Forja de Monterrey S.A. de C.V.

Orden de Servicio

Solicitante: Jose F. Estrada Hdz
Fecha de Solicitud: 13-abr-22
Fecha Requerida: 13-may-22
Herramental (Modelo): 1018
Proveedor: -
Nº de Orden: OS-11757
Hoja: 1 **de** 1

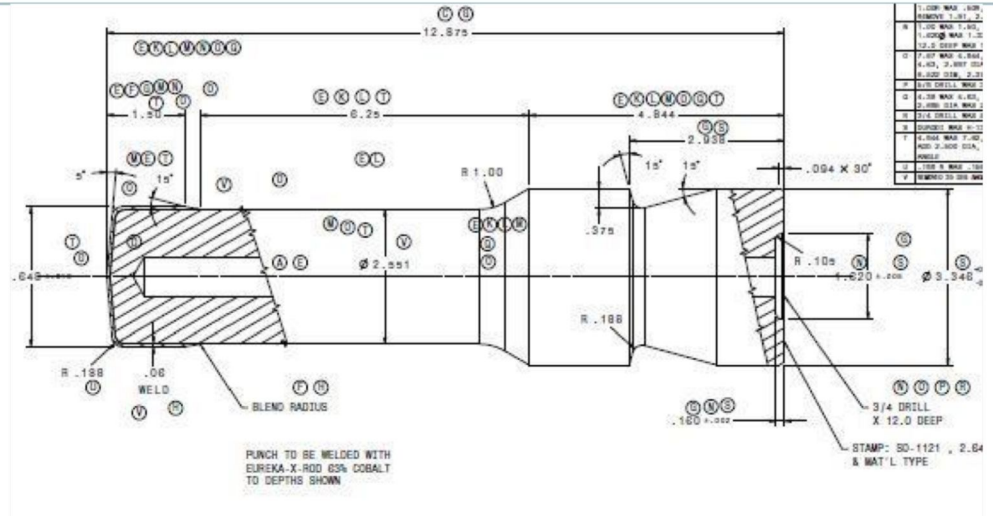
Herramienta(s)	Descripción del Servicio	Localización de Ingeniería (FTP)	Rev.	Proceso Sugerido
Punzon de 3a op.	Fabricacion	DRIVE\FMTING-COMPRAS\OS-11757	V	Fresa

Ayudas Visuales:

Fabricación de Punzón de 3a op.- Incluir el material, maquinado y tratamiento térmico. En la base se deberá marcar, ejemplo:

SD1121- MG - 001

Numero parte, Identificación del proveedor, consecutivo de fabricación (para trazabilidad de la pieza)



Reportes Requeridos para Validación de Servicio

Reporte Dimensional: Si — Reporte de Dureza: **Si**

Reportes Opcionales para Validación de Servicio

Registro de Temperaturas: **NO** — Líquidos Penetrantes: **NO**

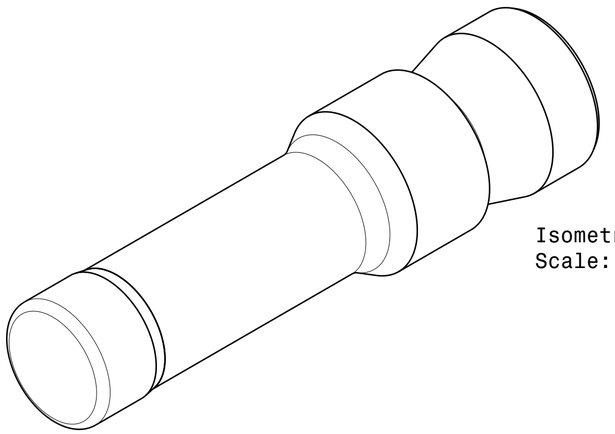
Notas:

Razon de la Orden de Servicio:

Para programa de produccion del mes de Abril 2022

Identificaciones requeridas para Validación de Servicio

Identificacion de revision: **No** — Marcajes sobre figura: **No** — Identificacion de herramienta: **Si**

