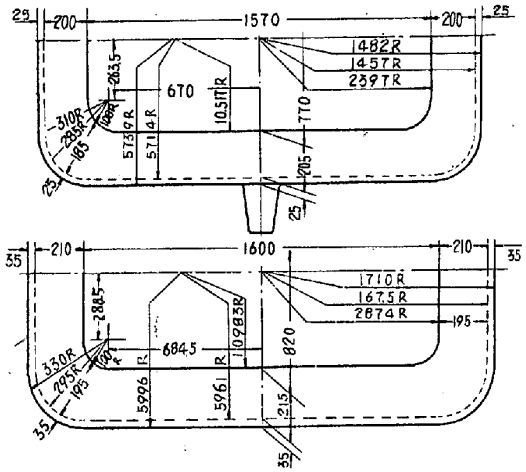


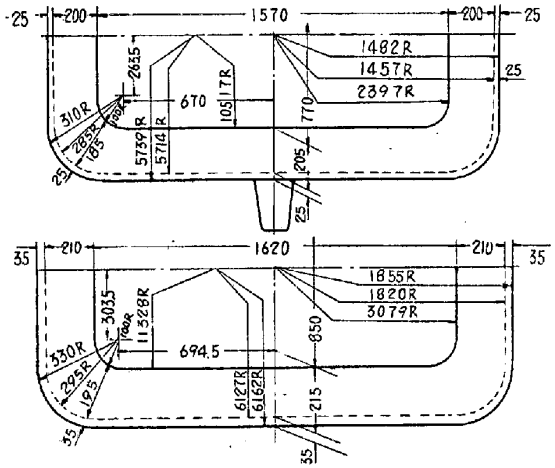




富士鉄・広畑

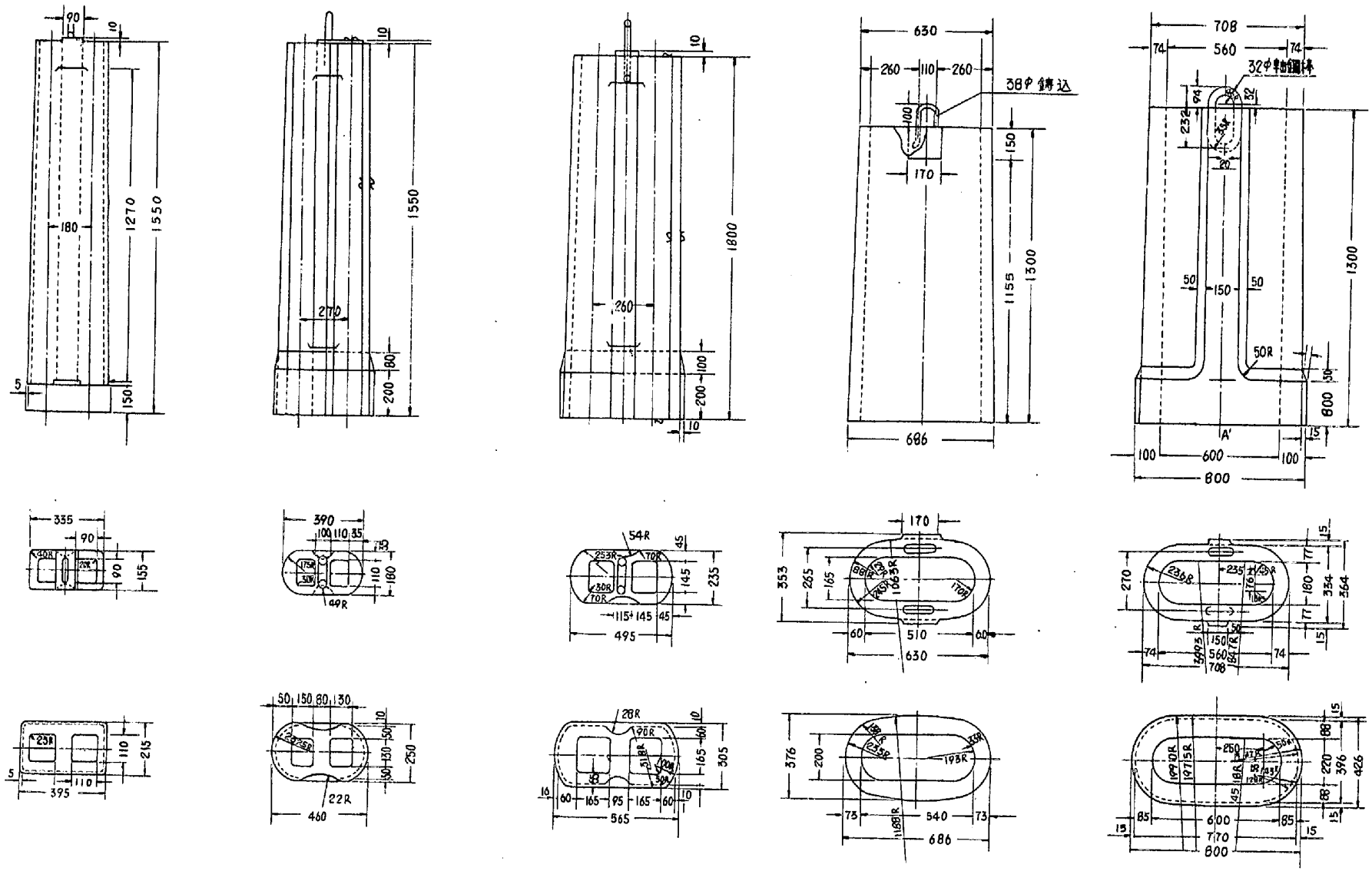
HB 13





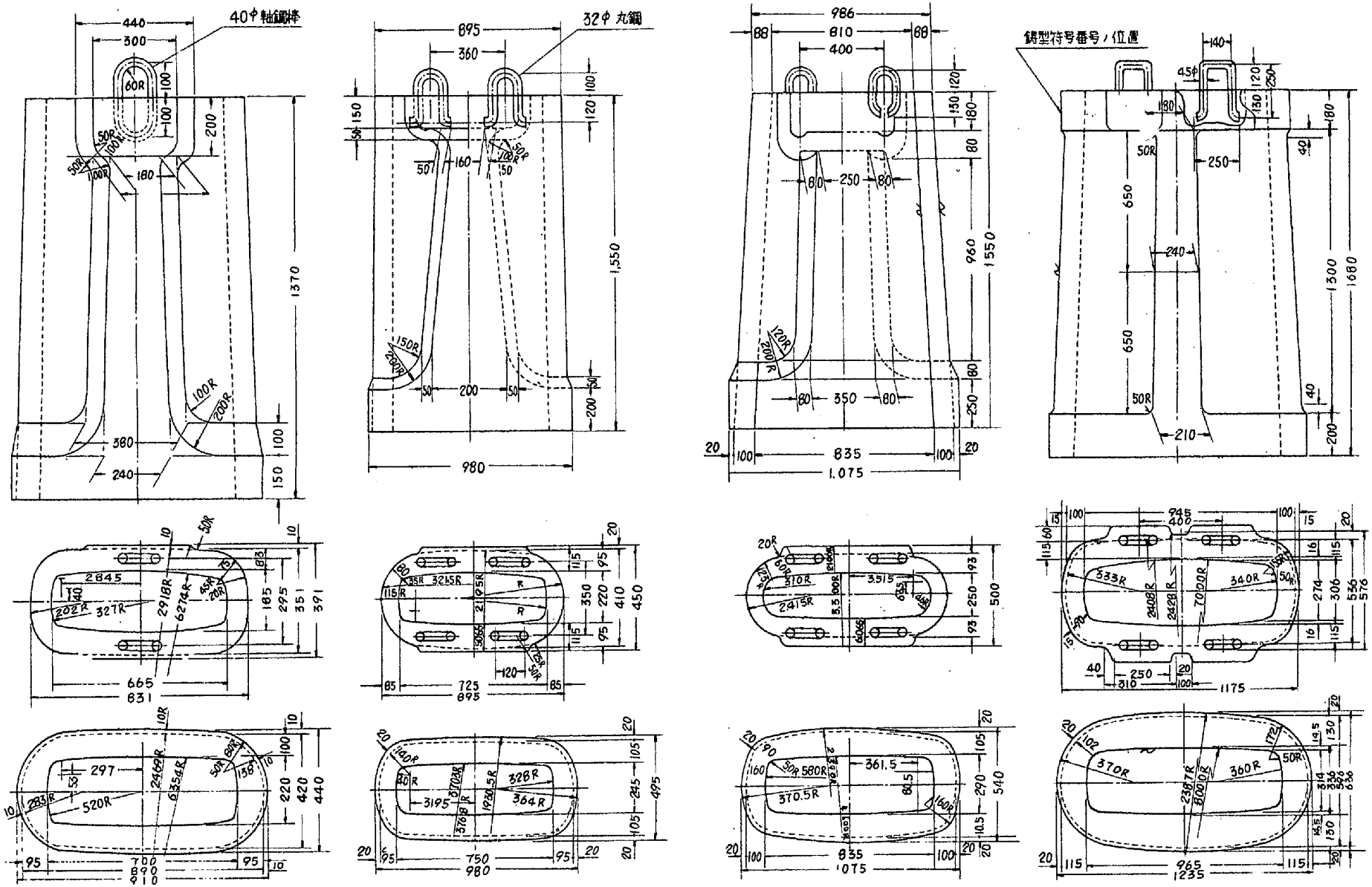
HB 15

HB 16



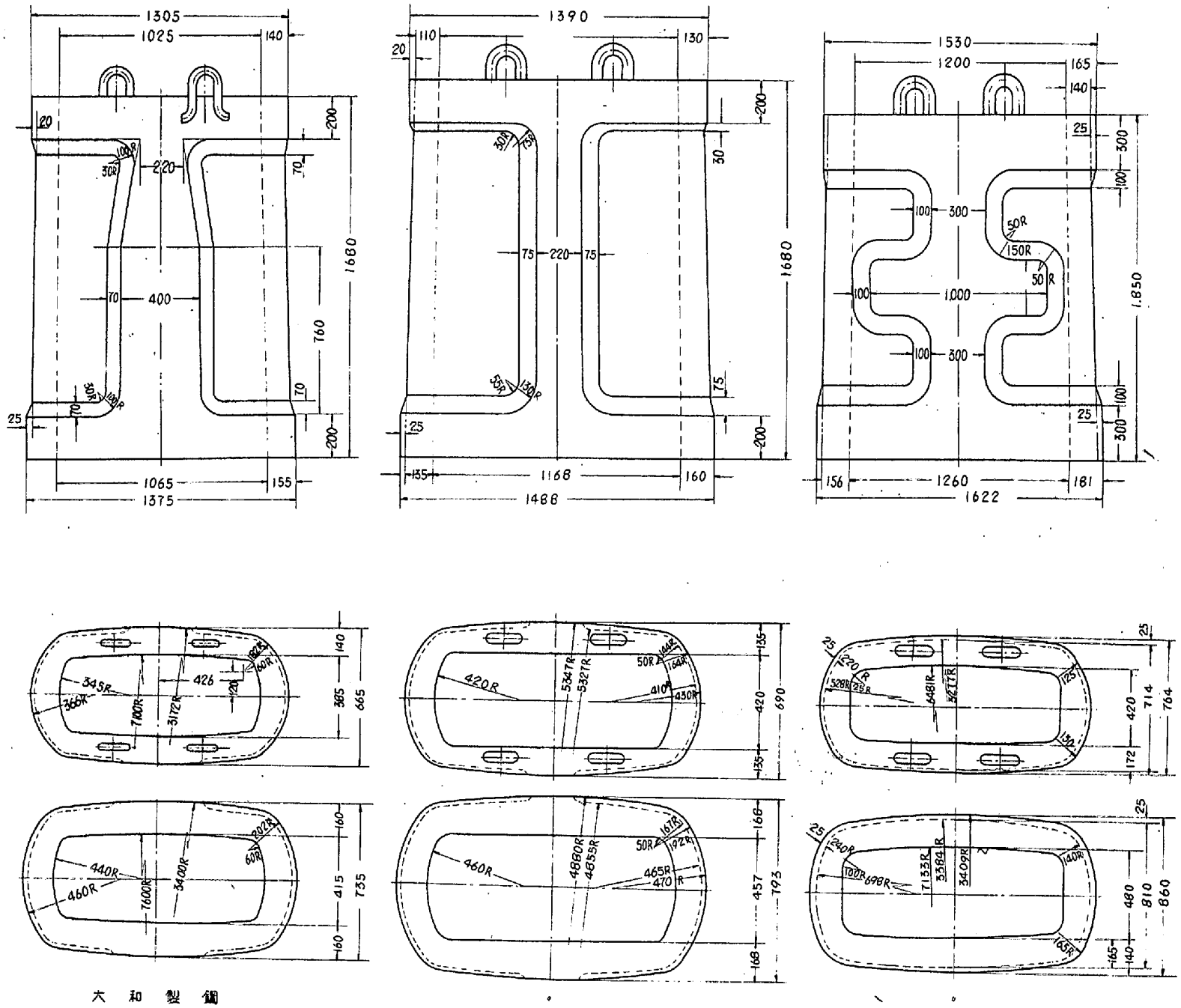
大和製鋼

