



# 天力铁芯

## TIANLI IRON CORE

GB/T19001-2016/ISO 9001:2015

GB/T24001-2016/ISO 14001:2015

GB/T45001-2020/ISO 45001:2018

GB/T23331-2020/ISO 50001 : 2018

RB/T 119-2015 《能源管理体系 机械制造企业认证要求》

**泰州市天力铁芯制造有限公司**

**Taizhou Tianli Iron Core Manufacturing Co., Ltd.**

地址：江苏省泰州市姜堰梁徐第三工业集中区

邮编：225500

Location: Jiangyan Liangxu No.3 Industrial concentration area, Taizhou City, Jiangsu Province

Postcode: 225500

**TEL : +86 523 8891 8899**

**FAX : +86 523 8891 8266**

E-mail : [tp66281988@163.com](mailto:tp66281988@163.com)

Website : [www.tztltx.com](http://www.tztltx.com)

**泰州市天力铁芯制造有限公司**  
**Taizhou Tianli Iron Core Manufacturing Co., Ltd.**



# 服务网络 SERVICE NETWORK

目前我们的服务网络已经覆盖国内中东部沿海地区，  
未来我们会将优质服务遍布全国，到达全球。  
AT PRESENT, OUR SERVICE NETWORK HAS COVERED THE COASTAL AREAS  
OF THE CENTRAL AND EASTERN PARTS OF THE COUNTRY. IN THE FUTURE,  
WE WILL PROVIDE QUALITY SERVICES ALL OVER THE COUNTRY AND  
REACH THE WORLD.

# 服务客户 CUSTOMERS

部分服务客户



## 铁芯抽样检验记录单

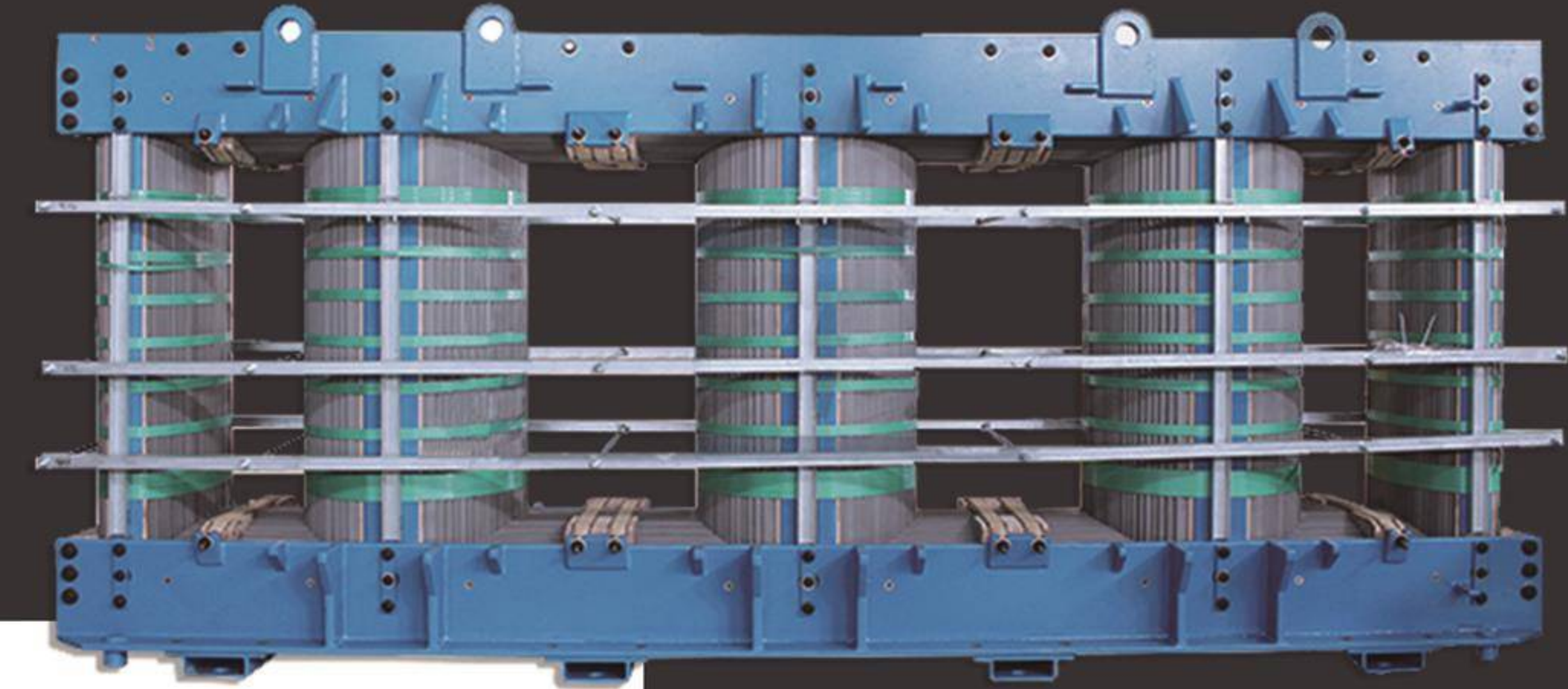
Iron core sampling inspection record

加工单位 Manufacturer		泰州市天力铁芯制造有限公司 Taizhou tianli iron core Co.,Ltd		采购订单号 Requested Form	234254/6
型号/规格 Model/specification		HTDSPZ-31500/110 (图号: 2164.3) Drawing number		检验日期 Inspection date	2023.9.2
序号 Number	检验项目 Test items	标准要求 Standard requirement	抽样数 Sample number	实测数据 Test Result	结论 conclusion
1	接缝 Seam	≤1.0mm	1	0.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
2	空载损耗 No-load Loss	P0≤25000W	1	12351W	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
3	空载电流 No-load current	按照技术协议严格执行, 未标准的按照国际执行 Strictly implement in accordance with the technical agreement, and implement in accordance with the international standard if there is no standard.	1	0.42%	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
4	窗口对角线 Windows diagonal	互差: ≤2.0mm Mutual difference	1	1.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
5	绝缘电阻 Insulation resistance	铁芯对地绝缘电阻≥200MΩ Ground insulation resistance	1	1000mΩ	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
6	心柱 Core Pillar	垂直度: ≤(2/1000) mm Verticality	1	1.8/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		弯曲度: ≤(1.5/1000) mm Curvature	1	1.1/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
7	叠片方式 Lamination method	纵向步进 Vertical stepping	1	纵向步进	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
8	叠厚 Stack thickness	主级厚 135 ±1mm Main leve	1	135mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		总叠厚: 503 ±1mm Total sack thickness	1	503mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
9	窗高和窗宽 Windows height and width	窗高: 2120 ±1mm Height	1	2120mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		窗宽: 530 ±1mm Width	1	530mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
10	铁芯噪音 Core noise	背景噪音: ≤ 40 dB Background noise	1	41dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		测试噪音: ≤ 50 分贝 Test noise	1	51dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
11	夹件尺寸 标准件尺寸 Clip size Standard parts size	按照技术协议严格执行, 未标准的按照国际尺寸公差 (C粗糙度) 执行 Strictly implementation in accordance with the technical agreement, not specified in accordance with the national standard size tolerance (C rough)			合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
12	整体外观 Overall appearance	夹件结构符合图面要求 The structure of the clamp shall meet the requirement of the drawing	1	目测合格	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片无磕碰损伤 Iron chip is free of colision damage	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片尖无变形 No deformation of iron chip tip	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		绑扎牢固可靠 Binding is farm and rellable	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		金属结构件油漆无缺损脱落 The paint of metal structure parts shall be free of defects and falling off	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		油漆颜色符合要求 Paint color meets the requirements	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
结论 Conclusion		本产品经以上项目的检验, 其质量符合标准规定的要求, 准予出厂。 The quality of this batch of products is in conformity with the requirements of the standard of the above items and it is allowed to leave the factory.			

检验员:

# 三相五柱变压器铁芯

## THREE-PHASE FIVE-LEG TRANSFORMER CORE



铁芯抽样检验记录单  
Iron core sampling inspection record

加工单位 Manufacturer		泰州市天力铁芯制造有限公司 Taizhou tianli iron core Co.,Ltd		采购订单号 Requested Form	235425/26
型号/规格 Model/specification		SFSZ18-240000/220 (图号: S20174A.102) Drawing number		检验日期 Inspection date	2023.8.6
序号 Number	检验项目 Test items	标准要求 Standard requirement	抽样数 Sample number	实测数据 Test Result	结论 conclusion
1	接缝 Seam	≤1.0mm	1	0.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
2	空载损耗 No-load Loss	P0≤95000 W	1	86331W	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
3	空载电流 No-load current	按照技术协议严格执行, 未标准的按照国际执行 Strictly implement in accordance with the technical agreement, and implement in accordance with the international standard if there is no standard.	1	0.42%	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
4	窗口对角线 Windows diagonal	互差: ≤2.0mm Mutual difference	1	1.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
5	绝缘电阻 Insulation resistance	铁芯对地绝缘电阻≥200MΩ Ground insulation resistance	1	1000mΩ	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
6	心柱 Core Pillar	垂直度: ≤(2/1000) mm Verticality	1	1.8/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		弯曲度: ≤(1.5/1000) mm Curvature	1	1.1/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
7	叠片方式 Lamination method	纵向步进 Vertical stepping	1	纵向步进	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
8	叠厚 Stack thickness	主级厚 148 ±1mm Main leve	1	148mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		总叠厚: 946 ±1mm Total sack thickness	1	946mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
9	窗高和窗宽 Windows height and width	窗高: 1940 ±1mm Height	1	1940mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		窗宽: 1080 ±1mm Width	1	1080mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
10	铁芯噪音 Core noise	背景噪音: ≤ 40 dB Background noise	1	41dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		测试噪音: ≤ 50 分贝 Test noise	1	51dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
11	夹件尺寸 标准件尺寸 Clip size Standard parts size	按照技术协议严格执行, 未标准的按照国际尺寸公差 (C粗糙度) 执行 Strictly implementation in accordance with the technical agreement, not specified in accordance with the national standard size tolerance (C rough)			合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
12	整体外观 Overall appearance	夹件结构符合图面要求 The structure of the clamp shall meet the requirement of the drawing	1	目测合格	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片无磕碰损伤 Iron chip is free of colision damage	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片尖无变形 No deformation of iron chip tip	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		绑扎牢固可靠 Binding is farm and rellable	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		金属结构件油漆无缺损脱落 The paint of metal structure parts shall be free of defects and falling off	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		油漆颜色符合要求 Paint color meets the requirements	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
结论 Conclusion		本产品经以上项目的检验, 其质量符合标准规定的要求, 准予出厂。 The quality of this batch of products is in conformity with the requirements of the standard of the above items and it is allowed to leave the factory.			

