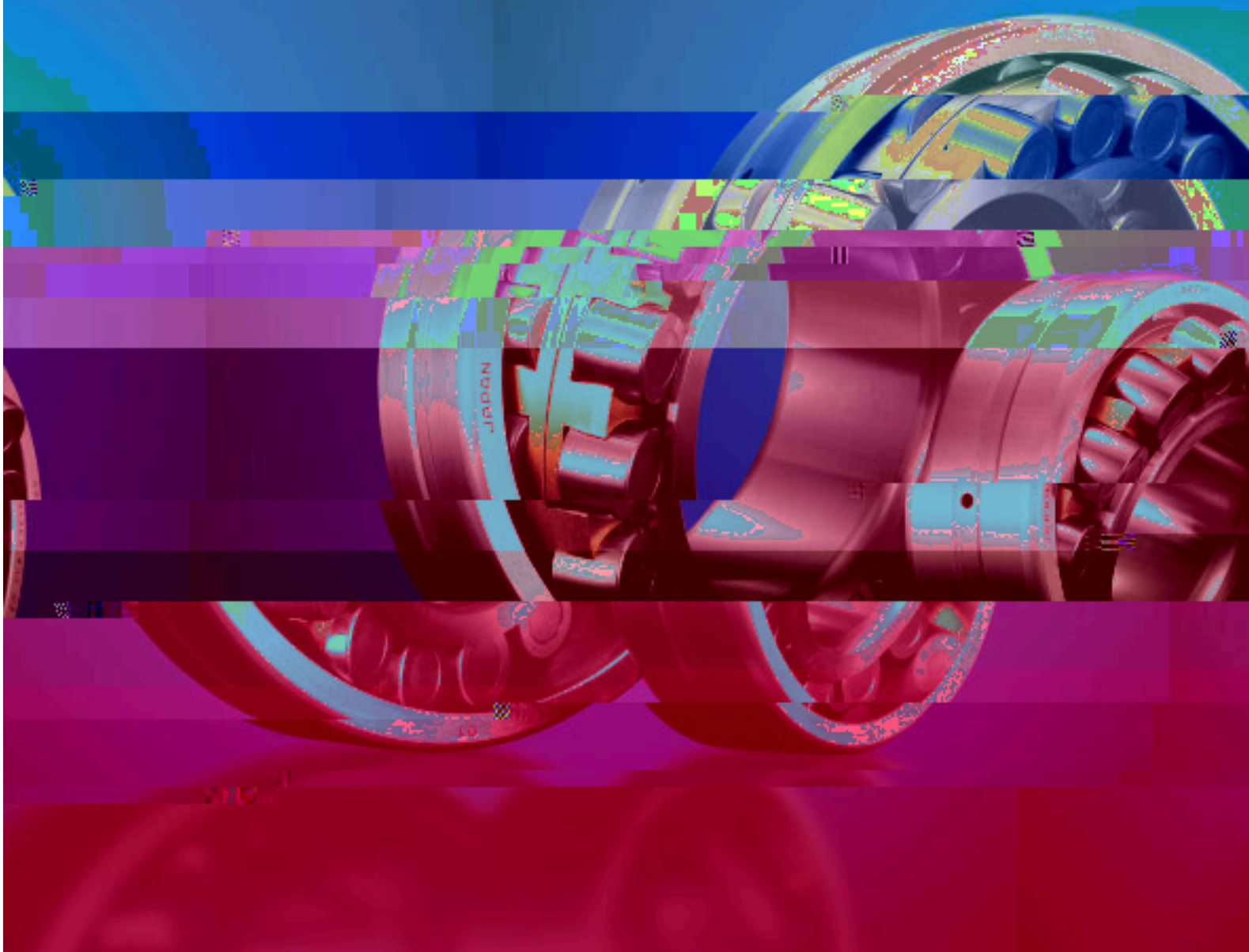