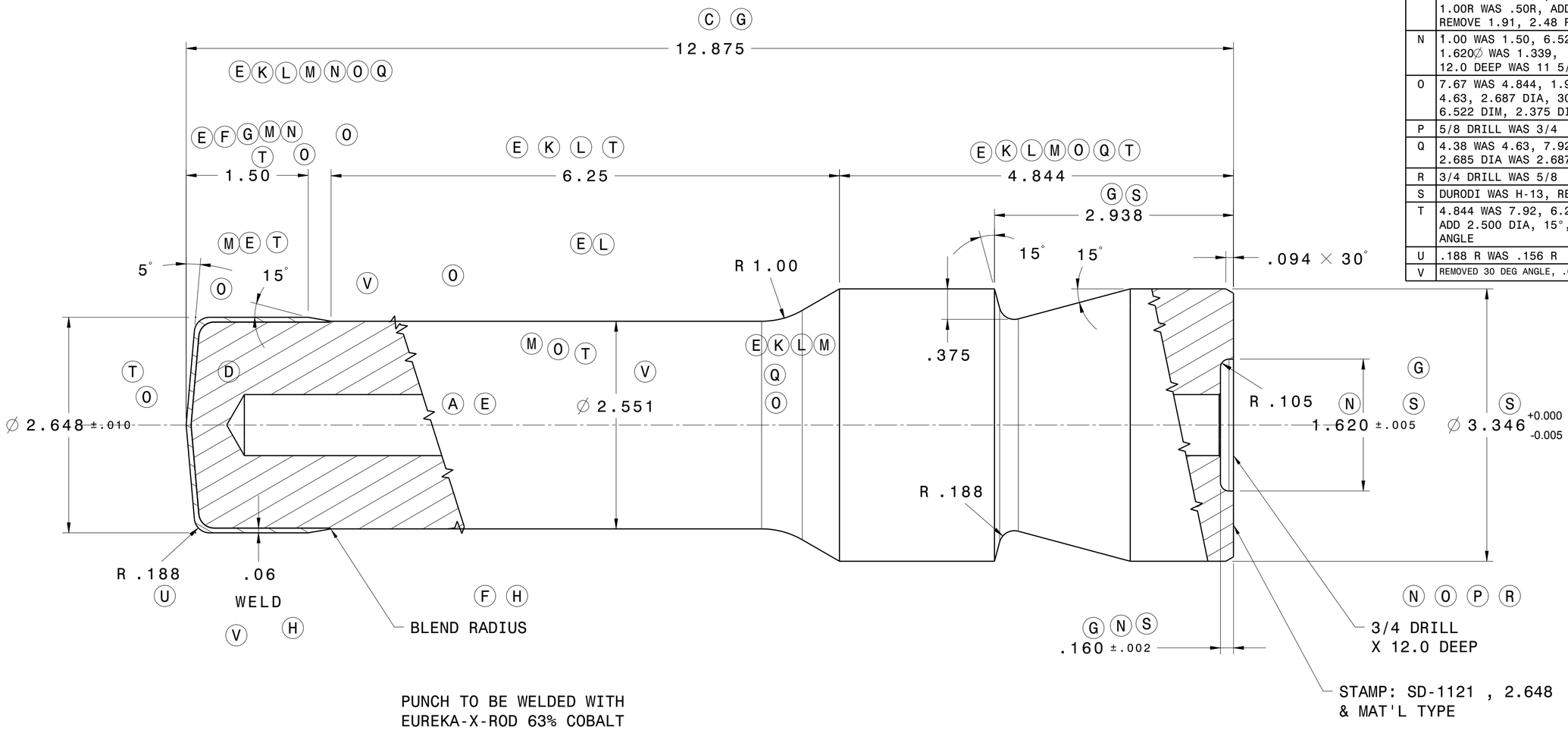


Isometric view
Scale: 1:2

Agregar ranuras para ventilación y evitar amarre por vació.

