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|  | | | | | **机械加工工艺过程卡片** | | | | | | | | | | 产品型号 | | |  | | | | 零件图号 | | | |  | | |  | | | | | | | | | | |
| 产品名称 | | | 空气压缩机气缸体 | | | | 零件名称 | | | | 空气压缩机气缸体 | | | 共 | | 1 | | | 页 | 第 | | 1 | | 页 |
| 材 料 牌 号 | | | KTH350 | | | | 毛 坯 种 类 | | | 铸造毛坯 | | | 毛坯外形尺寸 | | | |  | | | | 每毛坯件数 | | | | 1 | | 每 台 件 数 | | | 1 | | 备 注 | | | |  | | | |
| 工  序  号 | 工 名  序 称 | | | 工 序 内 容 | | | | | | | | | | 车  间 | | | 工  段 | | 设 备 | | | | 工 艺 装 备 | | | | | | | | | | | 工 时 | | | | | |
| 准终 | | | | 单件 | |
| 0 | 铸造毛坯 | | | 铸造毛坯 | | | | | | | | | | 铸造车间 | | |  | |  | | | |  | | | | | | | | | | |  | | | |  | |
| 5 | 粗铣、半精铣 | | | 粗铣、半精铣底面 | | | | | | | | | | 机加工 | | | 铣工 | | 立式铣床X52K | | | | 专用夹具、面铣刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 10 | 粗铣、半精铣 | | | 粗铣、半精铣上端面 | | | | | | | | | | 机加工 | | | 铣工 | | 立式铣床X52K | | | | 专用夹具、面铣刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 15 | 精铣 | | | 精铣底面和两端侧面 | | | | | | | | | | 机加工 | | | 铣工 | | 立式铣床X52K | | | | 专用夹具、面铣刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 20 | 精铣 | | | 精铣上端面 | | | | | | | | | | 机加工 | | | 铣工 | | 立式铣床X52K | | | | 专用夹具、面铣刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 25 | 钻孔 | | | 钻4-φ10.5mm孔 | | | | | | | | | | 机加工 | | | 钻工 | | 立式钻床Z535 | | | | 专用夹具、麻花钻、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 30 | 粗镗、半精镗 | | | 粗镗、半精镗2-φ52mm孔 | | | | | | | | | | 机加工 | | | 镗工 | | 卧式镗床T68 | | | | 专用夹具、镗刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 35 | 精镗 | | | 精镗2-φ52mm孔并孔口倒角 | | | | | | | | | | 机加工 | | | 镗工 | | 卧式镗床T68 | | | | 专用夹具、镗刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 40 | 钻孔攻丝 | | | 钻孔攻丝2XM8，孔口120度倒角 | | | | | | | | | | 机加工 | | | 钻工 | | 立式钻床Z535 | | | | 专用夹具、麻花钻、丝锥游标卡尺 | | | | | | | | | | |  | | | |  | |
| 45 | 钻孔攻丝 | | | 钻孔攻丝6XM8 | | | | | | | | | | 机加工 | | | 钻工 | | 立式钻床Z535 | | | | 专用夹具、麻花钻、丝锥游标卡尺 | | | | | | | | | | |  | | | |  | |
| 50 | 钻孔 | | | 钻、铰6－φ6.2孔 | | | | | | | | | | 机加工 | | | 钻工 | | 立式钻床Z535 | | | | 专用夹具、麻花钻、铰刀、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 55 | 钻孔 | | | 钻φ16孔，钻φ20孔、φ26孔、φ32孔 | | | | | | | | | | 机加工 | | | 钻工 | | 立式钻床Z535 | | | | 专用夹具、麻花钻、游标卡尺 | | | | | | | | | | |  | | | |  | |
| 60 | 去毛刺 | | | 去所有加工面锐边毛刺 | | | | | | | | | | 机加工 | | | 钳工 | | 平锉 | | | | 通用夹具 | | | | | | | | | | |  | | | |  | |
| 65 | 清洗 | | | 清洗零件 | | | | | | | | | |  | | |  | |  | | | |  | | | | | | | | | | |  | | | |  | |
| 70 | 终检 | | | 检验零件尺寸 | | | | | | | | | |  | | |  | |  | | | |  | | | | | | | | | | |  | | | |  | |
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