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REV.	DATE	DESCRIPTION	REF. NO.	BY	CHKD.
1	2005/09/13	進修貿易(34.95-037)			
2	2013/08/07	図面整理、寸法修復と寸法中心値標註			

CUTTING TOLERANCE	0.0000	0.0002	0.0004	0.0008	0.0016	0.0032	0.0064	0.0128	0.0256	0.0512	0.1024	0.2048	0.4096	0.8192	1.6384	3.2768	6.5536	13.1072	26.2144	52.4288	104.8576	209.7152	419.4304	838.8608	1677.7216	3355.4432	6710.8864	13421.7728	26843.5456	53687.0912	107374.1824	214748.3648	429496.7296	858993.4592	1717986.9184	3435973.8368	6871947.6736	13743895.3472	27487790.6944	54975581.3888	109951162.7776	219902325.5552	439804651.1104	879609302.2208	1759218604.4416	3518437208.8832	7036874417.7664	14073748835.5328	28147497671.0656	56294995342.1312	112589990684.2624	225179981368.5248	450359962737.0496	900719925474.0992	1801439850948.1984	3602879701896.3968	7205759403792.7936	14411518807585.5872	28823037615171.1744	57646075230342.3488	115292150460684.6976	230584300921369.3952	461168601842738.7904	922337203685477.5808	1844674407370955.1616	3689348814741910.3232	7378697629483820.6464	14757395258967641.2928	29514790517935282.5856	59029581035870565.1712	118059162071741130.3424	236118324143482260.6848	472236648286964521.3696	944473296573929042.7392	1888946593147858085.4784	3777893186295716170.9568	7555786372591432341.9136	15111572745182864683.8272	30223145490365729367.6544	60446290980731458735.3088	120892581961462917470.6176	241785163922925834941.2352	483570327845851669882.4704	967140655691703339764.9408	1934281311383406679529.8816	3868562622766813359059.7632	7737125245533626718119.5264	15474250491067253436239.0528	30948500982134506872478.1056	61897001964269013744956.2112	123794003928538027489912.4224	247588007857076054979824.8448	495176015714152109959649.6896	990352031428304219919299.3792	1980704062856608439838598.7584	3961408125713216879677197.5168	7922816251426433759354395.0336	15845632502852867518708790.0672	31691265005705735037417580.1344	63382530011411470074835160.2688	126765060022822940149670320.5376	253530120045645880299340641.0752	507060240091291760598681282.1504	1014120480182583521197362564.3008	2028240960365167042394725128.6016	4056481920730334084789450257.2032	8112963841460668169578900514.4064	16225927683221336339157801028.8128	32451855366442672678315602057.6256	64903710732885345356631204115.2512	129807421465770690713262408230.5024	259614842931541381426524816461.0048	519229685863082762853049632922.0096	1038459371726165525706099265844.0192	2076918743452331051412198531688.0384	4153837486904662102824397063376.0768	8307674973809324205648794126752.1536	16615349947618648411297588253504.3072	33230699895237296822595176507008.6144	66461399790474593645190353014016.2288	132922799580949187290380706028032.4576	265845599161898374580761412056064.9152	531691198323796749161522824112128.8304	1063382396647593498323045648224256.6608	2126764793295186996646091296448512.3216	4253529586590373993292182592897024.6432	8507059173180747986584365185794048.2864	17014118346361495973168730371588096.5728	34028236692722991946337460743176192.1456	68056473385445983892674921486352384.2912	136112946770891967785349842972704768.5824	272225893541783935570699685945409537.1648	544451787083567871141399371890819074.3296	1088903574167135742282798743781638148.6592	2177807148334271484565597487563276297.3184	4355614296668542969131194975126552594.6368	8711228593337085938262389950253105189.2736	1742245718667417187652477990050620338.5472	3484491437334834375304955980101240677.0944	6968982874669668750609911960202481354.1888	13937965749339337501219823920404962708.3776	27875931498678675002439647840809925416.7552	55751862997357350004879295681619850832.1504	111503725994714700009758591363239701664.3008	223007451989429400019517182726479403328.6016	446014903978858800039034365452958806656.2032	892029807957717600078068730905917613312.4064	1784059615915435200156137461811835226624.8128	3568119231830870400312274923623670453248.6256	7136238463661740800624549847247340906496.2512	