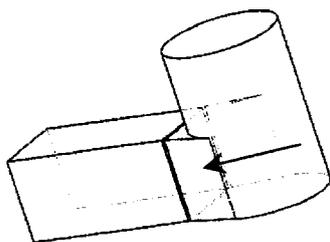
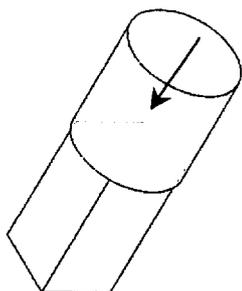
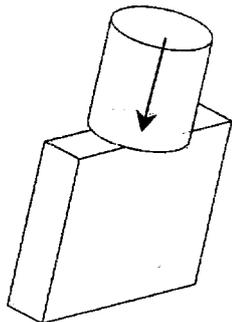
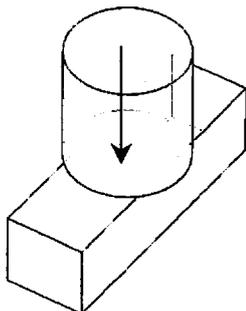


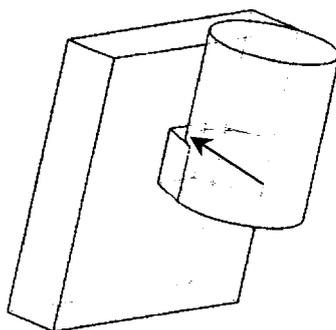
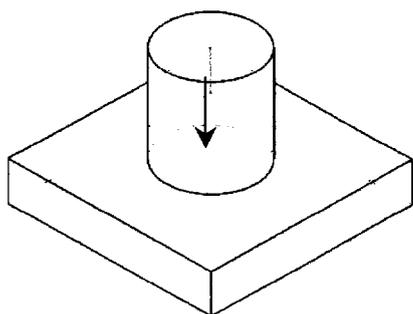
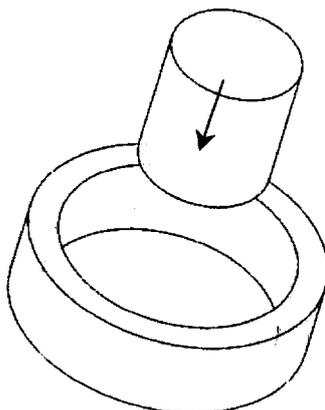
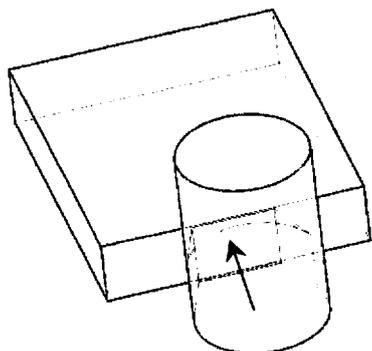
**SENS D'ALIMENTATION**



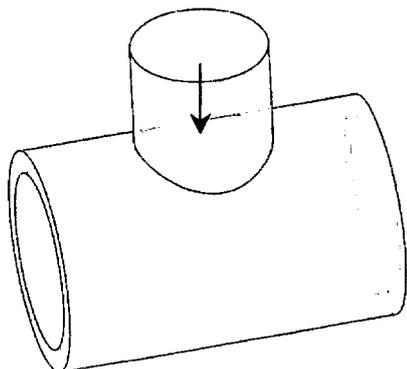
**Masselotte « en  
bout »  
 $2,8 < k < 3$**



**Masselotte « sur chant »  
 $3 < k < 3,6$**



**Masselotte « à plat »  
 $3,6 < k < 4,3$**



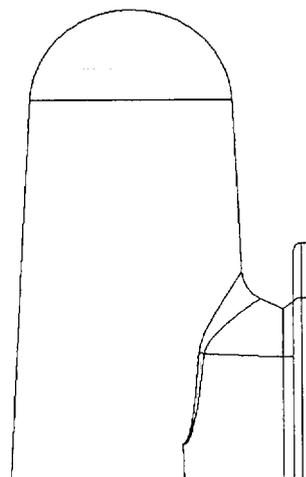
FORMULAIRE**MASSELOTTAGE**

$$D_0 = k \cdot e'$$

$H / D_0 = 1,5$  pour masselotte en charge

$H / D_0 = 2$  pour masselotte à talon

Exemple de définition  
masselotte borgne à  
talon, atmosphérique

**TEMPS DE REFROIDISSEMENT**

Temps de refroidissement (Tl) des pièces en alliages légers  
pour une épaisseur caractéristique de 6mm

Surchauffe	Tl
50°C	0,6 sec
100°C	2,7 sec
150°C	6 sec
200°C	11 sec

Rappel :

$$H = \left( \frac{H_i + \sqrt{H_i \times H_f}}{(1+a)\sqrt{H_i} + (1-a)\sqrt{H_f}} \right)^2$$