100 Kg　　150 kg　　250 kg　　0.7　　0.85



大和製鋼

B1t　　B1.5t　　B2t　　B3t

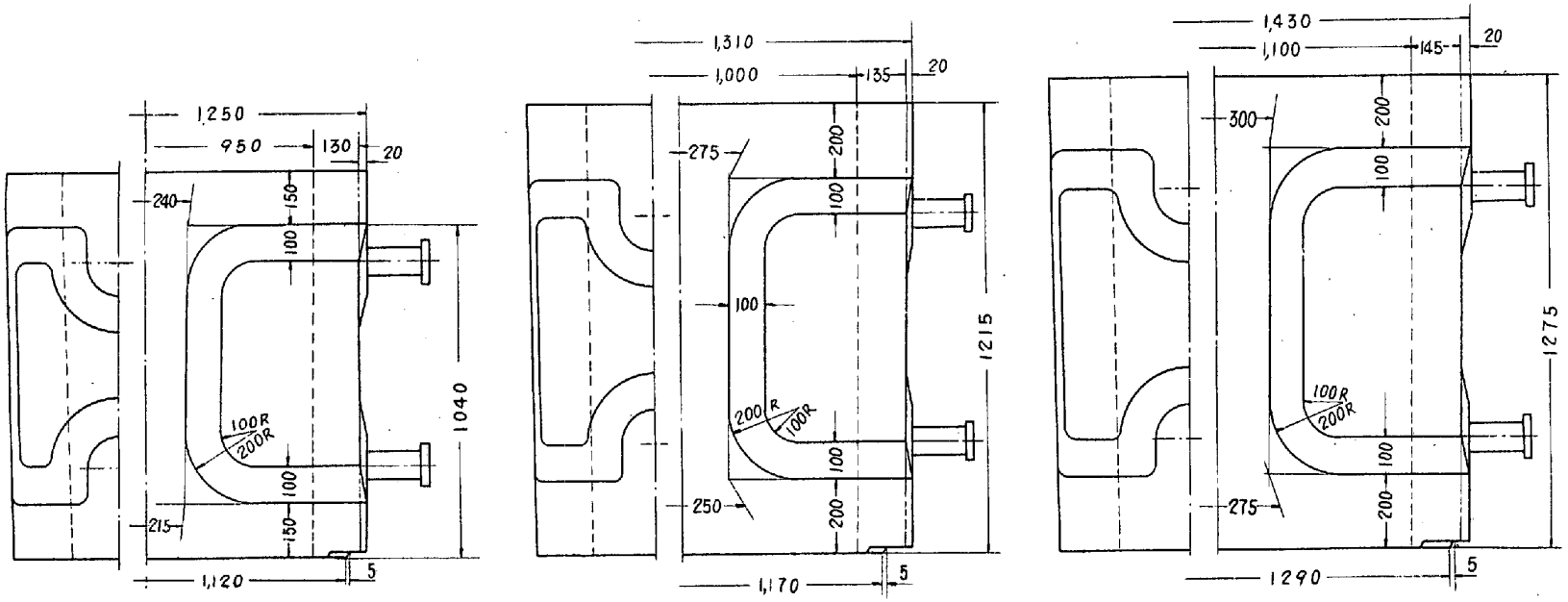


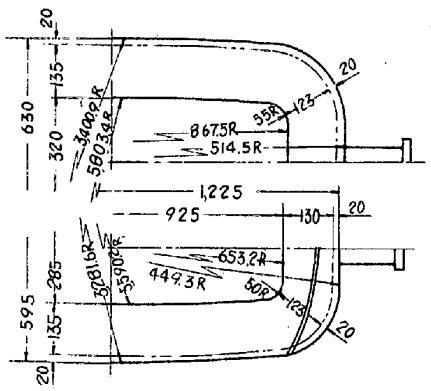
大 和 製 鋼

B 4 t

B 5 t

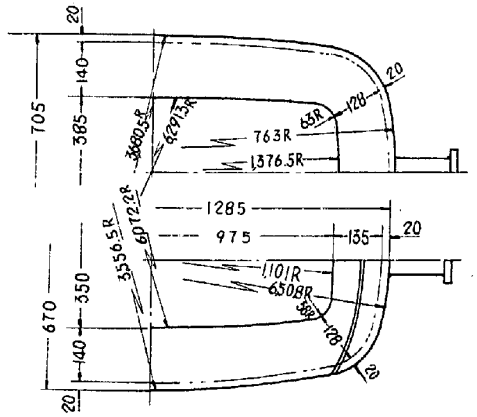
B 6 t





大　和　製　鋼

扁　平　2　T　(継足)