Ver ayuda 1121_Punchs P1

SYM	REVISION	DATE	BY
A	ADD DIM: 2.375	1-10-91	JT
B	5° WAS 15°	2-11-91	KM
C	13.000 WAS 12.844	9-9-91	KM
D	30° WAS RAD., ADD 6.15 DIM.	9-23-91	KM
E	7.675 WAS 4.844, 3.08 WAS 6.15, ADD 2.668∅, 2.49 TAPER LGT, .50R WAS 1.00 REMOVE 2.375∅, 1.50 DIM, 15°-	7-14-97	KM
F	ADD WELD .12 DEEP TO SHANK DIA, .50 R, & 30° RAMP ANGLE-	7-25-97	KM
G	12.875 WAS 13.000, H-13 WAS DURODI, 1.91 WAS 2.04, 46-48Rc WAS 42-46, ADD BEFORE HT DIMS TO 2.938, .079, 3.346∅-	6-3-99	KM
H	REMOVE .12 WELD FROM 2.49 TAPER LGTH OF NOSE AND 30° ANGLE, .12 WELD WAS .25-	7-9-99	KM
J	MAT'L WAS H-13, HRDN. WAS 46/48	7-26-99	KM
K	7.875 was 7.675,2.88 was 3.08, 2.28 was 2.49, 2.665 was 2.668-	12-15-99	DMc
L	7.688 WAS 7.875, 2.668 ∅ WAS 2.665, 3.07 WAS 2.88, 2.48 WAS 2.28, H-13 WAS DURODI-	1-14-02	KM
M	4.844 WAS 7.688, 6.022 WAS 3.07, 1.00R WAS .50R, ADD 1.50, 2.375∅, 15°, REMOVE 1.91, 2.48 REF TAPER, 2.688ō, 30°-	9-10-02	KM
N	1.00 WAS 1.50, 6.522 WAS 6.022, 1.620∅ WAS 1.339, .160 WAS .079, 12.0 DEEP WAS 11 5/8-	3-12-03	LES
O	7.67 WAS 4.844, 1.91 WAS 1.00, 3/4 DRILL ADD 4.63, 2.687 DIA, 30°, 0°15',WAS 5/8,REMOVE 6.522 DIM, 2.375 DIA, 15°	2-3-04	KM
P	5/8 DRILL WAS 3/4	2-10-04	KM
Q	4.38 WAS 4.63, 7.92 WAS 7.67, 2.685 DIA WAS 2.687	10-18-04	KM
R	3/4 DRILL WAS 5/8	3-21-05	KM
S	DURODI WAS H-13, REMOVE BEFORE HT DIM'S	6-22-05	KM
T	4.844 WAS 7.92, 6.25 WAS 4.38,1.50 WAS 1.91, ADD 2.500 DIA, 15°,REMOVE 2.685 DIA, 0°15' ANGLE	5-24-06	KM
U	.188 R WAS .156 R	12-08-10	MMc
V	REMOVED 30 DEG ANGLE, .06 WELD WAS .120, 2.551 WAS 2.500	11-27-12	RJS



PUNCH TO BE WELDED WITH
EUREKA-X-ROD 63% COBALT
TO DEPTHS SHOWN

UNLESS OTHERWISE SPECIFIED

3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .010
ANGLE DIMENSIONS ± 1°
BREAK ALL SHARP CORNERS

ArvinMeritor™
Commercial Vehicle Systems
1 Rockwell Drive
Morristown, TN 37813

MATERIAL: DURODI	DATE: 12-19-90	CUSTOMER: ArvinMeritor	
	SCALE: FULL	DESCRIPTION: 3RD STA. BACK EXT PUNCH	
HEAT TREAT: 42/46 Rc	DRAWN: JKT	PART NUMBER: 3213 V 1322	SHOP DRAWING NUMBER: 1121
	CHECKED: LM		

