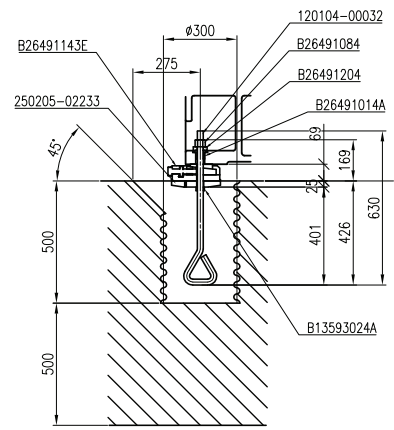
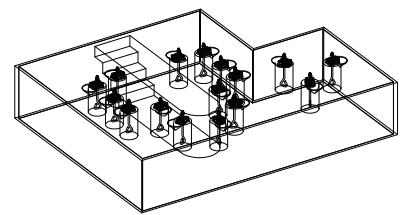


Reinforces the ground by driving files if necessary.  
필요에 따라 파일을 시공하여 지반을 보강할 것.

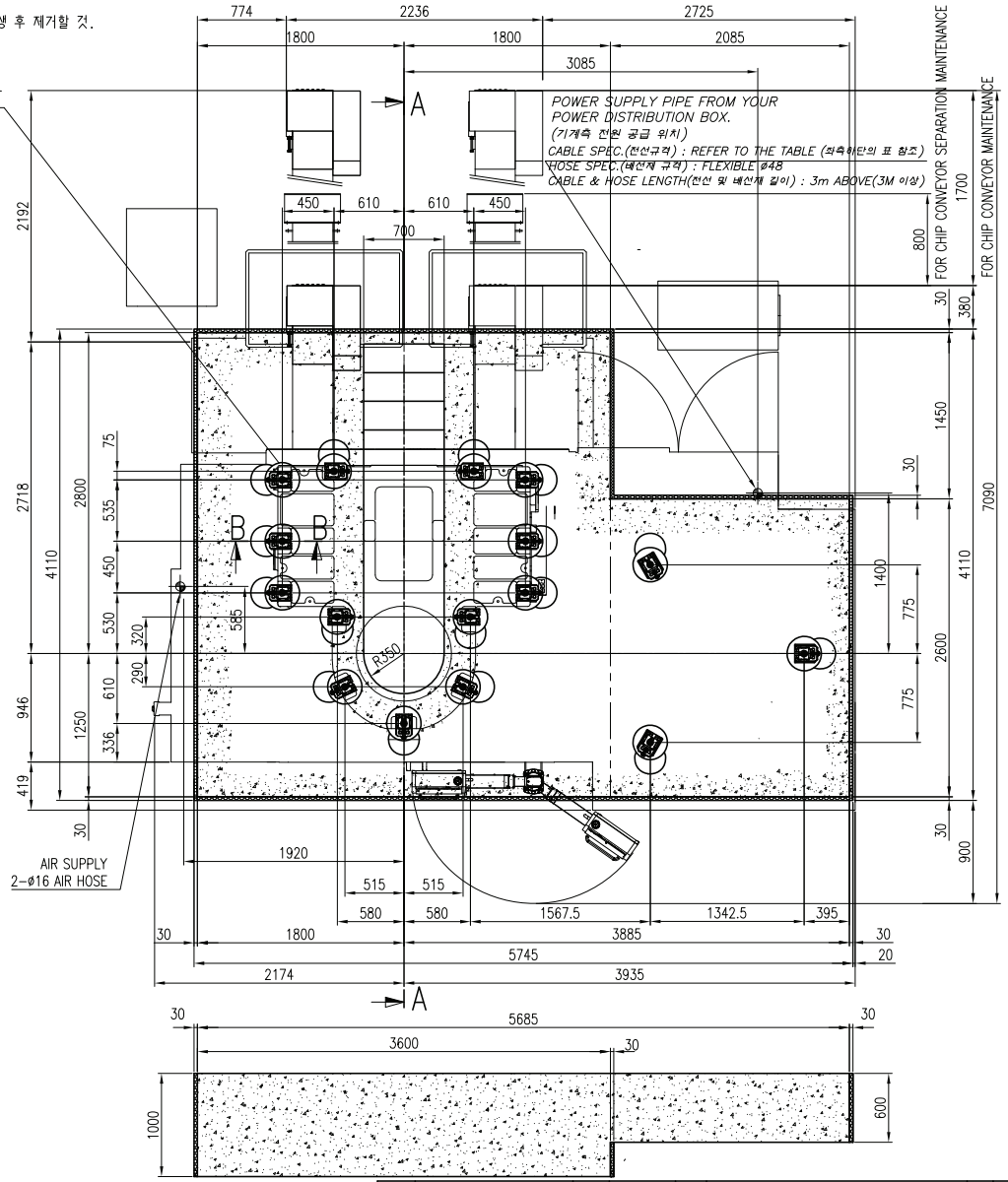
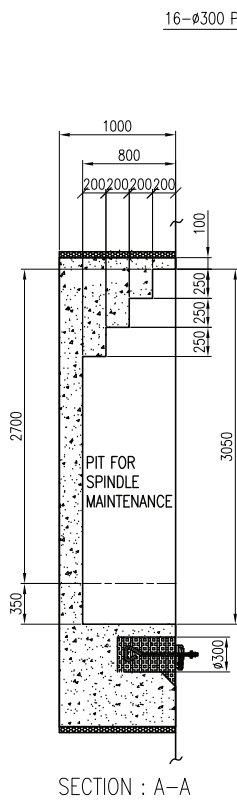
Filing with high quality rubbles and gravels and fully tamped down.  
양질의 배위와 자갈을 백백하게 다져 넣을 것.