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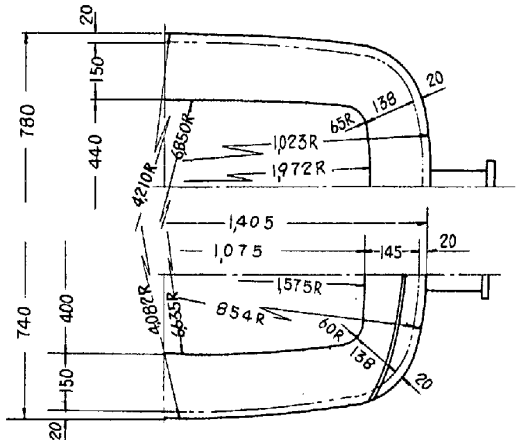
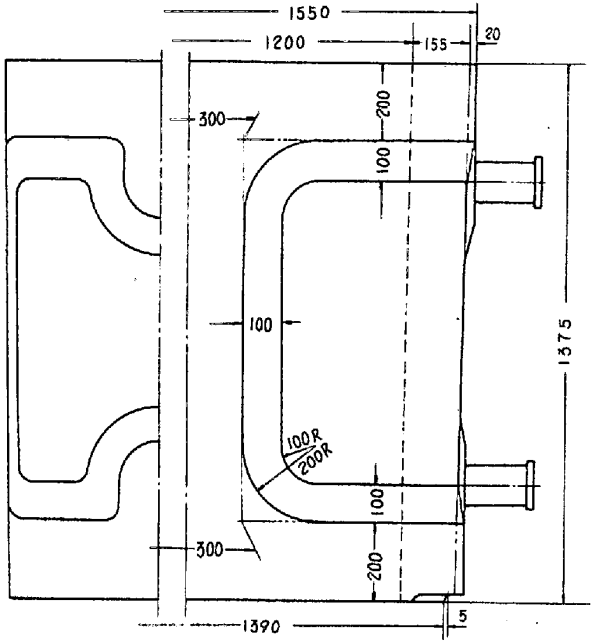
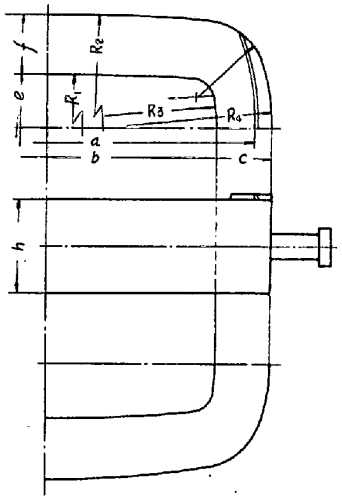
扁　平　3　T　(継足)

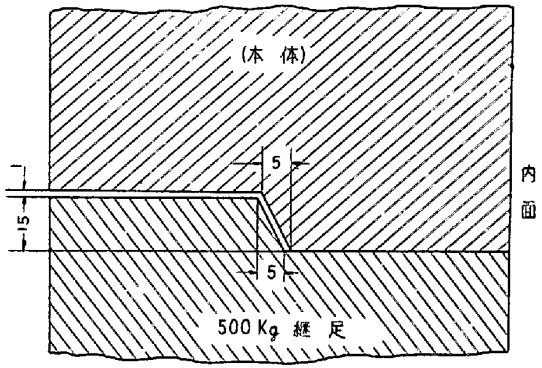


〃

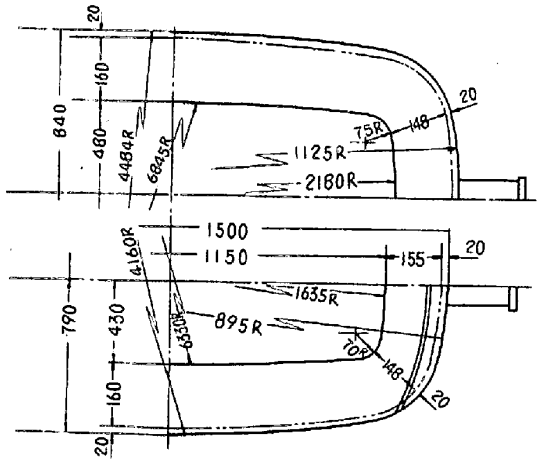
扁　平　4　T(継足)







2,3,4,5,t扁平鋼塊用鋳型で500 Kg 重い鋼塊を製造するさいに使用する

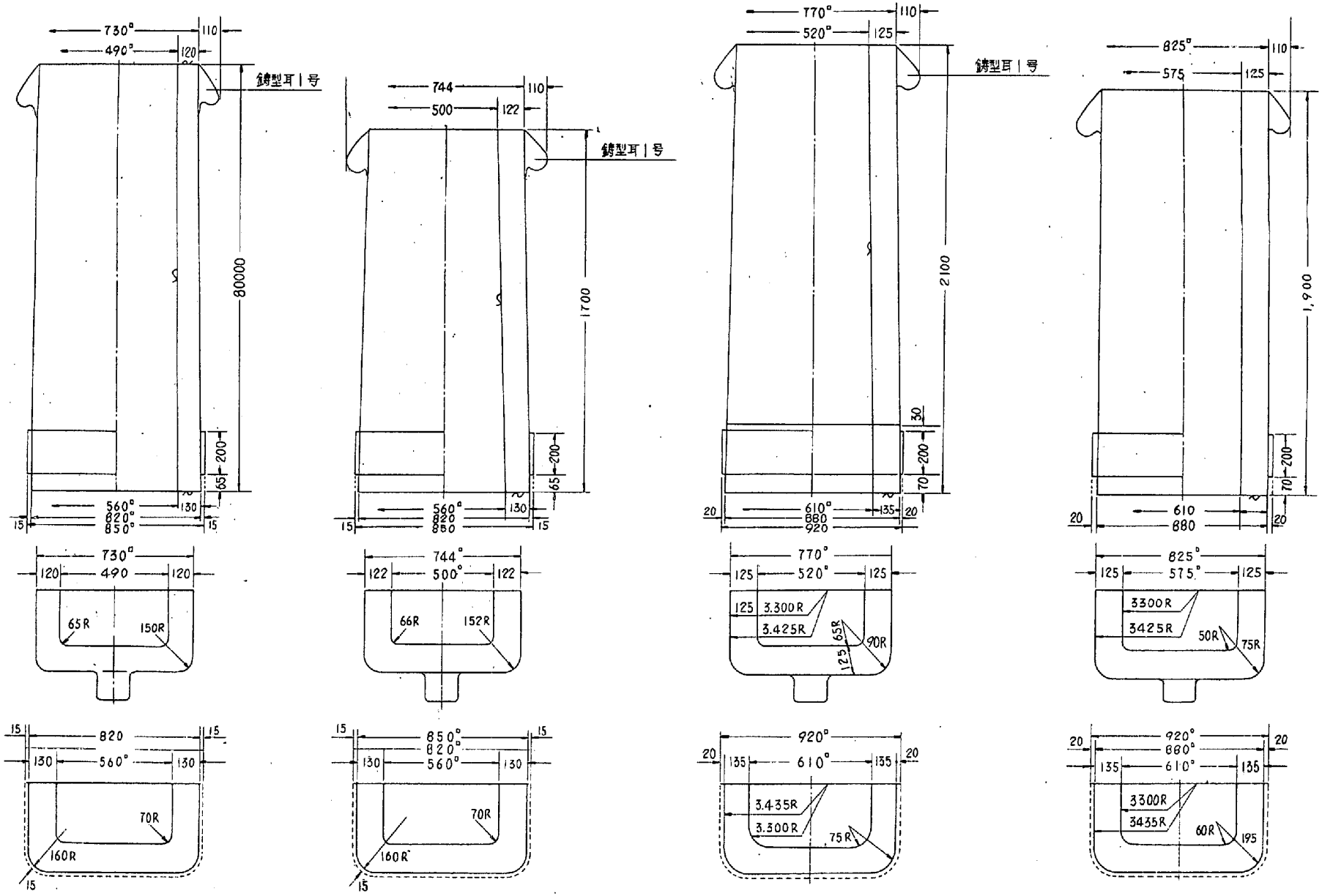


大 和 製 鋼

扁 平 5 T (継 足)

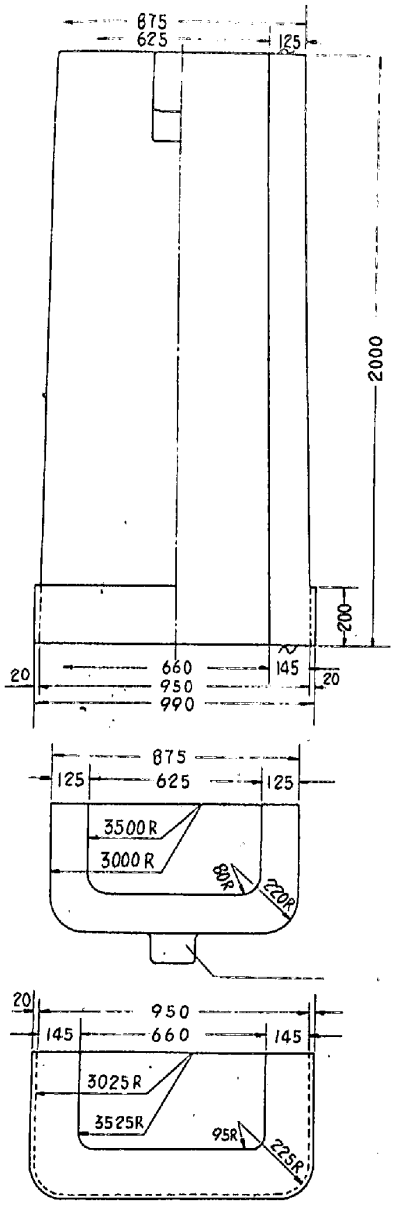
鋳型 / 符号	2 T 継 足		3 T 継 足		4 T 継 足		5 T 継 足	
	上	下	上	下	上	下	上	下
a	1122	———	1172	———	647	———	697	———
b	925	915.5	975	970.5	1075	1072	1150	1144.3
c	150	150	155	155	165	165	175	175
d	143	143	148	148	158	158	168	168
e	285	278	350	344	400	395	430	424
f	155	155	160	160	170	170	180	180
R_1	5590.2	5195.5	6072.2	6029	6635	6620	6330	6267
R_2	3281.6	3201.5	3556.5	3532	4082	4073	4160	4120.8
R_3	653.2	893	1101	1012	1575	1538	1635	1573
R_4	449.3	493	650.8	618	854	838	895	868.8
Y	50	49	58	57	60	59	70	69.5
h	280		220		170			

