1

2

2.1

2.2

2.3

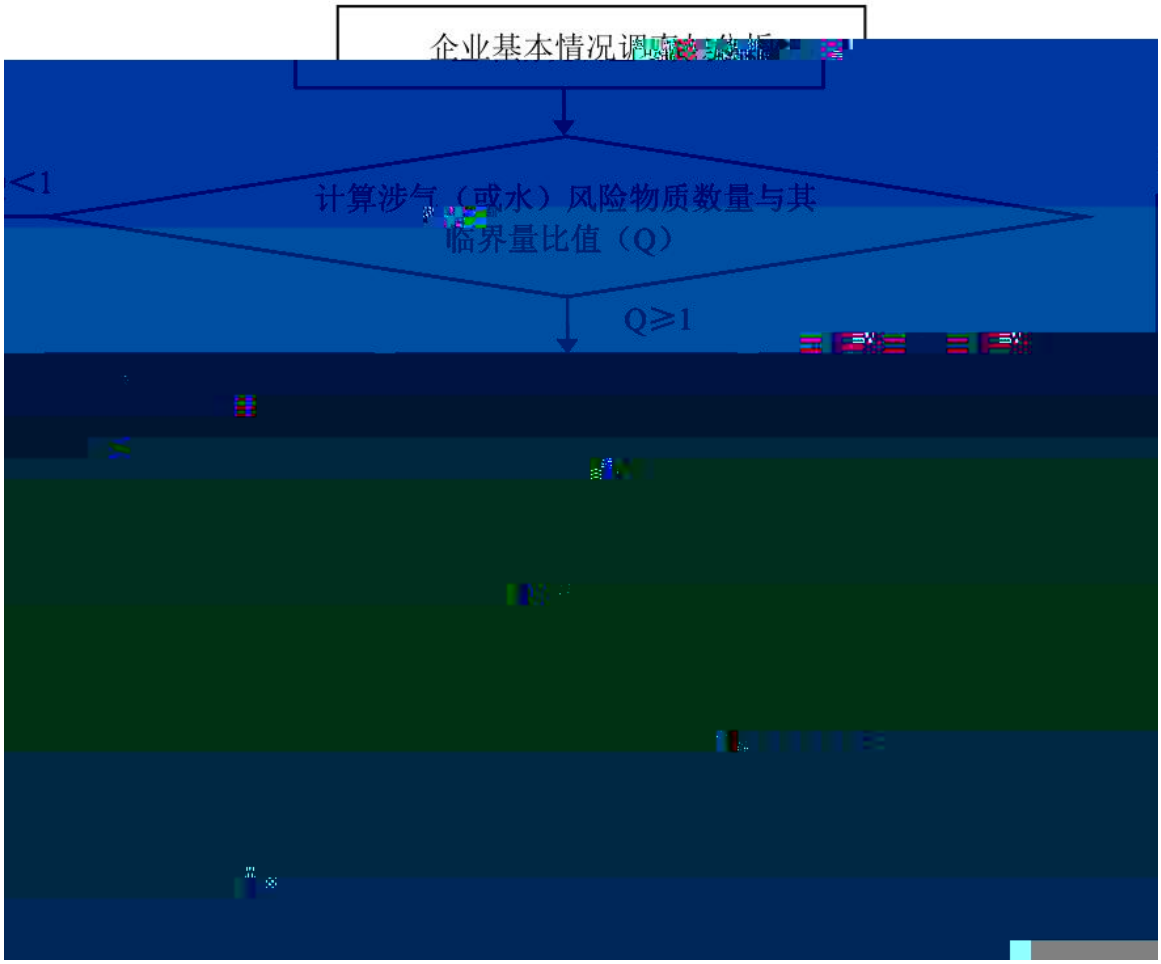
2.4

2.4.1

2.4.2

2.4.3

2.5



3

3.1

3.1.1

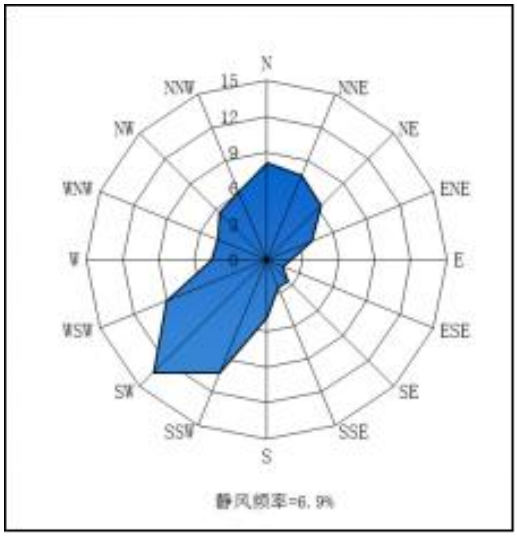
3.1.2

3.1.3

3.1.3.1

3.1.3.2

3.1.3.3



3.1.4

3.1.4.1

3.1.4.2