Reinforce concrete with diagonally placed steel bars.  
철근을 직각으로 배열하여 콘크리트를 보강할 것.  
(16mm 철근을 300mm x 300mm x 300mm, 3층 배근할 것)



- 주기.
1. 기계까지의 전선배선 작업은 사용자측에서 준비하여 작업할 것.
  2. 콘크리트의 양생기간은 1개월 이상으로 할 것.
  3. 그라우트용 구멍은 ø300 주름 튜브를 사용하며, 콘크리트 작업 후 반드시 제거할 것.
  4. 그라우트는 기초 위치에 기계를 안착시키고, 가래별 작업을 완료한 후에 주입할 것.
  5. 도면에 표기된 값은 추천치입니다. 지반 상태가 나쁜 경우에는 구조 설계자를 통한 검증이 필요합니다.
  6. B26491014A 부품은 그라우트 양생 후 제거할 것.

- REMARKS
1. WIRING FROM POWER SOURCE TO THE MACHINE MUST BE PERFORMED BY CUSTOMER.
  2. CURING PERIOD OF CONCRETE SHOULD BE MORE THAN ONE MONTH.
  3. USE ø300 CORRUGATED TUBE, AND REMOVE TUBE AFTER CONCRETE.
  4. POUR GROUT AFTER POSITIONING AND PRELIMINARY LEVELING WORK.
  5. THE FOUNDATION VALUES SHOWN IN THIS DRAWING ARE REFERENCE/RECOMMENDED VALUES. IF THE SOIL CONDITION IS POOR, VERIFICATION IS NEEDED THROUGH THE STRUCTURAL DESIGNER.
  6. REMOVE B26491014A PART AFTER CURING OF GROUT.



MAIN VALUES (주요 수치)

MACHINE WEIGHT (기계 중량)	26 ton
MAX. WORKPIECE WEIGHT (최대 공작물 중량)	8 ton
BEARING OF SOIL (지내력)	10 ton/m <sup>2</sup>

TOLERANCE (허용 공차)

PLATNESS (평면도)	±10mm	
PITCH OF HOLES (구멍 간격)	SINGLE (단일)	±10mm
	ACCUMULATED (누적)	±20mm
DIMENSION OF HOLES (구멍크기)	±10mm	

CABLE SPEC. (전선규격)

Main Spindle Motor Spec. (주축 모터 사양)	Power Supply Voltage (공급 전압)	
α40/6000	95SQ	35SQ
α40/7000HV	95SQ	35SQ
α60/5000HV	70SQ+50SQ	70SQ

FOUNDATION MATERIAL (기초 재료)

CONCRETE (콘크리트)	STRENGTH (강도)	240kg/cm <sup>2</sup>
	QUANTITY (필요량)	16.7 m <sup>3</sup> (40 ton)
GROUT (그라우트)	STRENGTH (강도)	400kg/cm <sup>2</sup>
	QUANTITY (필요량)	0.56 m <sup>3</sup> (1.36 ton)

SUPPL	MRK	SUBJECT	EDN NO.	DATE	NAME	CHECKED
△x						
△x						
△x						

SURFACE FINISH		GENERAL TOLERANCE (MACHINING)		GENERAL DIMENSIONS		APPROVED		TITLE		QTY	1
OVER - 6	±0.1	GENERAL DIMENSIONS	CO.5	CHECKED	TITLE		FOUNDATION		QTY	1	
6 - 30	±0.2	TREATMENT		CHECKED	ASY		VTR1216_24[23] WHEEL MAGAZINE		WT		
30 - 120	±0.3	HARDNESS			MODEL		VTR1216[M]		SCALE	N/S	
120 - 315	±0.5	FEAT TREATMENT		DESIGNED	MNT.		김영태				
315 - 1000	±0.8	BENCH			DEL. NO.		A1				
1000 - 2000	±1.2	SURFACE TREATMENT		DRWN	REF. DRG. NO.		TD200314				
2000 - 4000	±2.0				DATE		20.09.16				

DN SOLUTIONS CHANG WON KOREA