500 Kg 継 足 鋳 型 寸 法 表



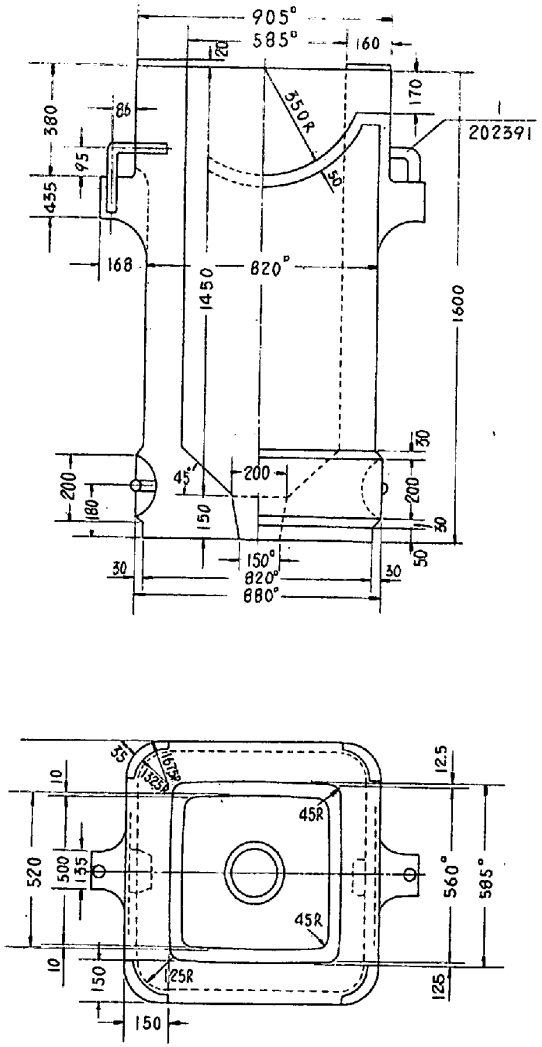
八幡製鉄

C-56　　C-56A　　C-61A　　C-61B

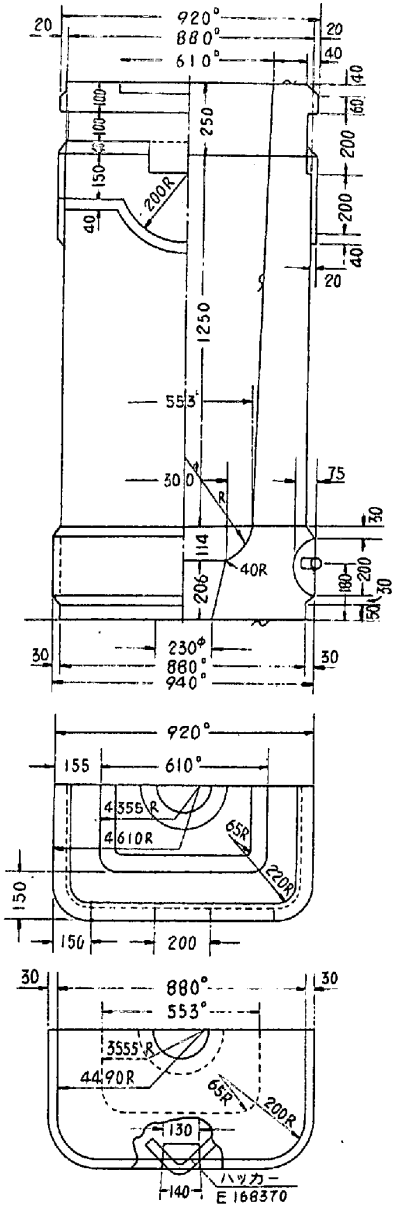


八幡製鉄

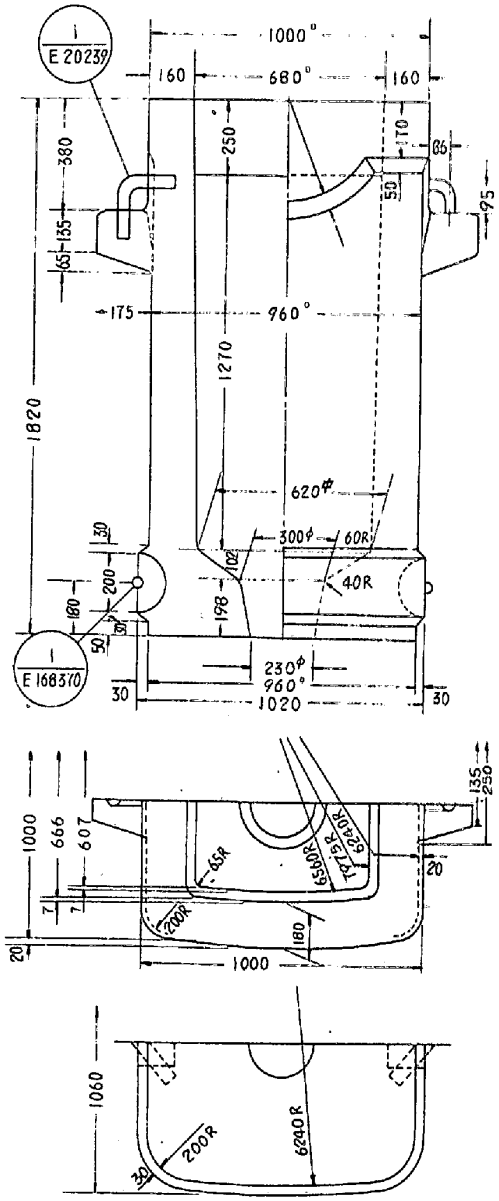
C-66



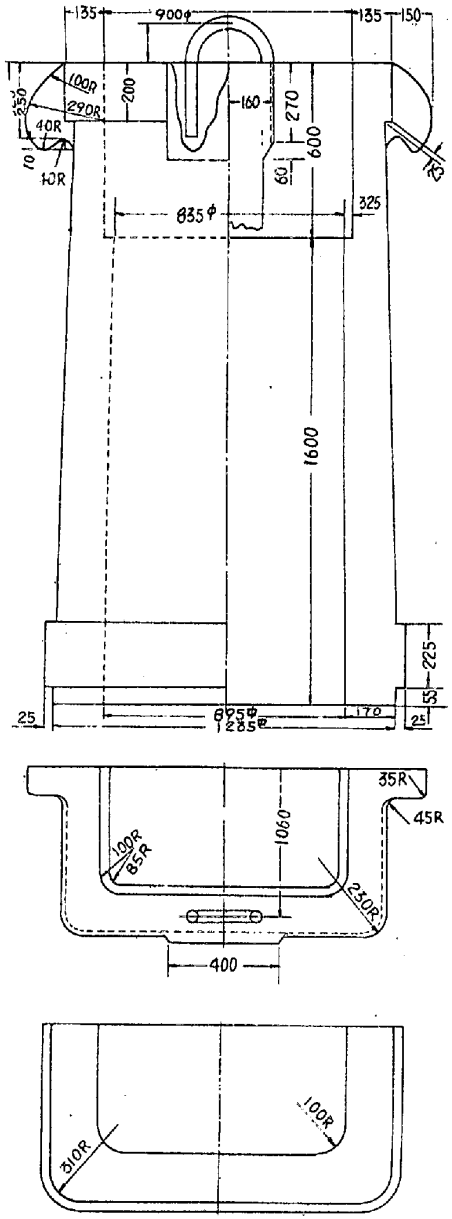