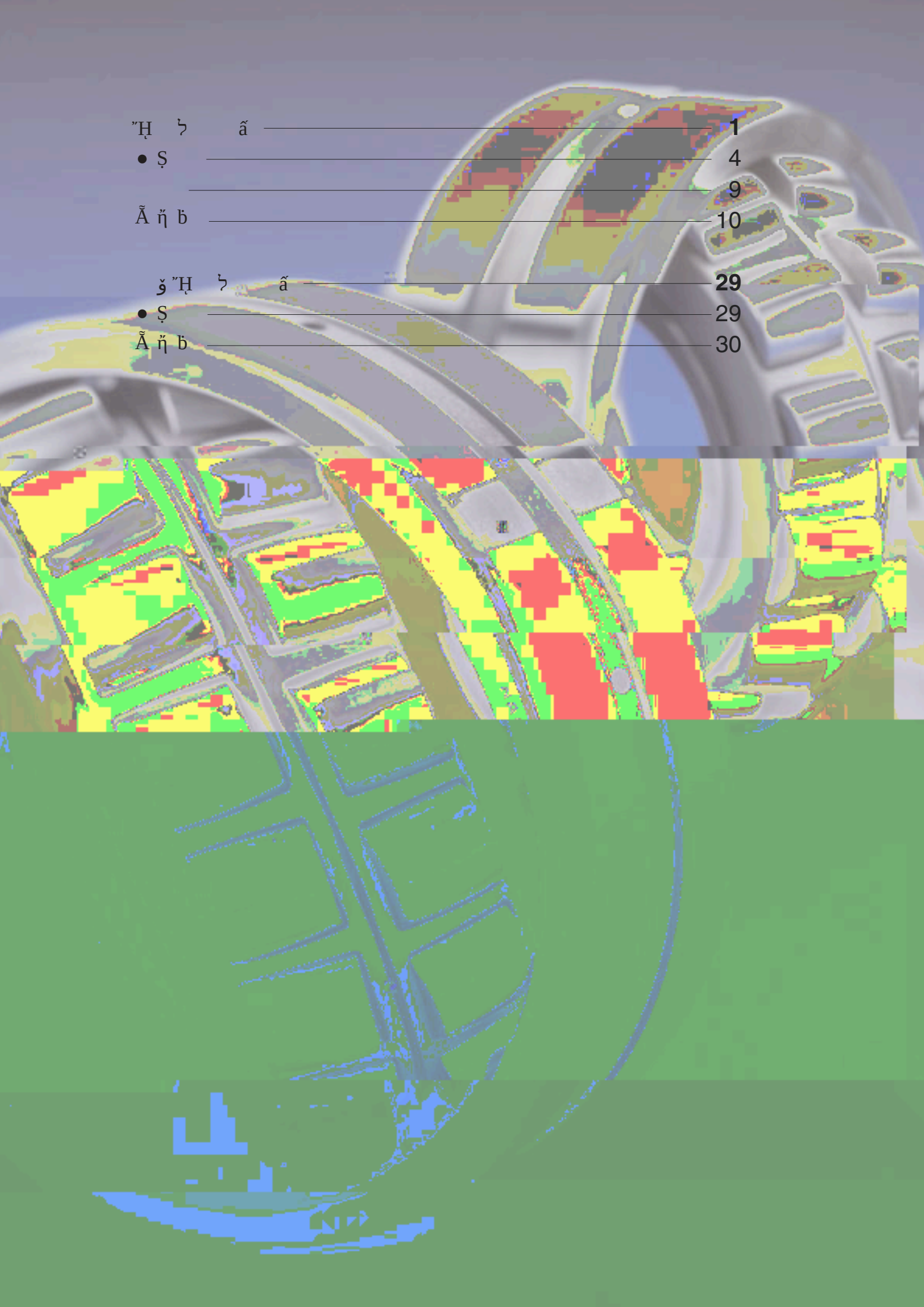
NACHI

