



- Technique requirement
1. All welding seams must be plump and symmetrical, welding angle's highness should be full, no welding defects like gas hole etc.
 2. Using a proper way to avoid the deformity during the assemble welding.
 3. All rotatable position must be rotate flexible.
 4. Can select the more high intensity material base on the require material grade, but must have the good welding capability ($Ceq \leq 45$).
 5. All steel plate's thickness and all dimension tolerance must be controlled ($\pm 4\%$).
 6. The selected welding rods must be suited the maternal material.
 7. Must carry out the stress remove heat-treatment after the welding. ($620 \pm 20^\circ C$).
 8. Anchor can be fitted U type shackle or swivel shackle. If fitted swivel shackle the anchor shank's length will be shorten 10%, but the anchor's actual weight should comply with the class rule.

12	LZS02-011-100~20000-12	卸扣转环 SWIVEL SHACKLE	1	U ₂						2	LZS02-011-100~20000-2	主轴 HEAD PIN	1	U ₂					
11	LZS02-011-100~20000-11	卸扣 SHACKLE	1	ZG200-400orU ₂						1	LZS02-011-100~20000-1	锚杆 SHANK	1	ZG200-400					
10	LZS02-011-100~20000-10	包角板 SIDE PLATE	4	Q235orGrade A						序号	代号	名称	数量	材料	单件重量	总计重量	备注		
9	LZS02-011-100~20000-9	吊耳轴 LIFT EYE PIN	1	U ₂															
8	LZS02-011-100~20000-8	吊耳 LIFT EYE	1	Q235orGrade A													图号 DRAWING NO.		
7	LZS02-011-100~20000-7	六角侧板 HEXAGON SIDE PLATE	2	Q235orGrade A						标记	处数	更改文件号	签字	日期			LZS02-011-100~20000		
6	LZS02-011-100~20000-6	三角板 TRIANGLE PLATE	2	Q235orGrade A						设计	俞德君						逆样标记	重量(Kg)	比例
5	LZS02-011-100~20000-5	筋板 STIFFENER PLATE	2	Q235orGrade A						校对									
4	LZS02-011-100~20000-4	定位块 POSITION PLATE	1	Q235orGrade A						审核									
3	LZS02-011-100~20000-3	五角板 PENTAGONAL PLATE	2	Q235orGrade A						批准	2006.6.12						共 46 张		第 1 张

DZ三角型大抓力锚装配图
ASS OF DZ DELTA TYPE H. H. P ANCHOR