$$S_d = \frac{V_0}{Tr \times \sqrt{2gH}} \times \frac{1}{Rh}$$

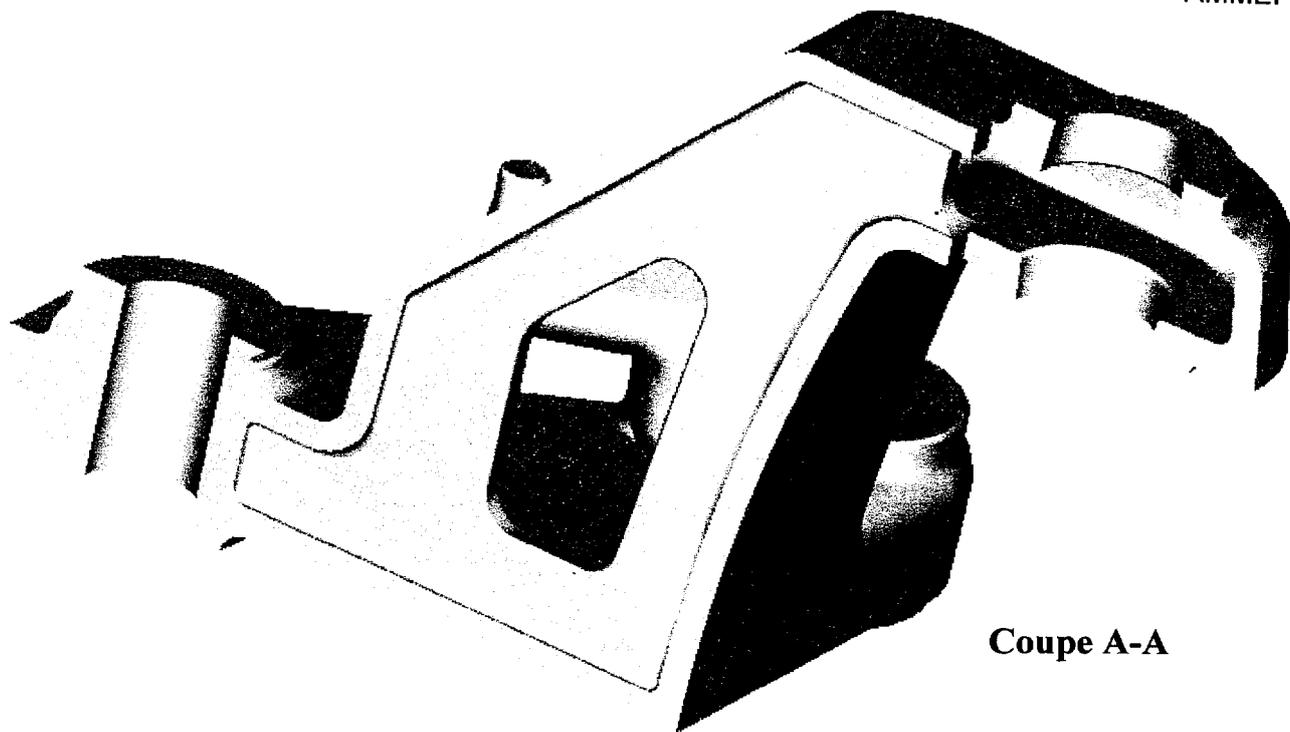
$a$  = proportion du volume en source

$1-a$  = proportion du volume total en chute

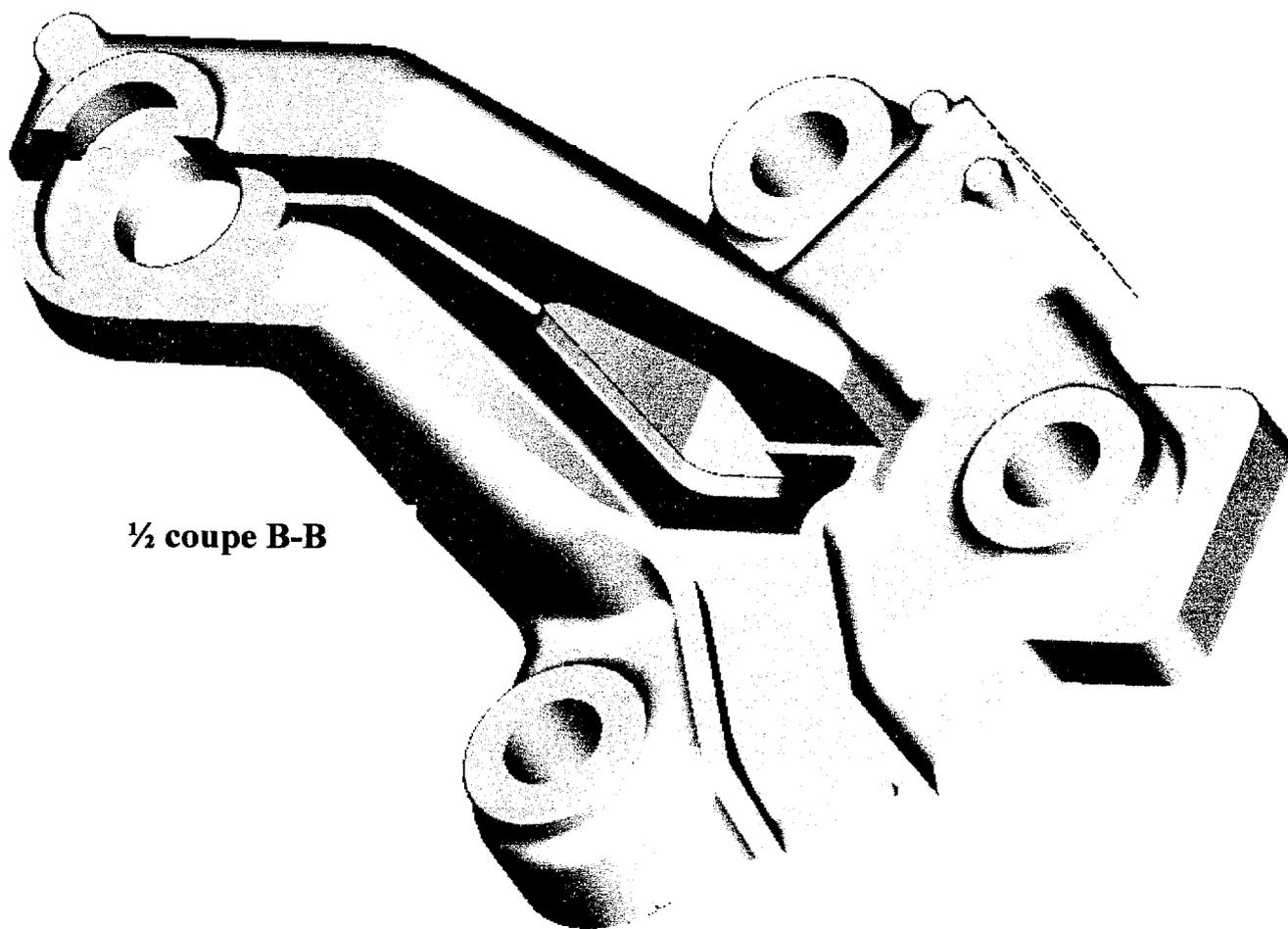
$V_0$  en  $dm^3$

Pour l'application, on prendra :