”Ḥ ᵘ ấ

`

گ”Ḥ ᵘ ấ





ʺĻ ƚ ấ — 1
• Ș — 4
— 9
Ã ň ƀ — 10

ǧ ʺĻ ƚ ấ — 29
• Ș — 29
Ã ň ƀ — 30

”Ḥ ƛ ấ

⅄´ Ȣ☼

”Ḥ ƛ ấ Ḇ ̓ ض بحس| ̎
Ṣ ⅂ ̄ ين ỗ ụ ʔ
NACHI”Ḥ ƛ ấ˘ مم ̄ –´ ấ Ă ň
í ˘ Ў ⅄´ Ḷ ʔ
ƀ NACHI”Ḥ ƛ ấ ỗ ƛ ʒ ὺ
´ mָ ã ặ ỗ Ȣ☼ ⅄ ʔ
بح ấ ևֿ ´ ` ʔ

1. Ɪ ấ i ỗ ` ỗ ụ̓ ˘ ` Fa í ỗ i 0.6 ụ ỗ ևֿ ` ʔ Ẇ ` Ṿ Ẇ 0.6Fᵲ NACHIỗ▲ạ ậ ₔ Ⱨ ỗ ⅄ ʔ
2. Ẇ ấ ạ̇ ` ^ ạ̇ ~ ⅂ ╗ ỗ ụ̓ ˘ ⅄ NACHIỗ▲ạ ậ ₔ ʔ
3. ⅄ à ` ⅂ ` ˘ ⅁ T̲ ⅂ ạ̇ ㄱ ấ ʔ
ậ ᶿ ڇ ⅂˘ ấ ᶻ ấ Ṿ Ẇ 0.02Cᵲ ⅂ ᶾ Ȯ¨Ω ạ̇ ` ~ ỗ à ` ʔ
4. ạ̇ Ȯ¨Ω∑ ِ ⅃ ấ ỗ Ḷ ئ ʔ ũşƿ كي ƛ ấ ʔ

⅄ ` Ꭻ☼

۰ ⊄	EX	EX1	E	E2	E	AEX	AX	A2X	AX
239					20,26, 44～/1060		28～40		
230			20～						

″Ḥ ᴸ ā̃

١ ق́ ṏ

″Ḥ ᴸ ā̃ ų ١ ق́ ṏ ت ○ ▌

١ ﻉ ʔ ﺽ ﻓﻡ ʒ ᴷ ˊ ₄ ω̃ í ˘

ﺵ Ɐ ق ʔ

″Ω ā̃

NACHI″Ḥ ᴸ ā̃ ˘ ﻓﻡ Ạ ﺵ ٥ ų ﺵ ″Ω ộ

گ ʔ

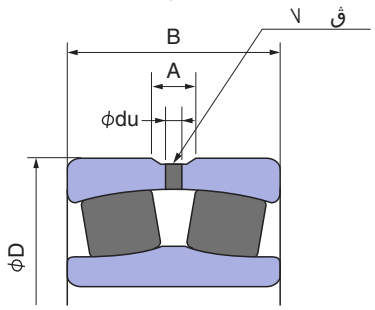
ɣ ˝ ω̃ ╗ ﻓﻡ Ã ŋ́ ١ ﻉ

ʔ

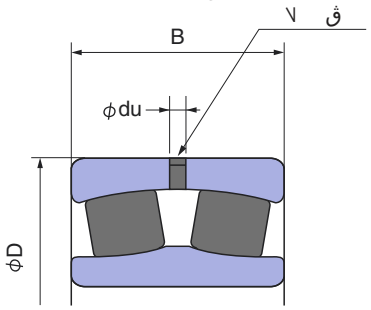
١ ق́ ṏ

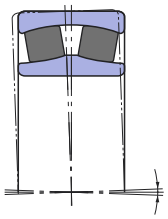
	~	ā ĭ ˘ˈ ‡ ﻩ
١ ق́ ṏ	W33	22330E W33
١ ق	W20	22330E W20

١ ق́ ṏ



١ ق





mm :

