PAYVAND CHOKLARNI BELGILANISHI

Payvand chokning old va orka tomoni bo`ladi. Bir yoklama chokning old tomoni qilib, payvandlanadigan tomoni kabul qilinadi, bu tomonining orqasi esa chokning ko`rinmas yoki orqa tomoni deyiladi.

Qirralari simmetrik kilib tayyorlanmagan ikki yokli chokning old tomoni qilib payvandlash bajariladigan tomoni qabul qilinadi.

Qirralari simmetrik ravishda tayyorlanadigan ikki yoklama chokning old tomoni kilib, xohlagan tomonini qabul qilish mumkin.

Chokning shartli belgisi chok tasvirining old tomonidan chizilgan chetga chikarish chizigining tokchasiga quyiladi. Bunda beliglar kurinadigan choklar uchun tokchaning ustiga, kurinmas choklar uchun esa tokchaning ustiga quyiladi.

Chok belgisida quyidagi ma`lumotlar (bu ma`lumotlar shakldagi to`rt burchakliklar ichiga yoziladi) bulishi lozim:

1. Chokning yopik chizik buyicha joylashishini ifodalovchi belgi yoki montaj chokining belgisi (2- jadval).

2. Chokning turi (tipi) konstruktiv elementlarini kursatuvchi standart belgisi.

3. Tegishli standart buyicha chokning harfiy-sonli belgisi (1- jadval). Chokning darfiy-sonli belgisidagi harflar: G — uchma-uch chokni; U — burchakli chokni; T —tavr shaklidagi chokni. N — ustma-ust chokni bildiradi. Sonlar esa shu turdagi chok detallarining qanday ulanishini bildiradi.

4. Payvandlash usulining shartli belgisi. Standart buyicha chokning pay-vandlash usullari harflar bilan qo`yidagicha belgilanadi: A — avtomatiq. P — yarimavtomatiq R — elektr yoyi bilan kulda; K — kontaktlab elektrik, payvandlash; SH —elektrshlak usulida;. e—elektrik parchinlash (masalan: EFZ —flyus ostida); IN—inert gazi shtirokida vol'fram elektrod bilan payvandlash matyeriali ishlatmay payvandlash.

Payvandlash turi va metodining yana quyidagi sharfli belgilari mavjud: G — gazaviy; E — elektr yoyi bilan; F —flyus ostida elektr yoyi bilan; Z —himoya gazi muhitida elektr yoyi bilan; KT — kontaktlab; Uz —- ul'tra tovush bilan; Tr —ishkalanish bilan; X — yurgizish bilan; Pz — plazmali yoy bilan; el — elektron

Chizmachilik.uz

nurli; Df — diffuzion; Lz—lazer bilan; Bz — portlatish bilan; I — indukqion; Gp— gazaviy presslab; Tm —termit bilan.

5. Chok kateti belgisi va katet ulchamlari. Bu belgi ingichka chiziklar bilan chizilib, balandligi chok belgisidagi sonlarning balandligiga teng bulishi lozim.

6. quyidagi ulchamlari: a) uzuq-uzuq chok uchun payvandlanadigan joyining umumiy uzunligi (/ yoki Z belgi) va chok kadamining ulchami; b) yakka payvand nuktalari uchun nuktaning hisoblab olingan diametrining ulchami; g) kontaktlab nuktaviy elektrik payvand yoki elektrik parchinlash choki uchun nuktaning yoki parchinning hisobiy ulchami; / belgi va kadamining ulchami; g) kontaktlab rolikaviy elektrik payvand chok uchun chok enining xisobiy ulchami; d) uzuk-uzuk kontaktlab rolikaviy elektrik payvand chok uchun chok enining xisobiy ulchami, kupaytirish belgisi, payvandlanadigan kiem uzunligi- ning ulchami. / belgi EE kadamining ulchami.