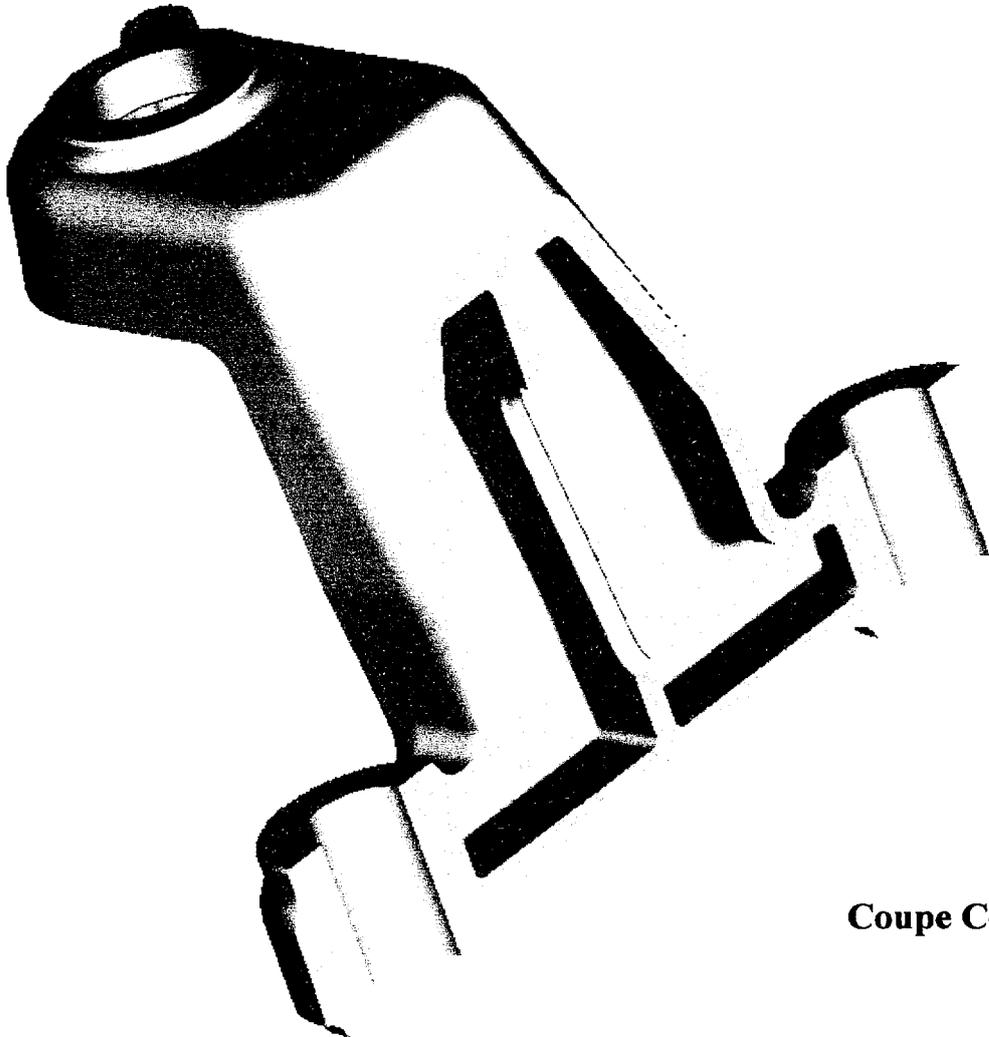
- $Rh = 0,45$
- La température du liquidus = 570°C



