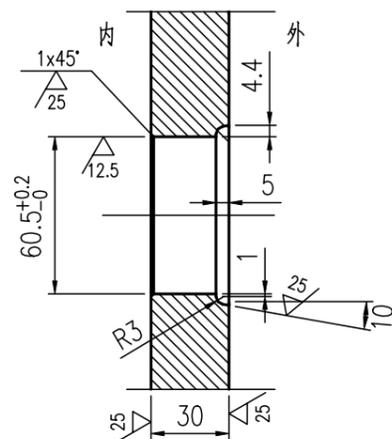


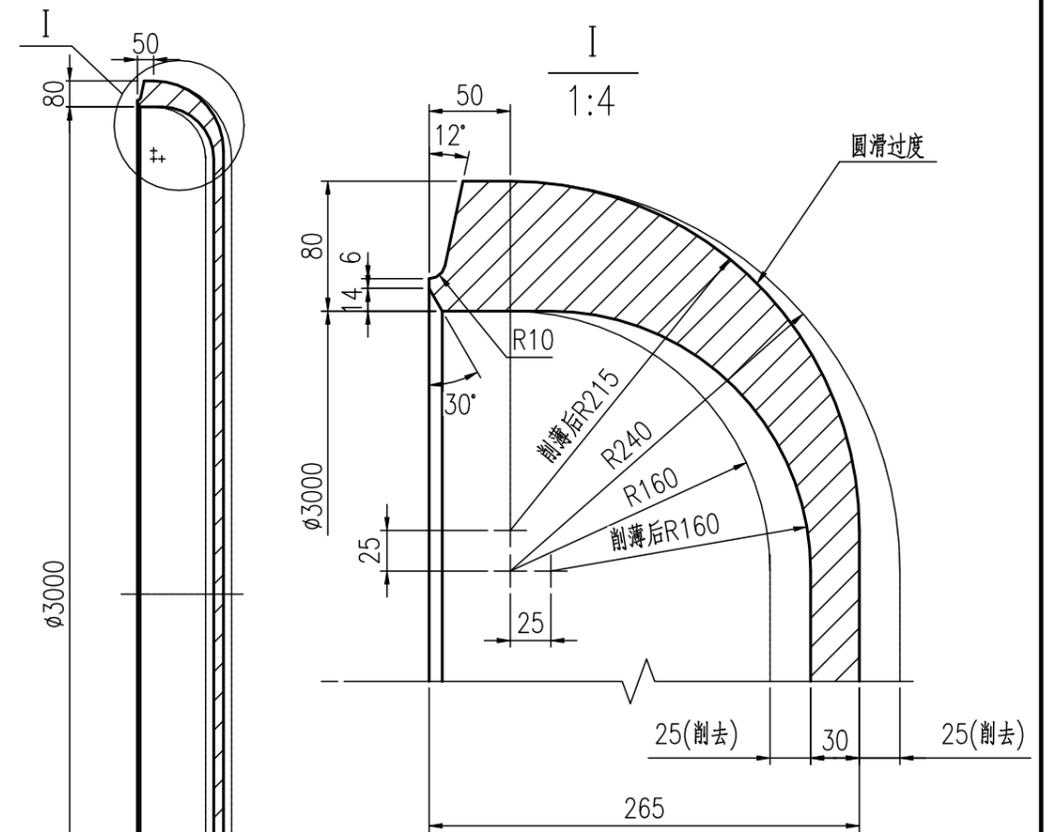
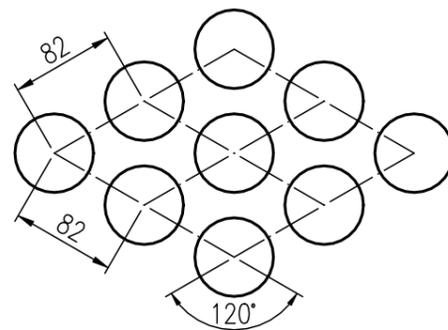
**∅60.5开孔详图**  
DRILLING DETAIL

1:2



**管孔排列详图**  
ARRANGE DETAIL

1:4



技术要求:

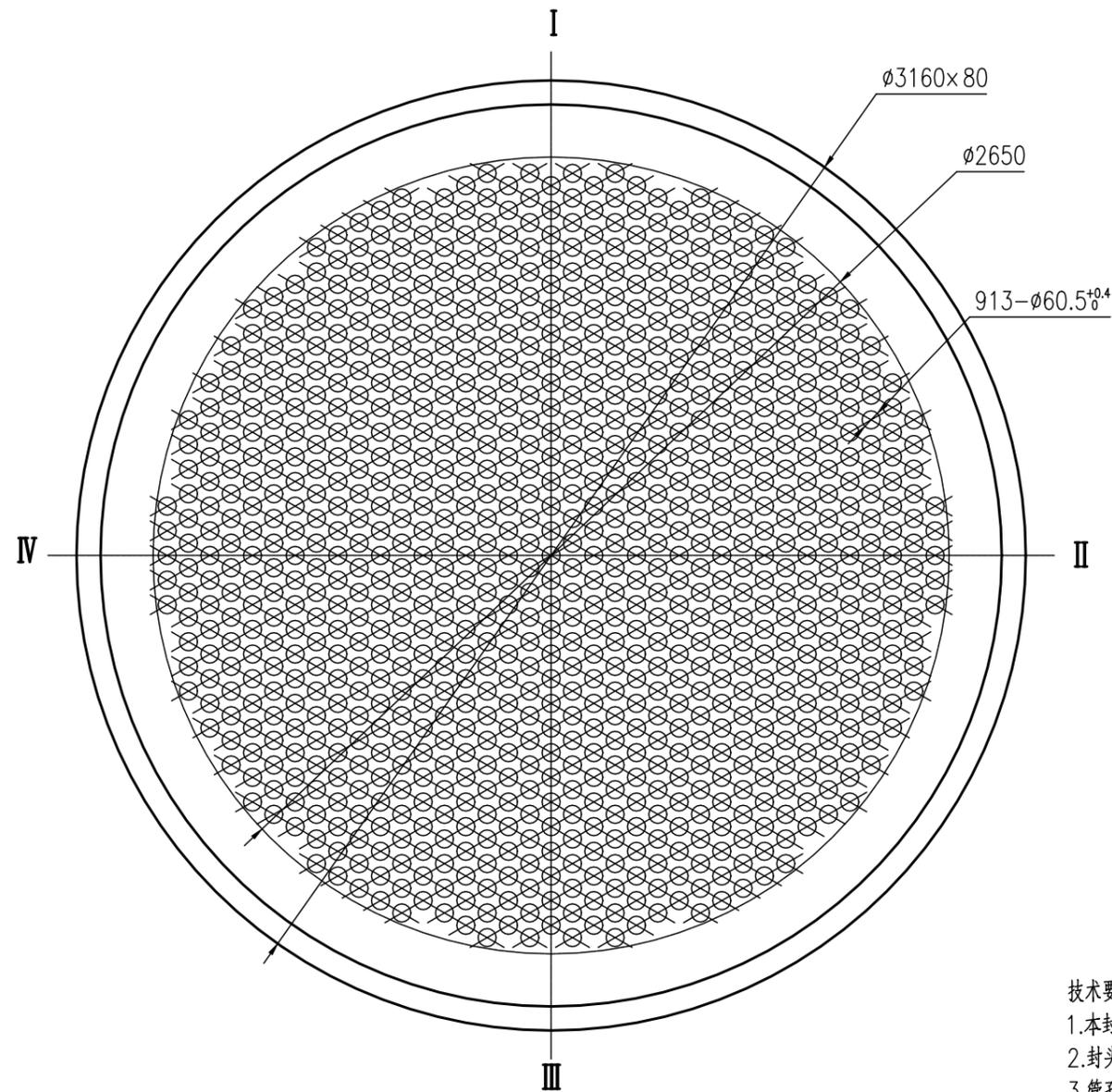
- 1.本封头采用整板热压成型,不允许拼接。
- 2.封头同一断面直径差值不大于1.5mm,内径偏差为 $\pm 5$ mm,削薄前管板平面度不大于10mm。
- 3.管孔划线偏差不得大于1.50mm,钻孔之前应经过签名验收手续。
- 4.钻孔需要与后管板、隔板一起配钻。

Technical Notes:

- 1.This header shall be formed by hotcompacting. It's fobidden to made of parts.
- 2.Differential length of radius at same cross-section shall be less than 1.5mm. The allowable tolerance of inside diameter shall be controled in  $\pm 5$ mm. The plane measure of header shall be less than 10 mm.
- 3.The allowable toerance of all the lines that connect collinear central points from head to end will be less than 1.50mm.
- 4.The drilling must be matched with the rear tube sheet and the partition plate.