1-jadval

Chok nomi	Bajarilgan chok ko`ndalang kesimi- ning shakli	Harfli sonli belgisi	Chizmada chokning shartli belgilanishi		
			ust tomoni	Bajarilgan chok ko`ndalang kesimi- ning shakli	Xarfli sonli belgisi

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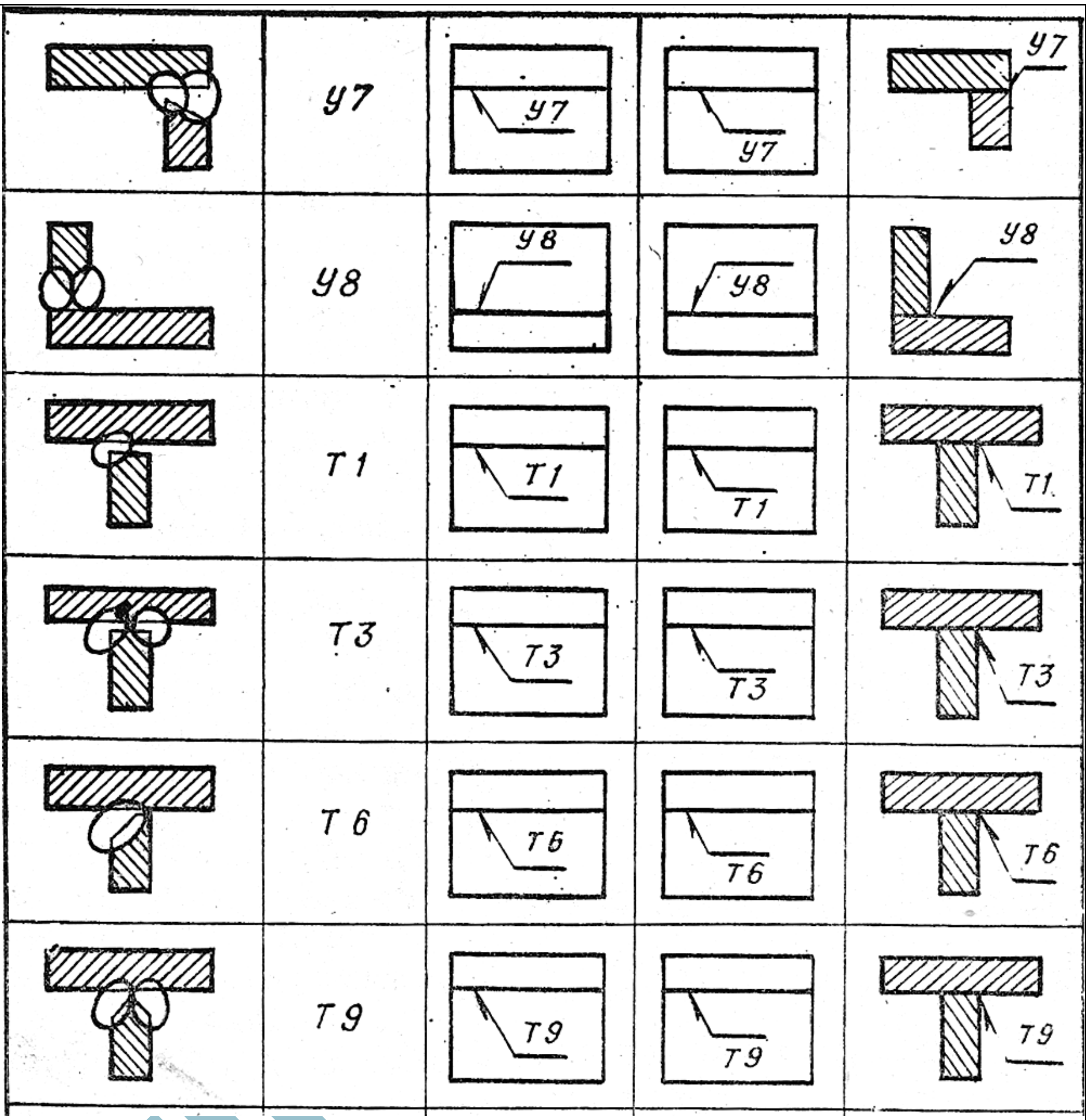
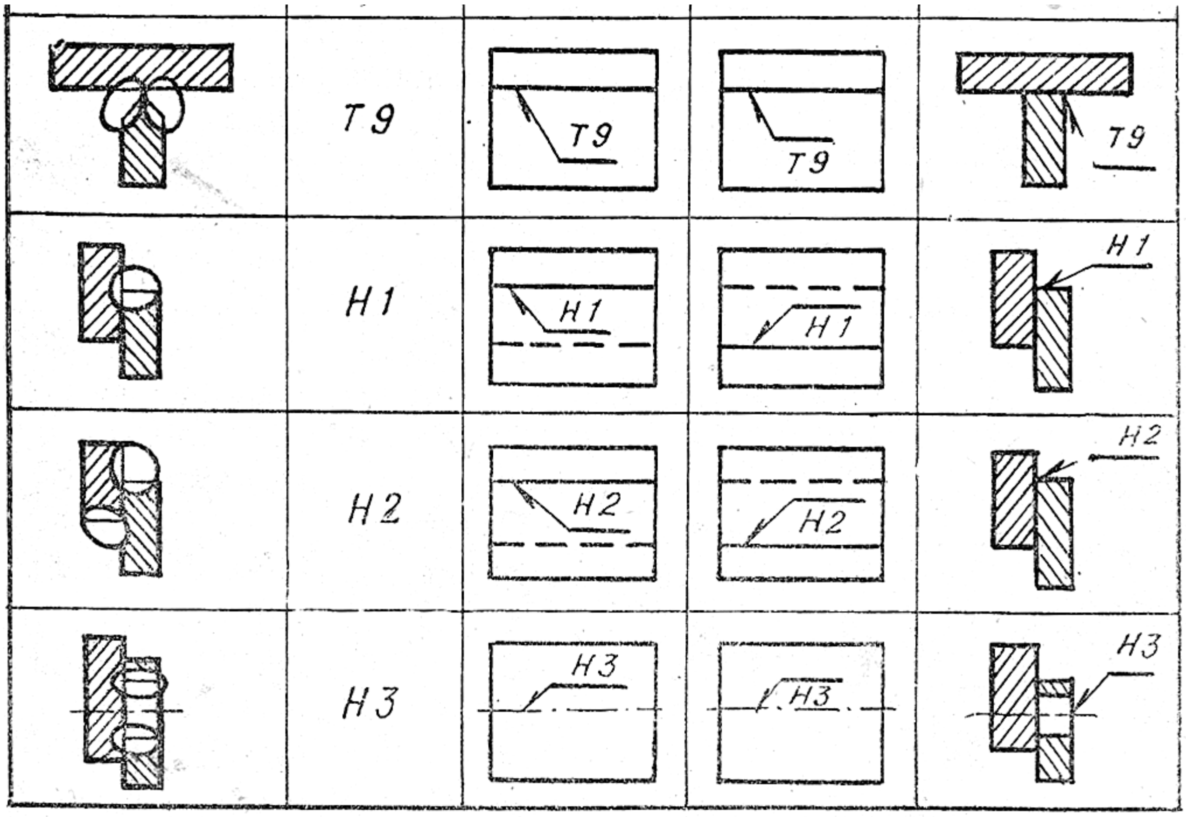
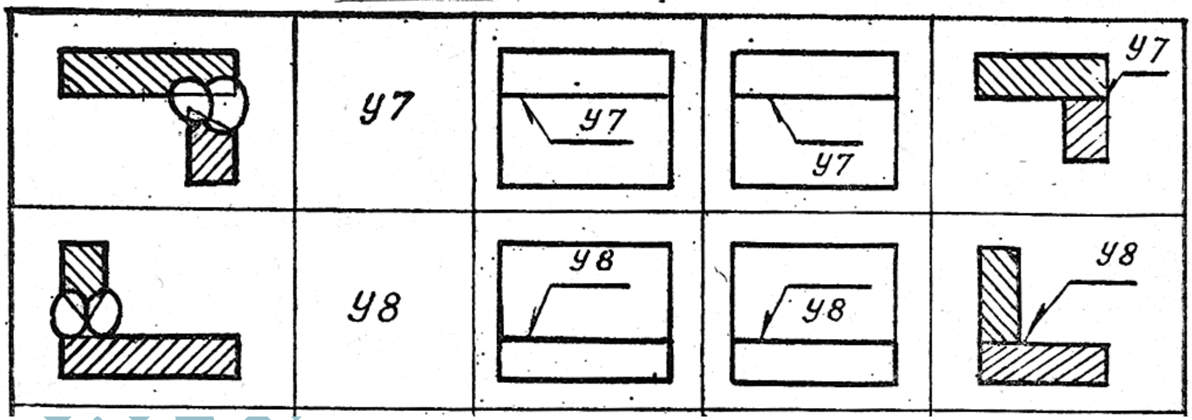
Uchma-uch	

