

0020900DL	(도면번호) DWG NO.	ON GMD	표면거칠기 SURFACE ROUGHNESS	적용 규정 APPLIED PRACTICES	가공일반공차 GENERAL TOLERANCE ON MACHINED DIMENSIONS	선형치수 LINEAR DIMENSIONS		각도 ANGLE		전직도 STRAIGHTNESS		NO.	DESCRIPTION	MATERIAL	SIZE, DWG. NO.	Q'TY	WT. (kg)		REMARK
			6.3/√	ISO 2768-mk		기준치수 (mm) DIMENSION RANGE (D.R.)	허용공차 (mm) TOLERANCE	기준치수 (mm) DIMENSION RANGE (D.R.)	허용공차 (mm) TOLERANCE	기준치수 (mm) DIMENSION RANGE (D.R.)	허용공차 (mm) TOLERANCE								
						D.R. ≤ 120	±0.2	D.R. ≤ 10	±1°	D.R. ≤ 300	0.4								
						120 < D.R. ≤ 400	±0.5	10 < D.R. ≤ 50	±0° 30'	300 < D.R. ≤ 1000	0.6								
						400 < D.R.	±0.8	50 < D.R.	±0° 20'	1000 < D.R.	0.8								

BOLT SIZE	TORQUE RANGE			
	N-M		IN-LB	
	MIN	MAX	MIN	MAX
M2	0.17	0.18	1.5	1.6
M2.5	0.34	0.38	3.0	3.4
M3	0.6	0.66	5.3	5.8
M4	1.43	1.58	12.7	14.0
M5	2.85	3.15	25.2	27.9
M6	4.94	5.46	43.7	48.3
M8	11.9	13.1	105	116
M10	23.3	25.7	206	227
M12	39.9	44.1	353	390
M14	64.6	71.4	572	632
M16	101	111	894	982
M20	194	214	1717	1894
M24	342	378	3027	3345
M30	665	735	5885	6505
M36	1178	1302	10425	11523
M42	1900	2100	16815	18585
M48	2803	3098	24807	27417
M52	3610	3990	31949	35312
M56	4560	5040	40356	44604
M64	6840	7560	60534	66906

BOLT SIZE	TORQUE RANGE			
	IN-LB		N-M	
	MIN	MAX	MIN	MAX
#10-32	20	22	2.3	2.5
1/4"-20	38	42	4.3	4.7
5/16"-18	78	86	8.8	9.7
3/8"-16	150	165	16.9	18.6
7/16"-14	230	253	26	28.6
1/2"-13	360	396	40.7	44.7
9/16"-12	500	550	56.5	62.1
5/8"-11	700	770	79.1	87.0
3/4"-10	1300	1430	147	162
7/8"-9	2000	2200	226	249
1"-8	3000	3300	339	373
1 1/8"-8	4600	5060	520	572
1 1/4"-8	6600	7200	746	814
1 3/8"-8	9000	9900	1017	1119
1 1/2"-8	12000	13200	1356	1491
1 5/8"-8	14400	15900	1628	1796
1 3/4"-8	18288	20100	2066	2271
2"-8	27900	30600	3152	3457
2 1/4"-8	40500	44700	4576	5051
2 1/2"-8	47748	52764	5395	5962
2 3/4"-8	64116	70860	7245	8007
3"-8	83700	92508	9458	10453

NOTES

1. TORQUE TABLE은 TURBINE BEARING에만 적용함.
2. ELLIPTICAL LINER BEARING HOLD BOLT 토크는 203~271N-m를 적용함.
1. TORQUE TABLE SHOULD BE APPLIED ONLY FOR TURBINE BEARING.
2. ELLIPTICAL LINER BEARING HOLD BOLT TORQUE IS 203~271N-m.

△	방경남	2017.05.15	이정재	2017.05.15	이영주	2017.05.15						
REV (기판)	NAME (성명)	DATE (일자)	NAME (성명)	DATE (일자)	NAME (성명)	DATE (일자)						
	PREPARED BY (제도)		REVIEWED BY (검도)		APPROVED BY (승인)							
PROJECT (공사업)												
DOOSAN Doosan Heavy Industries & Construction												
THIS DRAWING IS THE PROPERTY OF DOOSAN HEAVY INDUSTRIES & CONSTRUCTION CO., LTD. CHANG-WON, KOREA, AND IS NOT TO BE REPRODUCED OR USED TO FURNISH ANY INFORMATION FOR MAKING OF DRAWING OR APPARATUS EXCEPT WHERE PROVIDED FOR BY AGREEMENT WITH SAID COMPANY.												
PROJ (부호)	3000-002-02	TITLE (도명) BOLT TORQUE TABLE										
UNIT (단위)	mm											
SCALE (배수)	N/S											
ITEM NO. (분류번호)		DWG NO (도면번호) TD0060700			REV (기판)	SHEET (장)						
전면개정 DESCRIPTION OF REVISION (개정사유)					B	1/1						