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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 | | | 1 | | | 页 |
|  | | | | | | | | | | | | | | | | 车间 | | | | 工序号 | | | | | | 工序名称 | | | | | | | 材 料 牌 号 | | | | | | | | | |
| 金工 | | | | 30 | | | | | | 铣 | | | | | | | 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\*68.6 | | | | | | 1 | | | | | | | 1 | | | | | | | | | |
| 设备名称 | | | | 设备型号 | | | | | | 设备编号 | | | | | | | 同时加工件数 | | | | | | | | | |
| 立式铣床 | | | | X51 | | | | | |  | | | | | | | 1 | | | | | | | | | |
| 夹具编号 | | | | | | | 夹具名称 | | | | | | | | 切削液 | | | | | | | | | | | |
|  | | | | | | | 专用铣床夹具 | | | | | | | |  | | | | | | | | | | | |
| 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/z | | | mm | | | 机动 | | | 辅助 | | |
| 1 | | 以F平面为粗基准，粗铣D平面 | | | | | | | 专用夹具，高速钢面铣刀D=80  JB/T 7954-1999 | | | | | | | | 160 | | 40.21 | | | | | 0. 2 | | | 2 | | | 1 | | | | | | | 49.30 | | | |  | |
| 2 | | 以F平面为基准，精铣G平面 | | | | | | | 专用夹具，高速钢中齿莫氏锥柄立铣刀 | | | | | | | | 725 | | 22.78 | | | | | 0.043 | | | 1 | | | 4 | | | | | | | 81.6 | | | |  | |
| 3 | | 以D平面为基准，半精铣B平面 | | | | | | | 专用夹具，高速钢面铣刀D=80  JB/T 7954-1999 | | | | | | | | 160 | | 40.21 | | | | | 0.2 | | | 2 | | | 1 | | | | | | | 49.30 | | | |  | |
| 4 | | 以D平面为基准，精铣B平面 | | | | | | | 专用夹具，高速钢面铣刀D=80  JB/T 7954-1999 | | | | | | | | 160 | | 40.21 | | | | | 0.14 | | | 1.6 | | | 1 | | | | | | | 68.59 | | | |  | |
|  |  | |  |  | |  |  |  | |  |  |  | | 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 | |