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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | | | | | **机械加工工序卡片** | | | | | | | | 产品型号 | |  | | | | | | 零件图号 | | | |  | | | |  | | | | | | | | | | | | |
| 产品名称 | | 前横架 | | | | | | 零件名称 | | | | 前横架毛坯图 | | | | 共 | | | 2 | | | 页 | 第 | | 2 | | | 页 |
|  | | | | | | | | | | | | | | | | 车间 | | | | 工序号 | | | | | | 工序名称 | | | | | | | 材 料 牌 号 | | | | | | | | |
| 金工 | | | | 40 | | | | | | 钻 | | | | | | | HT200 | | | | | | | | |
| 毛 坯 种 类 | | | | 毛坯外形尺寸 | | | | | | 每毛坯可制件数 | | | | | | | 每 台 件 数 | | | | | | | | |
| 铸 件 | | | | 247\*54\*64 | | | | | | 1 | | | | | | | 1 | | | | | | | | |
| 设备名称 | | | | 设备型号 | | | | | | 设备编号 | | | | | | | 同时加工件数 | | | | | | | | |
| 摇臂钻床 | | | | Z3025 | | | | | |  | | | | | | | 1 | | | | | | | | |
| 夹具编号 | | | | | | | 夹具名称 | | | | | | | | 切削液 | | | | | | | | | | |
|  | | | | | | | 专用钻床夹具 | | | | | | | |  | | | | | | | | | | |
| 工位器具编号 | | | | | | | 工位器具名称 | | | | | | | | 工序工时 (分) | | | | | | | | | | |
| 准终 | | | | | | 单件 | | | | |
|  | | | | | | |  | | | | | | | |  | | | | | |  | | | | |
| 工步号 | | 工 步 内 容 | | | | | | 工 艺 装 备 | | | | | | | | | 主轴转速 | | 切削速度 | | | | | 进给量 | | | 切削深度 | | | 进给次数 | | | | | | 工步工时 | | | | | |
| r/min | | m/min | | | | | mm/r | | | mm | | | 机动 | | | 辅助 | | |
| 1 | | 钻C面上孔 | | | | | | 专用夹具，D10.2高速钢标准柄的右旋莫氏锥柄麻花钻 | | | | | | | | | 400 | | 12.8 | | | | | 0.6 | | | 5.1 | | | 1 | | | | | | 5.4s | | | |  | |
| 2 | | 锪孔口平面 | | | | | | 专用夹具，D25带导柱直柄平底锪钻 | | | | | | | | | 250 | | 19.63 | | | | | 0.15 | | | 7.4 | | | 1 | | | | | | 2.4s | | | |  | |
| 3 | | 倒角 | | | | | | 专用夹具，90°直柄锥面锪钻 | | | | | | | | | 300 | | 11.8 | | | | | 0.1 | | | 1 | | | 1 | | | | | | 4s | | | |  | |
| 4 | | 钻B平面四个通孔 | | | | | | 专用夹具，D10.2高速钢标准柄的右旋莫氏锥柄麻花钻 | | | | | | | | | 400 | | 12.8 | | | | | 0.6 | | | 5.1 | | | 4 | | | | | | 24s | | | |  | |
| 5 | | 倒角 | | | | | | 专用夹具，90°直柄锥面锪钻 | | | | | | | | | 300 | | 11.8 | | | | | 0.1 | | | 1 | | | 4 | | | | | | 16s | | | |  | |
|  |  | |  |  | |  |  | |  |  |  |  | | 设 计（日 期） | | | | 校 对（日期） | | | | 审 核（日期） | | | | | | 标准化（日期） | | | | | | 会 签（日期） | | | | | | | |
|  |  | |  |  | |  |  | |  |  |  |  | |
| 2020-4-19 | | | |  | | | |  | | | | | |  | | | | | |  | | | | | | | |
| 标记 | 处数 | | 更改文件号 | 签 字 | | 日 期 | 标记 | | 处数 | 更改文件号 | 签 字 | 日 期 | |