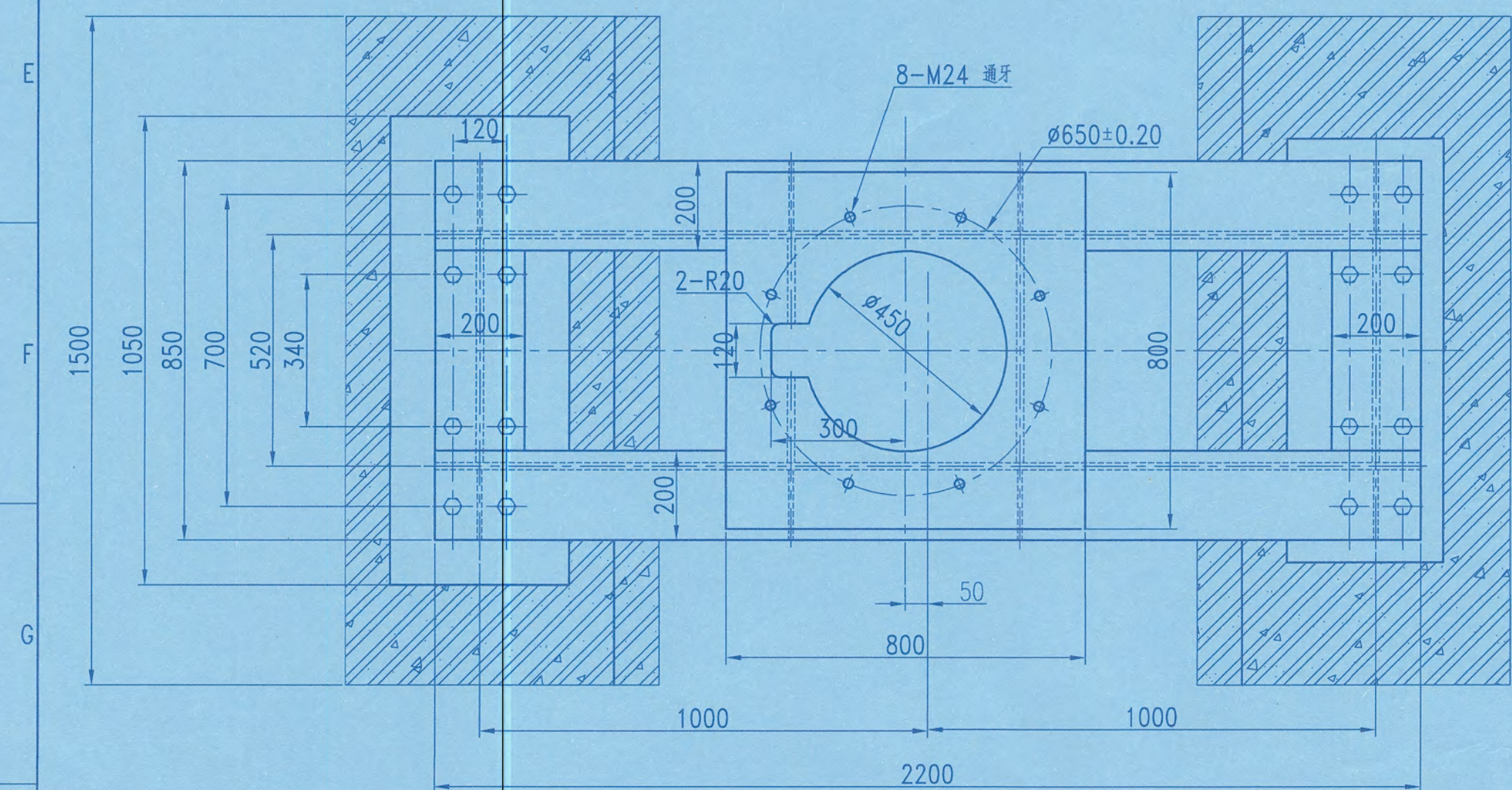




涂装前必须对金属表面进行清洗、喷丸等处理，除去灰尘、油污、水分、脏物、氧化皮、铁锈及渣子等等。处理后表面清洁度不低于GB8923中规定的Sa3级，使其粗糙度在40~70 μm的范围内。

底漆：环氧富锌底漆两道，干膜厚度60μm；

中间漆：环氧云铁中间漆三道，干膜厚度120μm；

面漆：丙烯酸脂肪族聚氨酯面漆两道，干膜厚度60μm。

面漆：丙烯酸脂肪族聚氨酯面漆一道，干膜厚度40μm（最后一道面漆现场涂装）。

Figure 10-1-1 is a schematic diagram of the gate structure and water pressure distribution. The diagram shows a gate structure with a total width of 2400mm and a height of 1050mm. The gate is divided into three sections: a left section (400mm wide), a middle section (1200mm wide), and a right section (200mm wide). The water pressure distribution is shown as a trapezoid, with the maximum pressure at the bottom. The pressure values are: $Q_{\text{上拔力}}=41\text{kN}$ (upward force), $Q_{\text{下压力}}=202\text{kN}$ (downward force) on the left; $Q_{\text{上拔力}}=36\text{kN}$ (upward force), $Q_{\text{下压力}}=18.3\text{kN}$ (downward force) on the right. The gate is labeled "吊点中心线" (hanging point center line) and "门槽定位线" (gate slot positioning line). The distance from the hanging point center line to the gate slot positioning line is 50mm.

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