检验员:



# 目录 CONTENTS

/// **董事长致辞** President Address **P3**

/// **企业宗旨** Company Tenet **P4**

/// **企业简介** Company Introduction **P5-6**

/// **企业资质** Company Qualification **P7-8**

/// **企业荣誉** Company Honor **P9-10**

/// **生产设备** Production equipment **P11-14**

/// **企业专利** Enterprise patent **P15-16**

/// **主要产品** Major Product **P17-32**

/// **服务网络与客户** Service & Customer **P33-34**

## 董事长致辞 PRESIDENT ADDRESS



栉风沐雨，砥砺前行；不懈奋进，书写华章。双十年华二十载，我们泰州天力坚持走专业化、精细化、特色化、高端化的创新创业之路，风雨兼程，搏风击浪，已发展成为驰名行业内的国家级“小巨人”企业。

Comb wind and rain, forge ahead; Make unremitting progress, write glorious-chapter. Over the past 20 years, Taizhou Tianli has adhered to the road of innovation and entrepreneurship of specialization, refinement, characteristic and high-end, and has gone through trials and hardships, fighting wind and waves, and has developed into a national-level "little giant" enterprise inside and outside the well-known industry.

作为一个生产制造型企业，我公司一直秉持着“以质量求生存，以诚信待客户，以创新求发展”的原则，严格把关每一道工序。没有最好，只有更好，尽自己最大的努力去满足客户的需求，在保证质量的基础上提高生产效率，扩大规模，促进效益，力争做国内一流铁芯生产企业。

As a manufacturing-oriented enterprise, our company has always been adhering to the principle as "Quality" "Honesty" and "Innovation", No Best, only better, try our best to meet the needs of our customers. In the quality assurance on the basis of improving production efficiency, we will insist to extend business scale, increase more benefits and rank the first class iron core manufacturer of China.

精雕细琢，我们脚踏实地；胸怀天下，我们志存高远。过去已成历史，未来充满挑战。我们公司不断创新，在今年也引进了国内外行业先进水平的生产设备及工艺技术，并取得了卓越的成效，不断完善自己的产品。虽然我们如今已经立足江苏，辐射全国，但是我们不应该满足于现状，应该走出国门，积极地顺应当今全球化发展的大趋势，把自己推销出去，实现自身发展的完美蜕变。

Crafted, we are down to earth; Mind the world, we aim high. The past has become history, the future is full of challenges our company continues to innovate, this year also introduced the domestic and foreign industry advanced level of production equipment and technology, and achieved excellent results, and constantly improve their products. Although we are now based in Jiangsu and radiating the whole country, we should not be satisfied with the status quo, we should go abroad, actively follow the general trend of today's globalization, promote ourselves to achieve the perfect transformation of our own development.

## 企业宗旨 CORPORATE MISSION



我们深信，在社会各界朋友的支持与帮助下，在全体员工的踏实工作中，天力铁芯的未来是美好的。在不久的将来，你们听到的不再是泰州天力铁芯，而是中国天力铁芯！

Greater coordination and support from the public and business circles, further diligence from our workers, we believe our business will have a large blooming, instead of Taizhou Tianli Iron core, we brand China Tianli Iron-core.

A handwritten signature in black ink, likely belonging to the president, written in a stylized cursive font.

## CORE QUALITY CORE HONESTY

# 关于天力 ABOUT US



泰州市天力铁芯制造有限公司成立于2009年5月18日，注册资本为人民币10009万元。泰州市天力铁芯制造有限公司法定代表人严桂娣：于1969.5月出生，文化程度大专，自2009年至今一直担任泰州市天力铁芯制造有限公司董事长。

Taizhou Tianli Iron Core Manufacturing Co., Ltd. was established on May 18, 2009, with a registered capital of RMB 10.09 million. Yan Guidi, legal representative of Taizhou Tianli Iron Core Manufacturing Co., LTD. : Born in 1969.5, college degree. Since 2009, she has been the chairman of Taizhou Tianli Iron Core Manufacturing Co., LTD.

我公司主要生产10~220、330kV级以及特高压级油浸式变压器铁芯、10~35kV干式变压器铁芯、新能源变压器铁芯、互感器铁芯等。作为一家现代化生产型企业，公司先后引进了国内领先设备：现有SL-04-01卷装硅钢分条纵剪机，它是引进了日本技术，速度达到220米/分钟；西安启源ZJX（2005）-1250/80型纵剪、HJX（D262）-800L型横剪线、HJX（D222）-600型横剪、电动HJX（22）-400型横剪以及大族激光切割机共22套生产设备，产品生产实现全数控自动化，各项质量性能指标均达到国家先进水平，年生产能力达到60000吨以上。随着企业生产能力和规模的不断扩大，天力铁芯成为了许多大型央企和国企的金牌配套生产企业。

Our company mainly produces 10 ~ 220, 330kV and UHV oil-immersed transformer core, 10 ~ 35kV dry transformer core, new energy transformer core, transformer core, etc. As a modern production enterprise, the company has introduced domestic leading equipment: the existing SL-04-01 coil-loaded silicon steel slitting machine, which is the introduction of Japanese technology, the speed of up to 220 meters/min; Xi 'an Qiyuan ZJX (2005) -1250/80 type slitting, HJX (D262) -800L type slitting, HJX (D222) -600 type slitting, electric HJX (22) -400 type slitting and large family laser cutting machine and other 22 sets of production equipment, product production to achieve full CNC automation, The quality performance indicators have reached the national advanced level, and the annual production capacity has reached more than 60,000 tons. With the continuous expansion of production capacity and scale of enterprises, Tianli Iron Core has become a gold supporting production enterprise of many large central enterprises and state-owned enterprises.

根据变压器产业的排名，自2013年开始，我在变压器铁芯行业全国名列前茅。我公司自投产以来，发展势头一直较好，近三年纳税销售年均40%以上幅度递增，2016年纳税销售2亿元，2023年纳税销售5亿元，我公司现已被姜堰经济开发区列入江苏省智能电网产业特色联盟重点培育的智能电网电器配件产业基地。

According to the ranking of transformer industry, since 2013, in the transformer core industry rankings, our company's transformer cores are among the top in the nation. Since the company put into operation, the development momentum has been good, the average annual tax sales of more than 40% increased in the past three years, sales of 200 million yuan in 2016, tax sales of 500 million yuan in 2023, my company has been included in Jiangyan Economic Development Zone in Jiangsu Province smart grid industrial characteristics alliance focus on the cultivation of smart grid electrical parts industrial base.

我公司以雄厚的资金实力、高素质的专业人才和优质高效的服务在社会上树立起了良好的企业形象，受到了社会各界与广大客户的普遍信赖与赞扬。我公司决策层卓越的超前意识，全体员工积极进取的敬业精神，社会各界的支持与厚爱，使它在变压器铁芯市场及其他相关领域都取得了显著成绩。在开展国内业务的同时，还对国外业务进行了积极的探索。公司十分注重产品科技含量，并与苏州大学——东吴商学院进行研究探讨，重视科技创新，不断开发和探索新的产品。

