



1:1 1

		1	
1		45	/
2		2	/
3		3	
4		2	
5		2	
6		2	
7		3	
8		2	
9		2	
10		6	
11		50	
12		2	
13		4	
14		1	
15		21	
16		2	
17		3	
		150	103

1 103 24m 103 16  
 /24 =4.3 28 /4.3 × 16 =104

4 制梁台座配置研究

5 存梁台座配置研究

(N ) 5.1  
 [3] N × k [3]  
 N --- / N M t× × K  
 --- / ---  
 k--- / t---  
 --- / ---  
 90 28 =90 k---  
 /28 =3.2 / t  
 k 1:1 30  
 k=4.3 / 14 1  
 N × k=3.2× 4.3=13.76 4.3 14

-4.3 +30 =39.7 t=40 32 1  
 90 28 102 33  
 =90 /28 =3.2 / 102 × 2 - 32 +1 =171  
 k k 161  
 k 1

6 制梁台座生产周期的优化

6.1

k 0.6 0.7 900t  
 k 0.7 2021 10 1  
 N M t<sub>x</sub> × K=40 × 3.2 / × 0.7=89.6 4  
 24m / 120 /

5.2 102 3 1  
 2h 2 1 1h

4.4 14 14 5 9  
 10 14 2  
 3.2  
 2

1		45		/	
2		2		/	
3		3			
4		2			
5		2			
6		2			
7		1			2h
8		2			
9		2			
10		6			
11		44			6h
12		1			1h
13		2			2h

14		1			
15		18			3h
16		2			
17		1			
		136		89	14h

89 /24  
 =3.7  
 6.2

16  
 28  
 $28 \div 3.7 \times 16 = 121$   
 120  
 6.3  
 14  
 3.7  
 $14 - 3.7 = 10.3$   
 4  
 41  
 1  
 $41 + 1 = 42$   
 102  
 $102 \times 2 - 42 = 162$   
 161

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7 结束语