



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

Solicitante: Jose F. Estrada Hdz

Fecha de Solicitud: 8-mar-21

Fecha Requerida: 4-abr-21

Orden de Servicio

Herramental (Modelo): NU05.4.x

Proveedor: -

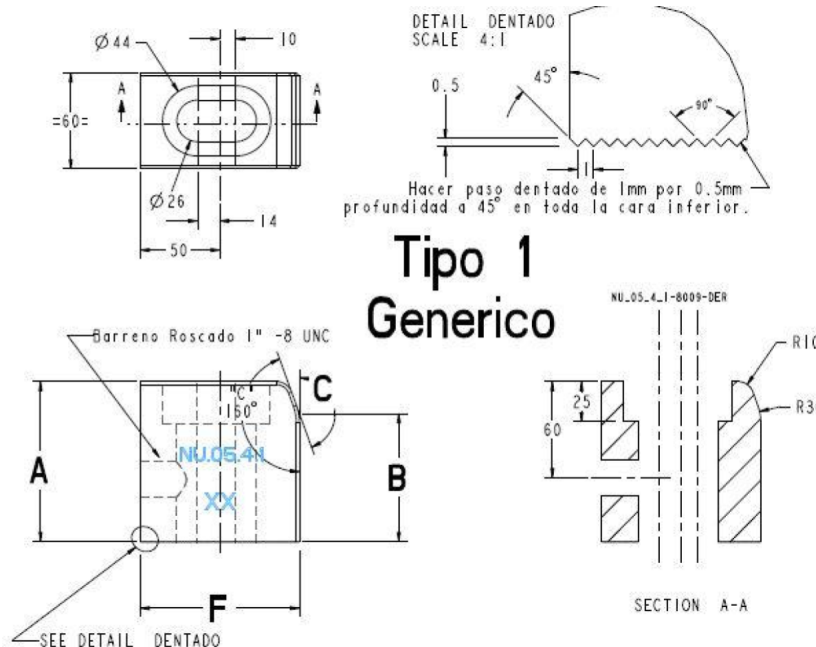
N° de Orden: OS-10814

Hoja: 1 de 1

| Herramienta(s) | Descripción del Servicio | Localización de Ingeniería (FTP) | Rev. | Proceso Sugerido |
|-----------------|--------------------------|----------------------------------|------|------------------|
| Centrador Twist | Fabricacion | DRIVE/FMTING-COMPRAS/OS 10814 | - | Fresa |
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Ayudas Visuales:

Fabricación de NU05.4 Tipo 1.-
Incluir el material indicado en el dibujo



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**

Identificaciones requeridas para Validación de Servicio




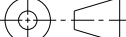

Identificación de revision **No**Marcajes sobre figura **No**Identificación de herramienta **Si**

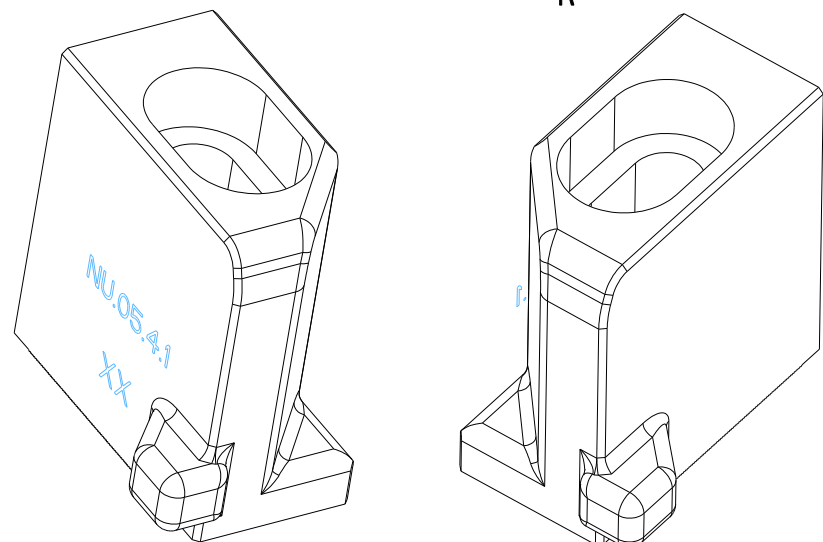
RG-PPP32-3

Notas:

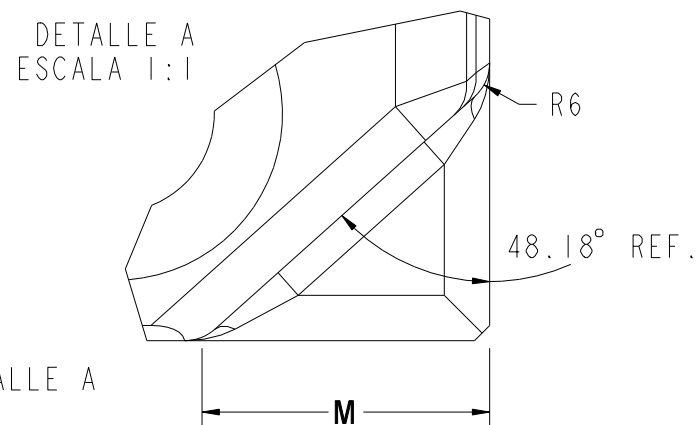
Razon de la Orden de Servicio:

