

414.1050004

REV.	DATE	DESCRIPTION	REF.No.	DWN.	DSGND.	CHKD.	CUTTING TOLERANCE	
Init.	2020/03/12	New production	DWCS-0332	Vinh_Tuyet	Pham_Phu_Quoc	Hirano_Takeshi	$0.5 \leq \leq 6$	$\pm 0.1$
							$6 < \leq 30$	$\pm 0.2$
							$30 < \leq 120$	$\pm 0.3$
							$120 < \leq 400$	$\pm 0.5$

TOLERANCES NOT OTHERWISE SPECIFIED APPLIES JIS B 0405-m, JIS B 0419-k

FINISH MARKS

 $\sqrt{Ra 1.6}$  ( $\sqrt{G Ra 1.6}$ )

213 104 097b.

100p

NOTE 1

ED-EW

 $\varnothing 5.0^{+0.05}_0$ 

GS2

13°

G

Ra 1.6

MC

 $\varnothing 0.9^{+0.04}_{+0.02}$ 

GS2

 $0.75 \pm 0.02$ 

1.3

2.05  $\pm 0.02$ 

MC

0.7  $\pm 0.02$ 

MC

1.0  $\pm 0.02$ 

GS2

0.02 A

19.5  $\pm 0.01$ 

8.9°

NA

0.03 A

C0.2

C0.5

AF

GS1-GS2

Ra 1.6

G

0.02 B

3.0  $\pm 0.03$ 

GS2

0.6  $\pm 0.01$ 

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$ 

GS2

0.02 B

0.6  $\pm 0.01$

SNO: R358740	
SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG: 30 P	
NGƯỜI THIẾT LẬP: 10197	
DIỄN GIẢI	THỜI GIAN CHUẨN 1P
<p>1.VT LIU: MO Ø5X24</p> <p>2.THỜI GIAN GIA CÔNG</p> <p><b>GS1: Cắt + Men C=&gt;2 phút/pc</b></p> <p><b>ED:Phóng lỗ cho EW xỏ dây</b> <b>=&gt;30 phút/pc</b></p> <p><b>EW:Gia công Ø0.7 đảm bảo độ đồng trục</b> <b>=&gt;12 phút/pc</b></p> <p><b>GS2:</b></p> <ul style="list-style-type: none"> <li>-Mài kích thước 19.5+men C=&gt;1 phút/pc</li> <li>-Mài kích thước 0.10 về kích thước chuẩn =&gt;2 phút/pc</li> <li>-Mài 0.6 trên đồ gá(chú ý kiểm tra lại bằng DI)=&gt;5 phút/pc</li> <li>-Mài 40° trên đồ gá=&gt;2 phút/pc</li> <li>-Mài 13° trên đồ gá=&gt;3 phút/pc</li> <li>-Mài 8.9° trên đồ gá=&gt;3 phút/pc</li> </ul> <p><b>=&gt;16 phút/pc</b></p> <p><b>MC:</b></p> <ul style="list-style-type: none"> <li>-Gia công Ø0.9=&gt;5 phút/pc</li> <li>-Gia công rãnh <math>1\pm 0.02</math> =&gt;10 phút/pc</li> <li>-Gia công lỗ 0.5</li> </ul> <p>+Dùng mũi chống tâm Ø1 đã mài phần mũi xuống Ø2 L=2 mm.</p> <p>+Dùng mũi khoan Ø0.5 để khoan =&gt;10 phút/pc</p> <p><b>=&gt;25 phút/pc</b></p> <p><b>AF:Gia công 6° và lấy ba vó=&gt;1 phút/pc</b></p> <p><b>AL:In lazer=&gt;1 phút/pc</b></p>	<p>GS1:2 GC:2 ED:30 EW:12 GS2:16 MC:25 AF:1 AL:1 KT</p>