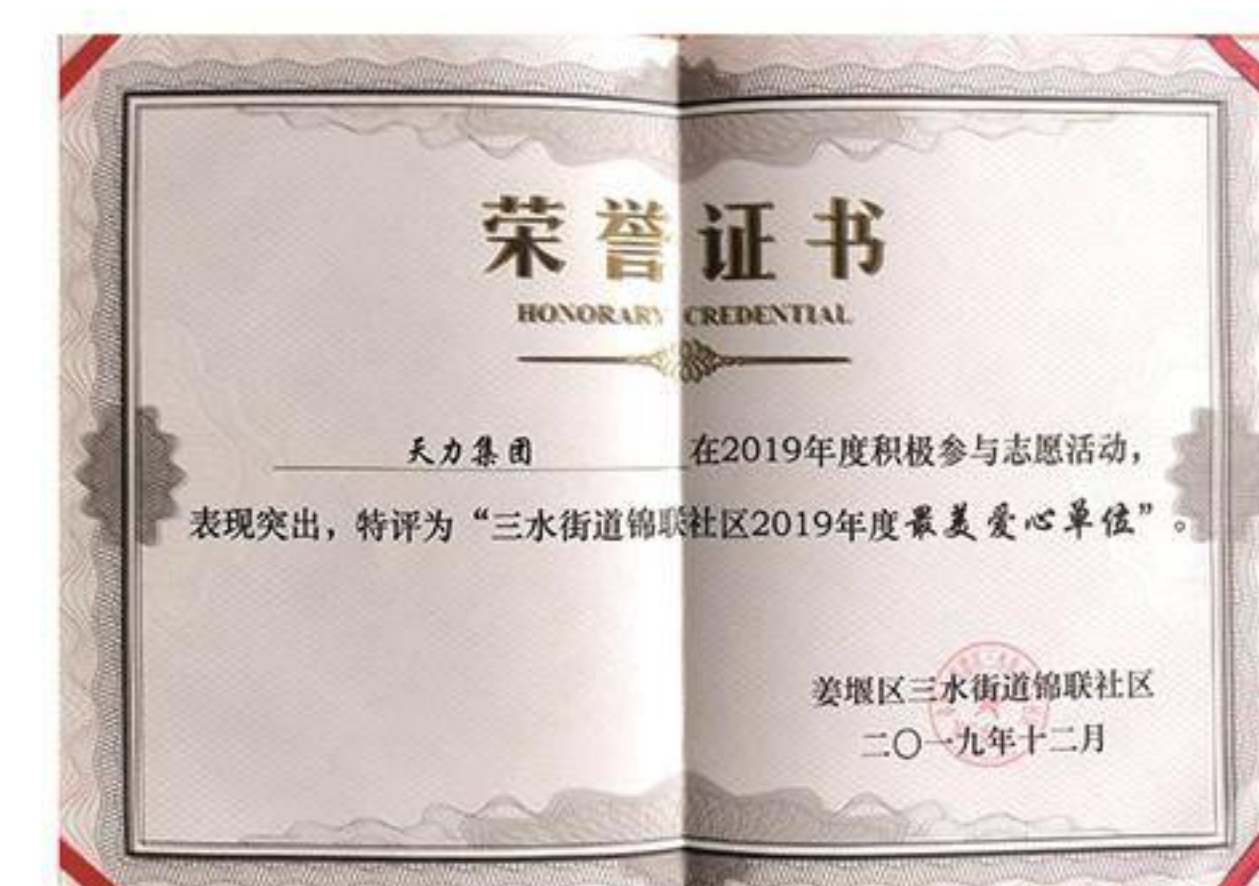
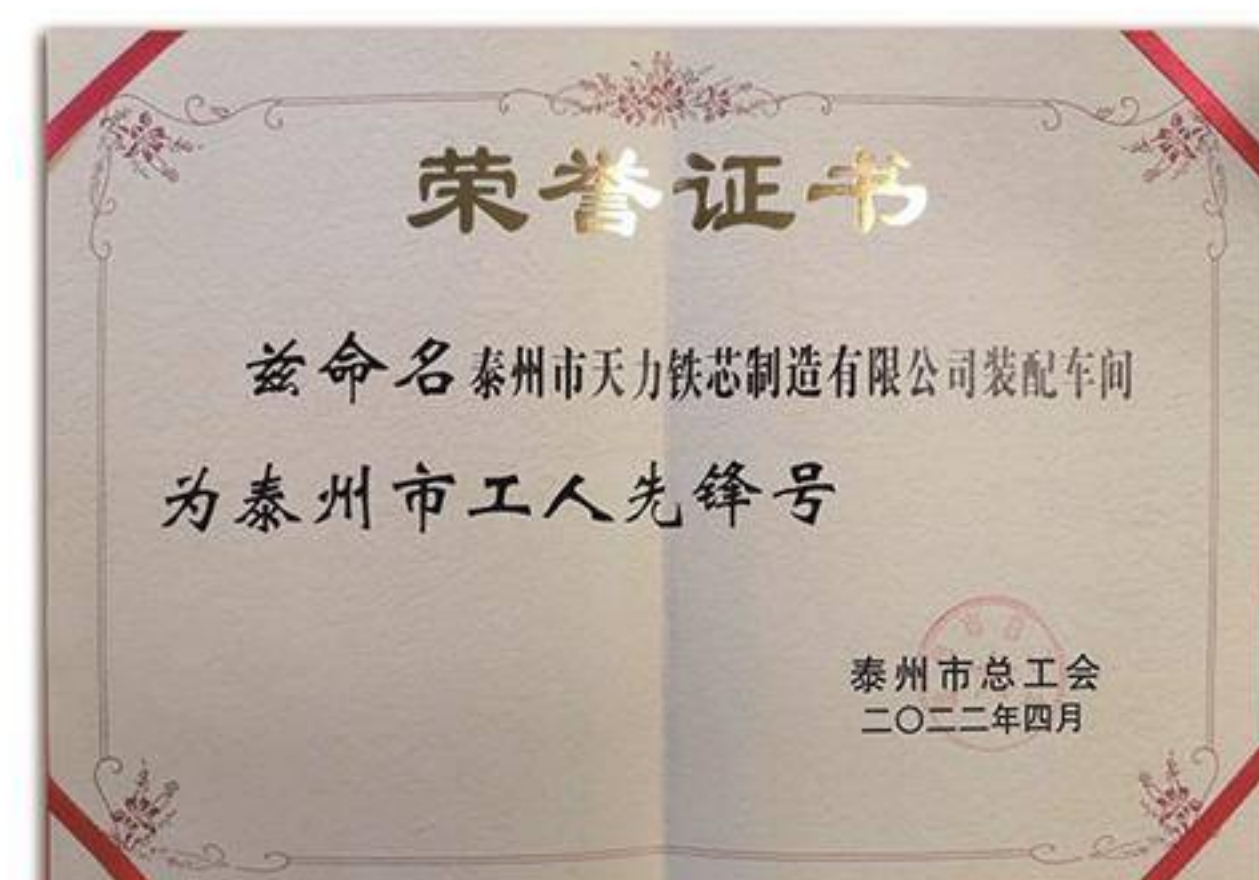
With strong financial strength, high-quality professionals and high-quality and efficient service, our company has established a good corporate image in the society, and has been widely trusted and praised by all walks of life and customers. Our company's outstanding advanced awareness of the decision-making level, the proactive dedication of all employees, the support and love of all walks of life, so that it has made remarkable achievements in the transformer core market and other related fields. While carrying out domestic business, we have also actively explored foreign business. The company attaches great importance to the scientific and technological content of products, and conducts research and discussion with Soochow University-Soochow Business School, attaches great importance to scientific and technological innovation, and constantly develops and explores new products.

“质量赢得市场，诚信铸就品牌”，凭借着设备和技术的优势，泰州市天力铁芯制造有限公司先后被授予国家级专精特新小巨人企业、国家级高新技术企业、江苏省专精特新小巨人企业、江苏省十佳民营企业、江苏省优秀民营科技企业、市级青年安全生产示范岗、市级信用管理示范企业。

"Quality wins the market, integrity casts the brand", with the advantages of equipment and technology, Taizhou Tianli Iron Core Manufacturing Co., Ltd. has been awarded the national specialized new specialty small giant enterprise, national high-tech enterprise, Jiangsu Province specialized new specialty small giant enterprise, Jiangsu Province top Ten private enterprises, Jiangsu Province excellent private science and technology enterprises, municipal youth safety production demonstration post, municipal credit management demonstration enterprise.