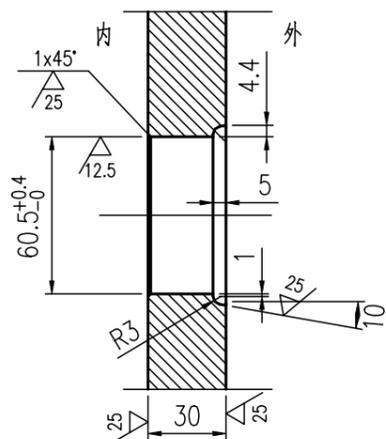
					江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.		
					P355GH/BS/EN10028.2 前平管板 ID3000 t=80		
					FRONT TUBESHEET		
MARK 标记	TOTAL NO. 总数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次
DESIGN 设计	李学亮	2026.1.12	TECH REVIEW 工艺		3350	1:20	0
CHECK 校对	苏杰	2026.1.12	APPROVE 批准				
REVIEW 审核					TOTAL-PAGES 共 张	No.-PAGE 第 张	11SCG2506-2-2

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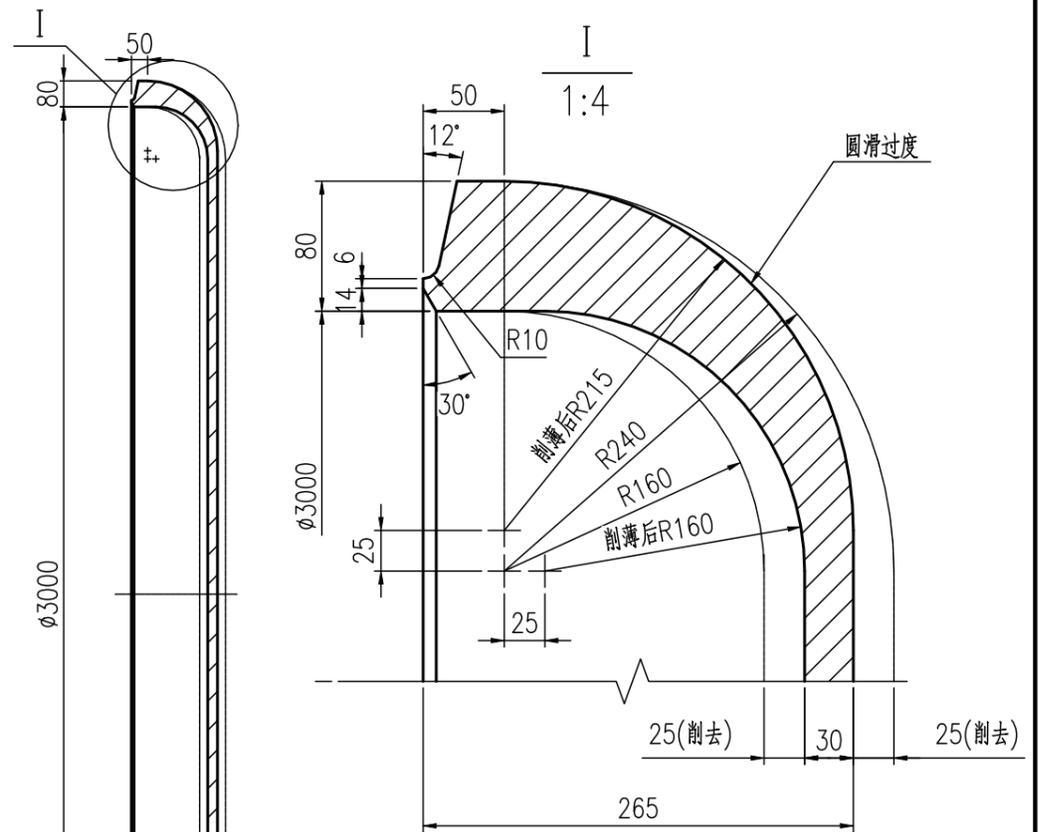
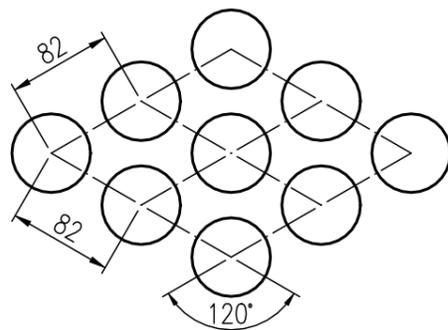
Ø60.5开孔详图  
DRILLING DETAIL

1:2



管孔排列详图  
ARRANGE DETAIL

1:4



技术要求:

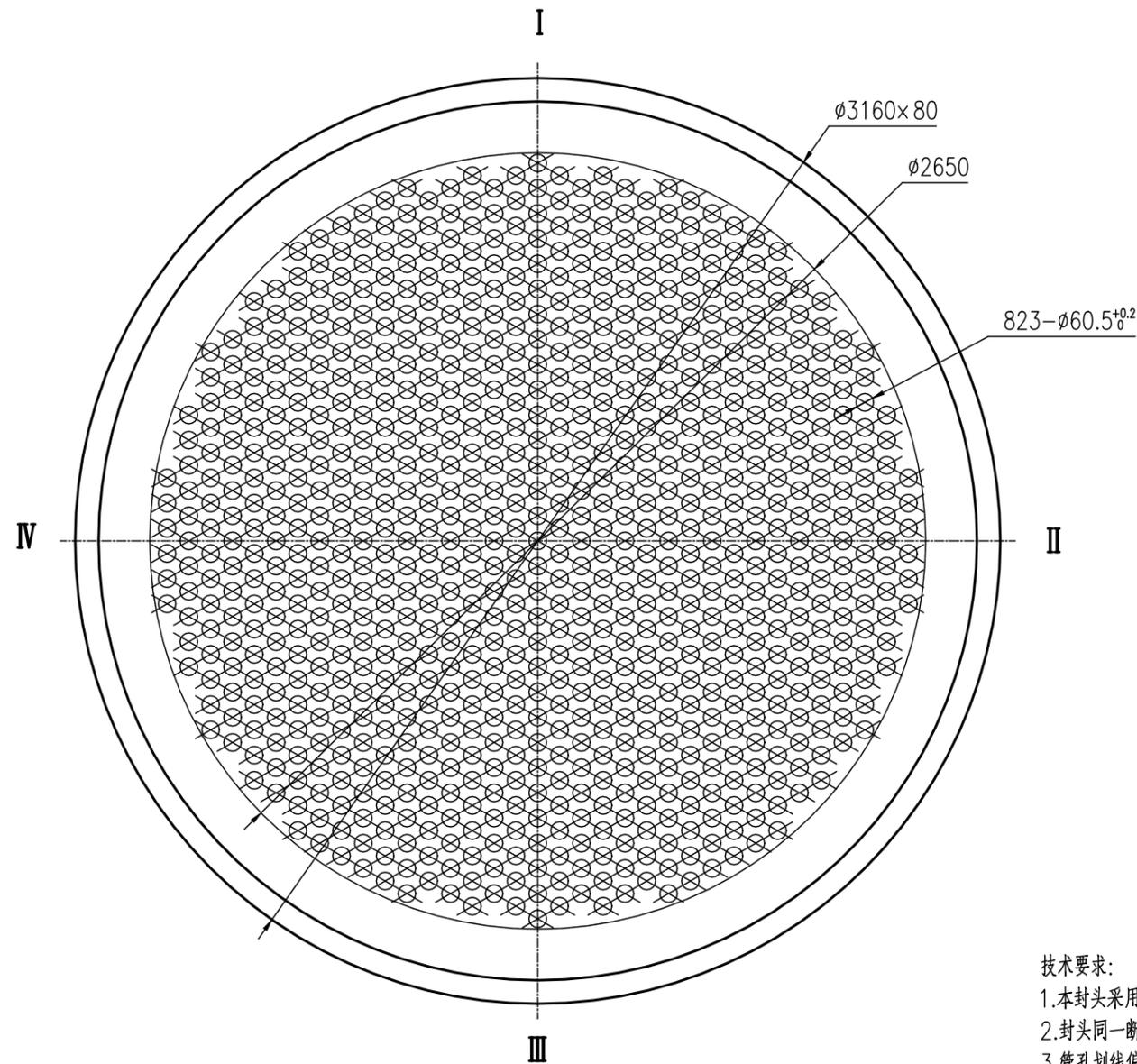
- 1.本封头采用整板热压成型,不允许拼接。
- 2.封头同一断面直径差值不大于1.5mm,内径偏差为±5mm,削薄前管板平面度不大于10mm。
- 3.管孔划线偏差不得大于1.50mm,钻孔之前应经过签名验收手续。
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- 4.The drilling must be matched with the rear tube sheet and the partition plate.