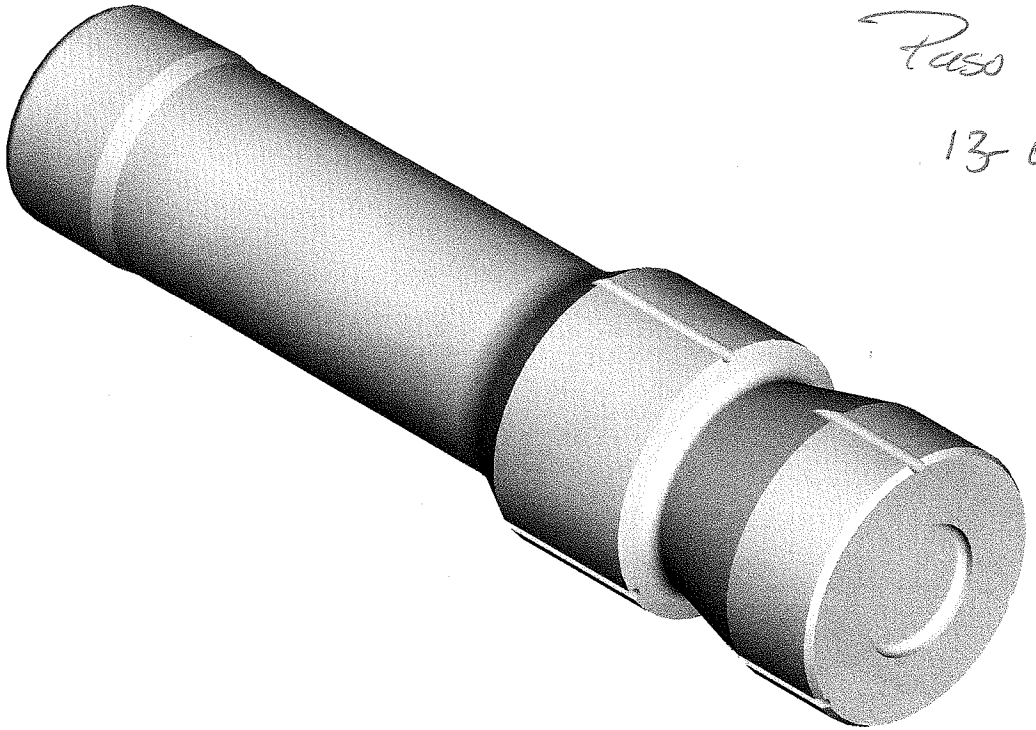
DO NOT CHANGE MANUALLY

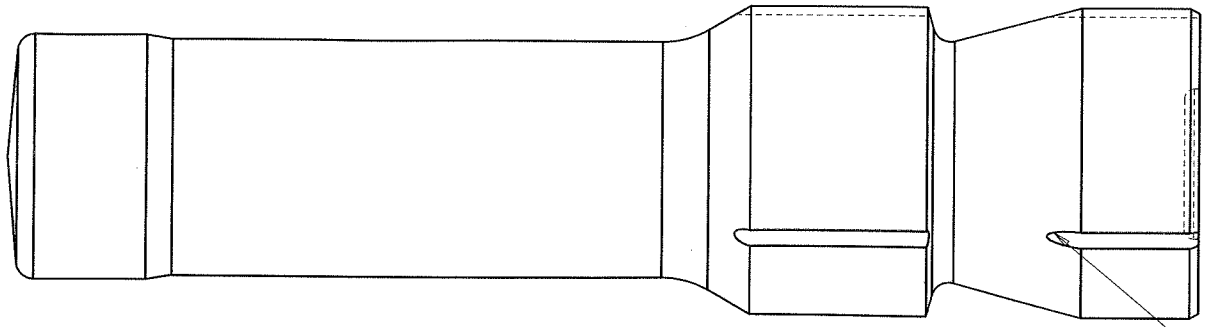
CAD CAM CENTER - MORRISTOWN

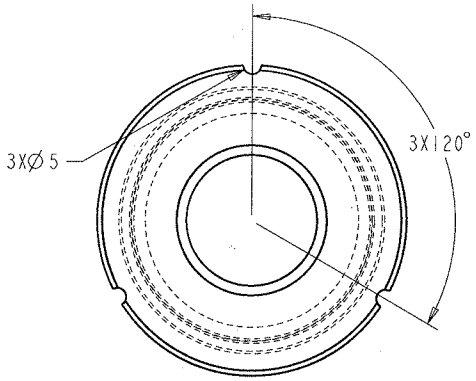
Ranuras para aire

Paso Libajo Adalberto Torres

13-07-15







HACER 3 RANURAS DE VENTILACION

LECCION APRENDIDA

GRUPO	LINEA	ESTACION	FECHA	LECCION#
Ingenieria	L3	PRENSA 1	07/12/2018	18-006

DESCRIPCION DE LA LECCION (Con foto si es posible)