# 企业荣誉 OUR HONOR





# 主要生产设备 MAIN PRODUCTION EQUIPMENT



▼ 横剪线: HJX (D262) -800型  
cut-to-length line: HJX (D262) -800

▲ 横剪线: 电动HJX (22) -400型  
cut-to-length line: Electric HJX (22) -400



▲ 纵剪线: ZJX (2005) -1250/80型  
slitting line: ZJX (2005) -1250/80



▲ 横剪线: HJX (D222) -600型  
cut-to-length line: HJX (D222) -600

▼ 自动叠装机  
automatic core stacking robot



# 主要生产设备 MAIN PRODUCTION EQUIPMENT



▲ 大族激光切割机  
Large family laser cutting machine



▲ 激光切割机  
Laser cutter



▲ 数控电液伺服折弯机  
CNC ELECTRO-HYDRAULIC SERVO bending machine



▲ 变压器综合性能测试台  
Comprehensive Performance test-bed of transformer



▲ 电纤激光切割机  
Electric Fiber laser cutting machine

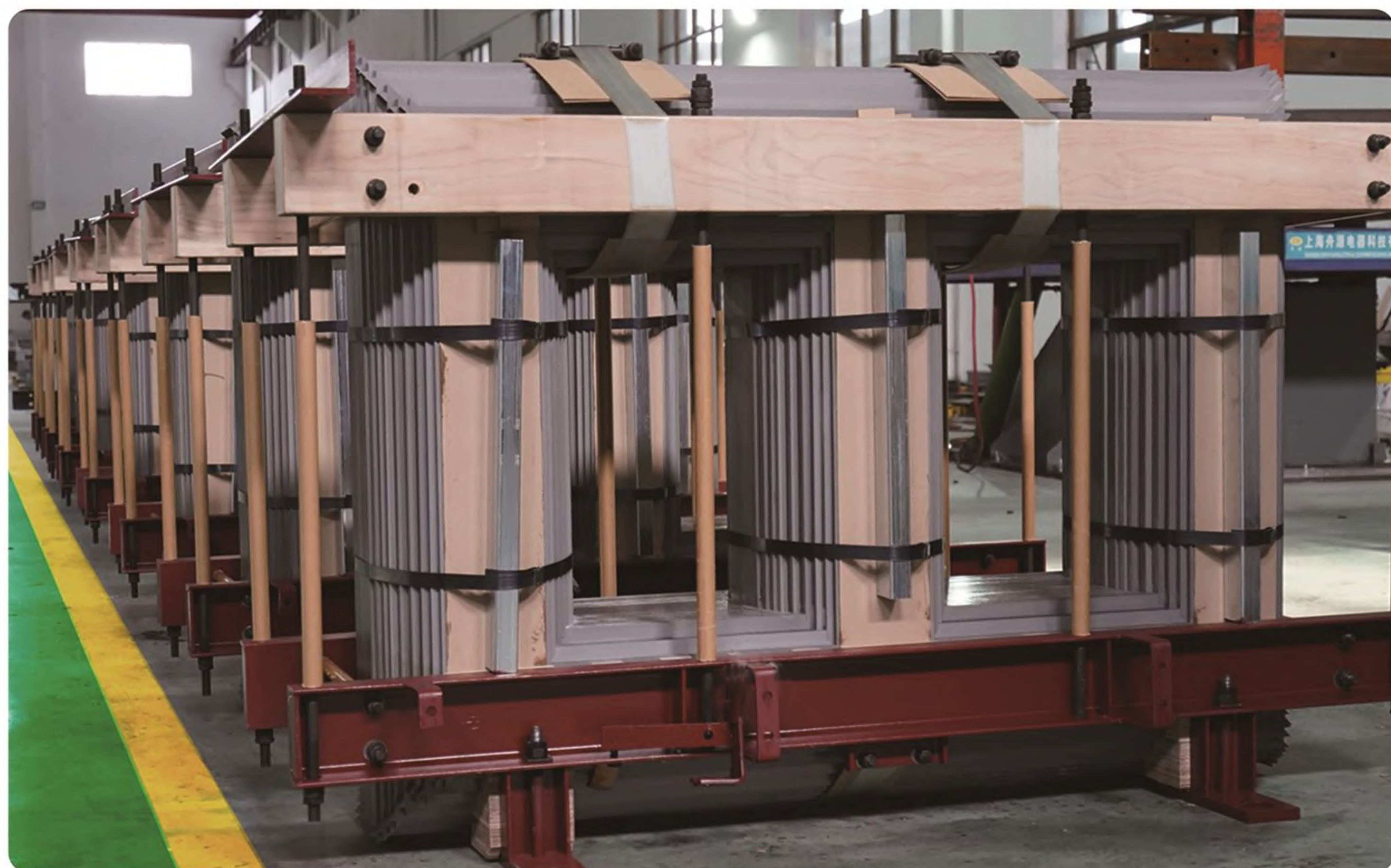
# 企业专利 ENTERPRISE PATENT



原料区  
RAW MATERIAL AREA



成品区  
FINISHED  
PRODUCT AREA



▲ 成品区  
Finished product area



▲ 成品区  
Finished product area



◀ 新能源叠装  
New energy stack

▼ 精致工艺  
Exquisite craftsmanship



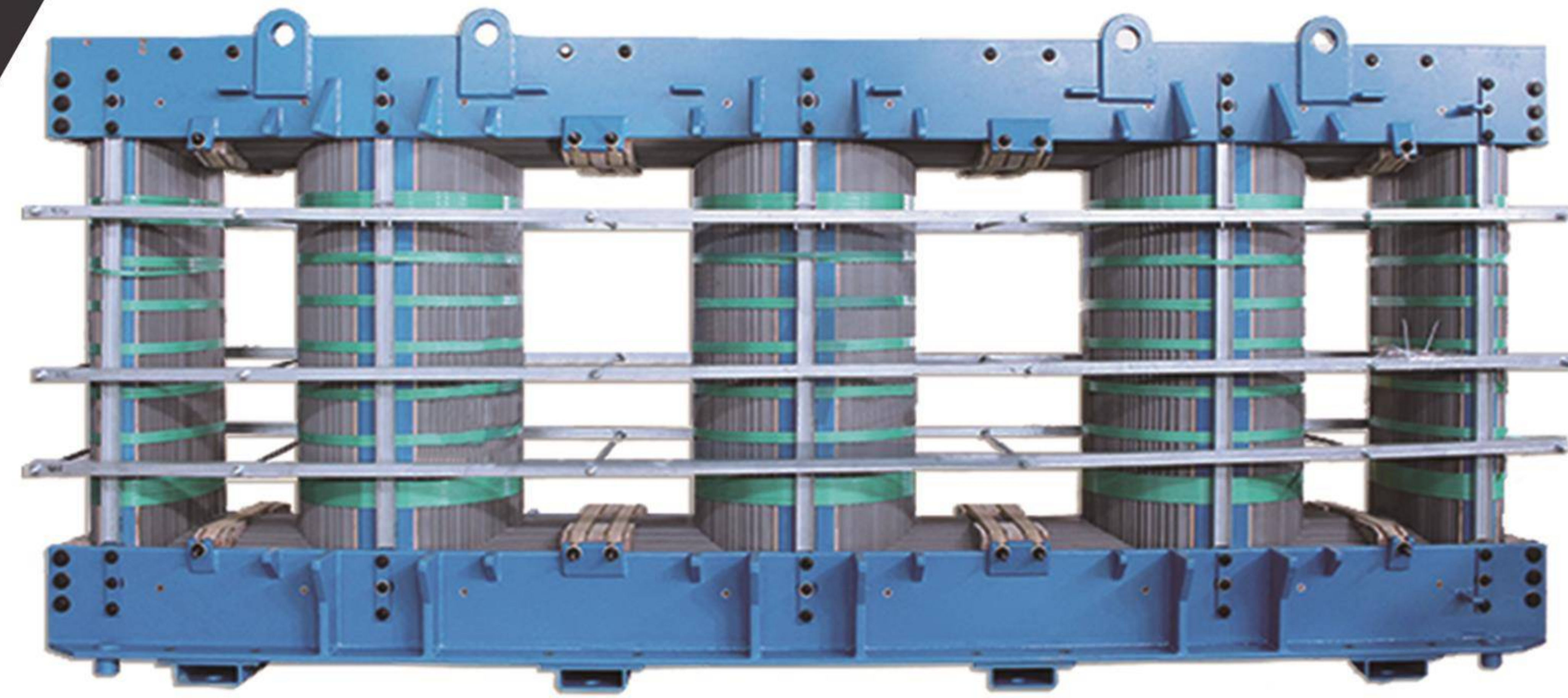
PILED UP

VOLUME CORE  
WORKSHOP



110千伏装备中 ▶  
110 kV equipment

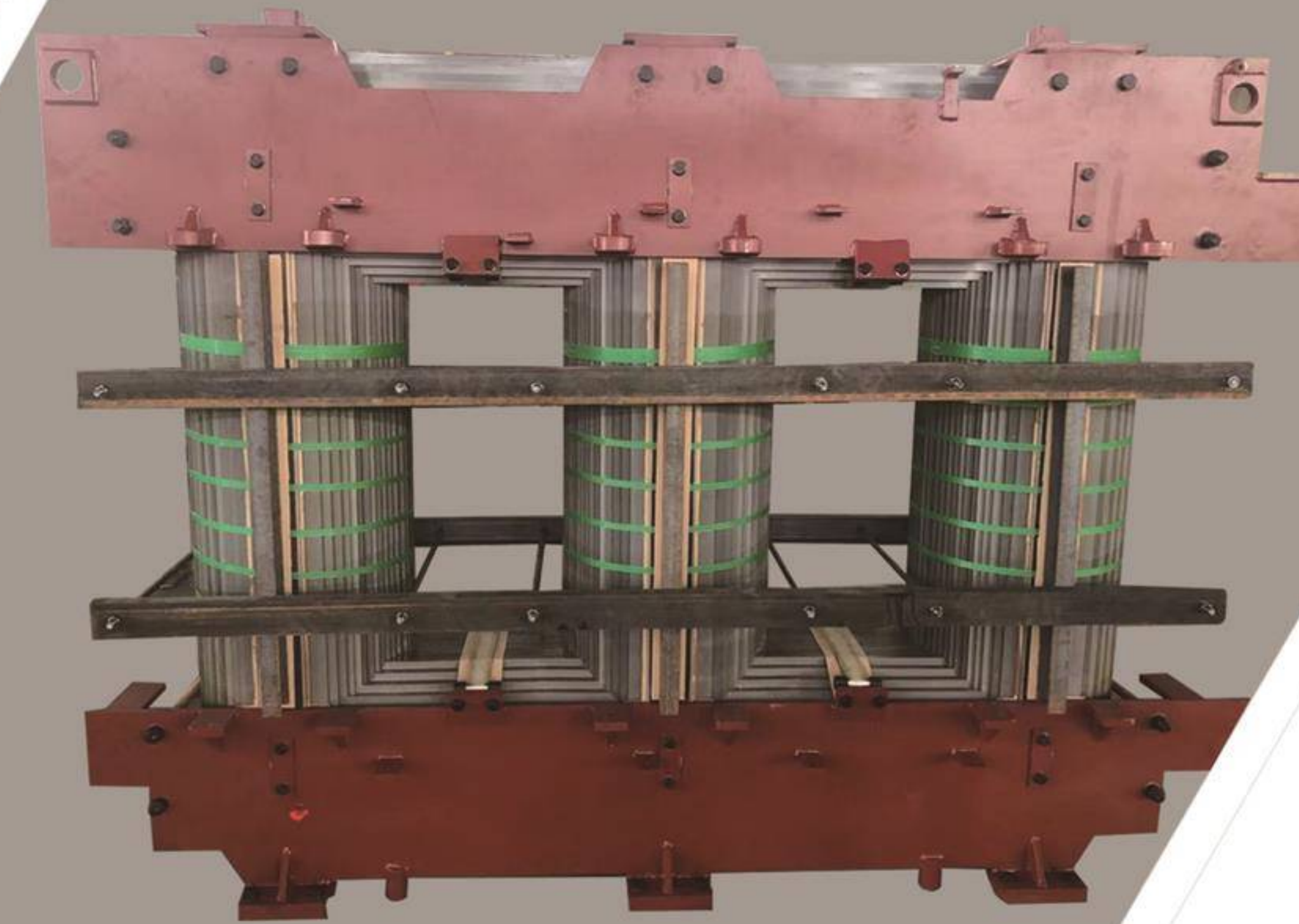




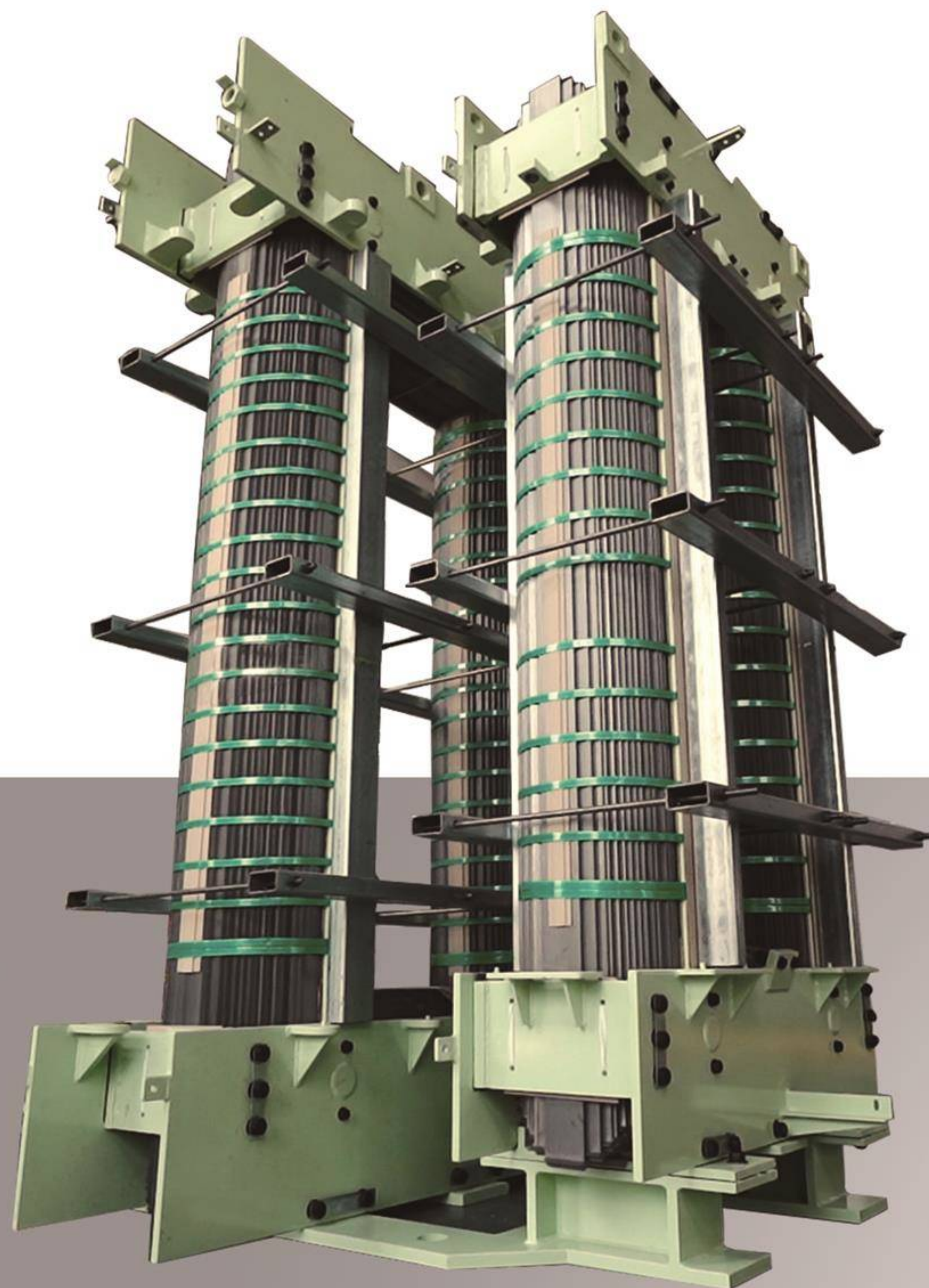
▲ 三相五柱变压器铁芯  
Three-phase five-leg transformer core



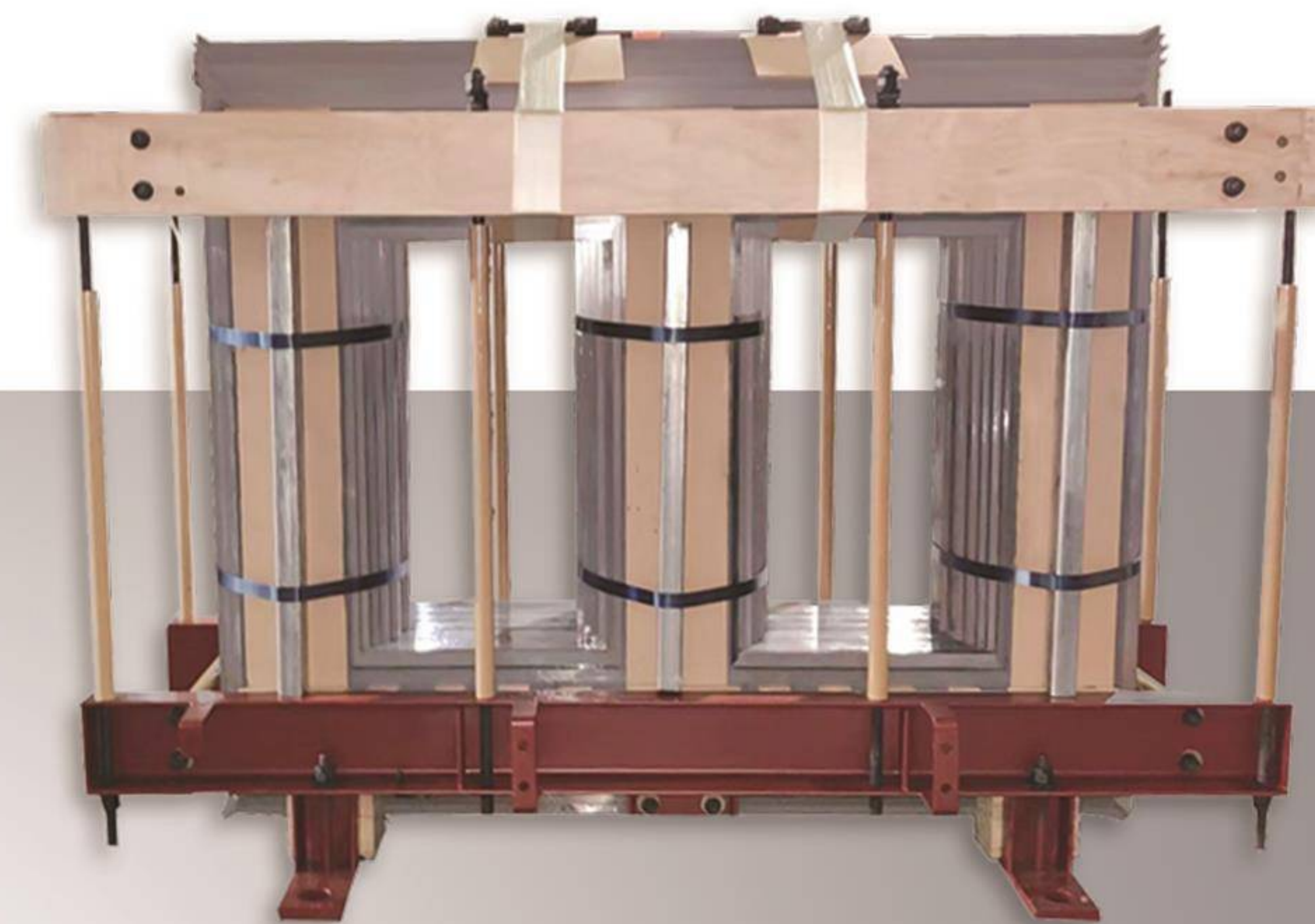
▲ 油浸接地变压器铁芯  
Oil immersed grounding transformer core



▲ 主变变压器铁芯  
Main transformer core



▶ 新能源变压器铁芯  
New energy transformer core



◀ 主串变压器铁芯  
Main string transformer core

# 油浸式变压器铁芯 OIL-IMMERSED TRANSFORMER CORE



## 铁芯抽样检验记录单 Iron core sampling inspection record

加工单位 Manufacturer	泰州市天力铁芯制造有限公司 Taizhou tianli iron core Co.Ltd		采购订单号 Requested form	235651/15	
型号/规格 Model/specification	S22-M-630/10-NX1(图号: 2261.001) Drawing number		检验日期 Inspection date	2023.10.14	
序号 Number	检验项目 Test items	标准要求 Standard requirement	抽样数 Sample number	实测数据 Test Result	结论 conclusion
1	接缝 Seam	≤1.0mm	1	0.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
2	空载损耗 No load Loss	PO ≤ 440 W	1	432 W	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
3	空载电流 No-load current	按照技术协议严格执行, 未标准的按照国际执行 Strictly implement in accordance with the technical agreement, and implement in accordance with the international standard if there is no standard.	1	0.42%	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
4	窗口对角线 Windows diagonal	互差: ≤2.0mm Mutual difference	1	1.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