ևև ãõ • Ș

ھ ´ ھ ¨ õ • Ș

• ŵ ھ ևև d (mm)		ق									
		ò ¤¤ كي ¤¤ 0 ھ ևևضع Ș (2) ⊿dmp								ò ھ ևևضع Ș (2) ⊿ds	
		0 ٨		6 ٨		5 ٨		4 ٨		4 ٨ ևև ئ 0,1,2,3,4	
Over	Incl.	ضع Ș	ضع Ș	ضع Ș	ضع Ș	ضع Ș	ضع Ș	ضع Ș	ضع Ș	ضع Ș	ضع Ș
0.6(1)	2.5	0	−8	0	−7	0	−5	0	−4	0	−4
2.5	10	0	−8	0	−7	0	−5	0	−4	0	−4
10	18	0	−8	0	−7	0	−5	0	−4	0	−4
18	30	0	−10	0	−8	0	−6	0	−5	0	−5
30	50	0	−12	0	−10	0	−8	0	−6	0	−6
50	80	0	−15	0	−12	0	−9	0	−7	0	−7
80	120	0	−20	0	−15	0	−10	0	−8	0	−8
120	150	0	−25	0	−18	0	−13	0	−10	0	−10
150	180	0	−25	0	−18	0	−13	0	−10	0	−10
180	250	0	−30	0	−22	0	−15	0	−12	0	−12
250	315	0	−35	0	−25	0	−18	–	–	–	–
315	400	0	−40	0	−30	0	−23	–	–	–	–
400	500	0	−45	0	−35	–	–	–	–	–	–
500	630	0	−50	0	−40	–	–	–	–	–	–
630	800	0	−75	–	–	–	–	–	–	–	–
800	1000	0	−100	–	–	–	–	–	–	–	–
1000	1250	0	−125	–	–	–	–	–	–	–	–
1250	1600	0	−160	–	–	–	–	–	–	–	–
1600	2000	0	−200	–	–	–	–	–	–	–	–

| • ŵ ھ ևև d (mm) | | ھ ^ ٨ ~ ò ھ ¨ ضع Ș (3) ⊿Bs(٨⊿Cs) | | | | | | | | ھ ^ ٨ ~ ھ ¨ ¨ ¨

ò ş: µm

● ŵ ɸ̈ Ŀ d (mm)0 Λ		ق	
		ò Ŀ ϫ ي ɸ̈ ɷ̃ ɸ̈ Ŀ ̄ ὐ ˍ (2) Vdp	
		0 Λ	
		Ŀ ɹ	
		7,8,9	
Over Incl.		ì	

ևւ ãẽ • Ṣ

• Ṣ

					0,1,2,3,4Over	Incl.

ò ş: µm

٧												● ŵ ٧ D (mm)	
ò ٧ ٭ كي ڤ ڜ ٧ ٬ ۋ ۈ ۋ ۈ ۋ ٧ ٬ ۋ ۈ ۋ ۈ ۋ ٧ ٬ ۋ ۈ ۋ ۈ ۋ

ق • Ṣ

ق ﻲﮕﭘ ق ٥ ﺭﺍ ﺵ Ṣ ﺽ آ
ﻕ ﻟ

1/12ş ق^ 0 ⁄ ~ ó ş: m 1/30ş ق^ 0 ⁄ ~

ق"Ḥ ل ãَ ۆ ևـ (ISO)