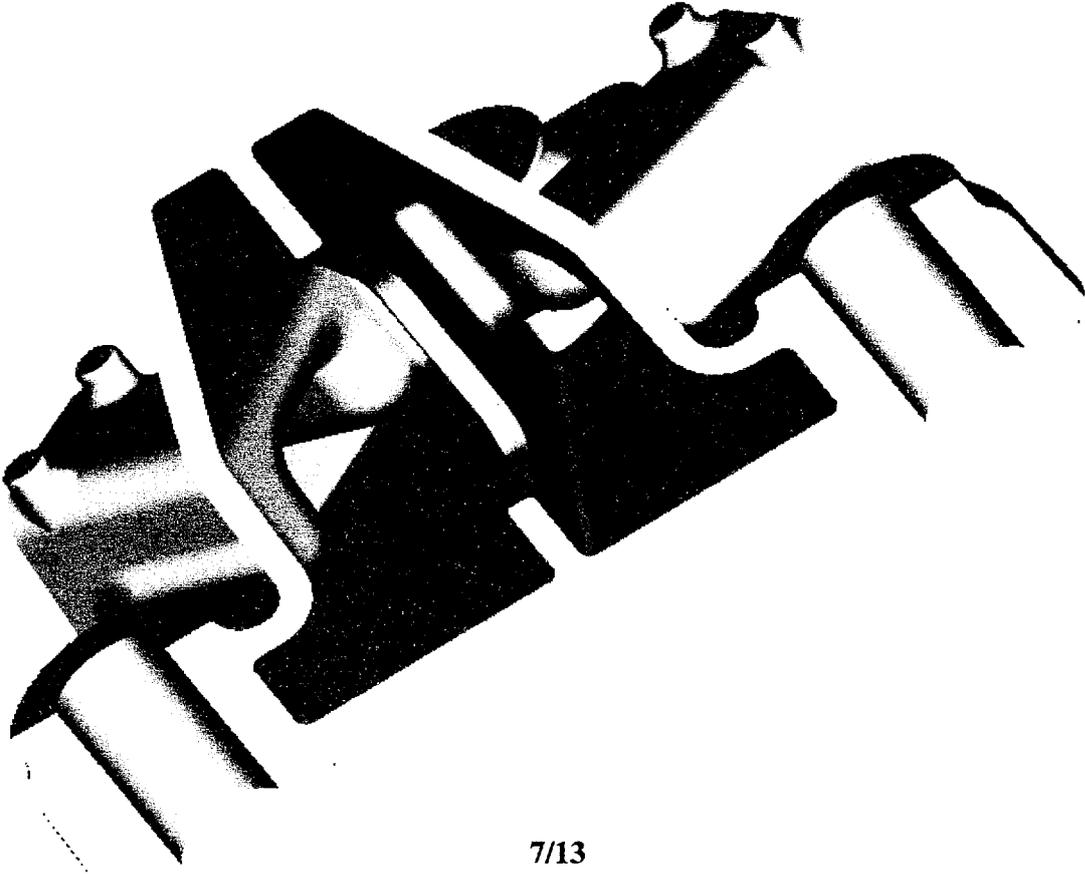
**Coupe A-A**

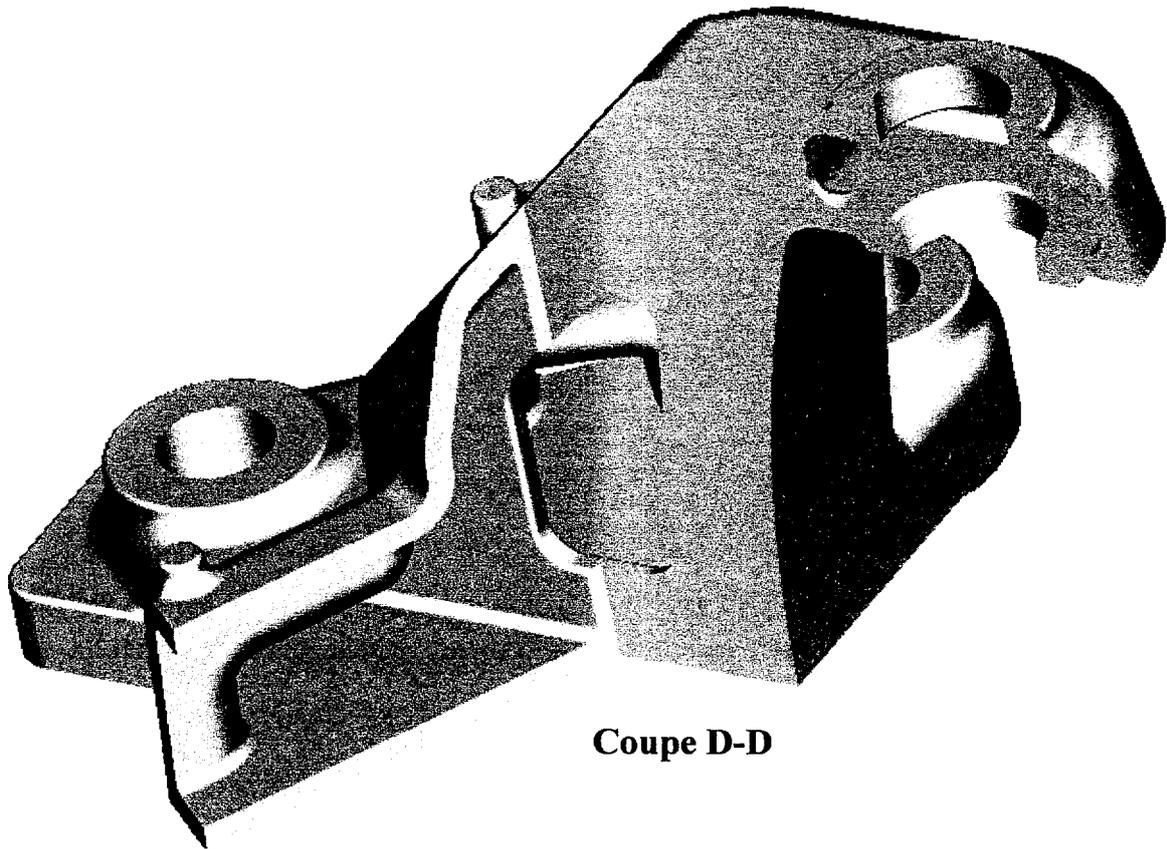


**½ coupe B-B**

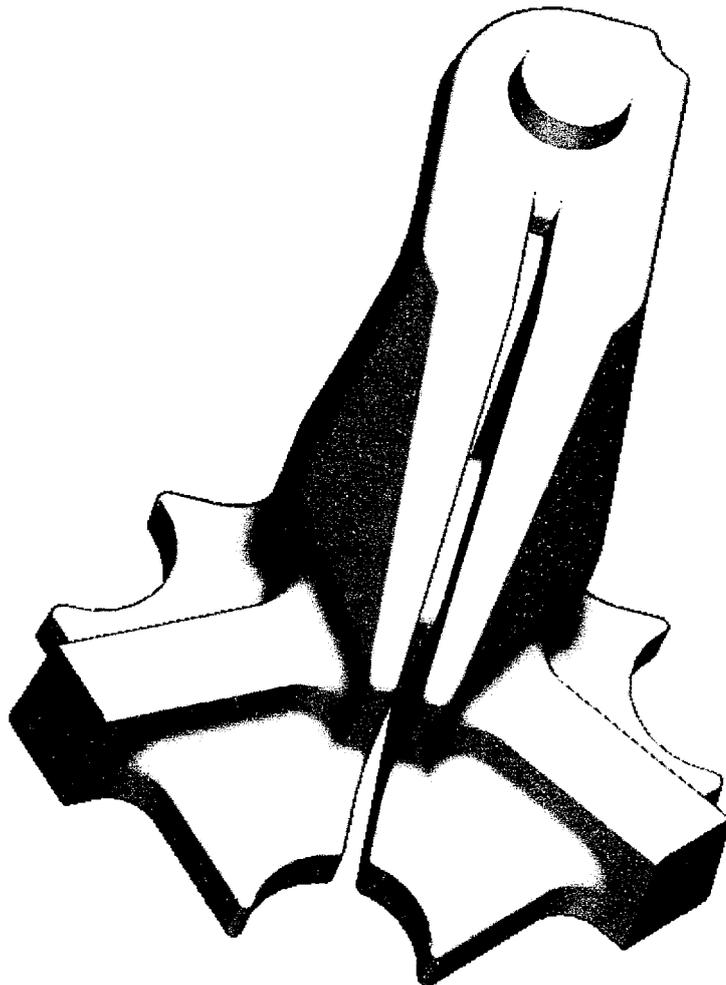


Coupe C-C

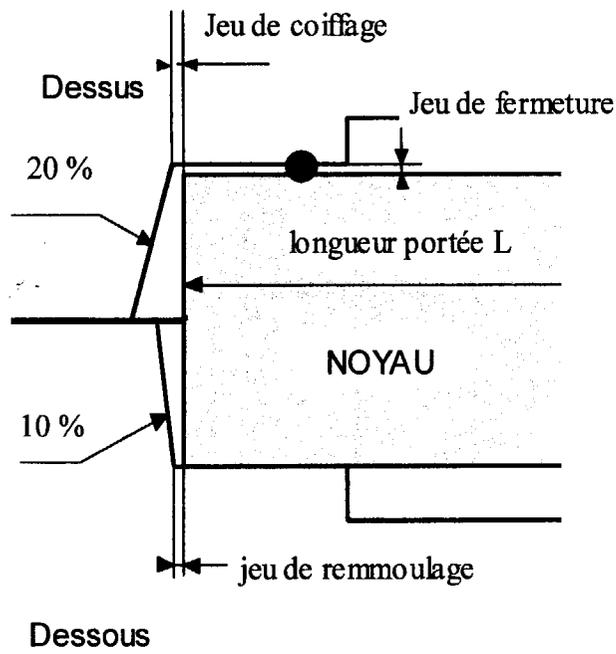




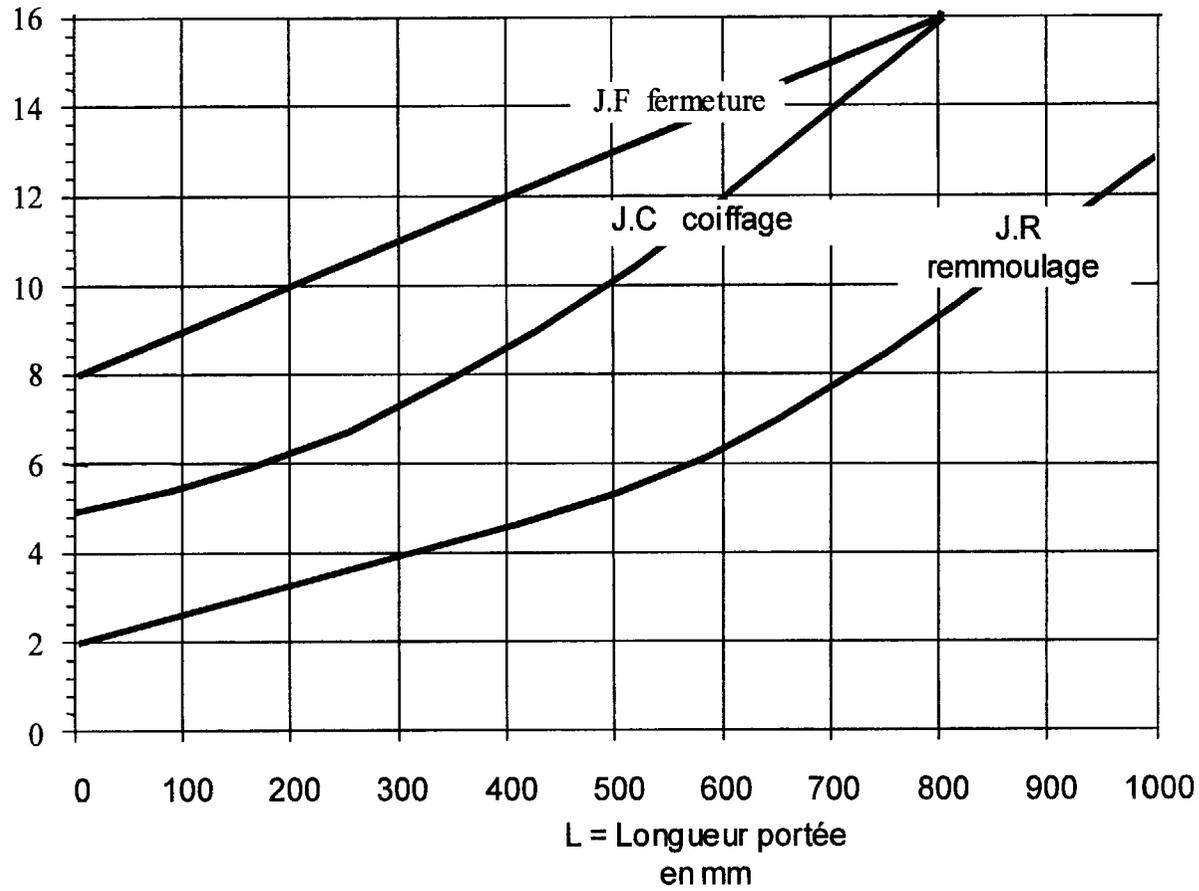
**Coupe D-D**

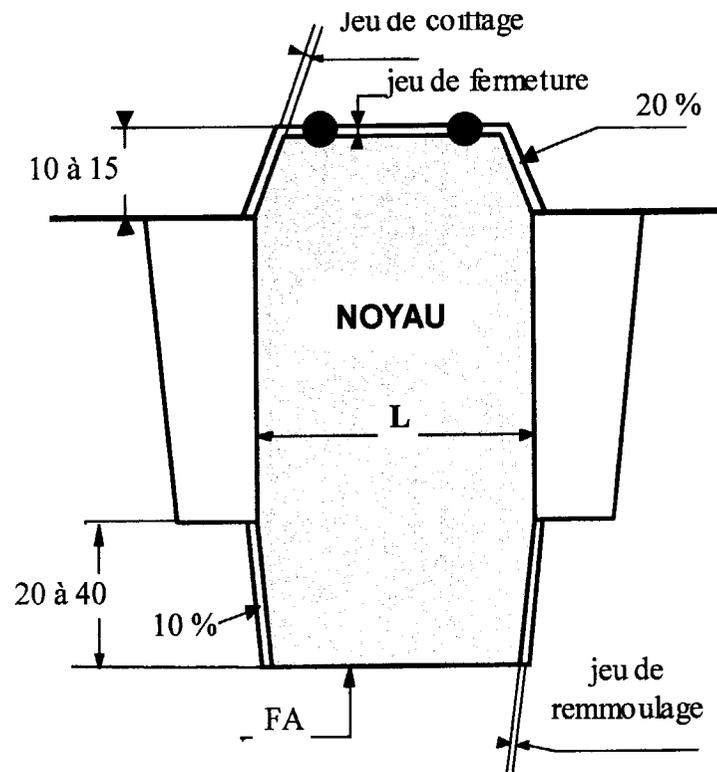