5	绝缘电阻 Insulation resistance	铁芯对地绝缘电阻 ≥ 200MΩ Ground insulation resistance	1	1000mΩ	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
6	心柱 Core Pillar	垂直度: ≤(2/1000) mm Verticality	1	1.8/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		弯曲度: ≤(1.5/1000) mm Curvature	1	1.1/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
7	叠片方式 Lamination method	纵向步进 Vertical stepping	1	纵向步进	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
8	叠厚 Stack thickness	主级厚 56 ± 1mm Main leve	1	56mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		总叠厚: 239 ± 1mm Total sack thickness	1	239mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
9	窗高和窗宽 Windows height and width	窗高: 645 ± 1mm Height	1	645mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		窗宽: 182 ± 1mm Width	1	182mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
10	铁芯噪音 Core noise	背景噪音: ≤ 40 dB Background noise	1	35dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		测试噪音: ≤ 56 dB Test noise	1	45dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
11	夹件尺寸 标准件尺寸 Clip size Standard parts size	按照技术协议严格执行, 未标准的按照国际尺寸公差(C粗糙度)执行 Strictly implementation in accordance with the technical agreement, not specified in accordance with the national standard size tolerance(C rough)			合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
12	整体外观 Overall appearance	夹件结构符合图面要求 The structure of the clamp shall meet the requirement of the drawing	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片无磕碰损伤 Iron chip is free of colision damage	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片尖无变形 No deformation of iron chip tip	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		绑扎牢固可靠 Binding is farm and reliable	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		金属结构件油漆无缺损脱落 The paint of metal structure parts shall be free of defects and falling off	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		油漆颜色符合要求 Paint color meets the requirements	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
结论 Conclusion	本产品经以上项目的检验, 其质量符合标准规定的要求, 准予出厂。 The quality of this batch of products is in conformity with the requirements of the standard of the above items and it is allowed to leave the factory.				

检验员: \_\_\_\_\_

的检验, 其质量符合标准规定的要求, 准予出厂。  
h of products is in conformity with the requirements of  
d it is allowed to leave the factory.



