

SNO: S856587	
SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:	
NGƯỜI THIẾT LẬP: 10197	
DIỄN GIẢI	THỜI GIAN CHUẨN 1P
<p>1.VẬT LIỆU: WCD25 Ø22 x 28</p> <p>2.THỜI GIAN GIA CÔNG EW1:Cắt vật liệu Ø22 x 26 =>40 phút/pc GR1:Kẹp trở đầu gia công -Ø20=>Ø20.10 -Ø18(-0.01~-0.02)=>Ø18.10 dài 4 mm =>75 phút/pc ED:Gia công lỗ xỏ dây =>15 phút/pc EW2: -Ø3.08=>ok =>40 phút/pc GR2:Gia công trên tâm giả -Ø18(-0.01~-0.02)=>ok -Ø20=>ok =>40 phút/pc GS: -25=>ok =>20 phút/pc EN: -Ø3.5=>ok =>30 phút/pc</p>	<p>EW1:40 GR1:75 ED:15 EW2:40 GR2:40 GS:20 EN:30 KT</p>

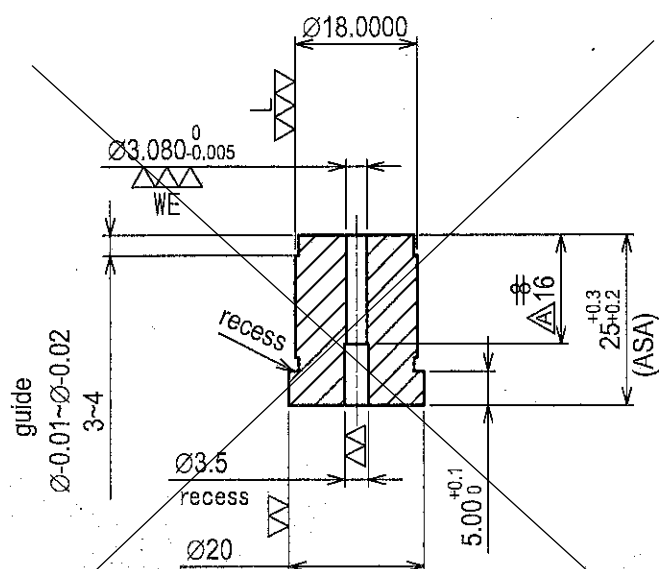
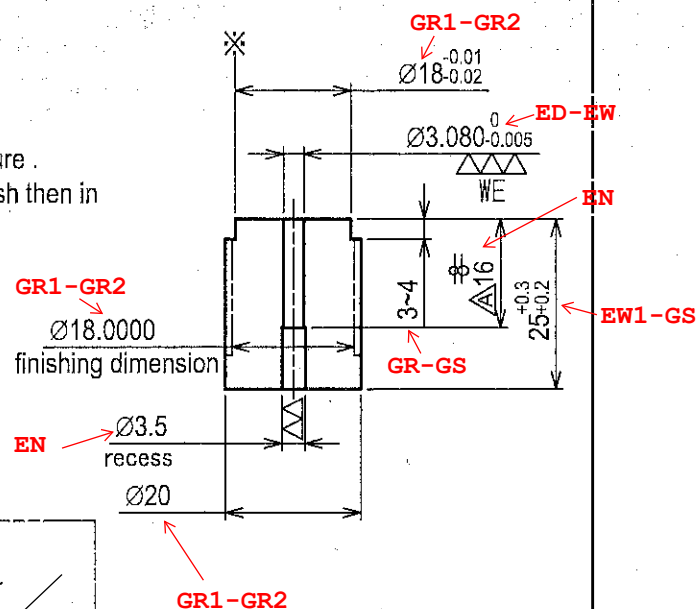
95/12/24

REV.	DATE	DESCRIPTION	REF.	DWN.	DSGND.	CHKD.	CUTTING TOLERANCE
init.							0.0000 ± 0.002 0.000 +0 -0.005
	2012/02/22	部品使用寿命延長の為(S723821-S856587)	DDM-12-02-003	Wu_Chin_Wuu		Chang_Fu_Rung	0.00 ± 0.002 0.000 +0 -0.005
	2012/10/19	部品使用寿命延長の為	DDM-12-09-008	Wu_Chin_Wuu		Chang_Fu_Rung	0.0 ± 0.1 0.00 +0 -0.01
	2020/08/30	注释英文化	PLM-EDP-20-08-001	Sun_Yin		Ye_Chang_Jing	0. ± 0.2 0.0 +0 -0.1

Slope of relief for cutting blade is [3']
from the upper face of die.

TOLERANCES NOT OTHERWISE SPECIFIED	
FINISH MARKS	
G	WE L
▽▽ (▽▽▽▽▽▽)	

Process spare parts above figure.
Take※ as the base level to finish then in each production base.



Process new parts for new die as above figure and finish them in each production base.

CHKD.	MATERIAL		TITLE	PARTS NAME
Ye_Chang_Jing	WC(D25/HIP)		部品図	ダイ
DSGND.	SURFACE	SCALE	PART DRAWING	DIE
Sun_Yin		1:1	部品図	下模
DWN.	QUENCH&TEMPER	SIZE	DATE	DWG.No.
Sun_Yin	HRC ~	A4V	2012/02/06	S856587

MABUCHI MOTOR CO.,LTD.