**Evidement**

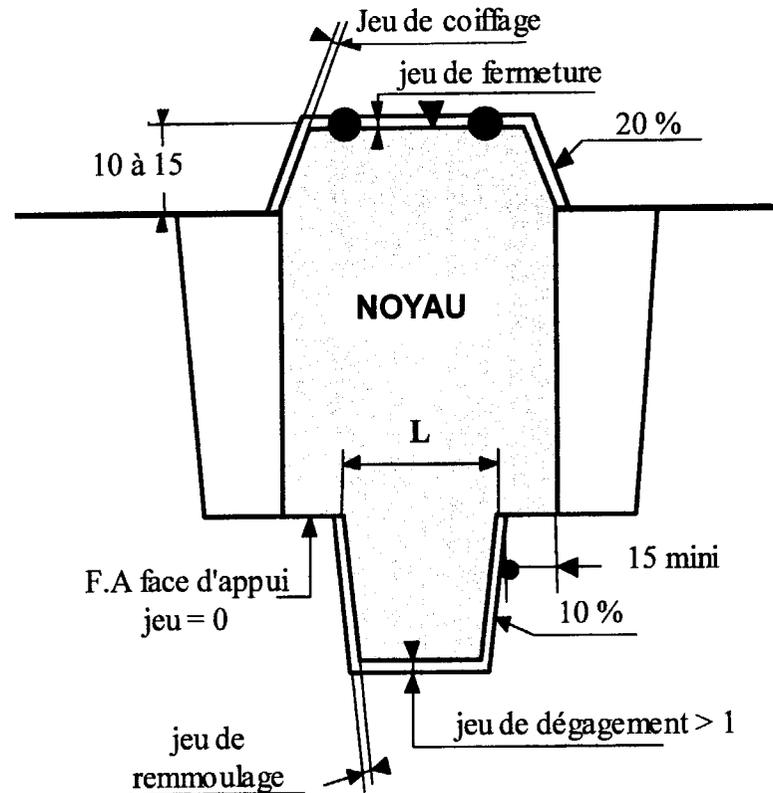


jeux en 10 ème de mm





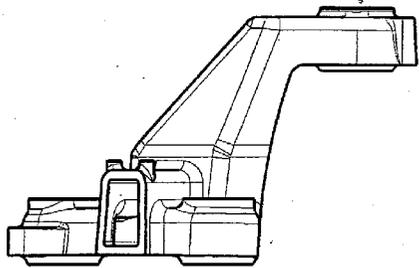
**SOLUTION COURANTE**



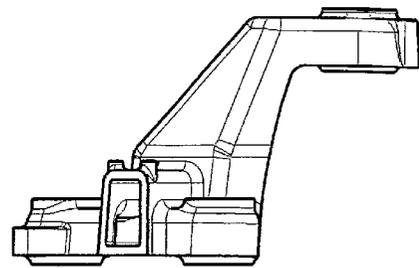
**SOLUTION ADOPTEE POUR UN POSITIONNEMENT PLUS PRECIS**

# METHODE

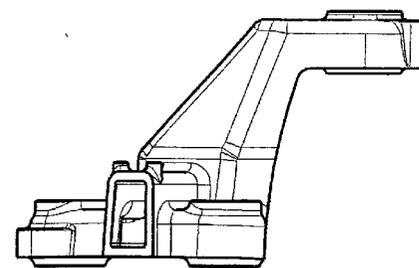
AMMEP/MG



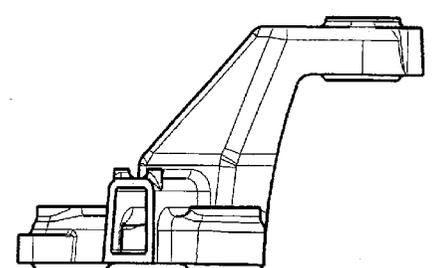
ECHELLE 0.35