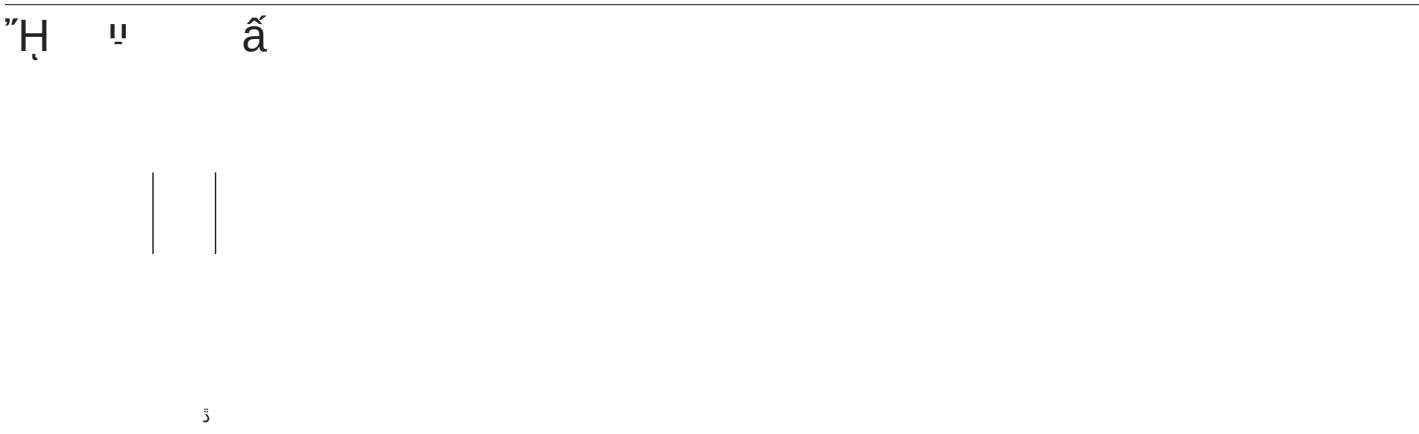
ò ş: µm

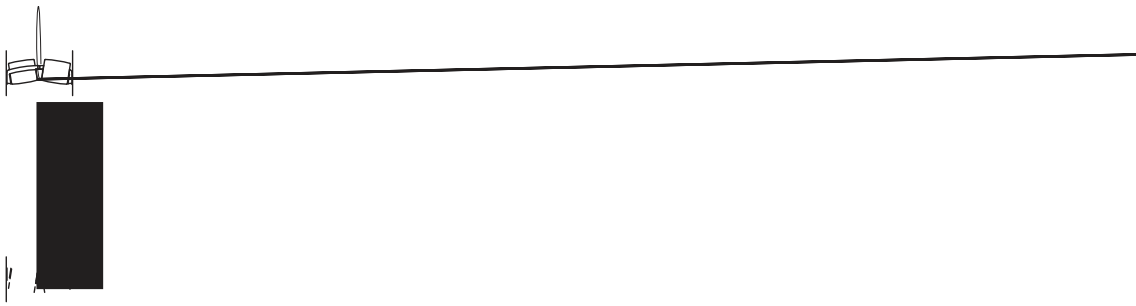
● ŵ ﻩ ևـ d(mm)		ևـ									
		C2		CN ~		C3		C4		C5	
Over	Incl.		i		i		i		i		i
14	18	10	20	20	35	35	45	45	60	60	75
18	24	10	20	20	35	35	45	45	60	60	75
24	30	15	25	25	40	40	55	55	75	75	95
30	40	15	30	30	45	45	60	60	80	80	100
40	50	20	35	35	55	55	75	75	100	100	125
50	65	20	40	40	65	65	90	90	120	120	150
65	80	30	50	50	80	80	110	110	145	145	180
80	100	35	60	60	100	100	135	135	180	180	225
100	120	40	75	75	120	120	160	160	210	210	260
120	140	50	95	95	145	145	190	190	240	240	300
140	160	60	110	110	170	170	220	220	280	280	350
160	180	65	120	120	180	180	240	240	310	310	390
180	200	70	130	130	200	200	260	260	340	340	430
200	225	80	140	140	220	220	290	290	380	380	470
225	250	90	150	150	240	240	320	320	420	420	520
250	280	100	170	170	260	260	350	350	460	460	570
280	315	110	190	190	280	280	370	370	500	500	630
315	355	120	200	200	310	310	410	410	550	550	690
355	400	130	220	220	340	340	450	450	600	600	750
400	450	140	240	240	370	370	500	500	660	660	820
450	500	140	260	260	410	410	550	550	720	720	900
500	560	150	280	280	440	440	600	600	780	780	1000
560	630	170	310	310	480	480	650	650	850	850	1100
630	710	190	350	350	530	530	700	700	920	920	1190
710	800	210	390	390	580	580	770	770	1010	1010	1300
800	900	230	430	430	650	650	860	860	1120	1120	1440
900	1000	260	480	480	710	710	930	930	1220	1220	1570