14272476927323481601249099694494681812992.5024	28544953854646963202498199388989363625984.0048	57089907709293926404996398777978727251968.0096	114179815418587852809992797555957454503936.0192	228359630837175705619985595111914909007872.0384	456719261674351411239971190223829818015744.0768	913438523348702822479942380447659636031488.1536	1826877046697405644959884760895319272062976.3072	3653754093394811289919769521790638544125952.6144	7307508186789622579839539043581277088251904.2288	14615016373579245159679078087162554176503808.4576	29230032747158490319358156174325108353007616.9152	58460065494316980638716312348650216706015232.1808	116920130988633961277432624697300433412030464.3616	233840261977267922554865249394600866824060928.7232	467680523954535845109730498789201733648121856.1456	935361047909071690219460997578403467296243712.2912	1870722095818143380438921995156806934592487424.5824	3741444191636286760877843990313613869184974848.1168	7482888383272573521755687980627227738369949696.2336	14965776766545147043511375961254455476739899392.4672	29931553533090294087022751922508910953479798784.9344	59863107066180588174045503845017821906959597568.8688	119726214132361176348091007690035643813919195137.7376	239452428264722352696182015380071287627838390275.4752	478904856529444705392364030760142575255676780550.9504	957809713058889410784728061520285150511353561101.9008	1915619426117778821569456123040570301022707122203.8016	383123885223555764313891224608114060204541424440.6032	766247770447111528627782449216228120409082848880.2064	1532495540894223057255564898432456240818165697760.4128	3064991081788446114511129796864912481636331395520.8256	6129982163576892229022259593729824963272662791041.6512	12259964327153784458044519187459649926545325582083.3024	24519928654307568916089038374919299853090651164166.6048	49039857308615137832178076749838599706181302328332.2096	98079714617230275664356153499677199412362604656664.4192	196159429234460551328712306999354398824725209313328.8384	392318858468921102657424613998708797649450418626656.6768	784637716937842205314849227997417595298900837253312.1336	1569275433875684410629698455994835190597801674506624.2672	3138550867751368821259396911989670381195603349013248.5344	6277101735502737642518793823979340762391206698026496.0688	12554203471005475285037587647958681524782413396052992.1376	25108406942010950570075175295917363049564826792105984.2752	50216813884021901140150350591834726099129653584211968.5504	10043362776804380228030070118366945219825930716843936.1008	20086725553608760456060140236733890439651861433687872.2016	40173451107217520912120280473467780879313722867375744.4032	80346902214435041824240560946935561758627445734751488.8064	16069380442887008364848112189387112357245489146950296.6128	32138760885774016729696224378774224714490978293900592.2256	64277521771548033459392448757548449428981956587801184.4512	128555043543096066918784897515096898857963913175602368.9024	257110087086192133837569795030193797715927826351200477.8048	51422017417238426767513959006038759543185565270240095.6096	102844034834476853535027918012077519086371130540480191.2192	205688069668953707070055836024155038172742261080960382.4384	411376139337907414140111672048310076345484522161920764.8768	822752278675814828280223344096620152690969044323841529.7536	164550455735162965656044668819324030538193808864768305.5072	329100911470325931312089337638648061076387617729536711.0144	658201822940651862624178675277296122152775235459073422.0288	131640364588130372524835735055459224430555047091814684.4576	263280729176260745049671470110918448861110094183629368.9152	526561458352521490099342940221836897722220188367258737.8304	1053122916705042980198685880443673795444440773734517545.6608	210624583341008596039737176088734759088888154746903509.1216	421249166682017192079474352177469518177776309493807018.2432	842498333364034384158948704354939036355552618987614036.4864	168499666672806876831789740870987807271110523797522807.2912	