CV 59



CV 61

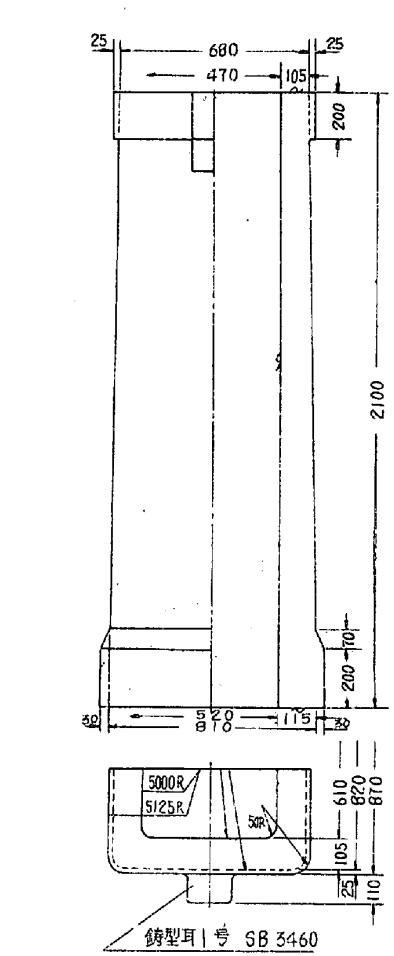


CV-68

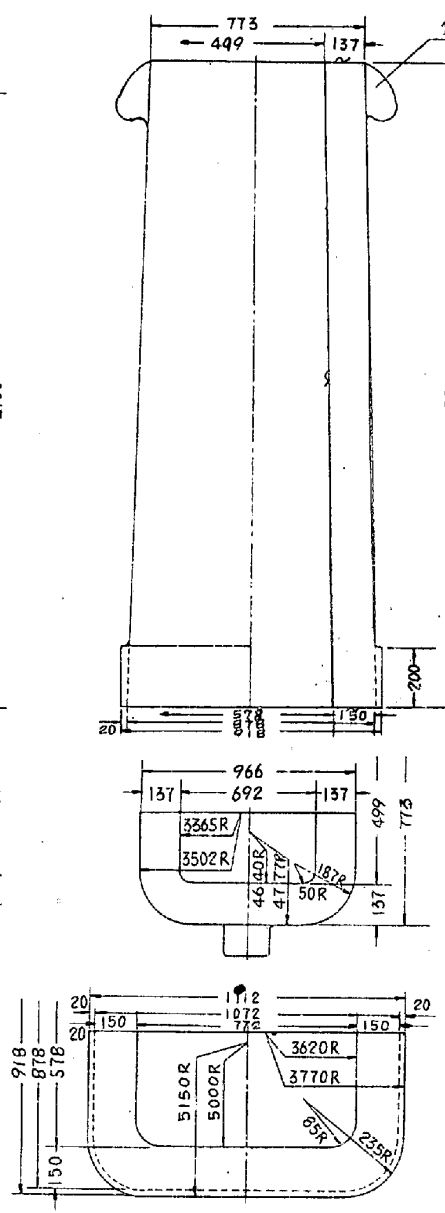


八幡製鉄

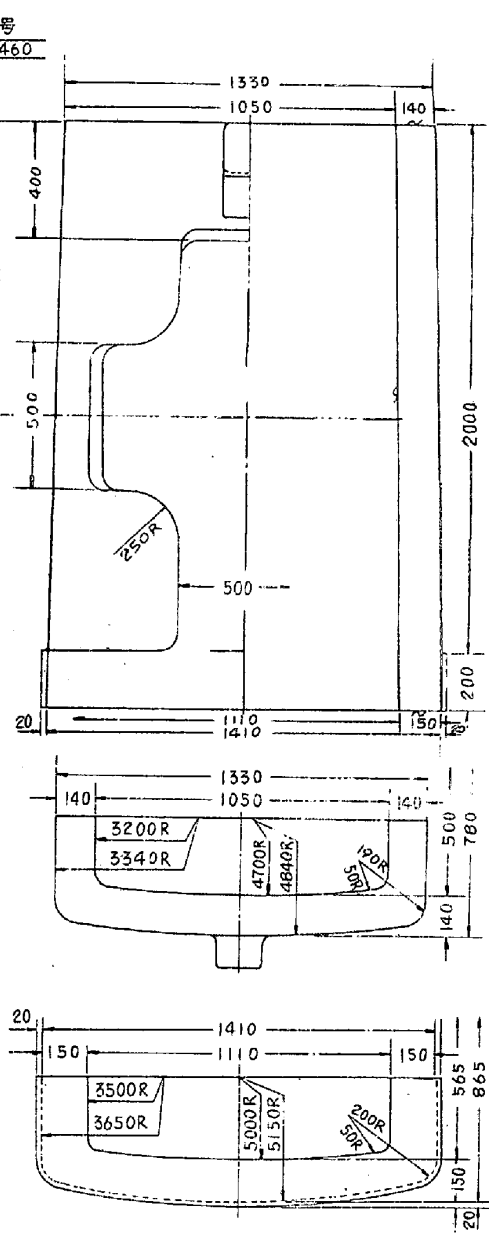
Cs 90



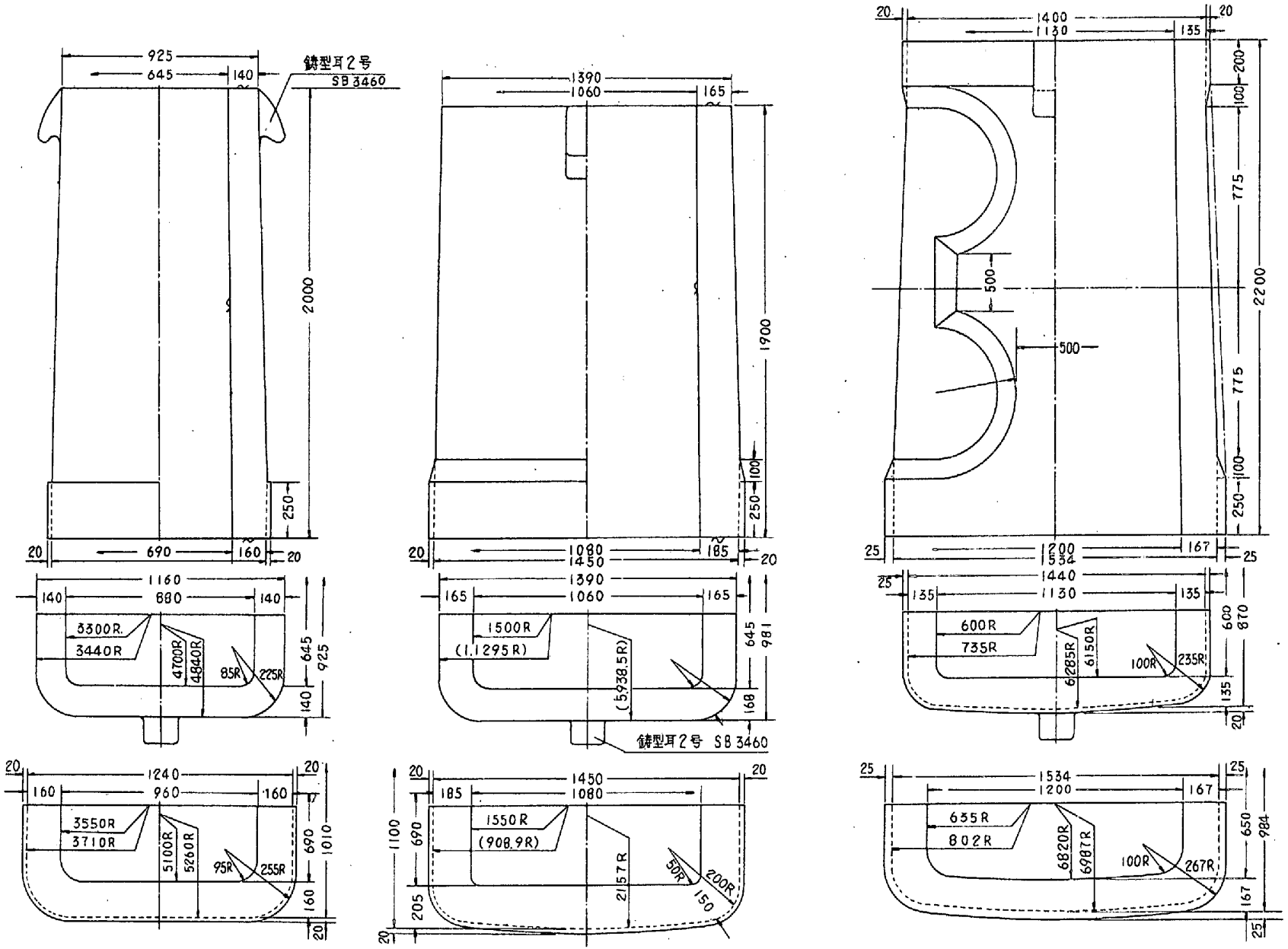