**“首钢”牌产品质量证明书**  
QUALITY CERTIFICATE OF "SHOUGANG" BRAND

首钢集团地址: 中国北京市石景山区  
ADD. OF SHOUGANG GROUP: SHIJINGSHAN DISTRICT, BEIJING, CHINA  
邮政编码 POST CODE: 100041  
电话 TEL.: (0315) 7706531  
制造厂地址: 中国河北省迁安市  
ADD. OF MANUFACTURER: Qian'an City Hebei Prov., China

制 造 厂: 首钢集团: 首钢智新迁安电磁材料有限公司  
MANUFACTURER: SHOUGANG GROUP: Shougang Zhixin Qian'an Electromagnetic Material Co., LTD.

订货单位 Customer	泰州市天力铁芯制造有限公司	合同编号 Contract No.	Y2111054/GGX220610025	车船号 Train/Ship No.	外库
收货单位 Purchaser	泰州市天力铁芯制造有限公司	交货状态 Condition of Supply	切边 trimming	证明书编号 Certificate No.	GQ220610378127
产品名称 Product	取向电工钢卷 oriented electrical steel	发货日期 Date of Delivery		表号 Record No.	SG-01-dc-01.A
标准 Specification	Q/SGZGS 0342-2020/ Q3	牌号 Steel Grade	20SQGD070	页号 Page No.	共 2 页, 第 1 页

序号 No.	检验号 Inspection No.	炉号 Heat No.	钢卷号/捆包号 Coil/Pack No.	尺寸 Size(mm)	件数 Pcs	重量 Wt. ton	*6 单片铁损 Pl. 7/50 W/kg	*8 单片磁感 B800 T	*9 单片铁损 Pl. 5/50 W/kg	*11 叠装系数 f %
1	Q220601185	222402462	2222124403	0.2 1160	1	3.922	0.68	1.90	0.49	合格 (OK)
2	Q220601234	222402476	2222106502	0.2 1160	1	2.524	0.68	1.91	0.48	合格 (OK)
3	Q220601187	222402464	2222023302	0.2 1140	1	2.642	0.68	1.91	0.48	合格 (OK)
4	Q220601186	222402427	2222129703	0.2 1150	1	4.922	0.68	1.90	0.49	合格 (OK)
5	Q220601186	222402427	2222129702	0.2 1140	1	2.654	0.67	1.91	0.47	合格 (OK)
6	Q220601088	222402333	2222227405	0.2 1180	1	4.440	0.67	1.91	0.47	合格 (OK)
7	Q220601188	222402469	2222267603	0.2 1160	1	4.848	0.67	1.91	0.47	合格 (OK)
8	Q220601188	222402469	2222267602	0.2 1160	1	2.518	0.67	1.91	0.48	合格 (OK)
合计 Total					8	28.470				

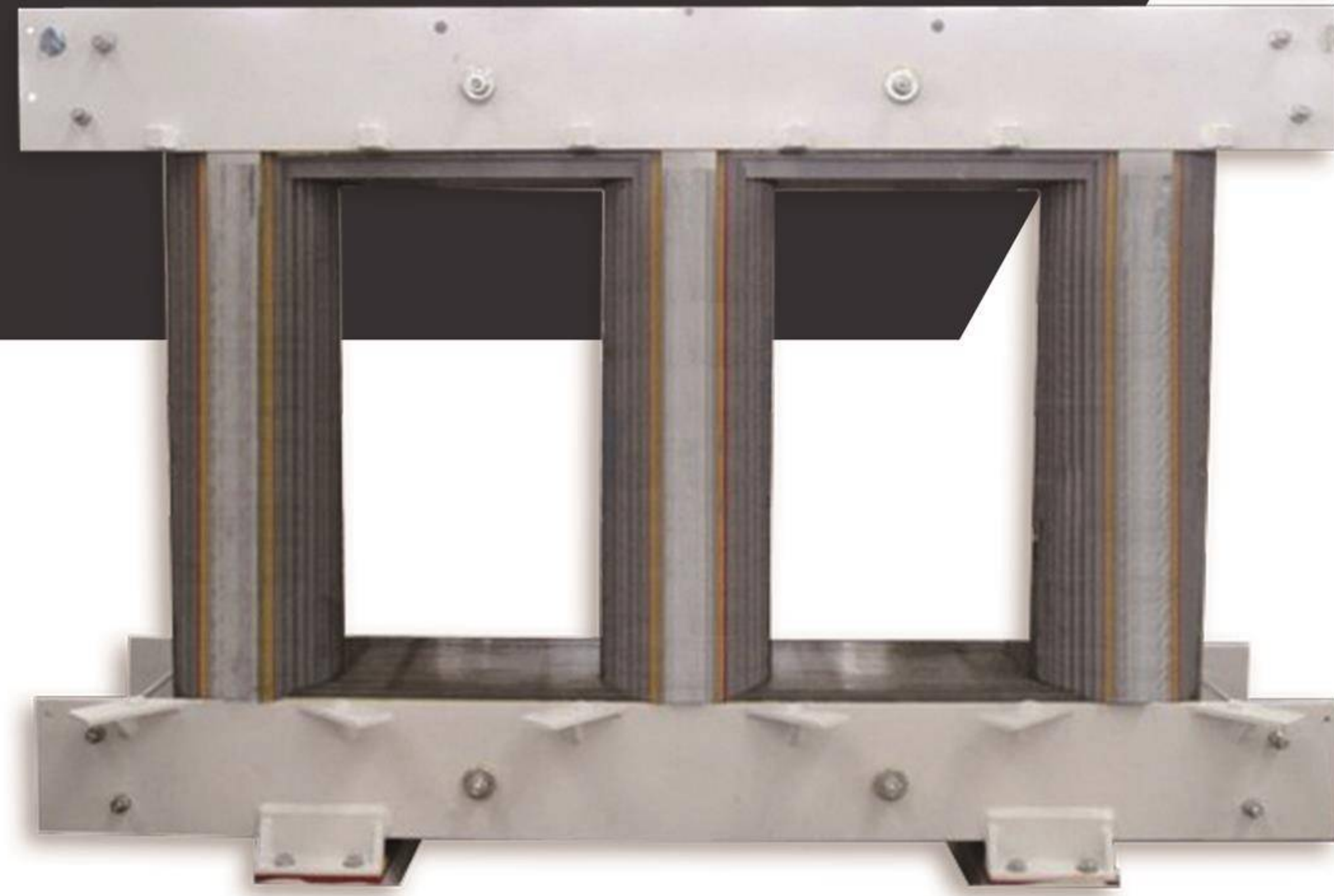
订单号 Order No: 80002111250022  
密度 Density kg/dm<sup>3</sup>: 7.65  
备注 Remarks: \_\_\_\_\_

1. 本产品经检验满足订货标准要求。  
We hereby certify that material described here in has been tested with satisfactory results in accordance with the requirements of the above material specification.  
2. 本证明书空白项目均不作为交货条件。  
Blank items in the quality certificate are not as delivery conditions.  
3. 盖章有效  
(Seal is valid for the entry into force)  
TEL.: 0315-7706098  
E-mail: gxs@gsgg.com

日期 Date: 2022-06-10 17:59:53

质量检验负责人  
Person in Charge of Quality Inspection  
审核  
Check  
NA

# 干式变压器铁芯 DRY-TYPE TRANSFORMER CORE



**WISCO** 武汉钢铁股份有限公司  
WUHAN IRON & STEEL COMPANY LIMITED

产品质量证明书  
CERTIFICATE OF PRODUCT QUALITY

地址：中国·武汉·青山  
ADDRESS: QINGSHAN, WUHAN, P. R. C.  
邮编：430083  
POST CODE: 430083  
TELEPHONE: (027) 86898888

订货单位 SOLD TO	上海武钢华东销售有限公司无锡分公司		产品名称 PRODUCT	冷轧取向硅钢卷 GRAIN ORIENTED SILICON STEEL S		
收货单位 PURCHASER	上海武钢华东销售有限公司无锡分公司		订单编号 ORDER NO.	76D80886E	证书编号 CERTIFICATE NO.	170618G0038
技术条件 SPECIFICATION	Q/WG (GG) 02-2016, 30Q120 约定密度 7.65kg/dm <sup>3</sup> 磁性性能标准 GB/T 3655 试样状态: 纵向, 经800°C 2h, 100% N2退火		客户编号 CUSTOMER NO.	214011024	合同号 CONTRACT NO.	
检验 INSPECTION	武钢检验 (WISCO INSPECTION)		发货日期 DATE OF DELIVERY	2017.06.17	证书日期 T/C ISSUE DATE	2017.06.18
份数	2	车船号 TRAIN/SHIP NO.	船号 W51012			

项 目 项 号	标签号 LABEL NO.	规格及重量 MATERIAL DESCRIPTION			炉号 HEAT NO.	钢卷号 COIL NO.	拉伸试验*A2 G.L.		屈服 Y.S.	抗拉 T.S.	伸长 EL.	*NB 磁感 铁损 P1.5 /50 W/kg	*NL 铁损 P1.7 /50 W/kg	*NC 铁损 P1.7 /50 W/kg	*ND 铁损 P1.7 /50 W/kg	*NE 铁损 P1.7 /50 W/kg	*NF 铁损 P1.7 /50 W/kg	*NG 铁损 P1.7 /50 W/kg	*NH 铁损 P1.7 /50 W/kg	*NI 铁损 P1.7 /50 W/kg	*NJ 铁损 P1.7 /50 W/kg	*NK 铁损 P1.7 /50 W/kg	*NL 铁损 P1.7 /50 W/kg	*NM 铁损 P1.7 /50 W/kg	*NN 铁损 P1.7 /50 W/kg	*NO 铁损 P1.7 /50 W/kg	*NP 铁损 P1.7 /50 W/kg	*NQ 铁损 P1.7 /50 W/kg	*NR 铁损 P1.7 /50 W/kg	*NS 铁损 P1.7 /50 W/kg	*NT 铁损 P1.7 /50 W/kg	*NU 铁损 P1.7 /50 W/kg	*NV 铁损 P1.7 /50 W/kg	*NW 铁损 P1.7 /50 W/kg	*NX 铁损 P1.7 /50 W/kg	*NY 铁损 P1.7 /50 W/kg	*NZ 铁损 P1.7 /50 W/kg
		厚度 THICK mm	宽度 WIDTH mm	数量 QTY			重量 WEIGHT t																														
01	C247015435	0.30	990	1	1.900	D722711A	730308654					1.88	0.759	1.062	97.0	2																					
合计	TOTAL	数量 QTY: 1			重量 WEIGHT: 1.900 t																																

