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List

Zadatak

TEHNOLOGIJA IZRADE LJUŠTENOG FURNIRA

Overio

Datum

Radio

Ivan Ostojić

29.10.2012.

|  |  |  |
| --- | --- | --- |
| Faza rada - operacije | Otpada | Ostaje |
| Po smeni | Godišnje | Po smeni | Godišnje |
| % | m3 | m3 | % | m3 | m3 |
| Mehanička priprema | 3,36 | 1,239 | 644,442 | 96,64 | 35,645 | 18535,368 |
| Ljuštenje | 17,56 | 6,476 | 3367,974 | 79,08 | 29,168 | 15167,393 |
| Mokre makaze | 8,73 | 3,219 | 1674,397 | 70,35 | 25,948 | 13492,996 |
| Usušenje | 6,53 | 2,408 | 1252,441 | 63,82 | 23,539 | 12240,554 |
| Suve makaze | 1,1 | 0,405 | 210,977 | 62,72 | 23,133 | 12029,576 |
| Obrada sljubnica | 5,86 | 2,161 | 1123,936 | 56,86 | 20,972 | 10905,639 |
| Upresovanje | 2,7 | 0,996 | 517,854 | 54,16 | 19,976 | 10387,785 |
| Formatizovanje | 5,5 | 2,028 | 1054,889 | 48,66 | 17,947 | 9332,895 |
| Brušenje | 3,38 | 1,246 | 648,277 | 45,28 | 16,701 | 8684,617 |
| Ostali tehnološki gubici | 4,45 | 1,641 | 853,501 | 40,83 | 15,059 | 7831,116 |
| Suma | 59,17 | 21,824 | 11348,693 | 40,83 | 15,059 | 7831,116 |

Mlj'= 19 179,81m3 Ds bukve=58cm

n=$\frac{Mlj'}{b ·m ·c}$ = $\frac{19179,81}{260 ·1,32 ·2}$ = 27,942 (kom/sm)

m=$\frac{Ds^{2} ·π}{4} ·Ltrlj$=$\frac{0,58^{2} ·π}{4} ·5=1,32$m3

N=$\frac{n}{Ek}$ = $\frac{27,942}{120}$ = 0,233 →1 (kom) Ek=$\frac{T ·k}{t}$ = $\frac{450 ·0,8}{3 }$ = 120(kom/sm)

Vz= N·T= 0,233 · 450= 104,85

ntrč= n · f= 27,942 · 3= 83,826 (kom) u=3m/min ; f=3

 k1=0,8 ; k2=0,7

 Ltrč= 1,85m

Vtrč=$\frac{Ds^{2} ·π}{4} ·Ltrč$ = $\frac{0,58^{2} ·π}{4} ·1,85$ = 0,488 m3

A=$\frac{60 · V\_{trč} ·u ·k1 ·k2}{Ltrč}$ = $\frac{60 ·0,488 ·3 ·0,8 ·0,7}{1,85}$ = 26,589 m3/h

Radio/la:

26.3.2020.

Kristina Ljubenković

67/2017

Datum

Overio

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