R 64



B 5.5



B 7

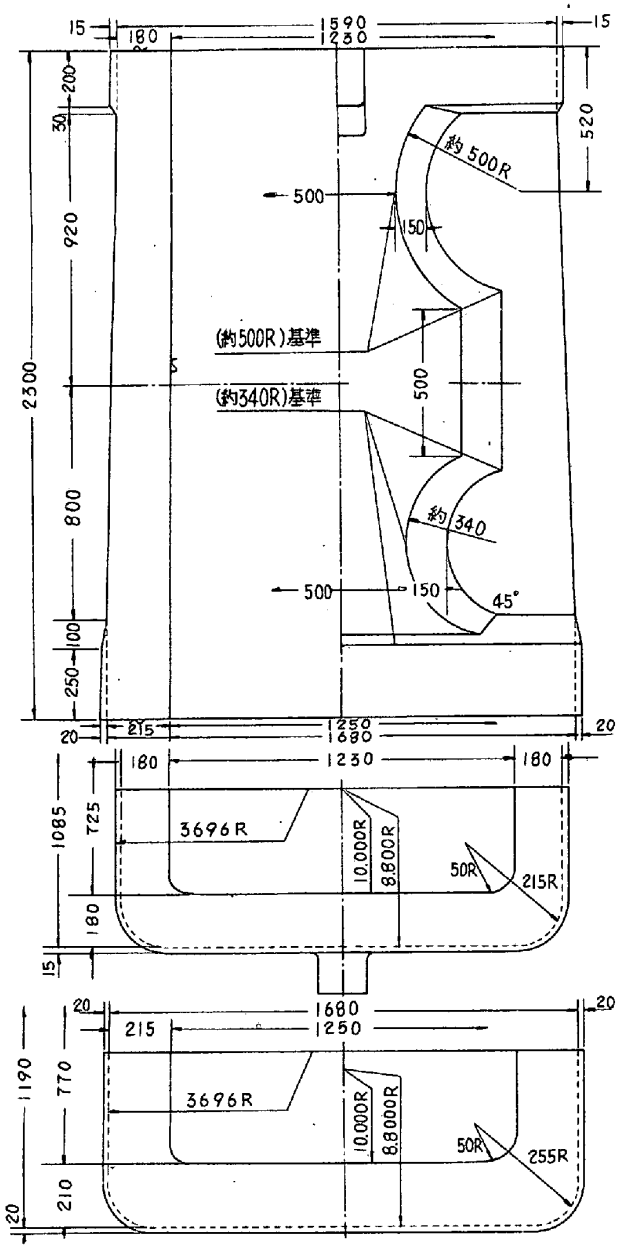


八 幡 製 鉄

B 7.5

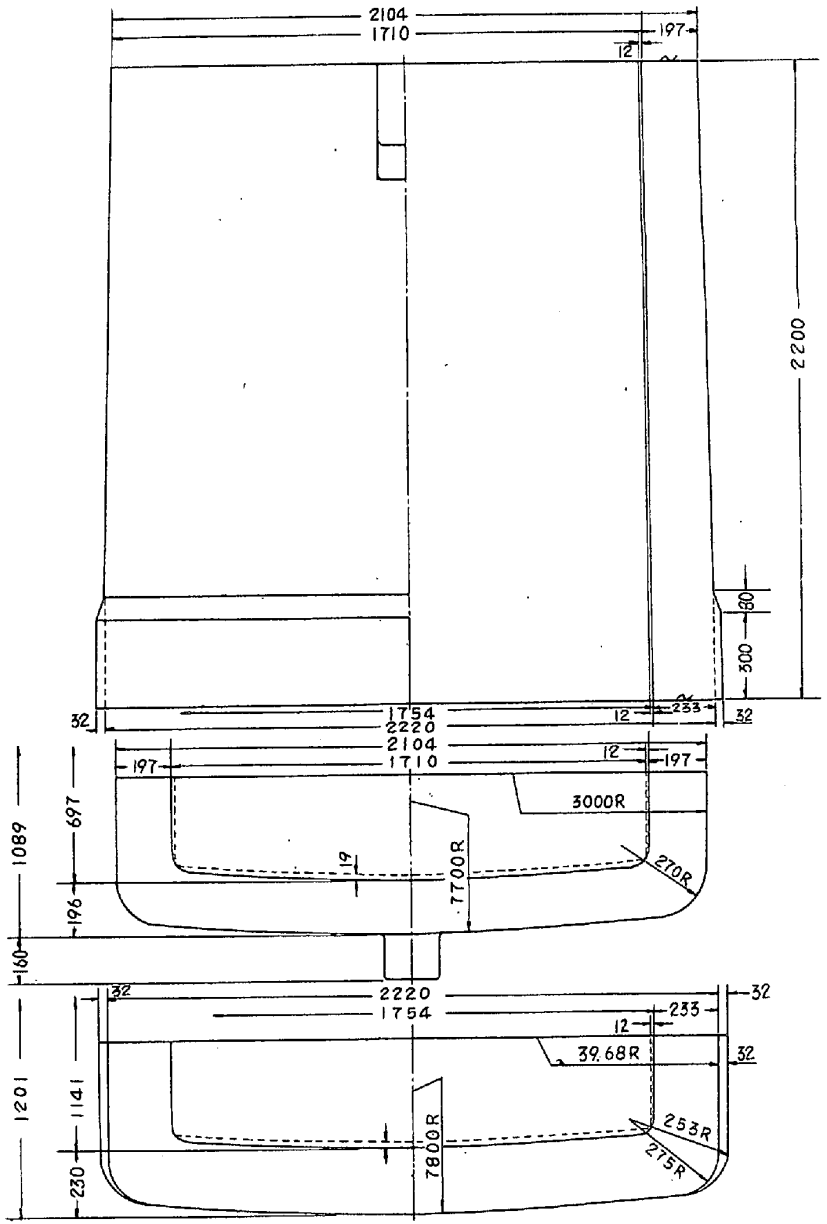
B 8.5

10 A

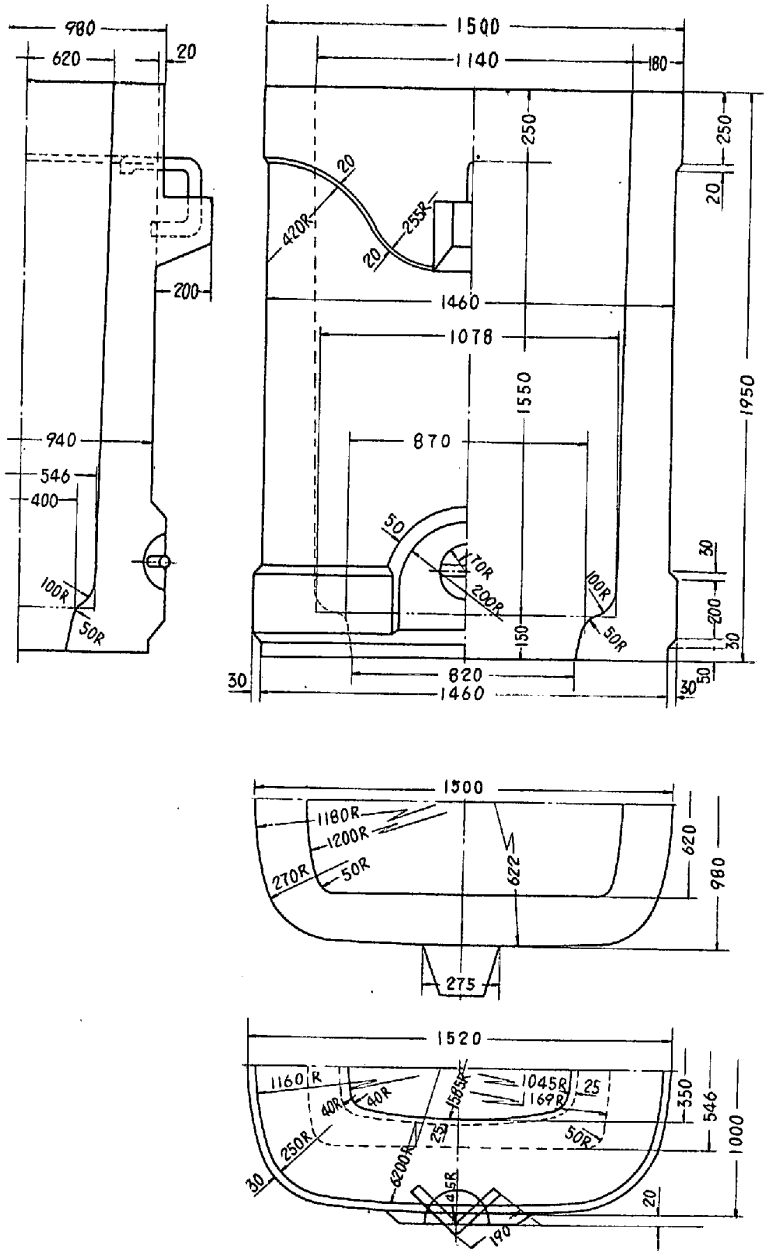


八幡製鉄

B13B

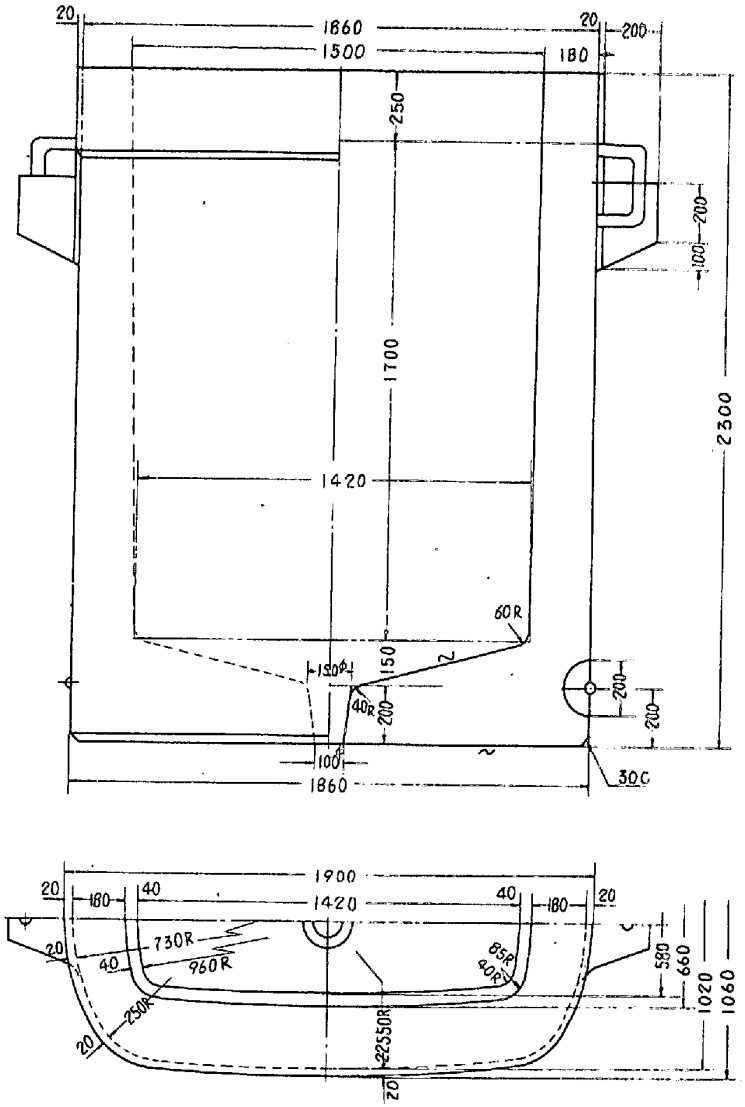


B16

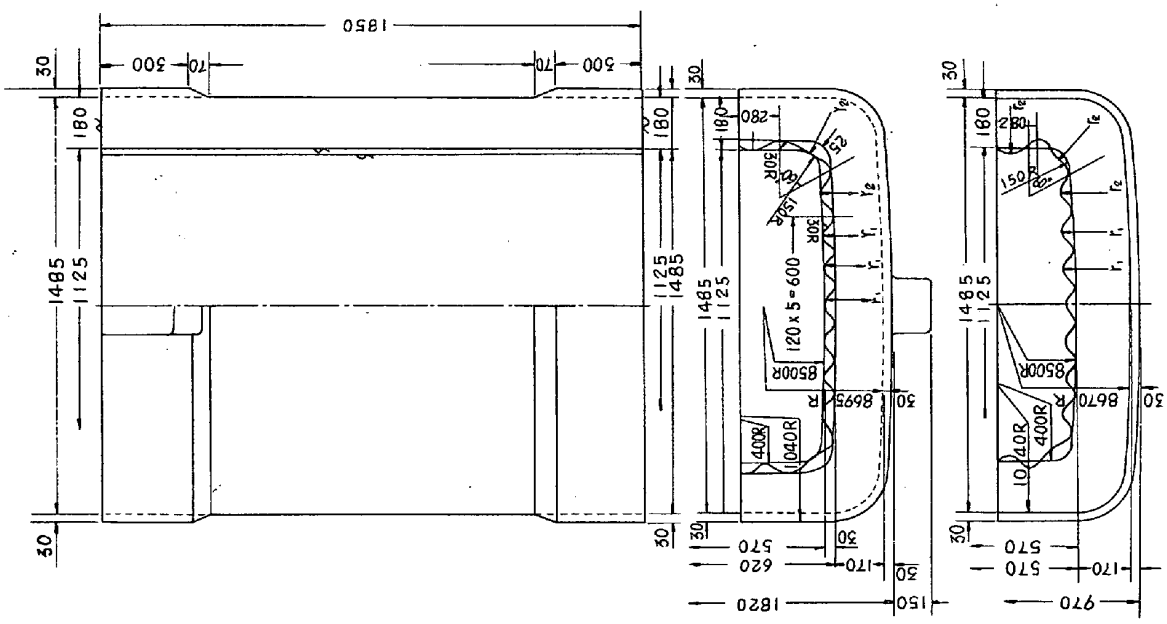


八　幡　製　鉄

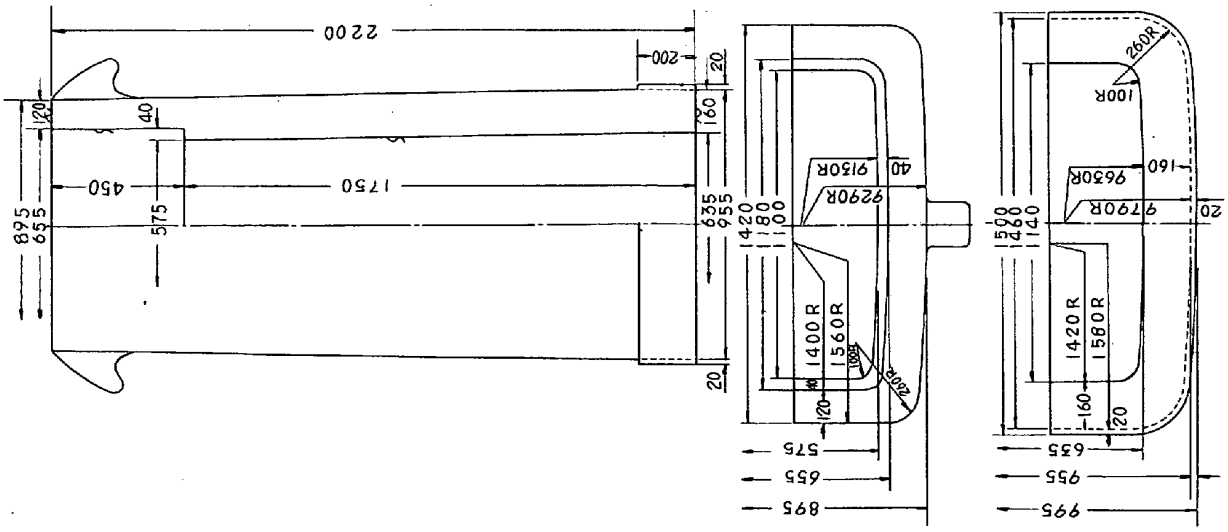
BV 10 A



BV 15

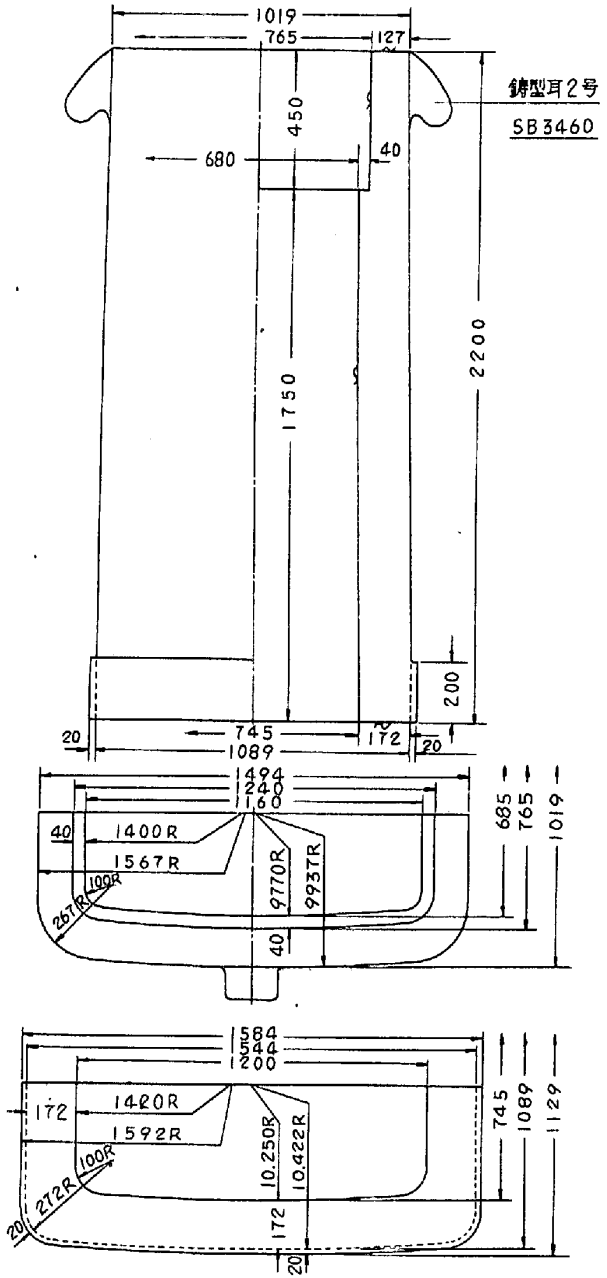


BS10A



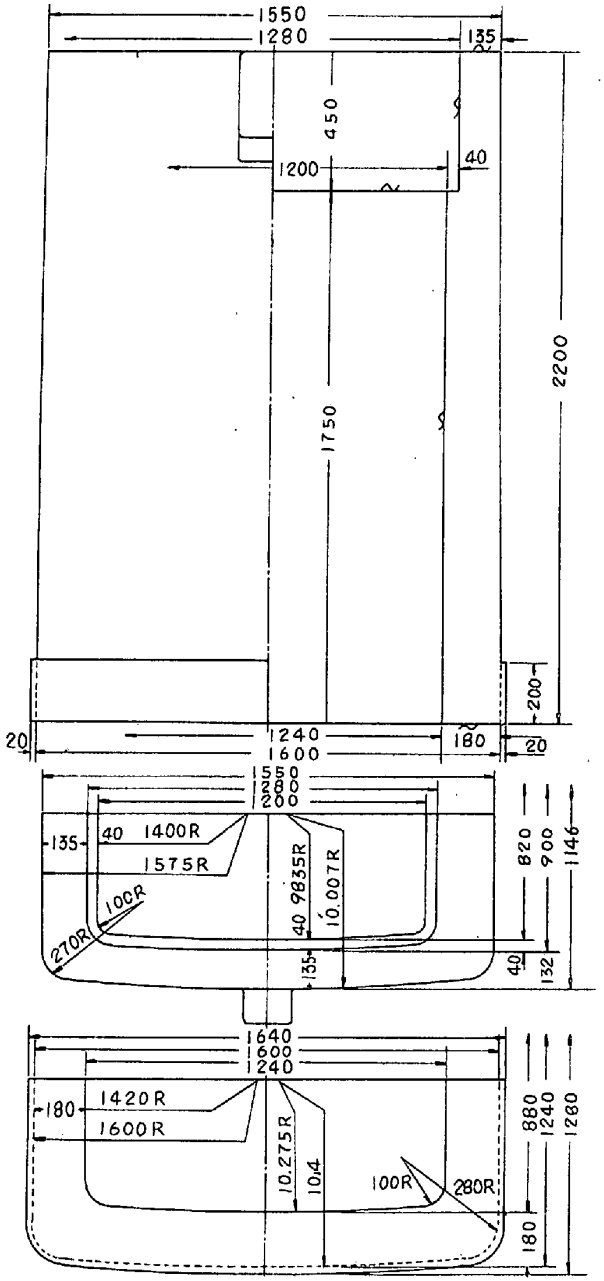