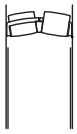
ق"Ḥ ل ãَ ۆ ևـ (ISO)

ò ş: µm

● ŵ ﻩ ևـ d(mm)		ևـ									
		C2		CN ~		C3		C4		C5	
Over	Incl.		i		i		i		i		i
18	24	15	25	25	35	35	45	45	60	60	75
24	30	20	30	30	40	40	55	55	75	75	95
30	40	25	35	35	50	50	65	65	85	85	105
40	50	30	45	45	60	60	80	80	100	100	130
50	65	40	55	55	75	75	95	95	120	120	160
65	80	50	70	70	95	95	120	120	150	150	200
80	100	55	80	80	110	110	140	140	180	180	230
100	120	65	100	100	135	135	170	170	220	220	280
120	140	80	120	120	160	160	200	200	260	260	330
140	160	90	130	130	180	180	230	230	300	300	380
160	180	100	140	140	200	200	260	260	340	340	430
180	200	110	160	160	220	220	290	290	370	370	470
200	225	120	180	180	250	250	320	320	410	410	520
225	250	140	200	200	270	270	350	350	450	450	570
250	280	150	220	220	300	300	390	390	490	490	620
280	315	170	240	240	330	330	430	430	540	540	680
315	355	190	270	270	360	360	470	470	590	590	740
355	400	210	300	300	400	400	520	520	650	650	820
400	450	230	330	330	440	440	570	570	720	720	910
450	500	260	370	370	490	490	630	630	790	790	1000
500	560	290	410	410	540	540	680	680	870	870	1100
560	630	320	460	460	600	600	760	760	980	980	1230
630	710	350	510	510	670	670	850	850	1090	1090	1360
710	800	390	570	570	750	750	960	960	1220	1220	1500
800	900	440	640	640	840	840	1070	1070	1370	1370	1690
900	1000	490	710	710	930	930	1190	1190	1520	1520	1860



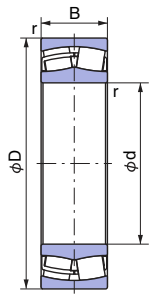




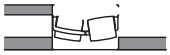


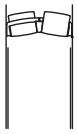


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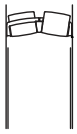






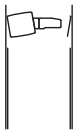


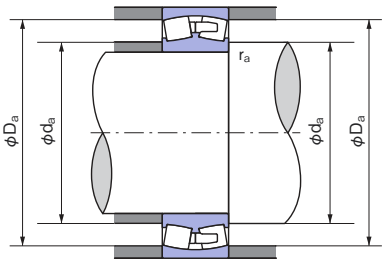
o





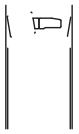


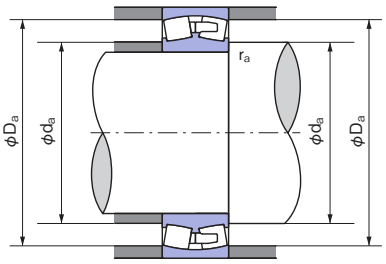




• lu ù ¸ ù ` Pr=XFr+YFa

b Y1 ʒ Y2 ´ e õ ? r 2 P r B 7B B g 3 D A 61d D r E a dXg) Cff



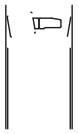


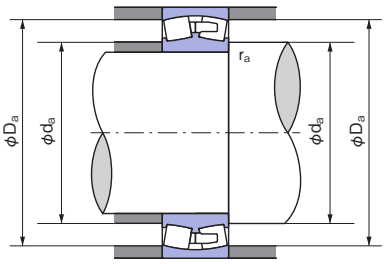
• Lu ù ¸ ù `
Pr=XFr+YFa

Fa/Fr ≦ e		Fa/Fr > e	
X	Y	X	Y
1	Y_1	0.67	Y

b Y_1 z Y_2 ´ e ỏ ?