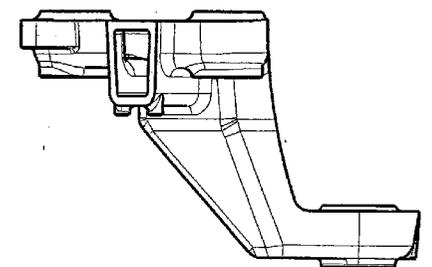
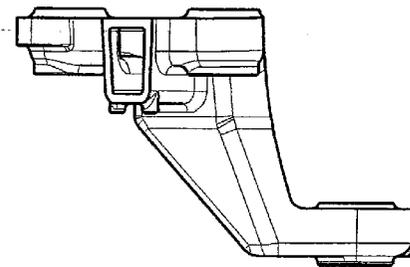
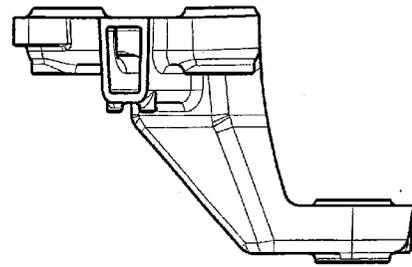
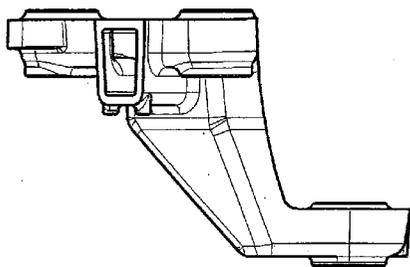
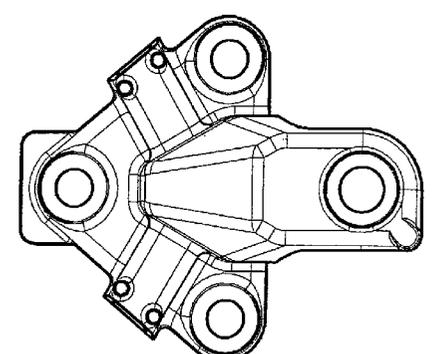
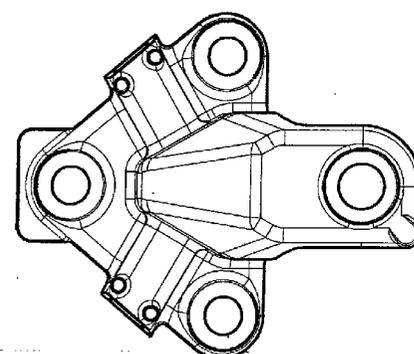
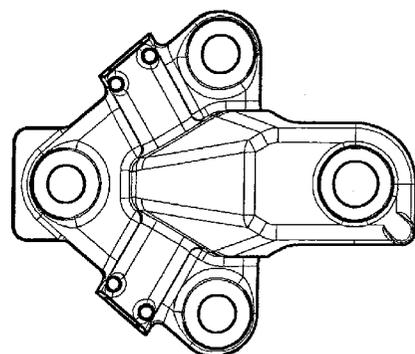
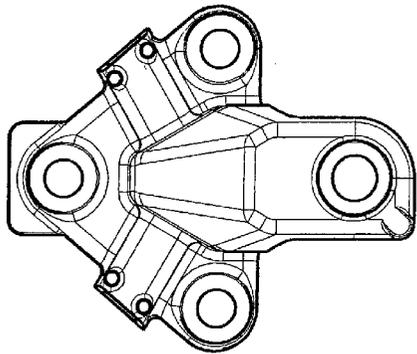
ECHELLE 0.35