Burchakli	
Burchakli	

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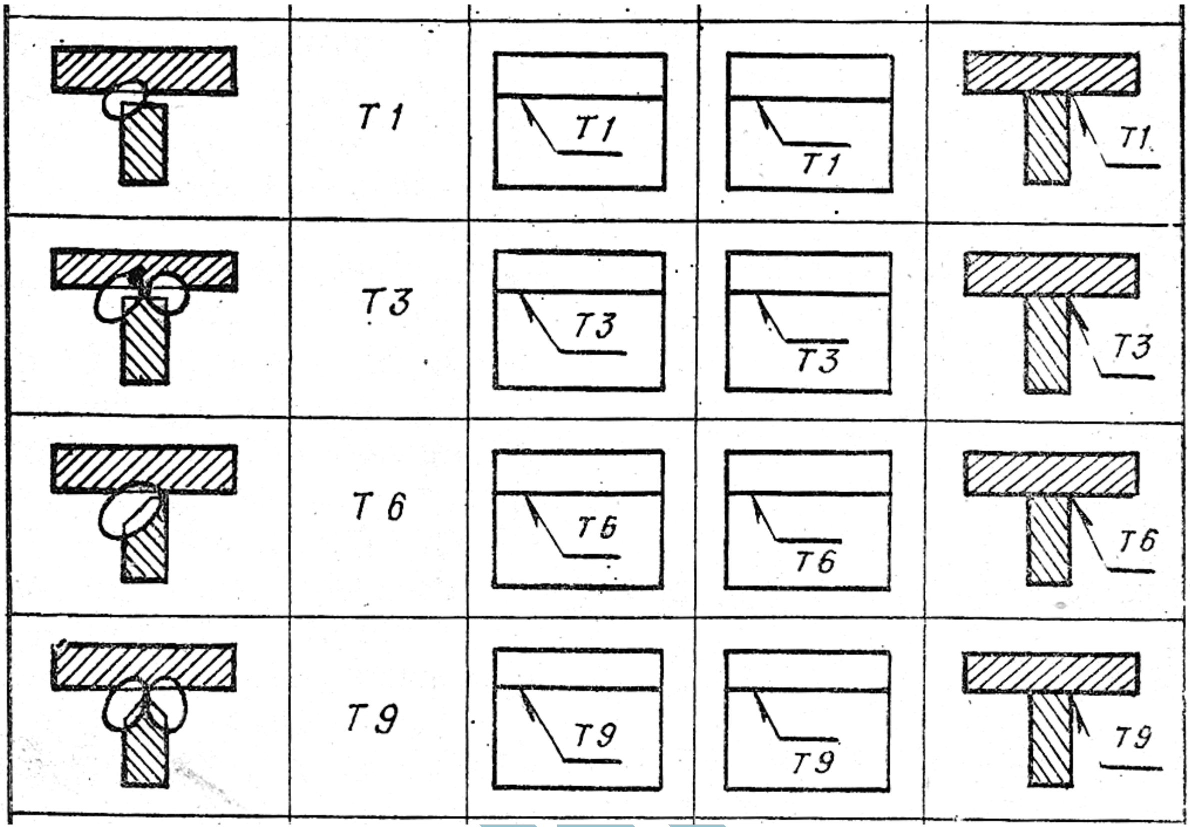
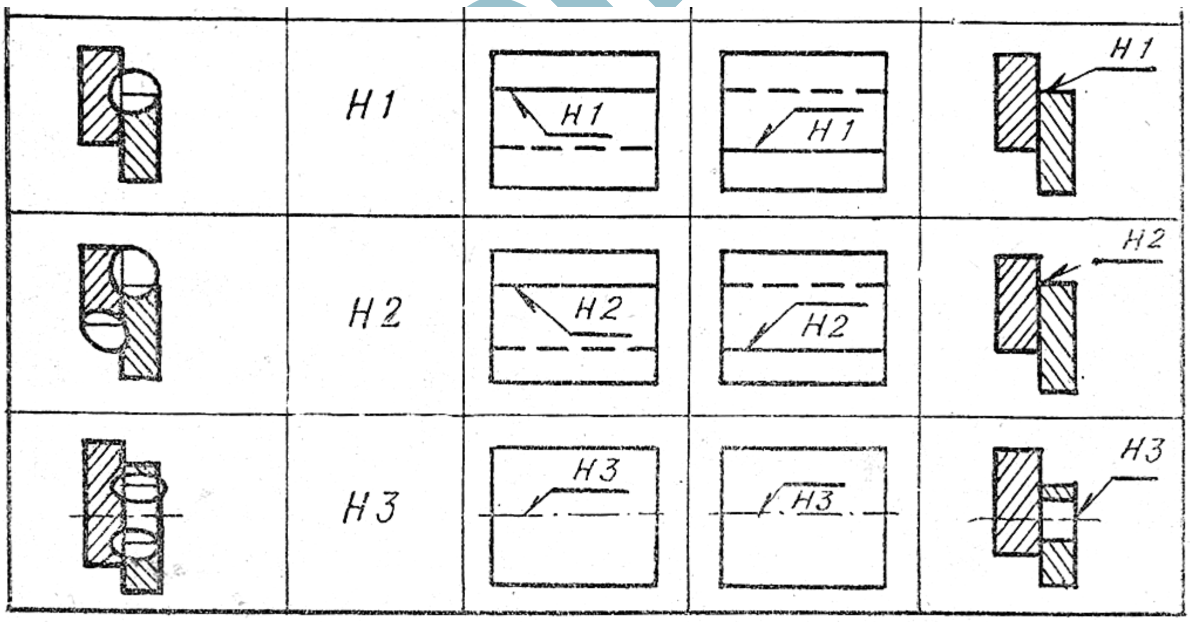