备注 MARK		
注释 NOTES	*NJ Magnetic Induction *ND Iron Loss *NL Iron Loss *NC Lamination Factor *ND Repeated Bending	磁感应强度 铁损 铁损 叠装系数 最小弯曲次数
会签者 SURVEYOR TO	兹证明本表所列产品, 均以产品标准制造及试验, 并符合标准之要求。 We hereby certify that the products listed in the table have been manufactured and tested according to the standards, and accordance with the request of standards.	
	 质量负责人 QUALITY MANAGER	

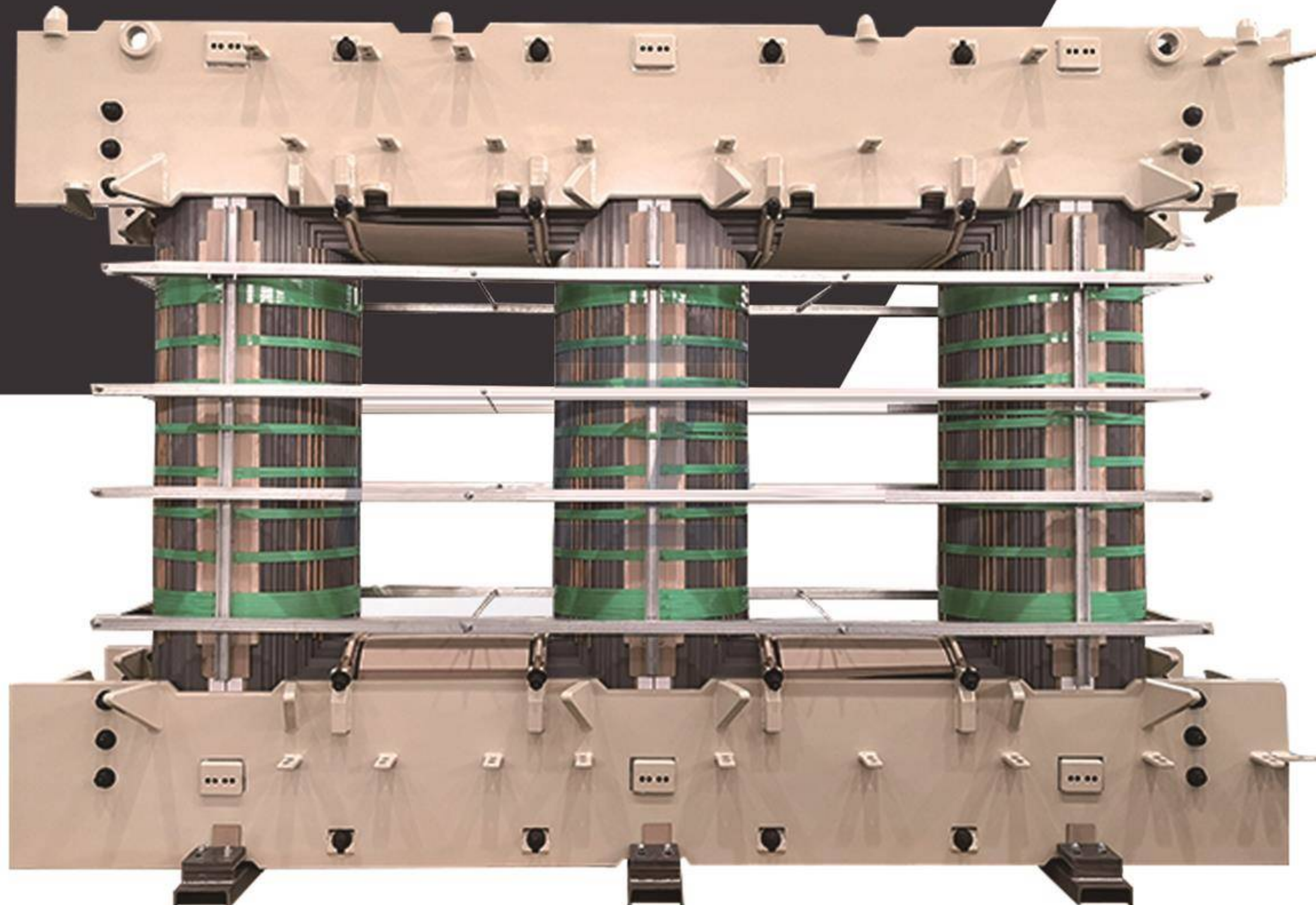
## 铁芯抽样检验记录单 Iron core sampling inspection record

加工单位 Manufacturer	泰州市天力铁芯制造有限公司 Taizhou tianli iron core Co., Ltd		采购订单号 Requested form	235905/9+	
型号/规格 Model/specification	SCLB18-2000/10.5 (图号: 6TX.280.2693.1-WG.J) Drawing number		检验日期 Inspection date	2023.10.25	
序号 No.	检验项目 Test items	标准要求 Standard requirement	抽样数 Sample number	实测数据 Test Result	结论 conclusion
1	接缝 Seam	≤1.0mm	1	0.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
2	空载损耗 No-load Loss	P0 ≤ 1707 W	1	1688W	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
3	空载电流 No-load current	按照技术协议严格执行, 未标准的按照国际执行 Strictly implement in accordance with the technical agreement, and implement in accordance with the international standard if there is no standard.	1	0.23%	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
4	窗口对角线 Windows diagonal	互差: ≤2.0mm Mutual difference	1	1.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
5	绝缘电阻 Insulation resistance	铁芯对地绝缘电阻 ≥200MΩ Ground insulation resistance	1	1000mΩ	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
6	心柱 Core Pillar	垂直度: ≤(2/1000) mm Verticality	1	1.7/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		弯曲度: ≤(1.5/1000) mm Curvature	1	1.2/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
7	叠片方式 Lamination method	纵向步进 Vertical stepping	1	纵向步进	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
8	叠厚 Stack thickness	主级厚 177 ±1mm Main level	1	178mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		总叠厚: 300 ±1mm Total sack thickness	1	301mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
9	窗高和窗宽 Windows height and width	窗高: 1360 ±1mm Height	1	1360mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		窗宽: 415 ±1mm Width	1	415mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
10	铁芯噪音 Core noise	背景噪音: ≤ 42 dB Background noise	1	37dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		测试噪音: ≤ 55 dB Test noise	1	46dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
11	夹件尺寸 Clip size 标准件尺寸 Standard parts size	按照技术协议严格执行, 未标准的按照国际尺寸公差 (C粗糙度) 执行 Strictly implementation in accordance with the technical agreement, not specified in accordance with the national standard size tolerance (C rough)			合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
12	整体外观 Overall appearance	夹件结构符合图面要求 The struture of the clamp shall meet the requirement of the drawing	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片无磕碰损伤 Iron chip is free of collision damage	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片尖无变形 No deformation of iron chip tip	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		绑扎牢固可靠 Binding is farm and reliable	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		金属结构件油漆无缺损脱落 The paint of metal structure parts shall be free of defects and falling off	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		油漆颜色符合要求 Paint color meets the requirements	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
结论 Conclusion	本产品经以上项目的检验, 其质量符合标准规定的要求, 准予出厂。 The quality of this batch of products is in conformity with the requirements of the standard of the above items and it is allowed to leave the factory.				

检验员:



# 主变压器铁芯 MAIN TRANSFORMER CORE



**WISCO** 武汉钢铁股份有限公司  
WUHAN IRON & STEEL COMPANY LIMITED

产品质量证明书  
CERTIFICATE OF PRODUCT QUALITY

地址：中国·武汉·青山  
ADDRESS: QINGSHAN, WUHAN, P. R. C  
邮编：430083  
POST CODE: 430083  
TELEPHONE: (027) 86898888

订货单位 SOLD TO	上海武钢华东销售有限公司无锡分公司		产品名称 PRODUCT	冷轧取向硅钢卷 GRAIN ORIENTED SILICON STEEL S		
收货单位 PURCHASER	上海武钢华东销售有限公司无锡分公司		订单编号 ORDER NO.	7GDS0886E	证书编号 CERTIFICATE NO.	170618G0038
技术条件 SPECIFICATION	Q/WG (GG) 02-2016, 30Q120 约定密度 7.65kg/dm <sup>3</sup> 磁性检验标准 GB/T 3655 试样状态: 纵向, 经800°C 2h, 100% N2退火		客户编号 CUSTOMER NO.	214011024	合同号 CONTRACT NO.	
检验 INSPECTION	武钢检验 (WISCO INSPECTION)		发货日期 DATE OF DELIVERY	2017.06.17	证书日期 T/C ISSUE DATE	2017.06.18
份数	2	车船号 TRAIN/SHIP NO.	船号 W51012			

