

大和球接欄杆的製作及尺寸偏差

MANUFACTURES AND TOLERANCES

1 空心球 Hollow Ball

1.1 空心球是無縫的整體成形的構件。Hollow ball is seamless forged structure

1.2 空心球表面平滑，不起皺，不開裂，失圓度（直徑差）不大於 0.5 mm。
Hollow ball surface smooth, no corrugation, no crack and out of round (diameter tolerance) not exceed 0.5mm

2 腳掌（基板）Base Plate

2.1 焊接固定型的腳掌，長度及寬度偏差不大於 1 mm。For welded fixing base plate, the tolerance of length and width shall be no more than 1mm.

2.2 螺栓固定型的腳掌，螺栓安裝孔之間的間距偏差不大於 1.0 mm。For bolted fixing base plate, the tolerance of space between bolt holes shall be no more than 1mm.

2.3 腳掌預開漏水孔。Base plate shall be with hole for water outlet.

3 立柱管 Stanchion Pipe

3.1 立柱長度偏差不大於 5 mm。The tolerance of stanchion length shall be no more than 5mm.

3.2 立柱空心球上的扶手管孔，橫杆孔，按照所選用的扶手管，橫杆管的外徑公稱尺寸 +2 mm 設置，孔位偏差不大於 1 mm。The holes on the balls for rails through shall be drilled addition 2mm than nominal diameter of top rail and mid rail being used. The tolerance of holes position shall be no more than 1mm.

4 扶手管 Top Rail

4.1 扶手管的表面應該光滑無毛刺，無粗糙的銹瘤，沒有未鍍上鋅的黑斑和汽泡存在。Top rail surface shall be smooth, no burrs, no rough dross, no uncoated black spots or bubble.

4.2 扶手管之間的連接，先用內接管連接，然後固定在空心球中，接縫不外露。The connection between top rails shall be use joiner tube and then fixed inside of the ball. The joint shall not be exterior.

5 彎頭 Bend

5.1 水準收口彎頭，用於水準欄杆的端頭，連接扶手管和下橫杆的彎頭，用與扶手管相同直徑的鋼管製作，角度最大偏差 1.5°。

Horizontal closure bend is used for end of horizontal handrails, connect top rail and mid rail. It is made from pipe same as the top rail. The maximum tolerance of angle is 1.5° .

5.2 角度收口彎頭，用於梯子欄杆的端頭，連接扶手管和下橫杆的彎頭，用與扶手管相同直徑的鋼管製作，角度最大偏差 1.5°。Angle closure bend is used for end of stair handrails, connect top rail and mid rail. It is made from pipe same as the top rail. The maximum tolerance of angel is 1.5° .

5.3 直角連接彎頭，用於水準欄杆的拐彎處，分扶手直角彎頭和橫杆直角彎頭，用與扶手管和橫杆相同直徑的鋼管製作，角度最大偏差 1.5°。Standard 90° bend is used for corner connection of horizontal handrails, divided into top rail 90° bend and mid rail 90° bend, which is made from pipe same as top rail and mid rail respectively. The maximum tolerance of angle is 1.5° .

5.4 任意角連接彎頭，用於水準欄杆的任意角拐彎處或水準欄杆與梯子欄杆的連接處，分扶手任意角彎頭和橫杆任意角彎頭，用與扶手管和橫杆相同直徑的鋼管製作，角度最大偏差 1.5°。Angle bend is used for angle corner of horizontal handrails or connection between horizontal handrail and stair handrails, divided into top rail angle bend and mid rail angle bend, which is made from pipe same as top rail and mid rail respectively. The maximum tolerance of angle is 1.5° .

5.5 所有彎頭在彎製成形後，無開裂、毛刺、分層，內側波浪度不超過 3mm。All bends shall be no crack, burrs or layer after bending formed and the inner wavy not exceed 3mm.

6 踢腳板 Toe Plate

6.1 踢腳板平直定尺交貨。Toe plates shall be supplied in standard length.

6.2 踢腳板的尺寸公差符合有關熱軋帶鋼規範要求。Dimension tolerance of toe plates shall be in accordance with specifications of relevant hot rolled steel coil.