1

2

3

4

3-7

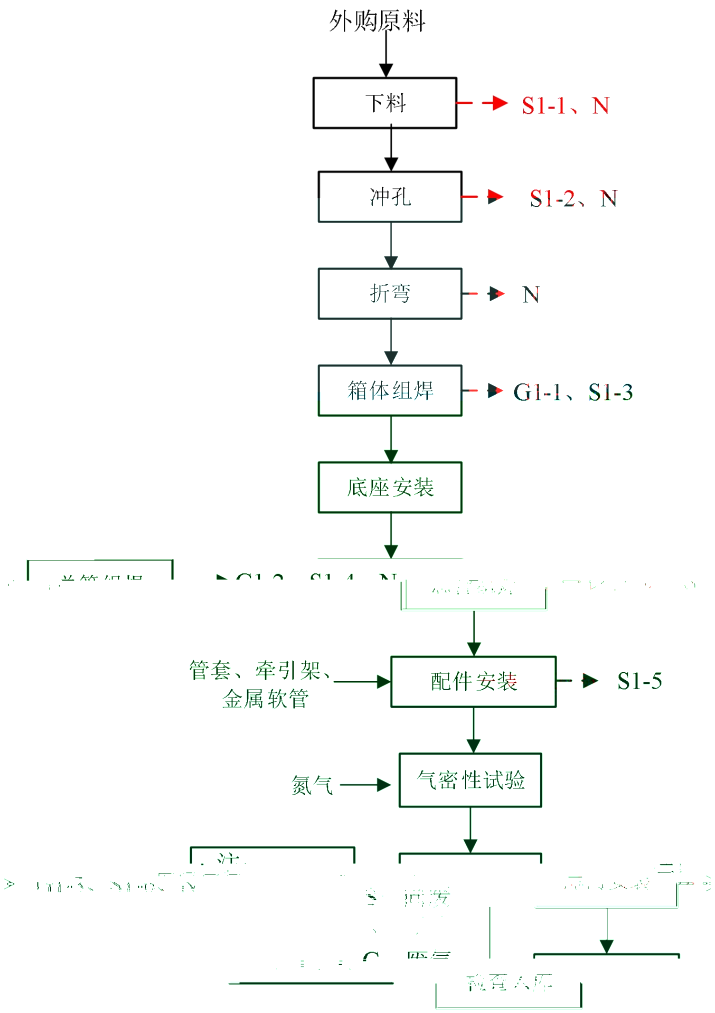
3-9

3-10

3.3.3

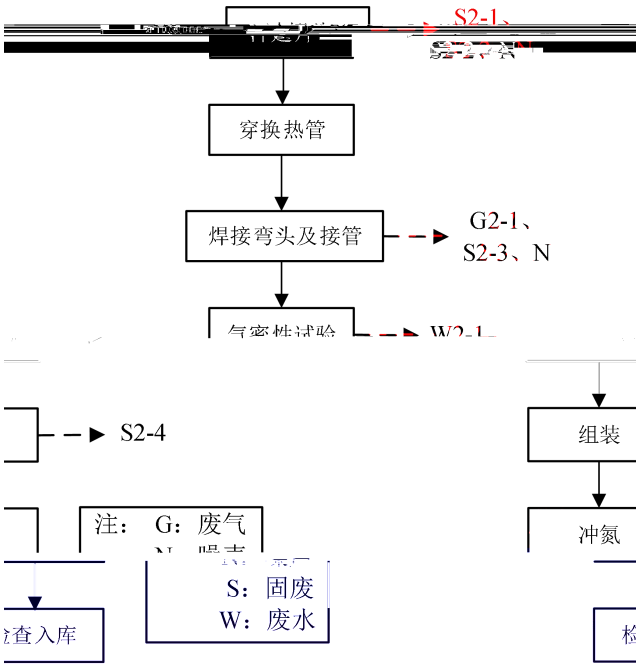
3.3.4

1


外购原料
下料
S1-1、N
冲孔
S1-2、N
折弯
N
箱体组焊
G1-1、S1-3
底座安装
管套、牵引架、
金属软管
配件安装
S1-5
氮气
气密性试验