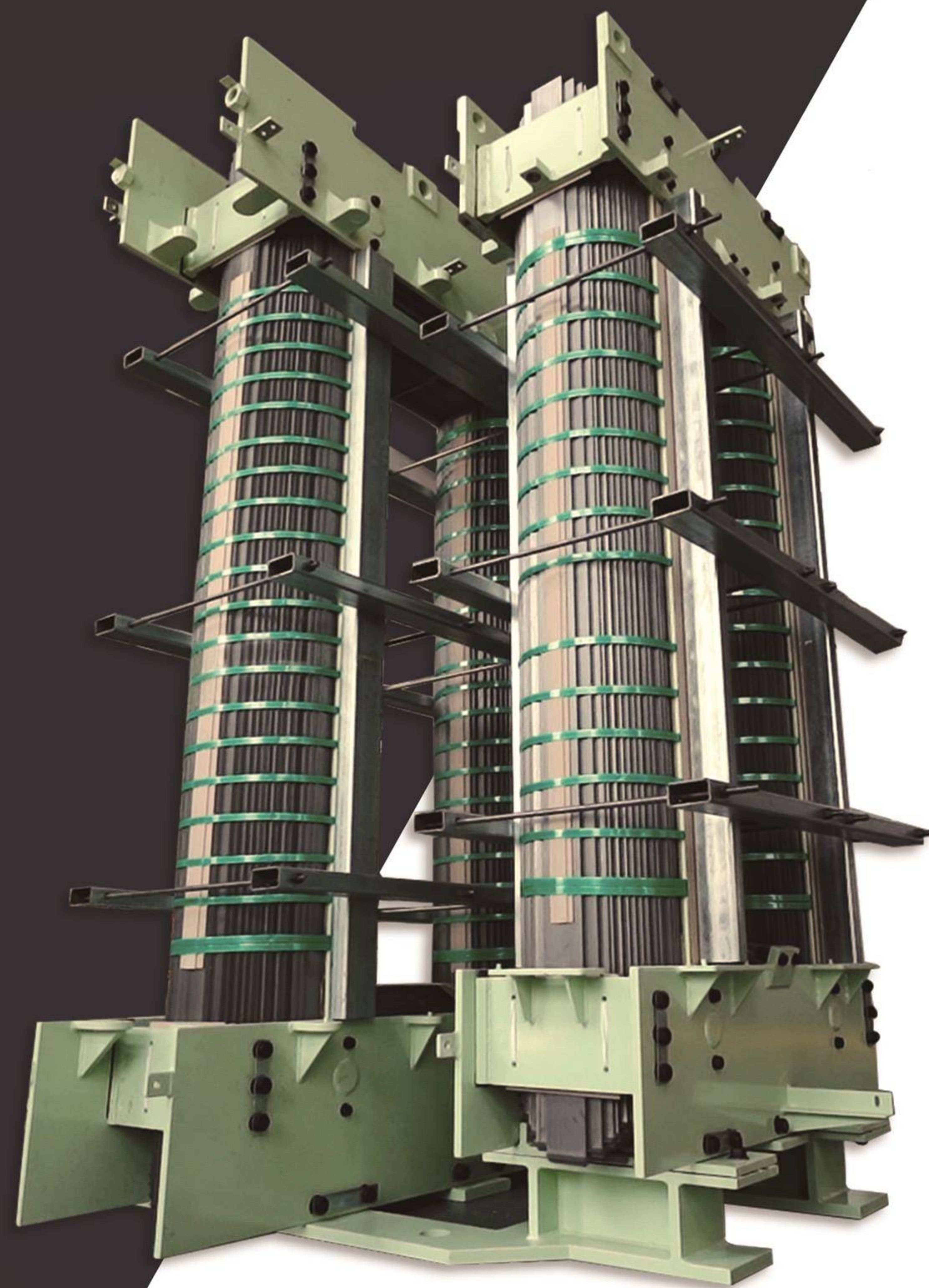
项 目 Item	标签号 LABEL NO.	规格及重量 MATERIAL DESCRIPTION			炉号 HEAT NO.	钢卷号 COIL NO.	拉伸试验*A2 G.L.		*NB 屈服 Y.S.	*NB 抗拉 T.S.	*NL 伸长 EL.	*NC P1.5 /50 W/kg	*ND P1.7 /50 W/kg	*ND 叠装系数 次数
		厚度 THICK mm	宽度 WIDTH mm	数量 QTY			重量 WEIGHT t	%						
01	C247015435	0.30	990	1	1.900	0722711A	730308654							
合计 TOTAL		数量 QTY: 1					重量 WEIGHT: 1.900 t							

备注 MARK	
注释 NOTES	*NJ Magnetic Induction 磁感应强度 *ND Iron Loss 铁损 *NL Iron Loss 铁损 *NC Lamination Factor 叠装系数 *ND Repeated Bending 最小弯曲次数
会签者 SURVEYOR TO	兹证明本表所列产品, 均以产品标准制造及试验, 并符合标准之要求。 We hereby certify that the products listed in the table have been manufactured and tested according to the standards, and accordance with the request of standards.
	 柳志斌 质量负责人 QUALITY MANAGER

## 铁芯抽样检验记录单 Iron core sampling inspection record

加工单位 Manufacturer	泰州市天力铁芯制造有限公司 Taizhou Tianli iron core Co., Ltd	采购订单号 Requested from	181006-1+8		
型号/规格 Model/specification	SFZ11-40000 (图号: 0050) Drawing number	检验日期 Inspection date	2019.6.9		
序号 Number	检验项目 Test items	标准要求 Standard requirement	抽样数 Sample number	实测数据 Test Result	结论 Conclusion
1	接缝 Seam	≤1.0mm	1	0.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
2	空载电流 No-load current	按照技术协议严格执行, 未标准的按照国际执行 Strictly implement in accordance with the technical agreement, and implement in accordance with the international standard if there is no standard.	1	0.42 %	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
3	空载损耗 No-load loss	PO ≤ 26500W	1	25580W	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
4	窗口对角线 Window diagonal	互差 ≤ 2.0mm Mutual difference	1	1.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
5	绝缘电阻 Insulation resistance	铁芯对地绝缘电阻 ≥ 500MΩ Ground insulation resistance	1	1000 MΩ	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
6	心柱 Core column	垂直度: ≤ (2/1000) mm Verticality	1	1.8/1000 mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
		弯曲度: ≤ (1.5/1000) mm Curvature	1	1.1/1000 mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
7	叠片方式 Lamination method	纵向步进 Vertical stepping	1	纵向步进	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
8	叠厚 Stack thickness	主级厚: 119 ±1mm Main level	1	119mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
		总叠厚: 581 ±1mm Total stack thickness	1	581mm	
9	窗高与窗宽 Window height and width	窗高: 955 ±1mm Height	1	954.9 mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
		窗宽: 1070 ±1mm Width	1	1070.1mm	
10	铁芯噪音 Core noise	背景噪音: ≤ 38dB Background noise	1	36dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
		测试噪音: ≤ 78dB Test noise	1	70dB	
11	夹件尺寸 Clip size 标准件尺寸 Standard parts size	按照技术协议严格执行, 未标准的按照国际尺寸公差 (C粗糙度) 执行 Strict implementation in accordance with the technical agreement, not specified in accordance with the national standard size tolerance (C rough)			合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
12	整体外观 Overall appearance	夹件结构符合图面要求 The structure of the clamp shall meet the requirements of the drawing	1	目测合格 Visually qualified	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Failed <input type="checkbox"/>
		铁芯片无磕碰损伤 Iron chip is free of collision damage	1		
		铁芯片尖无变形 No deformation of iron chip tip	1		
		绑扎牢固可靠 Binding is firm and reliable	1		
		金属结构件油漆无缺损脱落 The paint of metal structure parts shall be free of defects and falling off	1		
油漆颜色符合要求 Paint color meets the requirements	1				
结论 Conclusion	这批产品经以上项目的检验, 其质量符合标准规定的要求, 准予出厂。 The quality of this batch of products is in conformity with the requirements of the standard after the inspection of the above items, and it is allowed to leave the factory.				

# 主串变压器铁芯 MAIN STRING TRANSFORMER CORE



## 铁芯抽样检验记录单 Iron core sampling inspection record

加工单位 Manufacturer		泰州市天力铁芯制造有限公司 Taizhou tianli iron core Co.,Ltd		采购订单号 Requested form	234255/6
型号/规格 Model/specification		HTDSPZ-31500/110 (图号: 2164.5) Drawing number		检验日期 Inspection date	2023.9.2
序号 Number	检验项目 Test items	标准要求 Standard requirement	抽样数 Sample number	实测数据 Test Result	结论 conclusion
1	接缝 Seam	≤1.0mm	1	0.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
2	空载损耗 No-load Loss	P0≤25000W	1	9163W	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
3	空载电流 No-load current	按照技术协议严格执行, 未标准的按照国际执行 Strictly implement in accordance with the technical agreement, and implement in accordance with the international standard if there is no standard.	1	0.42%	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
4	窗口对角线 Windows diagonal	互差: ≤2.0mm Mutual difference	1	1.5mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
5	绝缘电阻 Insulation resistancance	铁芯对地绝缘电阻≥200MΩ Ground insulation resistance	1	1000mΩ	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
6	心柱 Core Pillar	垂直度: ≤(2/1000) mm Verticality	1	1.8/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		弯曲度: ≤(1.5/1000) mm Curvature	1	1.1/1000mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
7	叠片方式 Lamination method	纵向步进 Vertical stepping	1	纵向步进	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
8	叠厚 Stack thickness	主级厚 98 ±1mm Main leve	1	98mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		总叠厚: 416 ±1mm Total sack thickness	1	416mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
9	窗高和窗宽 Windows height and width	窗高: 1880 ±1mm Height	1	1880mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		窗宽: 250 ±1mm Width	1	250mm	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
10	铁芯噪音 Core noise	背景噪音: ≤ 40 dB Background noise	1	41dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		测试噪音: ≤ 50 分贝 Test noise	1	51dB	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
11	夹件尺寸 Clip size 标准件尺寸 Standard parts size	按照技术协议严格执行, 未标准的按照国际尺寸公差(C粗糙度)执行 Strictly implementation in accordance with the technical agreement, not specified in accordance with the national standard size tolerance(C rough)			合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
12	整体外观 Overall appearance	夹件结构符合图面要求 The struture of the clamp shall meet the requirement of the drawing	1	目测合格	合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片无磕碰损伤 Iron chip is free of colision damage	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		铁芯片尖无变形 No deformation of iron chip tip	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		绑扎牢固可靠 Binding is farm and reliable	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		金属结构件油漆无缺损脱落 The paint of metal structure parts shall be free of defects and falling off	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
		油漆颜色符合要求 Paint color meets the requirements	1		合格 <input checked="" type="checkbox"/> 不合格 <input type="checkbox"/> Qualified <input checked="" type="checkbox"/> Unqualified <input type="checkbox"/>
结论 Conclusion		本产品经以上项目的检验, 其质量符合标准规定的要求, 准予出厂。 The quality of this batch of products is in conformity with the requirements of the standard of the above items and it is allowed to leave the factory.			

检验员: