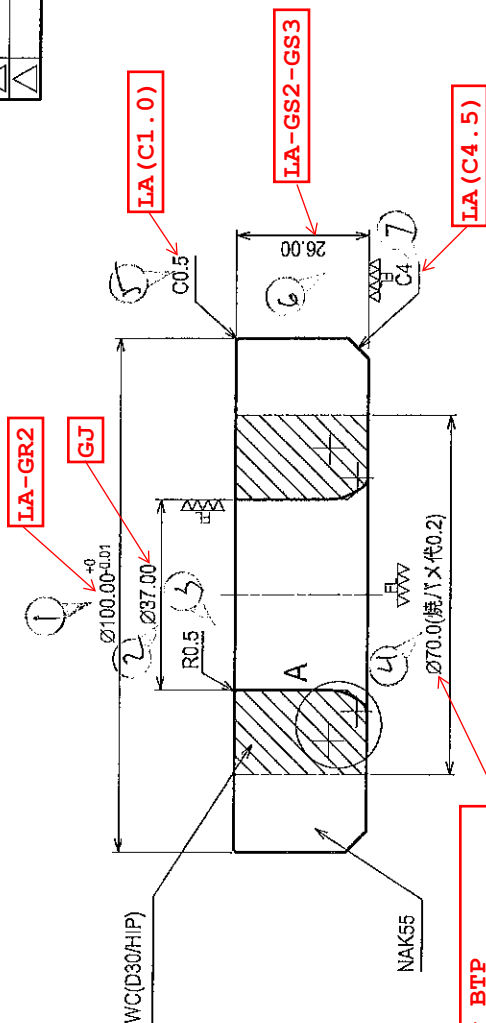


28/11/2023 @ 7am

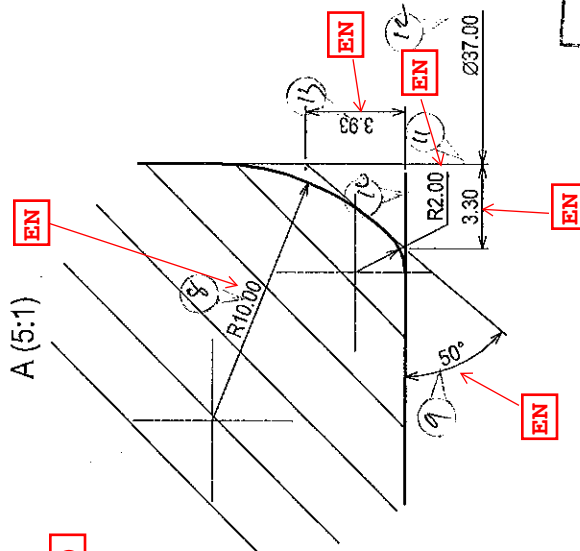
4142120438, S870614 - GIA CONG - 30/03/2023

REV.	DATE	DESCRIPTION	REF. NO.	DWN.	CHKD.	CUTTING TOLERANCE
init	2012/09/20			K.Hirahata	Y.Takahashi	0.0000 ±0.002 0.000 ±0.006 0.000 -0.008 -0.008
△						0.000 ±0.006 0.000 -0.008 -0.008
△						0.000 ±0.01 0.000 -0.01 -0.01
△						0.0 ±0.1 0.000 -0.01 -0.01
△						0 ±0.2 0.0 ±0.2 ±0.2

TOLERANCES NOT OTHERWISE SPECIFIED		FINISH MARKS	
0.0	0.0	6	FL (W)



GR1:Gia công BTP  
-Mài sáng Ø70 BTP (Ø70=A)  
LA:Gia công NAK 55  
-Ø74=A-0.21  
AF1:Ép nóng



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7  
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10  
11

DWN.	CHKD.	TITLE		PARTS NAME	
K. Hihara	Y. Takahashi	部品図		絞リダイ	
QUENCH&TEMPER	SURFACE	PART DRAWING		DRAW DIE	
HRC		部品図		引伸下模	
MATERIAL	DATE	SCALE		引伸下模	
VA55HC/Q30(HIP)	2012/09/20	1:1		DWG. No.	
				S870614	

ATP 5870514  
17120285419  
NAK 0110 X52

4

3

2

1

SNO: **S870614**

SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:

NGƯỜI THIẾT LẬP: **10197**

DIỄN GIẢI	THỜI GIAN CHUẨN 1P
<b>1.VẬT LIỆU:</b> <b>BTP S870614(GS1)</b> <b>NAK:Ø110*31(LA)</b>	GS1:30 GR:40 LA:120 AF:30 GS2:60 GR2:90 GJ:300 EN:300 KA:1 GS3:30 AF:30 KT