336999333345613753663579481741975614542221047595045614.5824	673998666691227507327158963483951229084442095190091229.1648	1347997333382455014654317968967902578168884190380182458.3296	269599466676491002930863593793580515633776838076036491.6592	539198933352982005861727187587161031267553676152072983.3184	1078397866705964011723454375174322062535107352304145966.6368	215679573341192802344690875034864412507021470460829193.2736	431359146682385604689381750069728825014042940921658386.5472	862718293364771209378763500139457650028085881843116773.0944	172543658672954241875752700027891530005617176368623354.1888	345087317345908483751505400055783060011234352737246709.3776	690174634691816967503010800111566120022468705474493418.7552	1380349269383633935006021600223132240044937410948986837.5104	276069853876726787001204320044626448008987482189797365.0208	552139707753453574002408640089252896017974964379594730.0416	1104279415506907148004817280178505792035949928759189460.0832	2208558831013814296009634560357011584071899857518378920.1664	4417117662027628592019269120714023168143799715036757840.3328	8834235324055257184038538241428046336287599430073515680.6656	1766847064811051436807707648285609267257519886014703137.1312	3533694129622102873615415296571218534515039772029406274.2624	70673882592442057472308305931424370690300794440588124.5248	141347765184884114944616611862848741380600158888011769.0496	282695530369768229889233223725697482761200317777023538.0992	565391060739536459778466447451394965522400635554047076.1984	1130782121479072919556932894902789931044801271108094152.3968	2261564242958145839113865789805579862089602542216188304.7936	452312848591629167822773157961115972417920508443237660.7872	904625697183258335645546315922231944835841016886475321.5744	180925139436651667129109263184446388967168203377295064.1488	361850278873303334258218526368892777934336406754590128.2976	723700557746606668516437052737785555868672813509180256.5952	1447401115493213337032874105475571111737345627018360512.1104	289480223098642667406574821095114222347469125403672102.2208	578960446197285334813149642190228444694938250807344204.4416	115792089239457066962629928438045688978987650161468840.8832	231584178478914133925259856876091377957975300322937681.7664	463168356957828267850519713752182755915950600645875363.5328	926336713915656535701039427504365511831901201291507467.0656	1852673427831313071402078855008731023663802402583014934.1312	370534685566262614280415771001746204732760480516602988.2624	741069371132525228560831542003492409465520961033205976.5248	1482138742265050457121663084006948891331041922066411952.0496	296427748453010091424332616801389782666203844013282390.0992	592855496906020182848665233602779565332407688026564780.1984	1185710993812040365697330467205559130664815376053129560.3968	2371421987624080731394660934411118261329630752106259120.7936	474284397524816146278932186882223652265926150421251824.1472	948568795049632292557864373764447304531852300842503648.2944	1897137590099264585115728747528894609063704601645007296.5888	3794275180198529170231457495057789218127409203290014593.1776	758855036039705834046291499011557836244881840658002918.3552	1517710072079411668092582998023115624889763681316005836.7104	303542014415882333618516599
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SNO: <b>S648308</b>	
SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:	
NGƯỜI THIẾT LẬP: <b>10197</b>	
DIỄN GIẢI	THỜI GIAN CHUẨN 1P
<b>1.VẬT LIỆU:</b> <b>BTP S648308</b>  <b>2.THỜI GIAN GIA CÔNG</b> <b>GS1:</b> -20.500=>lướt sáng -29.000=29.10 -28.200=>28.30 Chú ý:các kích thước đảm bảo vuông góc và song song.Max=0.005.Và canh theo vị trí các lỗ có sẵn trên BTP. -4-C0.5=>ok <b>120 phút/pc</b> <b>EW:</b> -2-Ø1.425=>ok -4-Ø2.100=>ok -4-Ø2.60=>ok -2-Ø4.500=>ok -Ø5.4750=>ok -4-R1.5800=>ok <b>350 phút/pc</b> <b>GS2:</b> -Canh lại tất cả vị trí lỗ EW=>ok -Mài phần lưỡi cắt đảm bảo kích thước trên bản vẽ. -29.000=>ok -28.200=>ok -20.500=>ok <b>250 phút/pc</b>	GS1:120 EW:350 GS2:250 KT