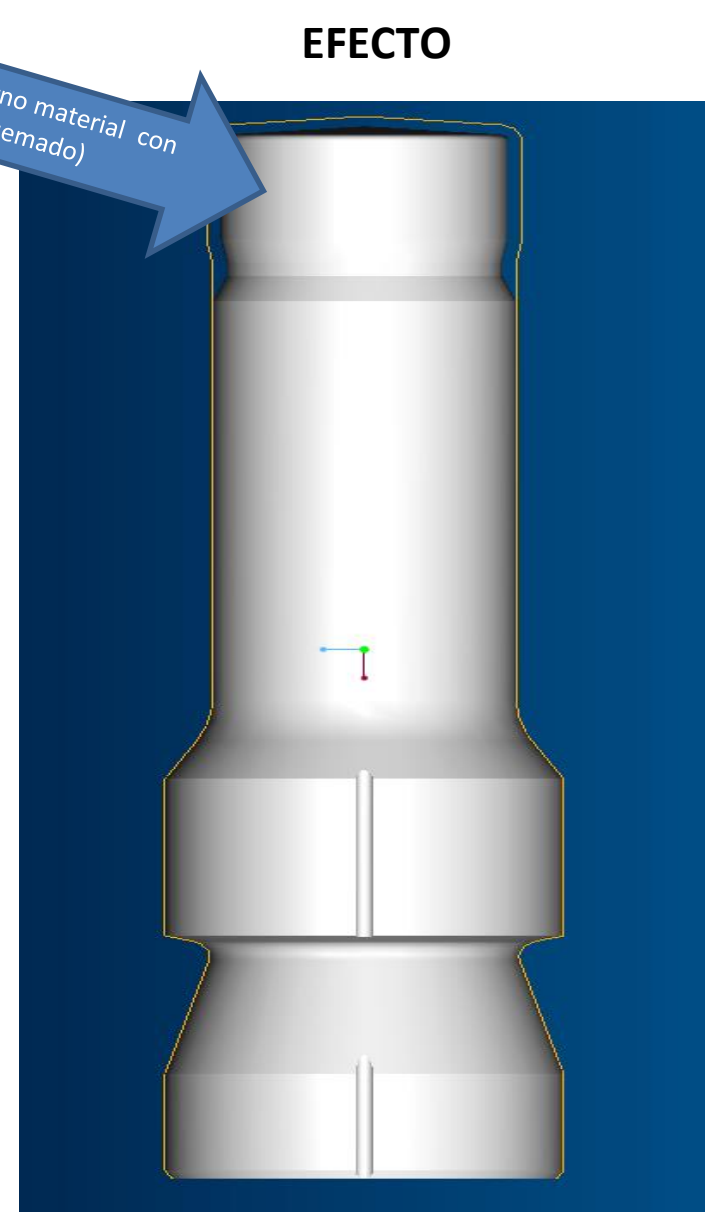
Descripcion: Recuperación de punzones de operación 3a

1. El punzon se recupera por soldadura, cumpliendo con las medidas señaladas en el dibujo, altura y diametro.

Procedimiento.

1.- Remover material quemado 4 mm o más.
2.- Pre-calentar punzón 300° C
3.-Aplicar 1.5 mm de soldadura UTP 653 como colchon. (Puede ser un equivalente)
4.-Volver a calentar a 400°C para relevo de esfuerzos
5.-Enfriar en colcha termica hasta 100 ° C
6.- Pre-calentar
7.-Aplicar 2 mm de soldadura.
UTP 730 G4, Stellite 6 o Stoodite 6 (5/32)
8.-Volver a calentar a 400°C para relevo de esfuerzos
9.-Enfriar en colcha temperatura ambiente
10.-Maquinar
11.-Libre de poros y grietas.

EFECTO



COMENTARIOS ESPECIALES:

ASEGURAR LAS TEMPERATURAS, SI SE USA CAJA DE CAL QUE NO ESTE HUMEDA.