• Lu ù ¸ ụ `
Por=Fr+Y_0Fa
b Y_0 ỏ ?

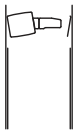




• Lr ù _ ù `
Pr=XFr+YFa

b Y1 z Y2 ´ e õ ?

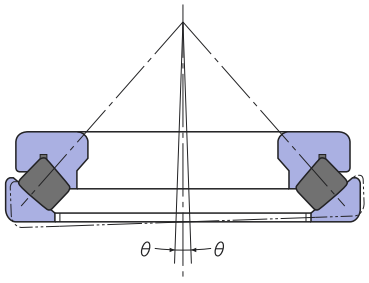
• Lr ù _ ùh `
Por=Fr+Y0Fa
b Y0 õ ?





ğ ″Ḥ ל ãő

ę ő̃ ⁴ ˘ ì Ⱶ 2˜ Ȯ
ȷ ώ ã Ȣ ☼ ő̃ ˘ ˚ ʔ



K

K “So” ᶻ ì 4ʔ

ğ ″Ḥ ל ãˆ 0ʌ˜ ő̃ ● Ș
ቋ ● Ș

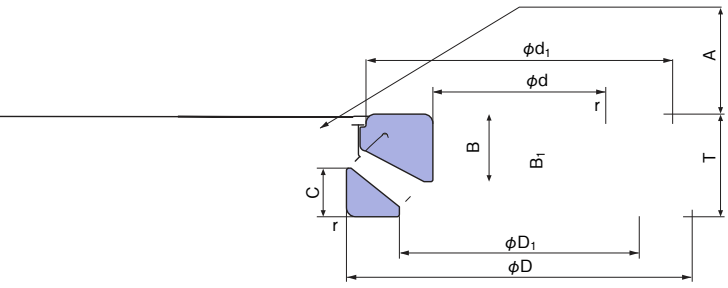
ğ θ ڪ ל ´ ל ώ ĭ Ţ ∨ ά Ỉ ő̃ ∀˘
ğ ″Ḥ ל ã˘ ﻓ ã ᶻ Ụ Ẅ `

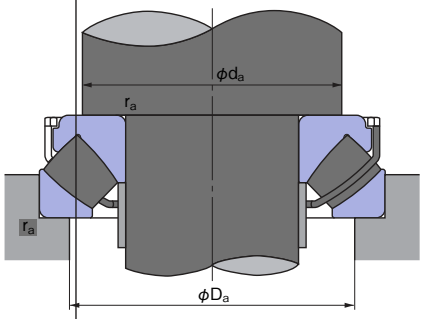
Fa min

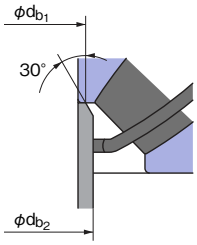
$$Fa\,min = \frac{Coa}{1000}$$

∨
ğ ″Ḥ ל ã E ቋ ķ ή Ў ■ ∨ ά b ي m̨
ã ả Ί ˇY ù ˘ ל ĭ ي Ί ù ˜ ˘ ă
∨ˆ í ∨˜ ʔ

ò ș: m ● Ș

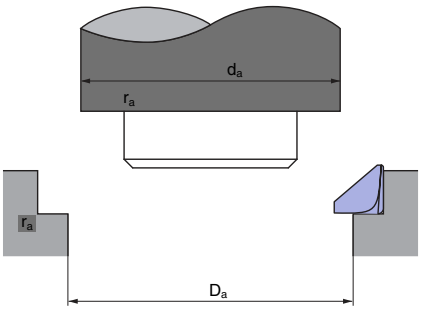

ϕd1
ϕd
r
A
B
B1
T
C
r
ϕD1
ϕD





- ù _ ù `
  Pa=Fa+1.2Fr
- ù _ ù `
  Poa=Fa+2.7Fr
  , Fa: `
  Fr : ù `

§§§§Ù z m § Fr/Fa ≦ 0.55


d_a
r_a
r_a
D_a