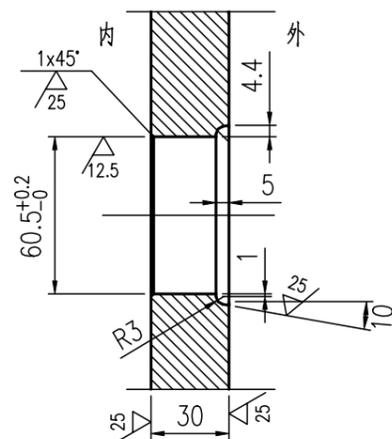
					江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.		
					P355GH/BS/EN10028.2 后平管板 ID3000 t=80		
					TAIL TUBESHEET		
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次
DESIGN 设计	李学亮	2026.1.12	TECH REVIEW 工艺		3350	1:20	0
CHECK 校对	苏杰	2026.1.12	APPROVE 批准				
REVIEW 审核					TOTAL-PAGES 共 张	No.-PAGE 第 张	11SCG2506-2-3

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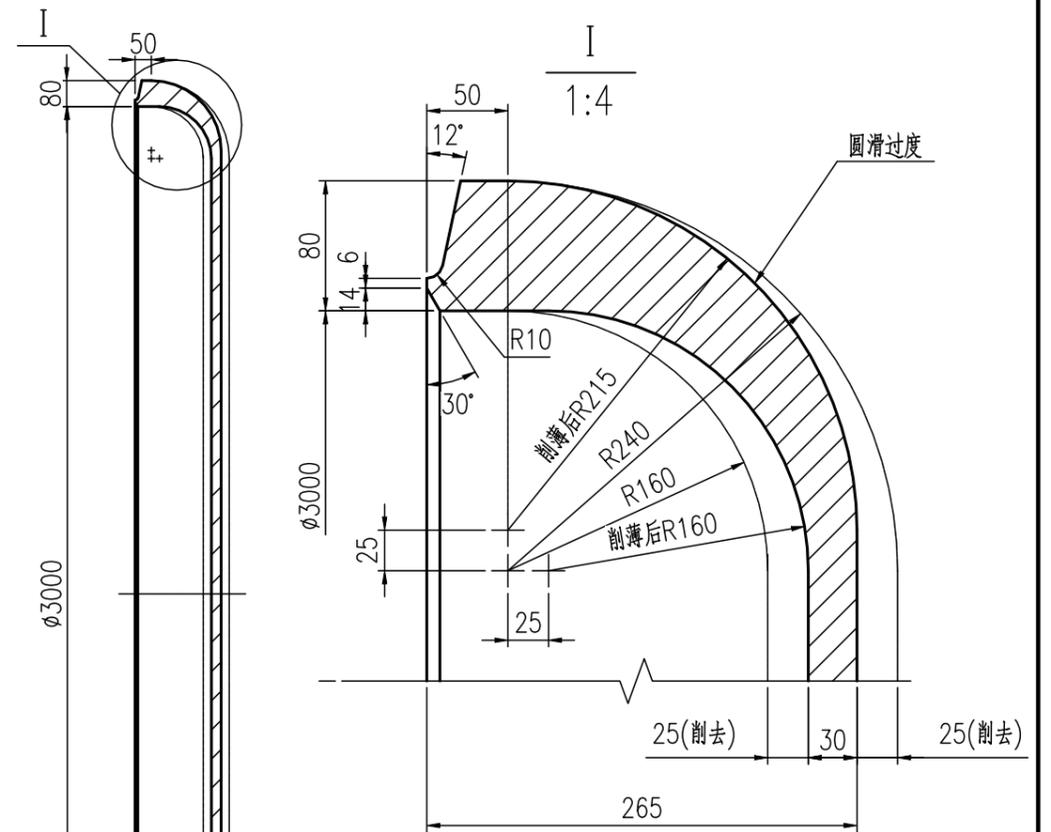
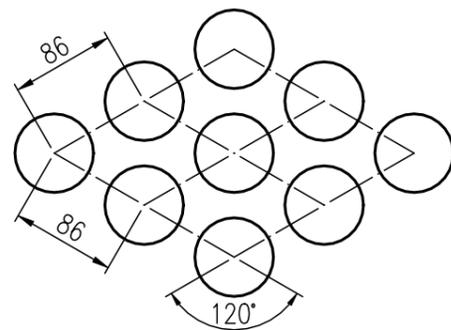
**φ60.5开孔详图**  
DRILLING DETAIL

1:2



**管孔排列详图**  
ARRANGE DETAIL

1:4



**技术要求:**

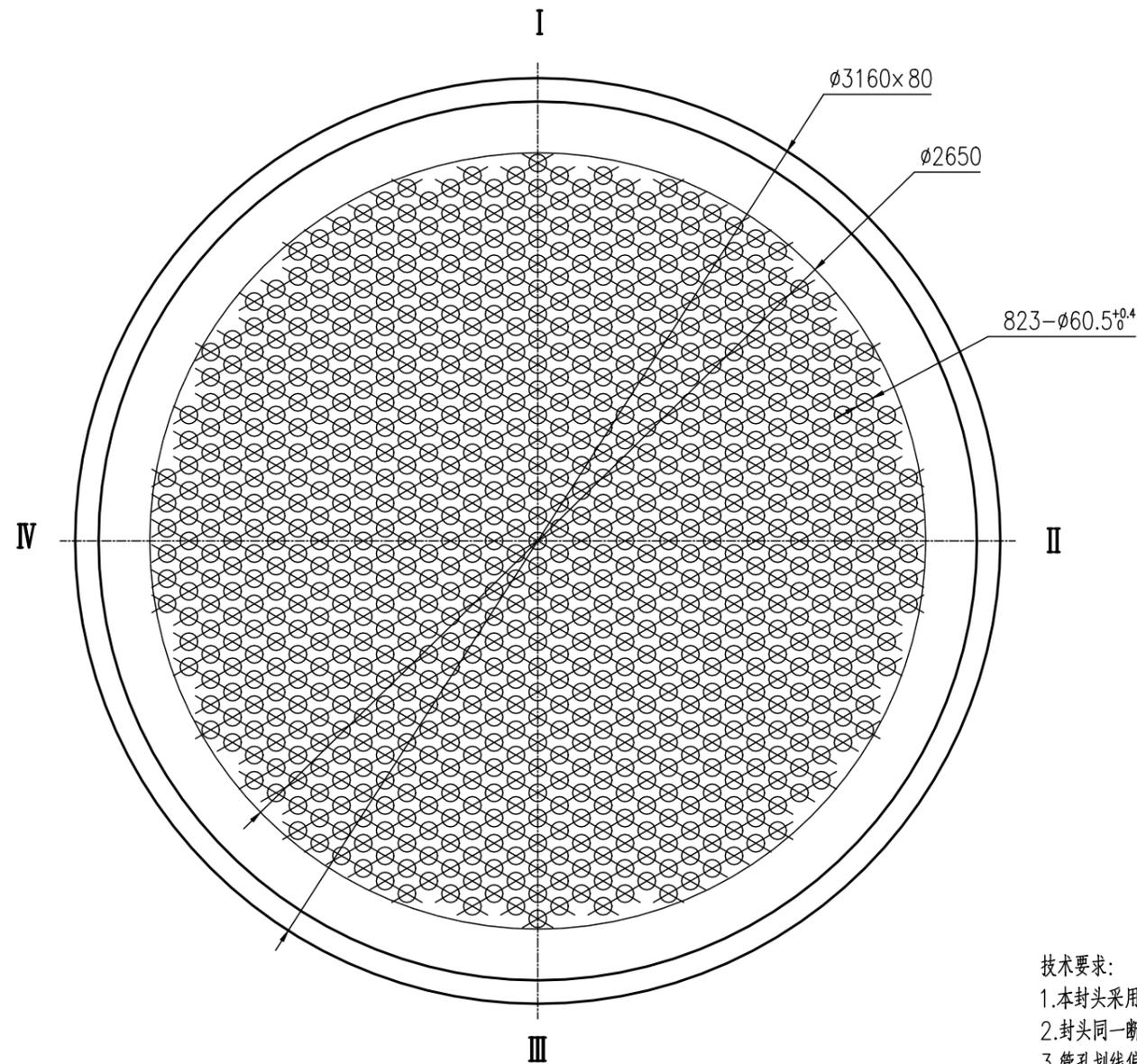
- 1.本封头采用整板热压成型,不允许拼接。
- 2.封头同一断面直径差值不大于1.5mm,内径偏差为±5mm,削薄前管板平面度不大于10mm。
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- 4.The drilling must be matched with the rear tube sheet and the partition plate.

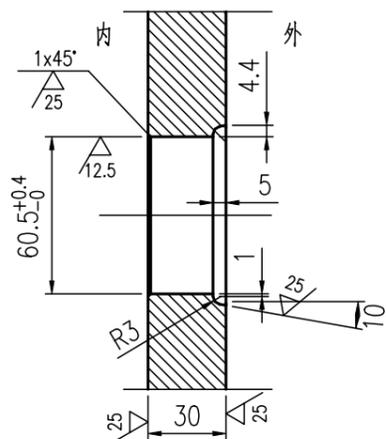
					江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.		
					P355GH/BS/EN10028.2 前平管板 ID3000 t=80 FRONT TUBESHEET		
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次
DESIGN 设计	李学亮	2026.1.12	TECH REVIEW 工艺		3450	1:20	0
CHECK 校对	苏杰	2026.1.12	APPROVE 批准		TOTAL-PAGES 共 张		
REVIEW 审核					No.-PAGE 第 张		
					11SCG2506-3-2		

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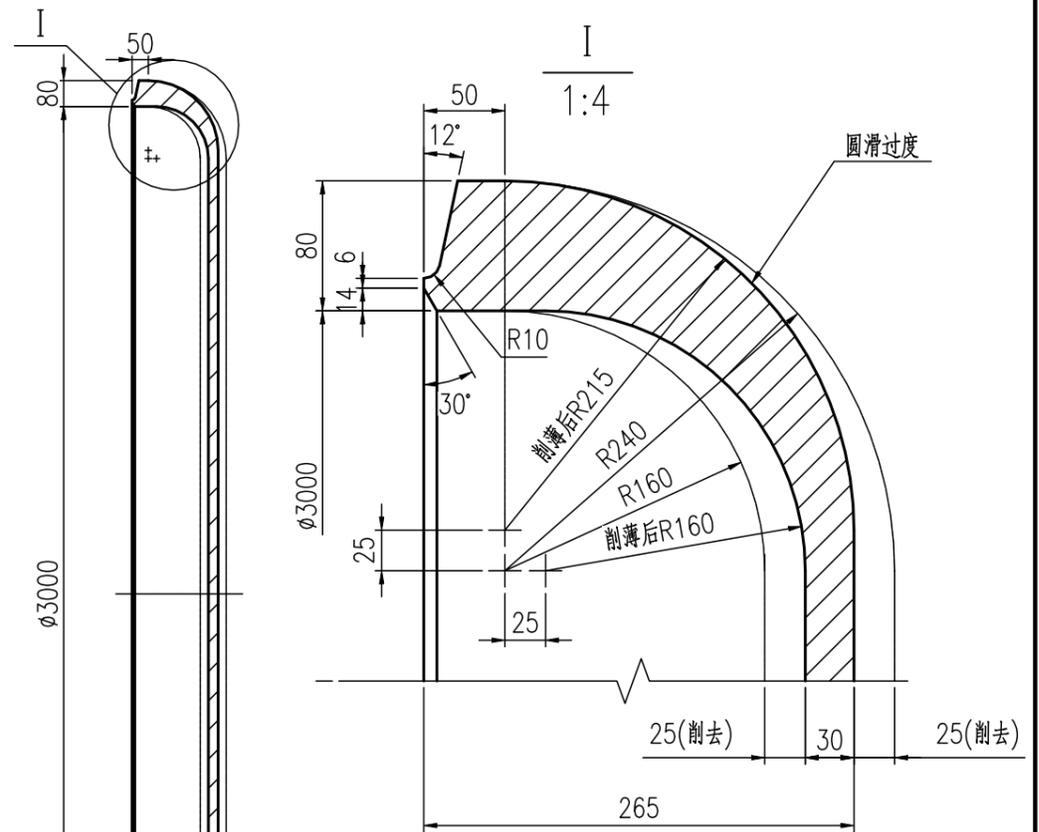
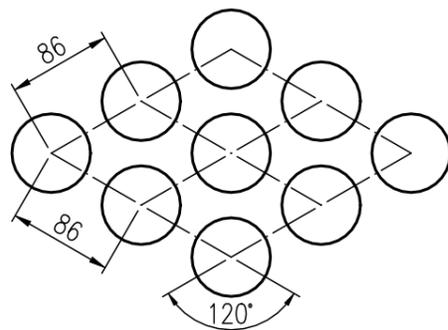
φ60.5开孔详图  
DRILLING DETAIL

1:2



管孔排列详图  
ARRANGE DETAIL

1:4



技术要求:

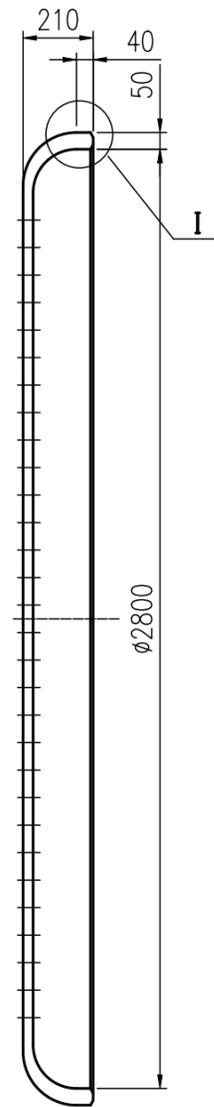
- 1.本封头采用整板热压成型,不允许拼接。
- 2.封头同一断面直径差值不大于1.5mm,内径偏差为±5mm,削薄前管板平面度不大于10mm。
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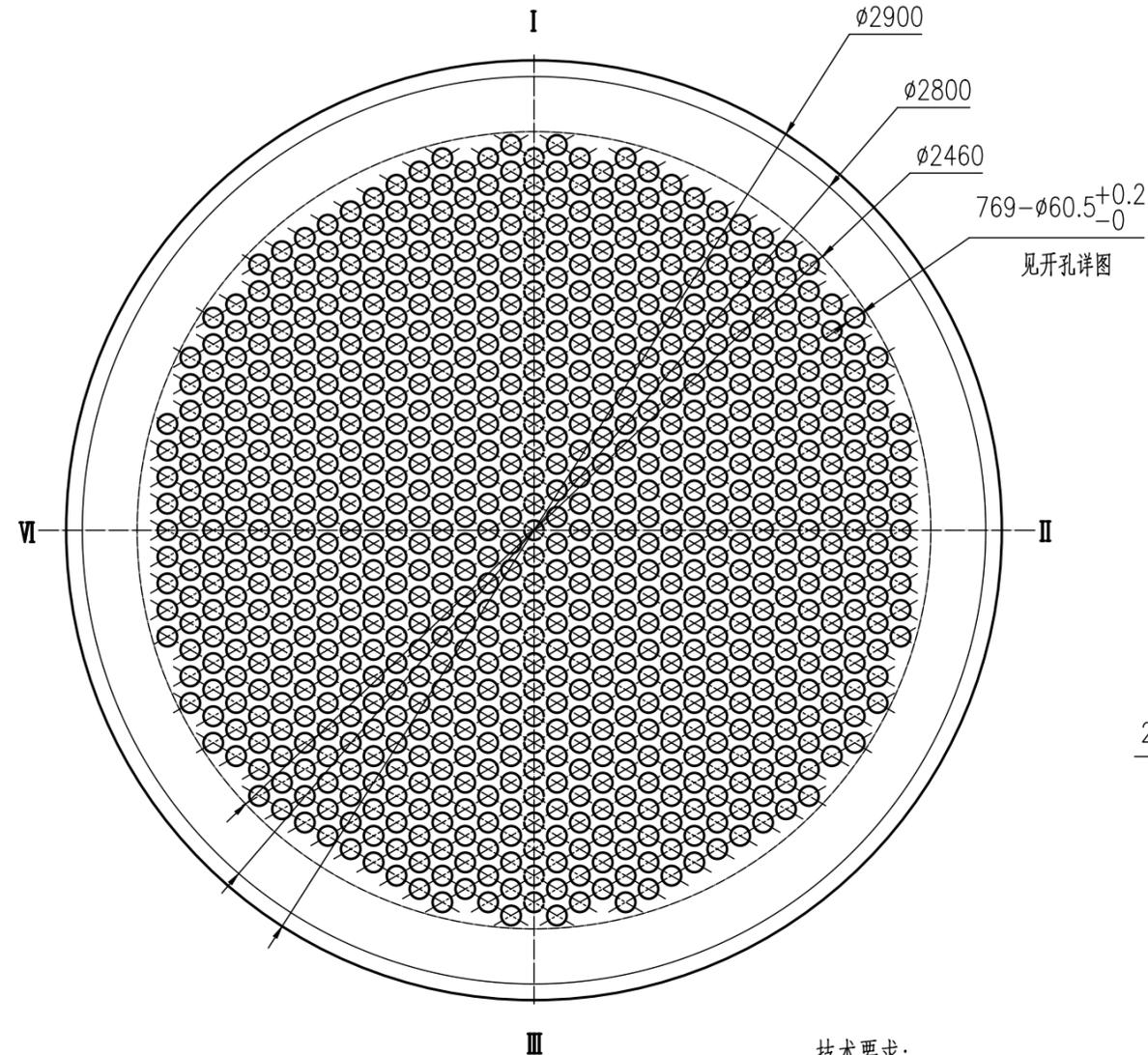
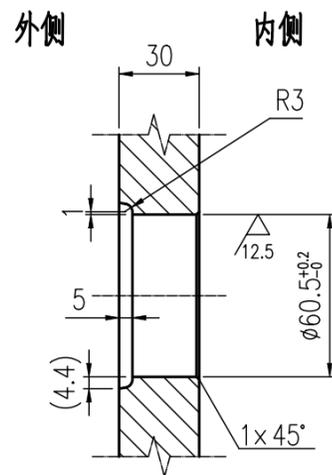
					江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.		
					P355GH/BS/EN10028.2 后平管板 ID3000 t=80		
					TAIL TUBESHEET		
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次
DESIGN 设计	李学亮	2026.1.12	TECH REVIEW 工艺		3450	1:20	0
CHECK 校对	苏杰	2026.1.12	APPROVE 批准				
REVIEW 审核					TOTAL-PAGES 共 张	No.-PAGE 第 张	11SCG2506-3-3

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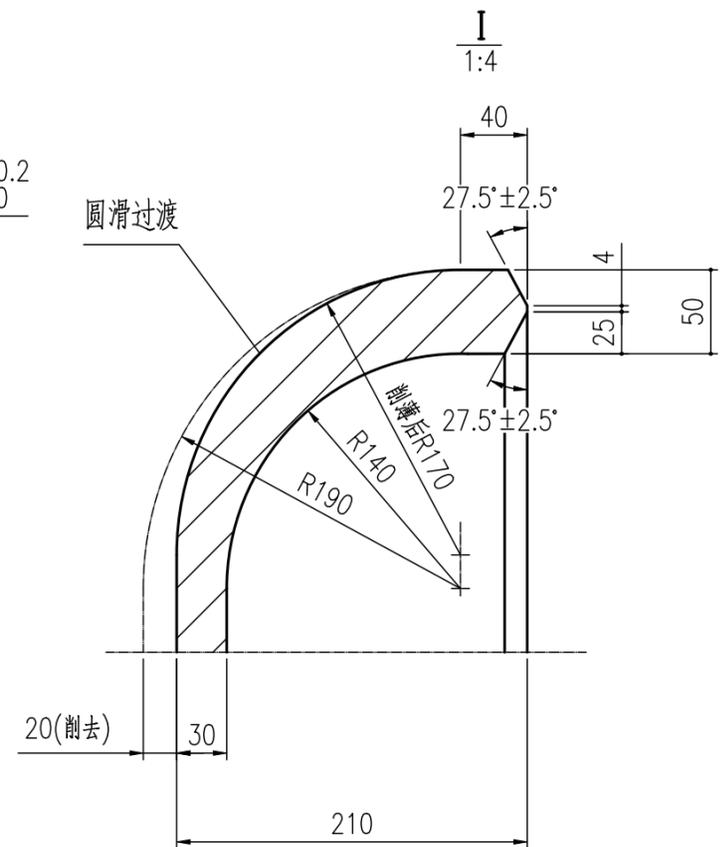
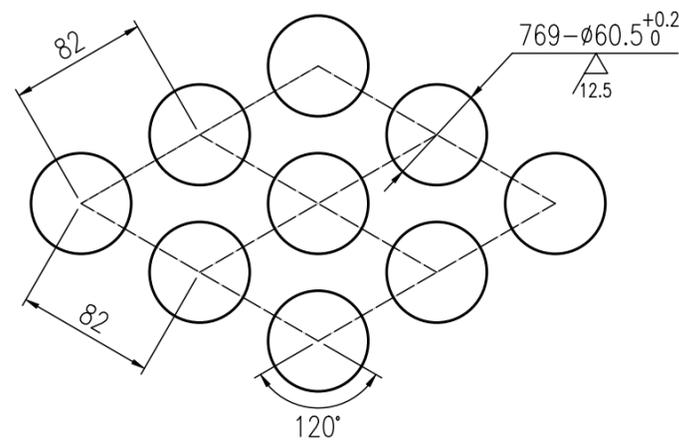
开孔详图

1:4



管孔排列详图

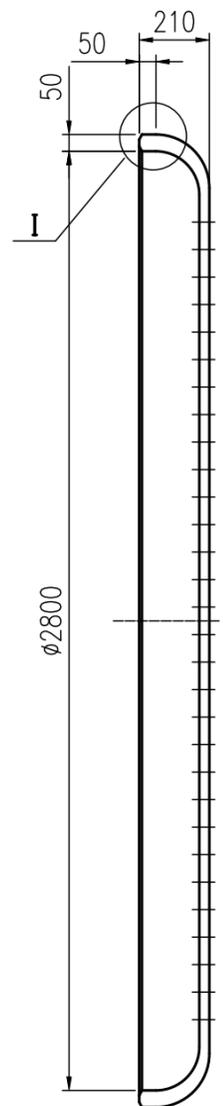
1:4



技术要求:

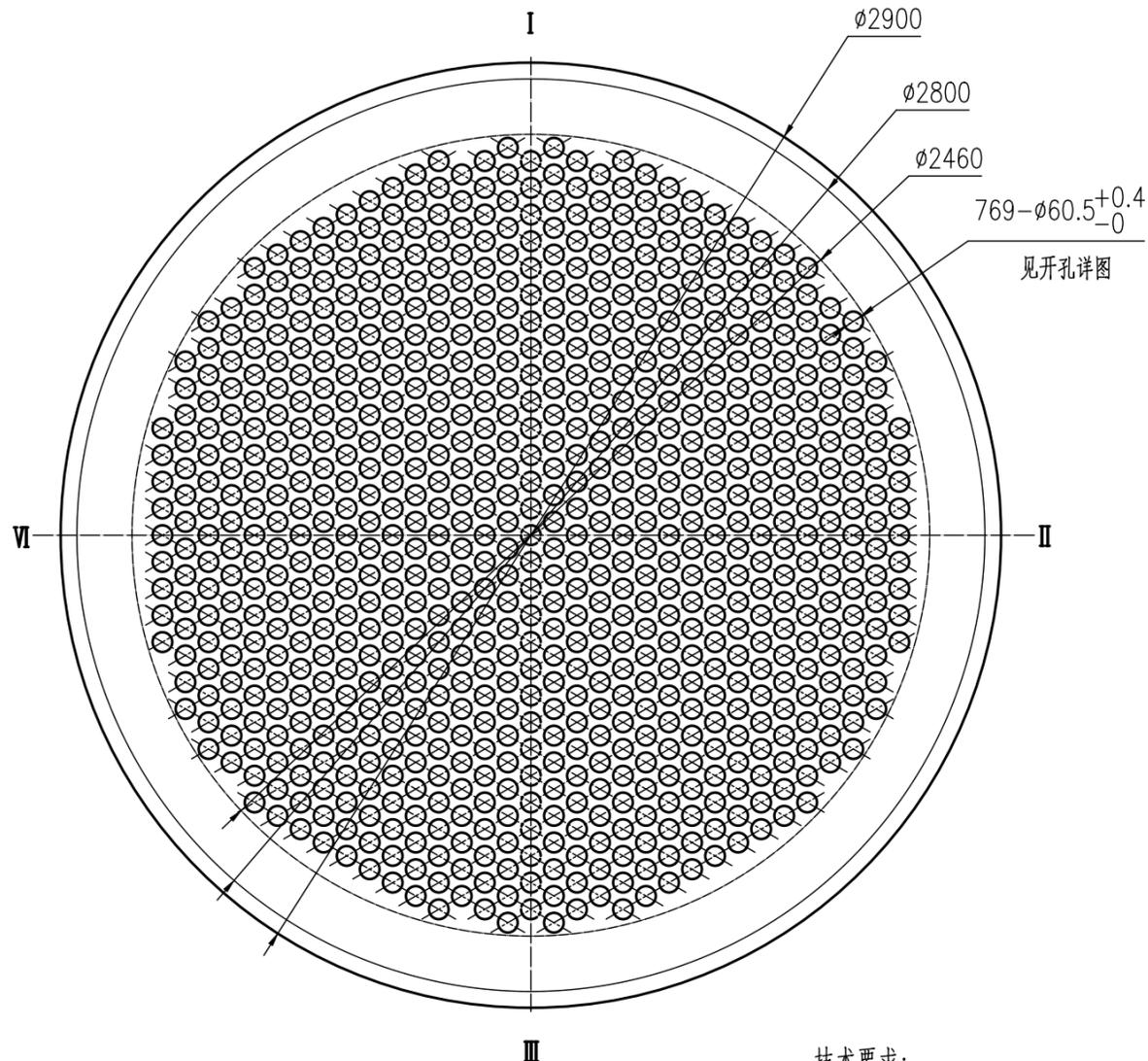
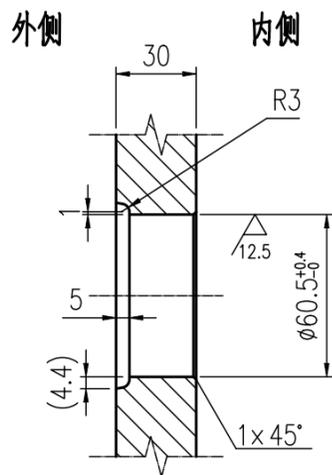
1. 本管板采用整板热压成型, 不允许拼接.
2. 削薄前管板同一截面内径差值不大于1.5mm, 内径偏差为±5mm, 管板平面度不大于10mm.
3. 管孔划线偏差不得大于1.50mm, 钻孔之前应经过签名验收手续, 管板应配钻.
4. 未详尽处可参照GB/T16508.4-2022《 锅壳锅炉 第4部分: 制造、检验与验收》进行.
5. 下料理论毛重: 2593Kg.

					江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.		
					Q345R/GB/T713		前管板 Dn2800 t=50
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	
DESIGN 设计			TECH REVIEW 工艺		1528	1:20	0
CHECK 校对			APPROVE 批准		TOTAL-PAGES 共 张		11SCG2508-2-2
REVIEW 审核					No.-PAGE 第 张		
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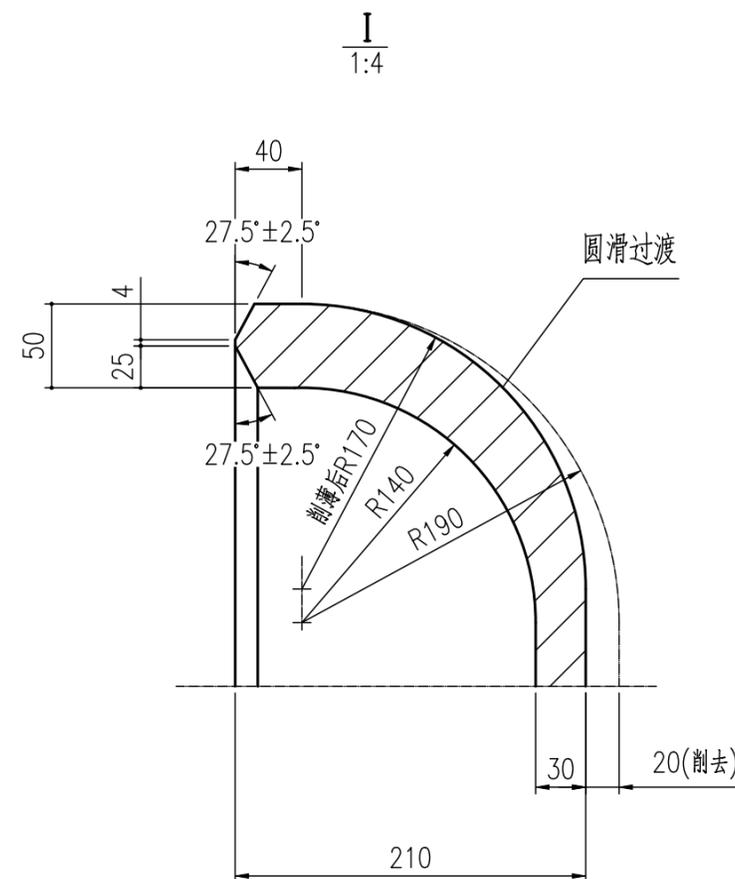
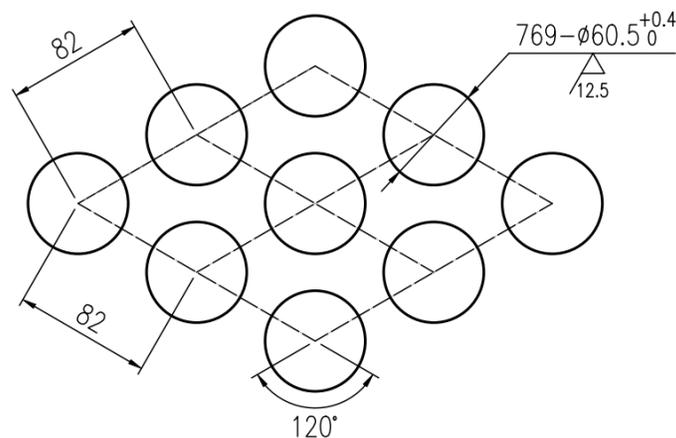
开孔详图

1:4



管孔排列详图

1:4



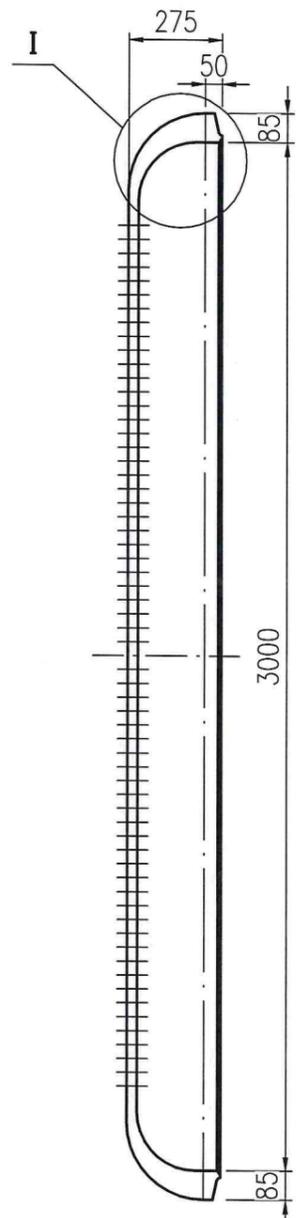
技术要求:

- 1.本管板采用整板热压成型,不允许拼接。
- 2.削薄前管板同一截面内径差值不大于1.5mm,内径偏差为±5mm,管板平面度不大于10mm。
- 3.管孔划线偏差不得大于1.50mm,钻孔之前应经过签名验收手续,管板应配钻。
- 4.未详尽处可参照GB/T16508.4-2022《锅壳锅炉 第4部分:制造、检验与验收》进行。
- 5.下料理论毛重:2593Kg。

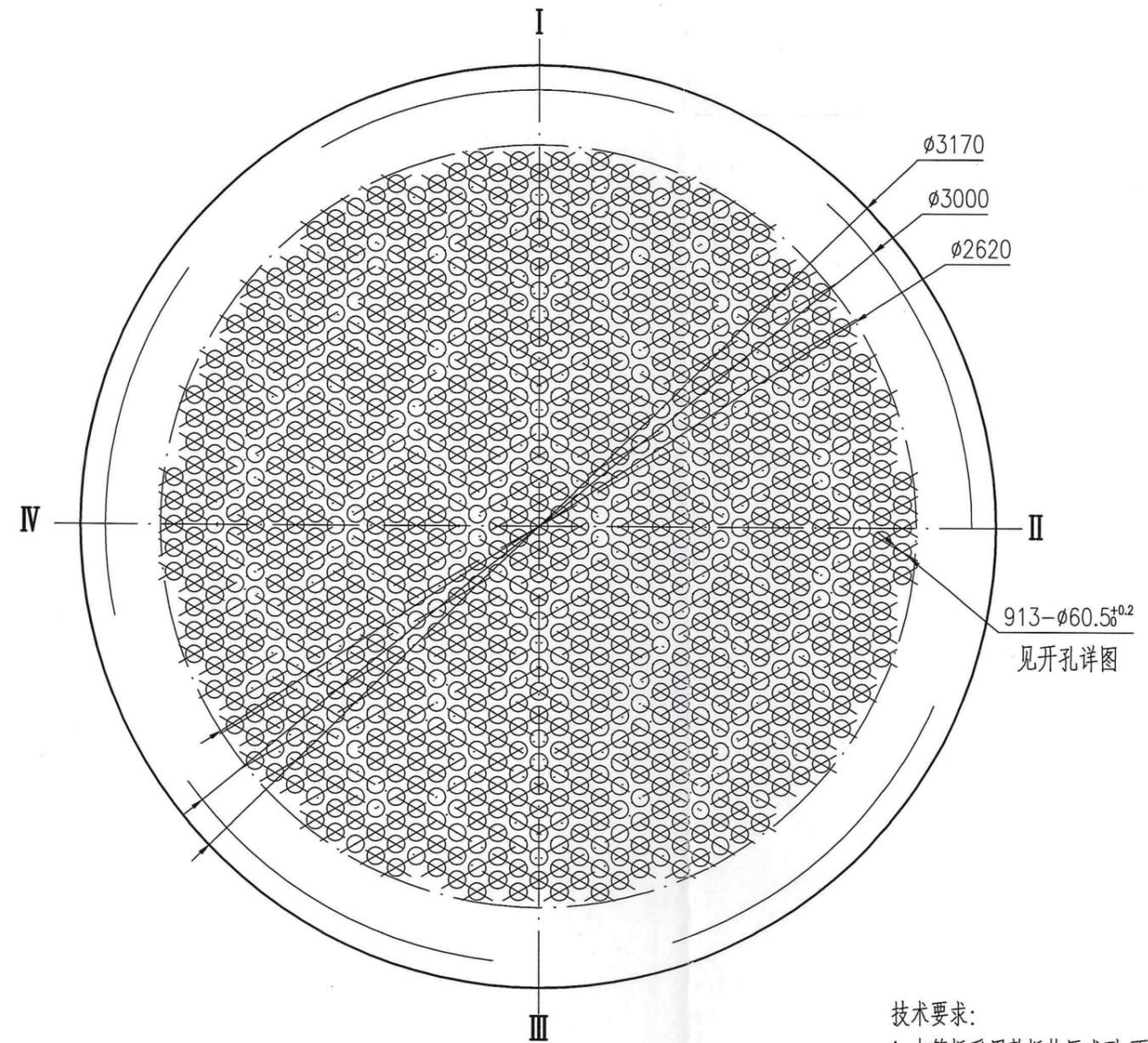
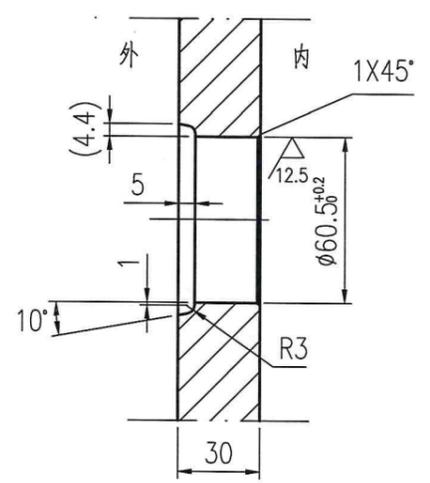
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					Q345R/GB/T713		后管板 Dn2800 t=50
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	
DESIGN 设计			TECH REVIEW 工艺		1528	1:20	0
CHECK 校对			APPROVE 批准		TOTAL-PAGES 共 张		11SCG2508-2-3
REVIEW 审核					No.-PAGE 第 张		

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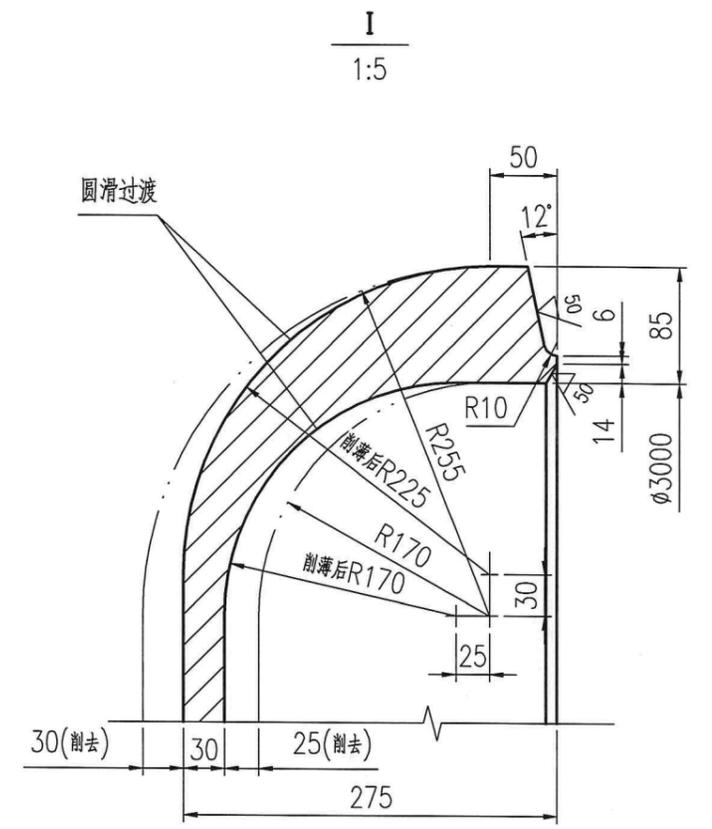
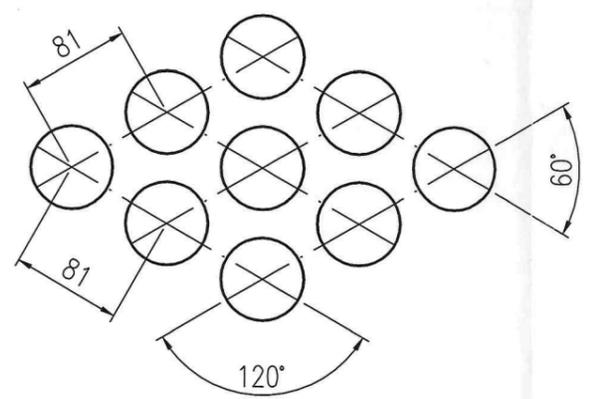
其余 25/



ø60.5开孔详图  
1:2



管孔排列详图  
1:4



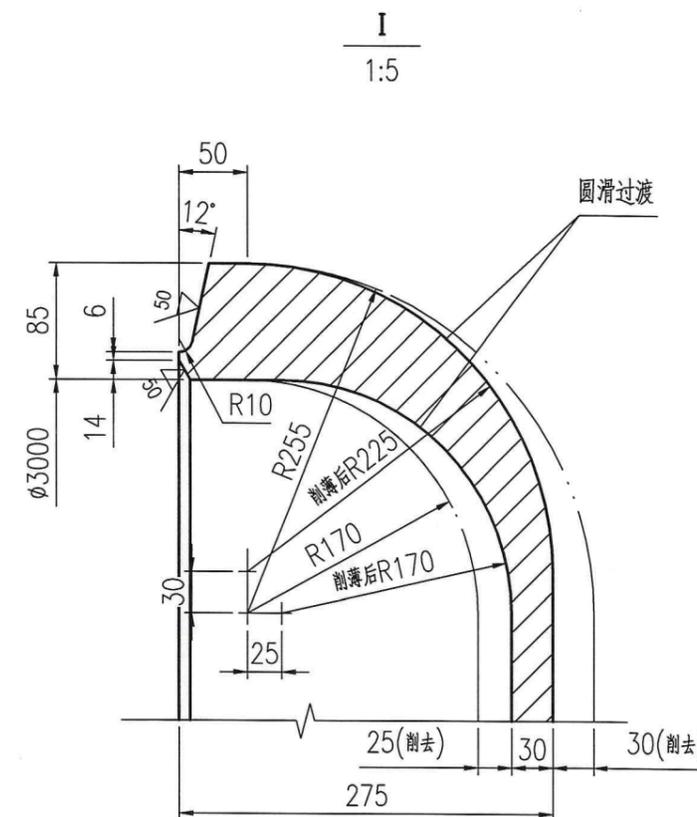
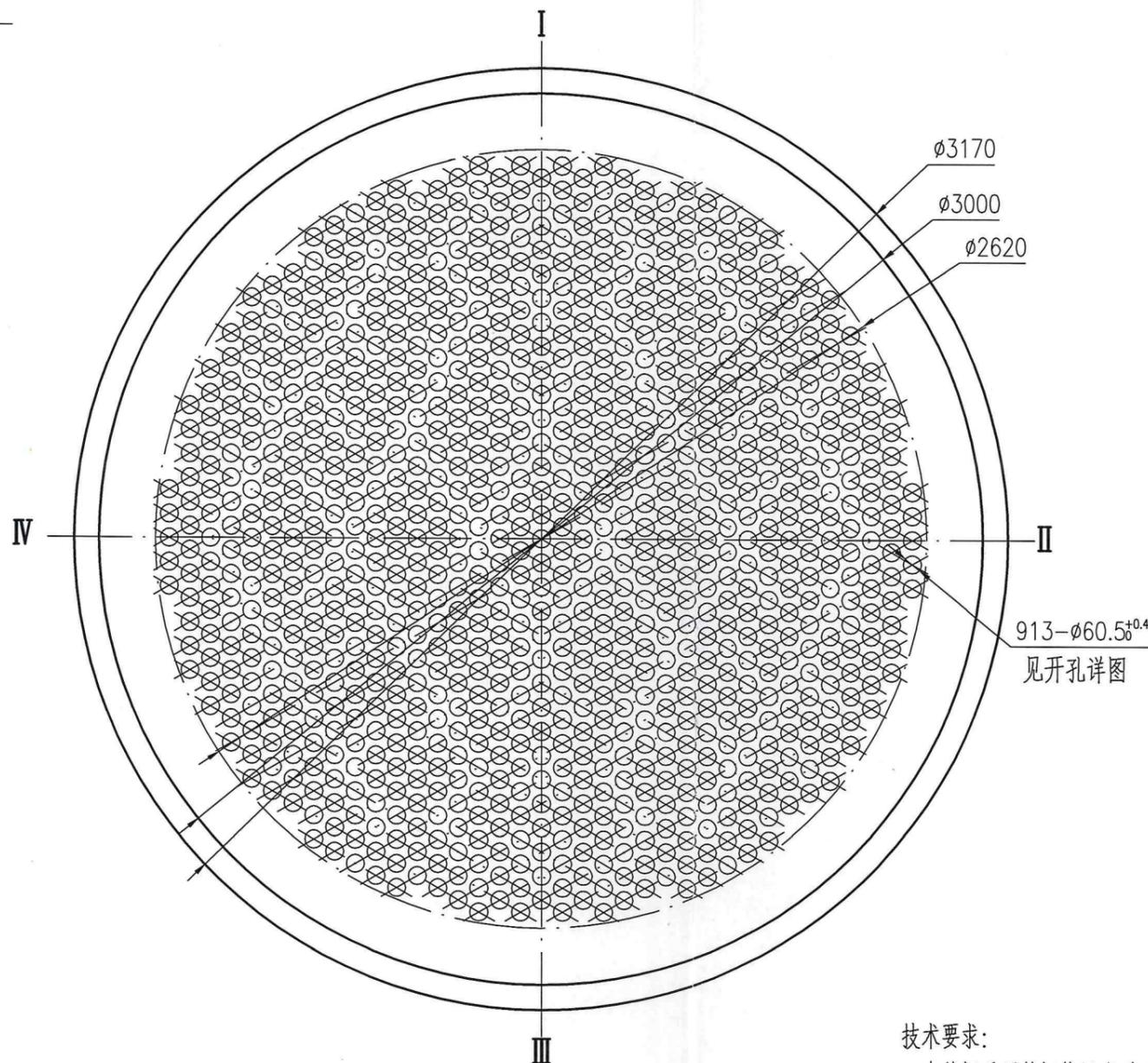
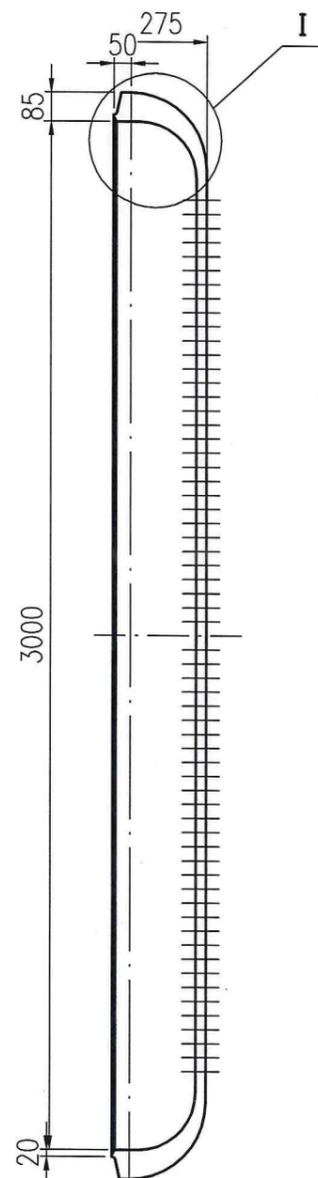
受控文件

技术要求:

- 1.本管板采用整板热压成型,不允许拼接。
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- 4.未详尽处可参照GB/T16508.4-2022《锅壳锅炉 第4部分:制造、检验与验收》进行。
- 5.下料理论毛重: 6050Kg。

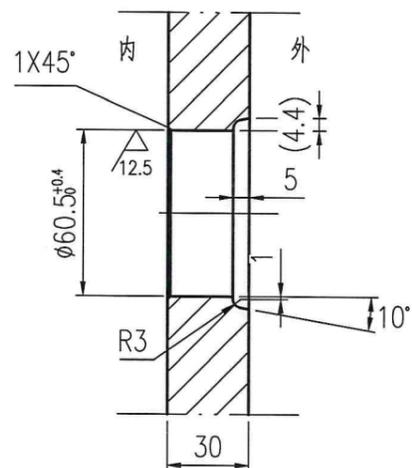
					江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.		
					P355GH/BS EN10028.2		
					前管板 DN3000 t=85		
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次
DESIGN 设计	李学亮	2025.12.24	工艺	尹德	2025.12.24	2350.6	1:20
CHECK 校对	黄杰	2025.12.24	APPROVE 批准	王德明	2025.12.24	0	
REVIEW 审核	许大宇	2025.12.24					
					TOTAL-PAGES 共 张	No.-PAGE 第 张	
					11SCG2504-2-3		

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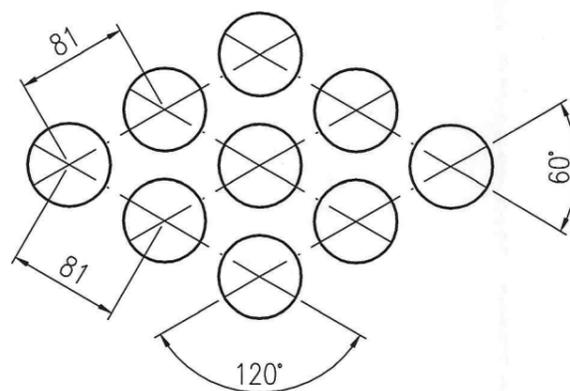
ø60.5开孔详图

1:2



管孔排列详图

1:4



受控文件

25057/27

技术要求:

- 1.本管板采用整板热压成型,不允许拼接.
- 2.削薄前管板同一截面内径差值不大于1.5mm,内径偏差为±5mm,管板平面度不大于10mm.
- 3.管孔划线偏差不得大于1.50mm,钻孔之前应经过签名验收手续,管板应配钻.
- 4.未详尽处可参照GB/T16508.4-2022《锅壳锅炉 第4部分:制造、检验与验收》进行.
- 5.下料理论毛重:6050Kg.

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