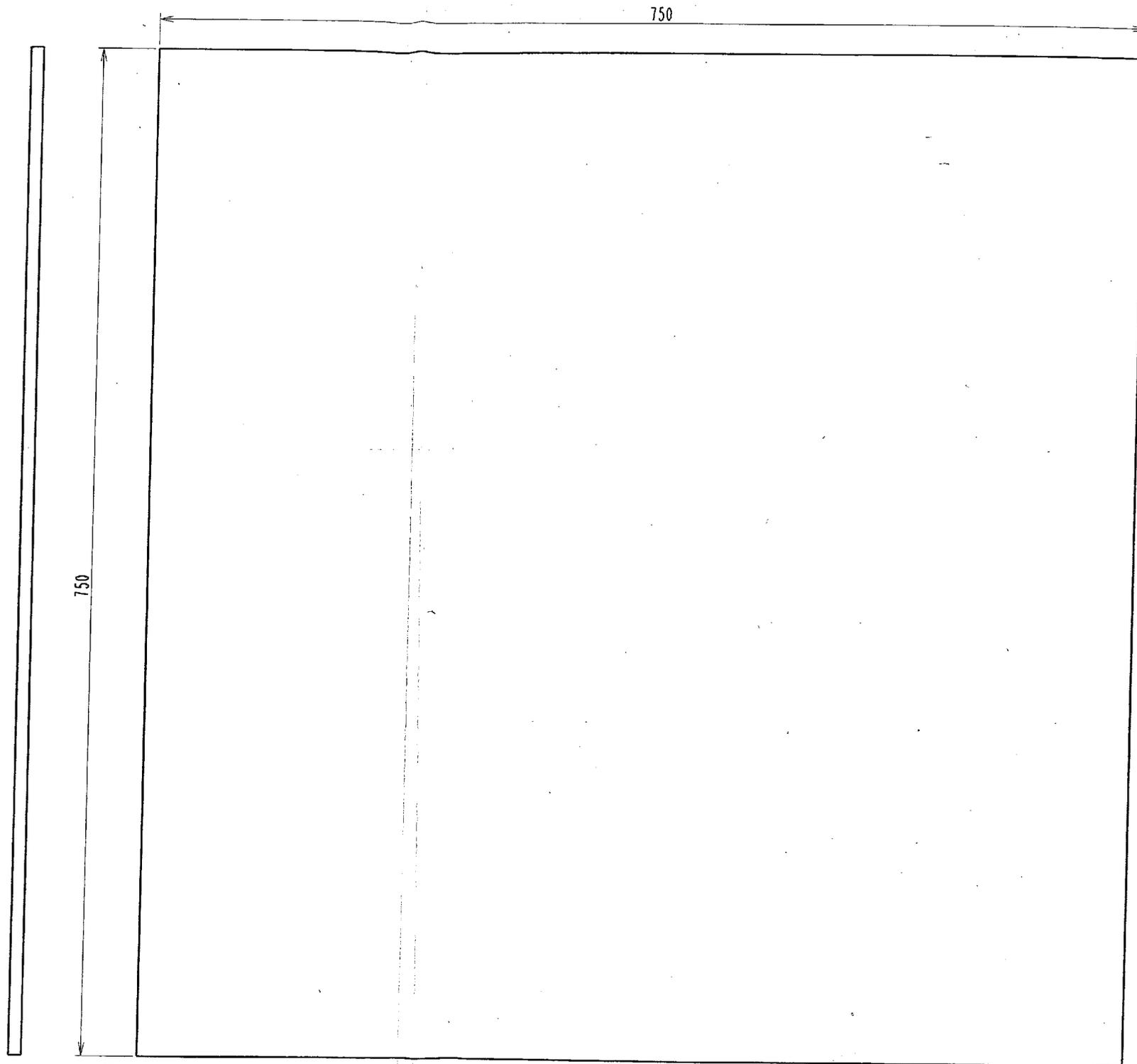
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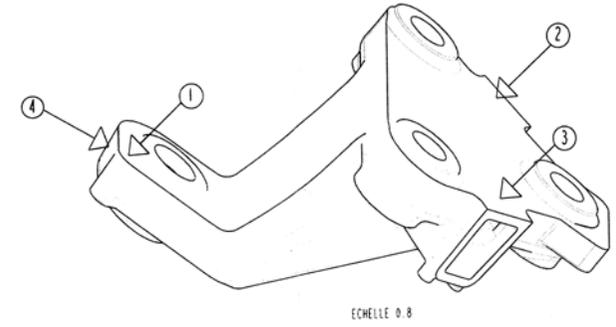
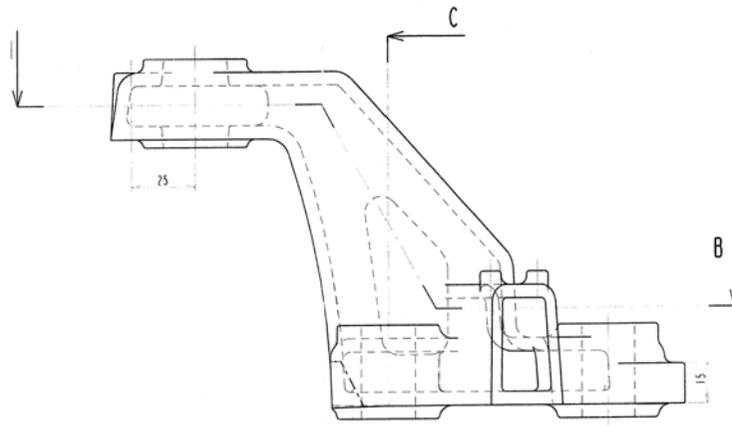
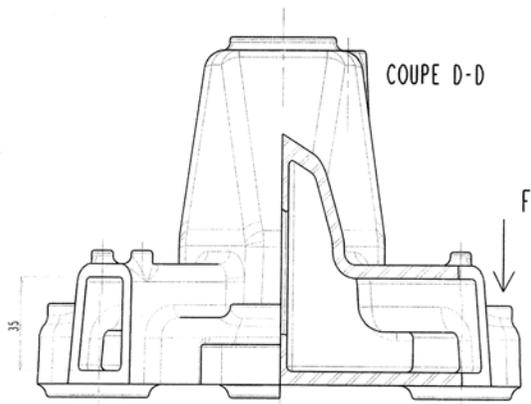