Para programa de produccion del mes de Marzo 2021

| | | | | | | | |
|--|--|---|--|---|--|---|--|
| LA INFORMACION CONTENIDA EN ESTE DOCUMENTO ESTA PROTEGIDA POR LAS LEYES DE DERECHO DE AUTOR Y PROPIEDAD INTELECTUAL Y SE PROHIBE SU REPRODUCCION TOTAL O PARCIAL POR CUALQUIER MEDIO SIN AUTORIZACION DE SU PROPIETARIO: FORJA DE MONTERREY S.A. DE C.V. | | | |  FORJA DE MONTERREY | | UNA EMPRESA DEL  GRUPO QUIMCO | |
| MATERIAL: AlSi L6 | | NOM. ARCHIVO DE DIBUJO: NU.05.4.1 | | FORJA DE MONTERREY S.A. DE C.V. CARR. MONTERREY COLOMBIA Km.6:5 CD. GENERAL ESCOBEDO C.P. 66050 NUEVO LEON, MEXICO. | | | |
| TRATAMIENTO: Tratado | | NOM. ARCHIVO SOLIDO: NU.05.4.1 | | DESCRIPCIÓN: Centrador Twist Ajustable | | | |
| PESO: 3582 | | | | | | | |
| TOLERANCIA: ±0.5 | | DIBUJO: EGP | | FECHA: 10/ENE/07 | | | |
| EQUIPO DE MFR. Fresa | | REVISO: JOC | | FECHA: 10/ENE/07 | | | |
| CLIENTE: Linea 1 | | AUTORIZO: MRC | | FECHA: 10/ENE/07 | | | |
| | |  | | REF. CLIENTE: Normativa | | HOJA: 1 DE 2 | |
| | |  | | REF. F. de M. NU.05.4.1 | | ESC: 25 | |
| | | | | | | COTAS: mm | |
| | | | | | |  | |



EL TOPE IZQUIERDO ES UN ESPEJO DEL DERECHO



| MODIFICACIONES | | | | |
|----------------|------|------|-------------|-------|
| No. | AUT. | LOC. | DESCRIPCION | FECHA |
| | | | | |

| Tabla Maestra de Partes | | | Dimensiones Especificas (Son tomadas de acuerdo al tipo) | | | | | | | | | | | | | | | | | | |
|-------------------------|---------------------|---------------------|--|------|------|-------|--------|--------|-------|-------|-----|-----|-----|------|------|------|------|-----|------|------|-----|
| | | | Las dimensiones generales y no marcadas en cada tipo son tomadas del Tipo 1 (Generico) | | | | | | | | | | | | | | | | | | |
| Tipo | Parte | Producto | A | B | C | D | E | F | G_ | H | I | J | K | L | M | N | O | P | Q | R | |
| 1 | NU_05_4_1_3002 | 3002 | 110 | 95 | 160° | N/A | N/A | 83 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1001 | 1001 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1002 | 1002 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1003 | 1003 | 100 | 80 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1005 | 1005 | 100 | 80 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1006 | 1006 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1027 | 1027 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1028 | 1028 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_1029 | 1029 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_5001 | 5001 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_5002 | 5002 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_5003 | 5003 | 100 | 80 | 160° | N/A | N/A | 110 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_5007 | 5007 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_5008 | 5008 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | NU_05_4_1_8002 | 8002 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | 2 | NU_05_4_1_8003 | 8003 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A |
| NU_05_4_1_8004 | | 8004 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_8006 | | 8006 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_8007 | | 8007 | 100 | 80 | 160° | N/A | N/A | 64 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_11011 | | 11011 | 120 | 100 | 160° | N/A | N/A | 90 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_8010 | | 8010 | 120 | 105 | 160° | 30 | 104 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_8011 | | 8010 | 120 | 105 | 160° | 30 | 104 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_11003 | | 11003 | 120 | 105 | 160° | 50 | 100 | 97.6 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_11004 | | 11004 | 120 | 105 | 160° | 30 | 103.5 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_11012 | | 11012 | 100 | 80 | 160° | 35 | 103.5 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_11013 | | 11013 | 100 | 80 | 160° | 30 | 105 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_15001 | | 15001 | 120 | 105 | 160° | 60 | 104.5 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_15002 | | 15002 | 120 | 105 | 160° | 60 | 104.5 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_5004 | | 5004 | 130 | 115 | 160° | 75 | 101.5 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| NU_05_4_1_5006 | | 5006 | 130 | 115 | 160° | 75 | 101.5 | 100 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| 3 | | NU_05_4_1_11014_120 | 11014 | 120 | 105 | 160° | N/A | N/A | 100 | N/A | N/A | 55 | 40 | 35 | 9.7 | N/A | N/A | N/A | N/A | N/A | N/A |
| | 120 | 105 | | 160° | N/A | N/A | 100 | N/A | N/A | 45 | 40 | 35 | 9.7 | N/A | N/A | N/A | N/A | N/A | N/A | | |
| 4 | NU_05_4_1_16001_120 | 16001 | 120 | 105 | 160° | N/A | N/A | 80 | 65.2 | 10.8° | 80 | 35 | 35 | 43 | N/A | N/A | N/A | N/A | N/A | N/A | |
| | 120 | | 105 | 160° | N/A | N/A | 80 | 65.2 | 10.8° | 15 | 35 | 35 | 43 | N/A | N/A | N/A | N/A | N/A | N/A | | |
| 5 | NU_05_4_1_16002_120 | 16002 | 120 | 105 | 160° | N/A | N/A | 80 | 59 | 10.8° | 80 | 35 | 35 | 43 | N/A | N/A | N/A | N/A | N/A | N/A | |
| | 120 | | 105 | 160° | N/A | N/A | 80 | 59 | 10.8° | 15 | 35 | 35 | 43 | N/A | N/A | N/A | N/A | N/A | N/A | | |
| 6 | NU_05_4_1_11005_120 | 11005 | 120 | 105 | 160° | N/A | N/A | 118.75 | 65.2 | N/A | N/A | N/A | N/A | N/A | 38.0 | 100 | 50 | 25 | 8.8 | 13.0 | |
| | 120 | | 105 | 160° | N/A | N/A | 118.75 | 65.2 | N/A | N/A | N/A | N/A | N/A | 38.0 | 100 | 50 | 25 | 8.8 | 13.0 | | |
| 7 | NU_05_4_1_11006_120 | 11006 | 120 | 105 | 160° | N/A | N/A | 118.75 | 65.2 | N/A | N/A | N/A | N/A | N/A | 38.0 | 100 | 50 | 25 | 7.6 | 13.0 | |
| | 120 | | 105 | 160° | N/A | N/A | 118.75 | 65.2 | N/A | N/A | N/A | N/A | N/A | 38.0 | 100 | 50 | 25 | 7.6 | 13.0 | | |
| 8 | NU_05_4_1_11010_120 | 11010 | 120 | 105 | 160° | N/A | N/A | 114.25 | 65.2 | N/A | N/A | N/A | N/A | N/A | 25.0 | 100 | 48.5 | 20 | 7.6 | 17.0 | |
| | 120 | | 105 | 160° | N/A | N/A | 114.25 | 65.2 | N/A | N/A | N/A | N/A | N/A | 25.0 | 100 | 48.5 | 20 | 7.6 | 17.0 | | |
| 9 | NU_05_4_1_11010_120 | 11016 | 120 | 105 | 160° | N/A | N/A | 100 | 65.2 | N/A | N/A | N/A | N/A | N/A | 25.0 | 100 | 50 | 25 | 9.3 | 13.0 | |
| | 120 | | 105 | 160° | N/A | N/A | 100 | 65.2 | N/A | N/A | N/A | N/A | N/A | 25.0 | 100 | 50 | 25 | 9.3 | 13.0 | | |
| 10 | NU_05_4_1_8009_120 | 8009 | 135 | 120 | 160° | 50 | 106.5 | 100 | N/A | N/A | 75 | 15 | 40 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |
| | 135 | | 120 | 160° | 50 | 106.5 | 100 | N/A | N/A | 75 | 15 | 40 | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | |

NOTAS:

- 1.- Matar filos con chaflanes de: $1 \times 45^\circ$
- 2.- Acabado general de maquinado ()

LA INFORMACION CONTENIDA EN ESTE DOCUMENTO ESTA PROTEGIDA POR LAS LEYES DE DERECHO DE AUTOR Y PROPIEDAD INTELECTUAL Y SE PROHIBE SU REPRODUCCION TOTAL O PARCIAL POR CUALQUIER MEDIO SIN AUTORIZACION DE SU PROPIETARIO: FORJA DE MONTERREY S.A. DE C.V.

FORJA DE MONTERREY

FORJA DE MONTERREY S.A. DE C.V.
CARR. MONTERREY COLOMBIA Km.6.5
CD. GENERAL ESCOBEDO
C.P. 66050
NUEVO LEON, MEXICO.

UNA EMPRESA DEL

GRUPO QUIMICO

MATERIAL:

ASI L6

TRATAMIENTO:

Tratado

PESO:

3.582

TOLERANCIA:

+0.5

EQUIPO DE MFRA.

Fresa

CLIENTE:

Linea 1

NOM. ARCHIVO DE DIBUJO:

NU.05.4.1

NOM. ARCHIVO SOLIDO:

NU.05.4.1

DIBUJO:

EGP

FECHA:

10/ENE/07

REVISO:

JOC

FECHA:

10/ENE/07

AUTORIZO:

MRC

FECHA:

10/ENE/07

DESCRIPCION:

Centrador Twist Ajustable

PROYECCION

REF. CLIENTE:

Normativa

REF. F. DE M.

NU.05.4.1

HOJA

2 DE 2

ESC:

12

COTAS:

mm

REV:

R