Ustma-ust



Qo`shimcha belgilar (2 jadvalga qarang). Belgilashda yuzanyng gadir-bu-durlik darajasi eng oxirida qo`yiladi.

7- shakl, ada sim elektrod yordamida elektr-shlak usulida payvandlash yuli bilan bajarilgan, chetlari yunilgan burchakli birikmaning shartli belgi- lanishi, 7- shakl, b da esa shu chokni o`quv chizmalarida tavsiya etiladigan belgilanishi ko`rsatilgan.

Agar chizmada bir necha xil choklar tasvirlangan bulsa, u holda shartli belgi fakat bitta chok tasviriga qo`yiladi, dolgan bir xildagi choklar tasviridan esa tokchali chetga chiqarish chiziqlari utkaziladi. Bunda bir xil hamma choklar uchun bitta tartib nomyeri belgilanadi va 8-shaklda ko`rsatilgandek qo`yiladi.

Agar chizmada hamma choklar bir xil va bir tomoni bilan tasvirlangan bulsa, bunday choklarga tartib nomerlari belgilanmaydi va bir chokning belgisi qo`yilib, kolganlaridan tokchasiz chetga chiqarish chizihlari chikariladi(7- shakl). Chizmada gramma choklar bir xil bo`lganda, iayvand choklarga oid ko`rsatmalarni texnikaviy talablarda yozuv bilan kursatish mumkin, bunda payvandlash joyi, payvandlash usuli, chokning turi va chok zexlarining konstruktiv strelka bilan tugallanadigan chiqarish elementlarining ulchamlari va choklarining joylashishi, to`g`risidagi ma`lumotlar byeriladi.

Buyum yoki uzelning barcha choklari bir xil payvandlash turi vausuli bilan bajarilsa, ularning harfiy belgilari asosiy belgilashda har bir chokning belgisida kursatilmasdan, balki bu turrida texnikaviy talablarda kursatma byeriladi. Payvand birikma chokining asosiy shakl). belgisi chokni ko`rsatuvchi bir tomonli strelka bilan tugallanadigan chiqarish chizig`iga tutashgan gorizontal chiziq (tokcha) ustiga yoki ostiga yoziladi (1-jadval),

Payvandlab ishlanadigan uzelning ish chizmasini bajarishda, odatda, shu uzelga kiruvchi hamma detallarning chizmalari alohida-alohida chiziladi va uzel chizmasida payvandlash .uchun hamda ularga ishlov byerish uchun zarur buladigan ulchamlargina ko`rsatiladi (9-shakl).

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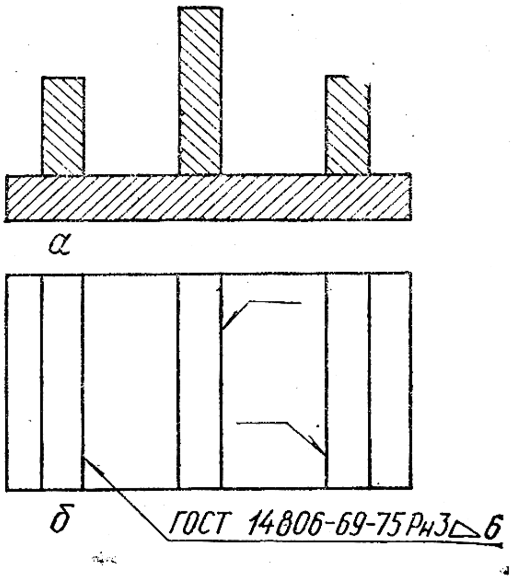
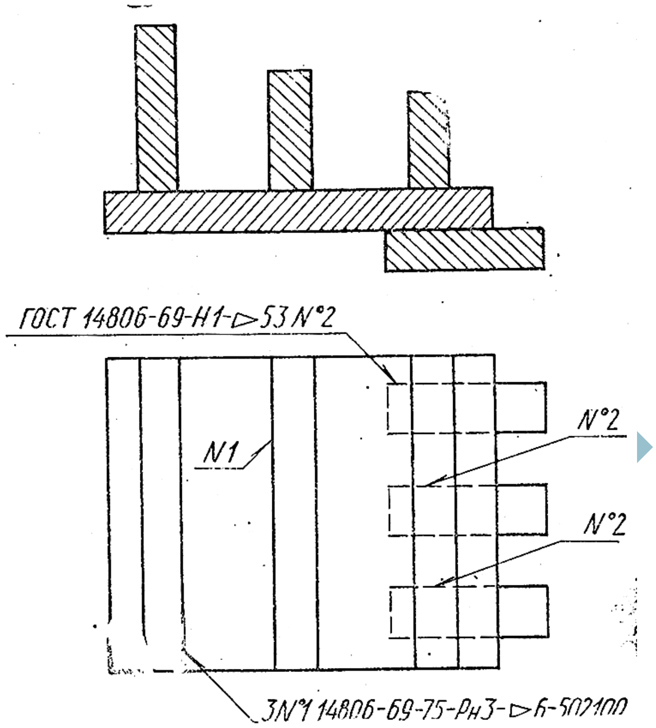
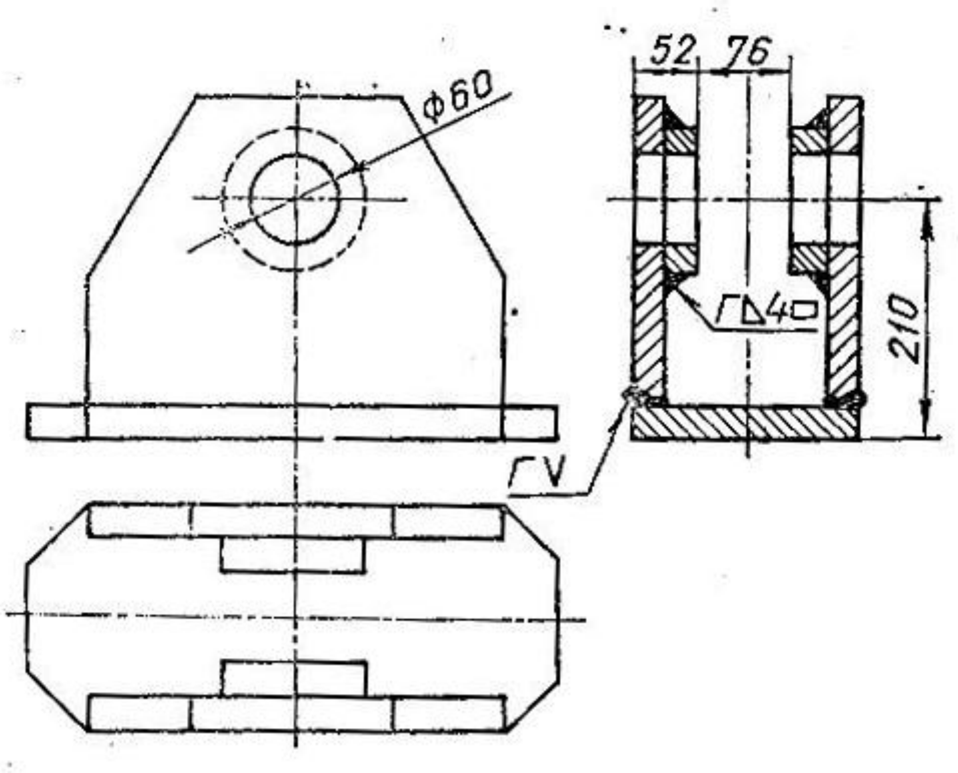


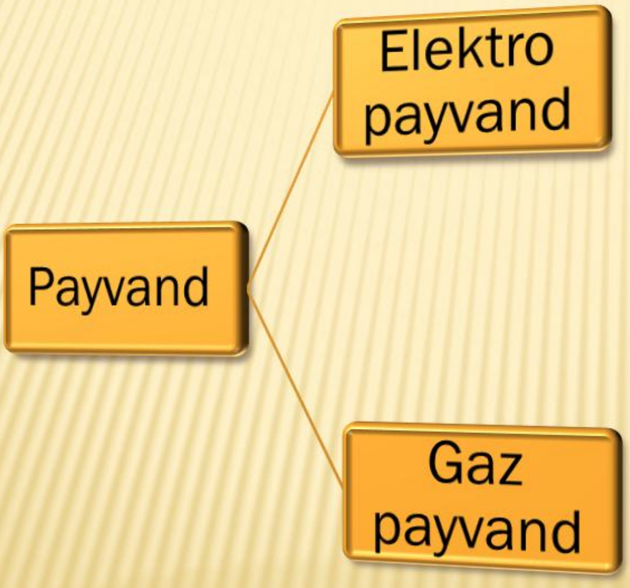
7-shakl



8-shakl



9-shakl



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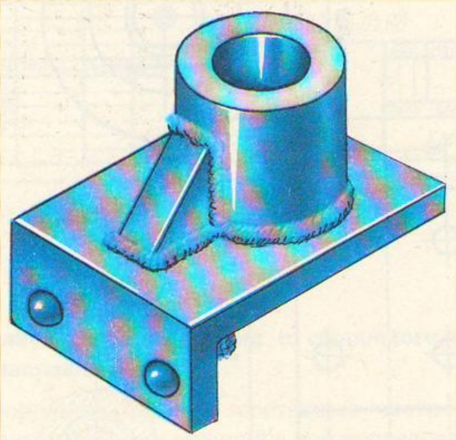

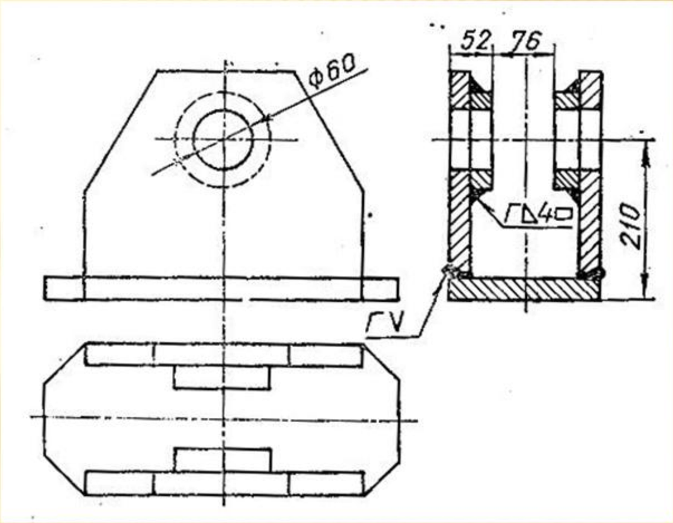

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