ECHELLE 0.35

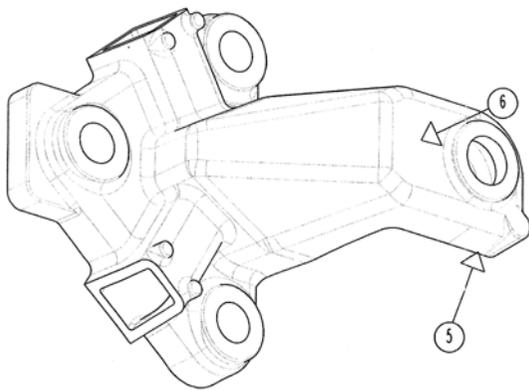
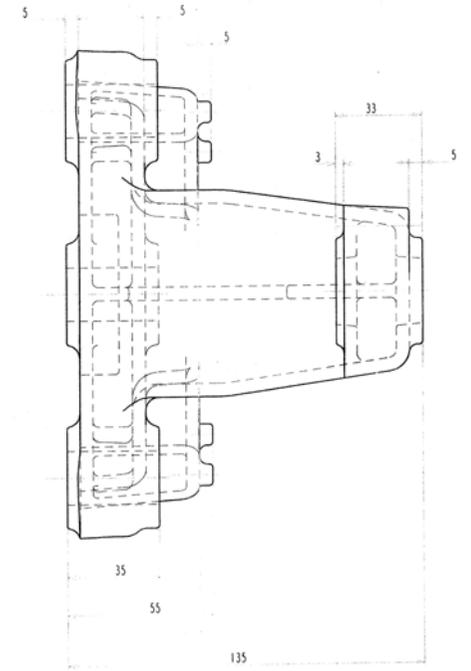
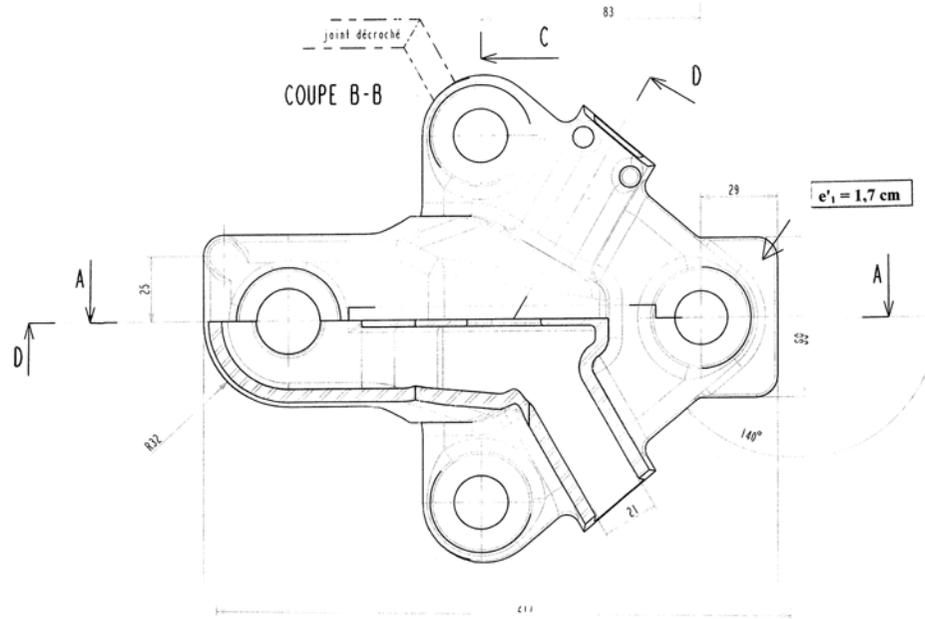
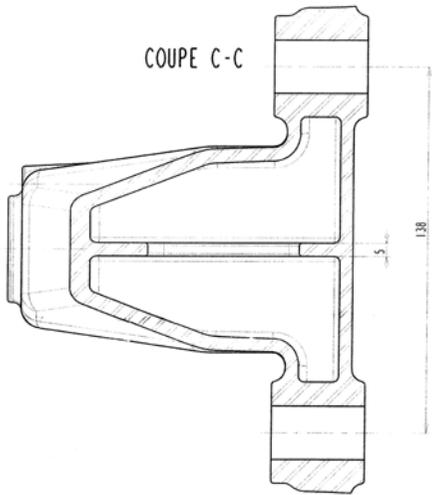


COLLER L'ÉTIQUETTE À CET EMPLACEMENT



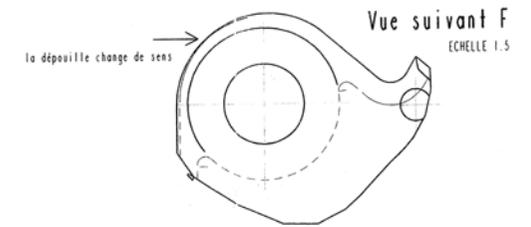
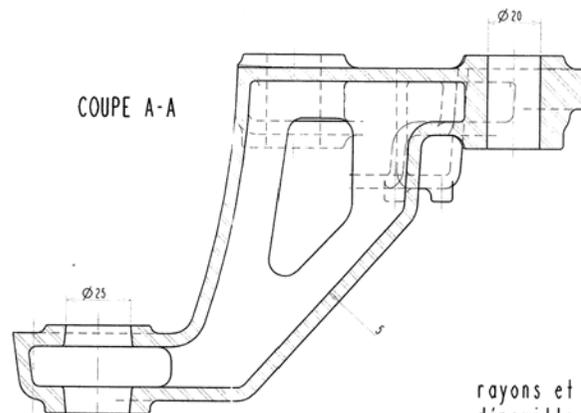


COUPE C-C



ECHELLE 0.8

COUPE A-A



rayons et congés non cotés: 3 mm  
dépuille 3°

COLLER L'ÉTIQUETTE À CET EMPLACEMENT

B.T.S. M.F.A.M.	Session 2008	Matière	[ENTRAC AISI/Ag3]
Echelle 1/1		Volume	0.433 dm3
AI	<b>SUPPORT MOTEUR</b>		