八幡製鉄

BS 9.5

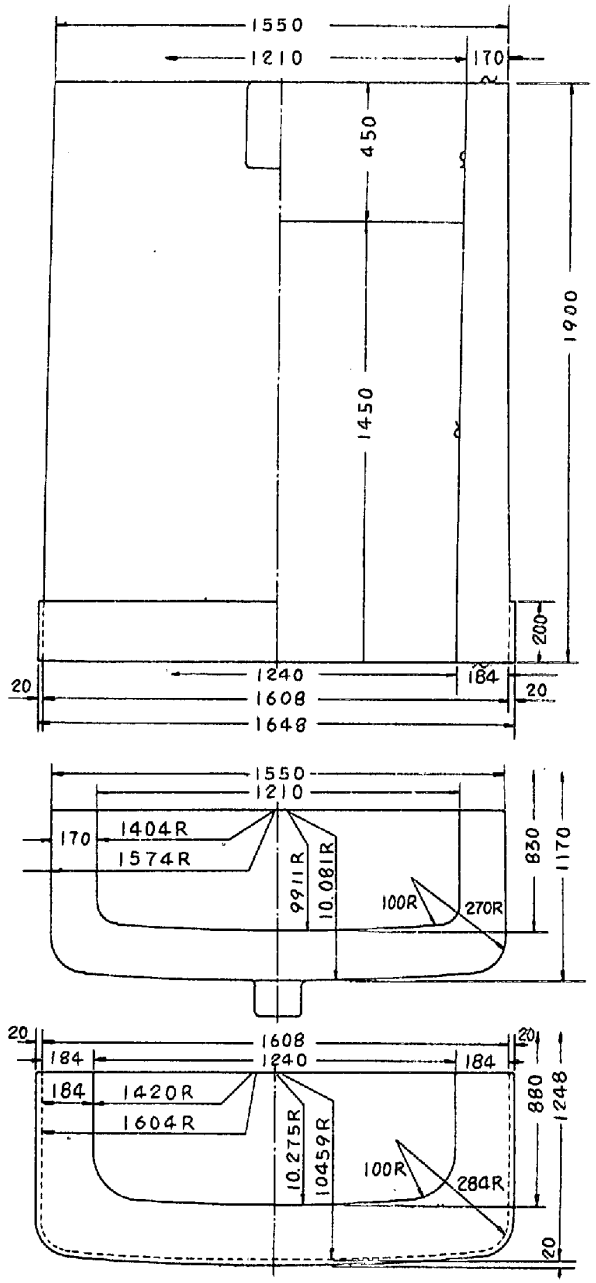


八幡製鉄

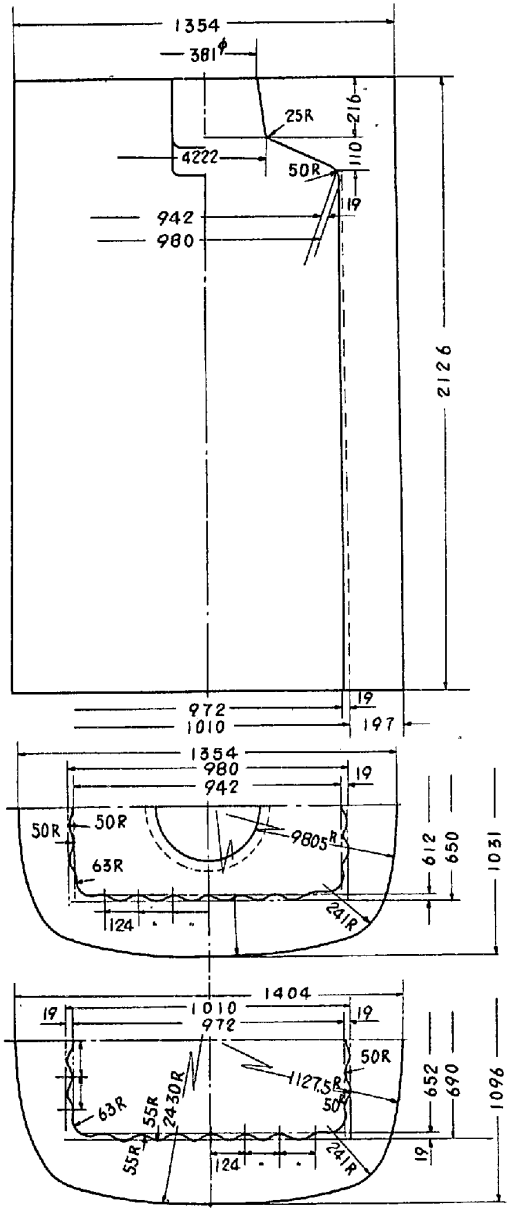
BS 12



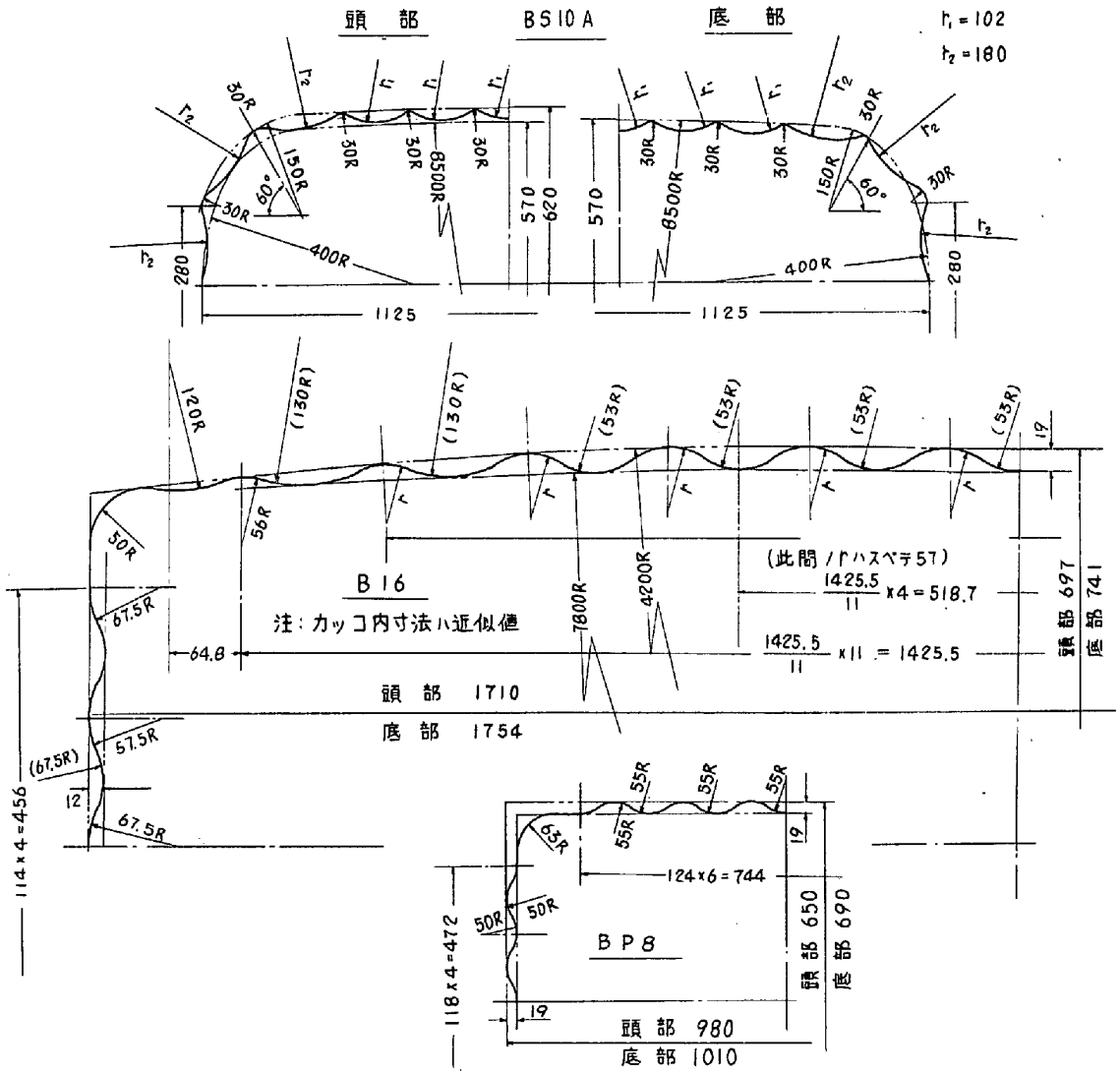
BS 15



BS 15 A



八 幡 製 鉄

B P 8

コルゲート・フリュート 詳 細 (BS10A, B16, BP8)