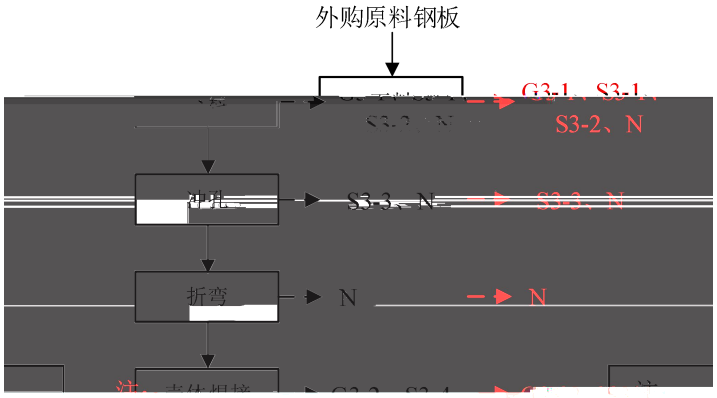
3-2

2



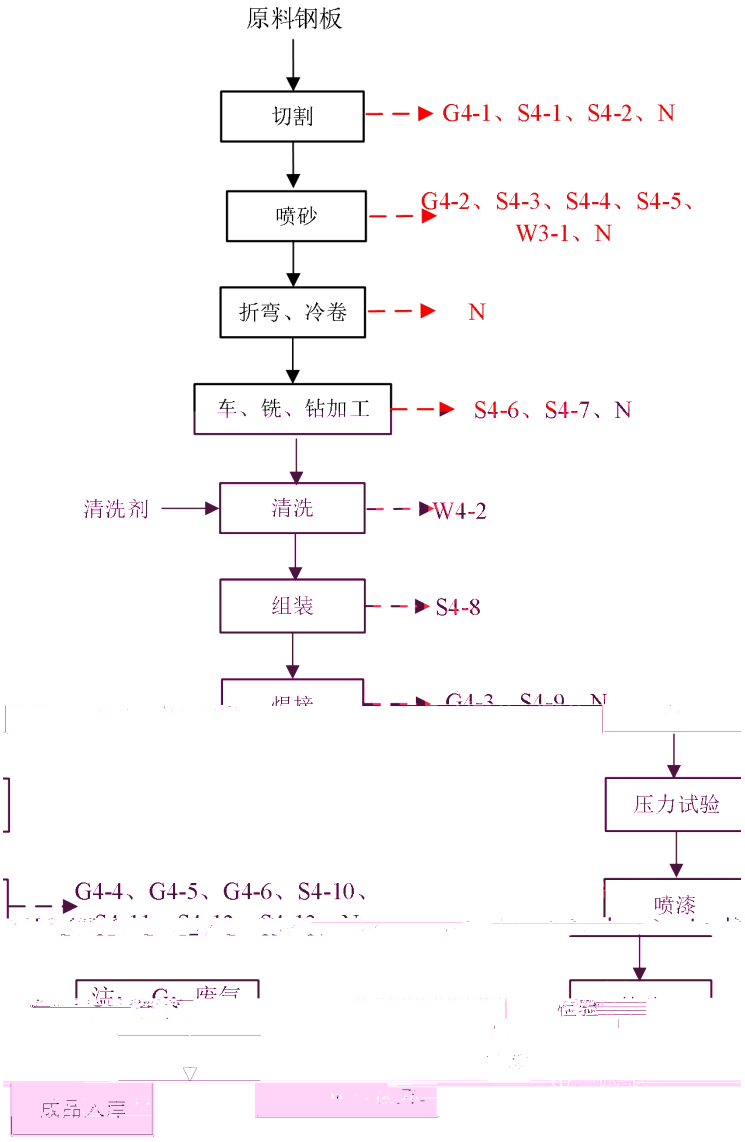
3-3

3



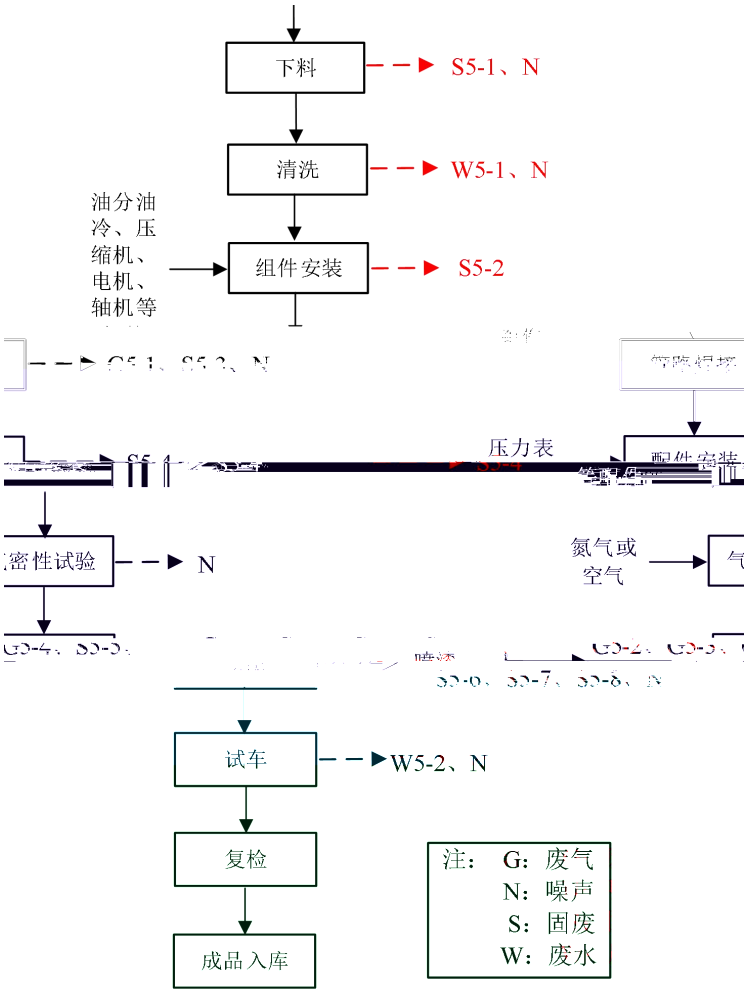
3-4

4


原料钢板
切割
G4-1、S4-1、S4-2、N
喷砂
G4-2、S4-3、S4-4、S4-5、
W3-1、N
折弯、冷卷
N
车、铣、钻加工
S4-6、S4-7、N
清洗剂
清洗
W4-2
组装
S4-8
压力试验
G4-4、G4-5、G4-6、S4-10、
喷漆

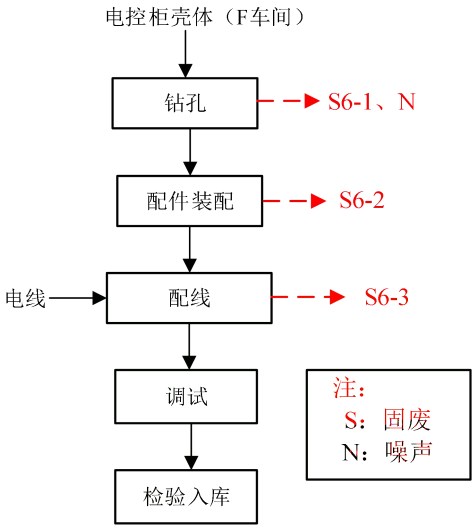
3-5

5


下料
S5-1、N
清洗
W5-1、N
油分油冷、压缩机、电机、轴机等
组件安装
S5-2
压力表
密性试验
N
氮气或空气
试车
W5-2、N
复检
成品入库
注：
G：废气
N：噪声
S：固废
W：废水

3-6

6



3-7

7

3-12

3.4

3.4.1

3.4.2

3-13

3.5

	237	MPa		6.08	
	LD 501600 2000mg/kg( ) LC 5056.2g/m 3 8 ( ) 67.4g/m 3×67 20 50ml 100 150ml 2.9 4.0g/m 3 20 4.69g/m 3,8 / 75				

Fw>

$$\frac{dm}{dt} = \frac{0.001H_c}{C_p(T_c - T_0) + H}$$

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