

MV

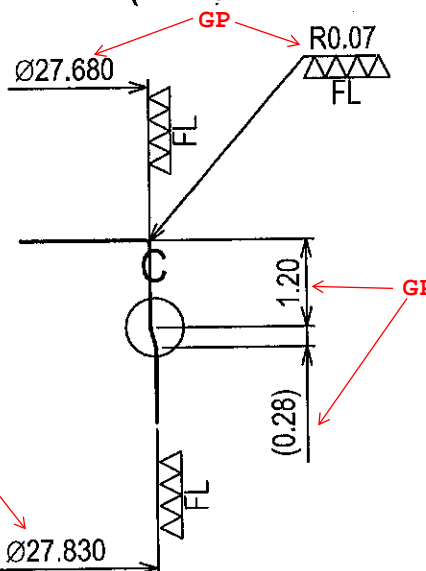
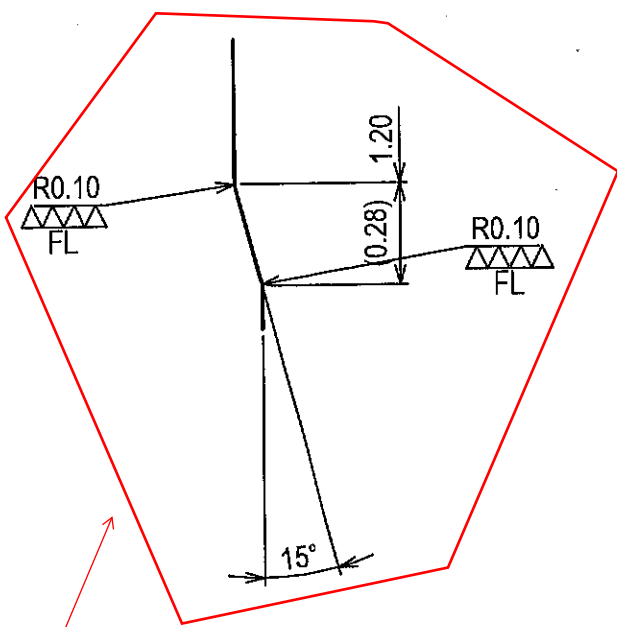
REV.	DATE	DESCRIPTION	REF.No.	DWN.	CHKD.	CUTTING TOLERANCE			
init.	2017/07/29	新規設計		K.Kamakura	K.Indei	0.0000	±0.002	0.000 +0	+0 -0.005
△						0.000	±0.005	0.000 -0	+0.005 -0
△						0.00	±0.01	0.00 +0	+0 -0.01
△						0.0	±0.1	0.00 -0	+0.01 -0
△						0.	±0.2	0.0 +0	+0 -0.1
								0.0 -0	+0.1 -0
TOLERANCES NOT OTHERWISE SPECIFIED									
FINISH MARKS									
G FL ▽▽▽ (▽▽▽)									

C (50:1)

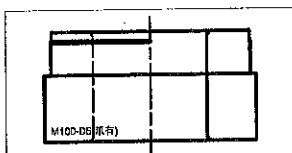
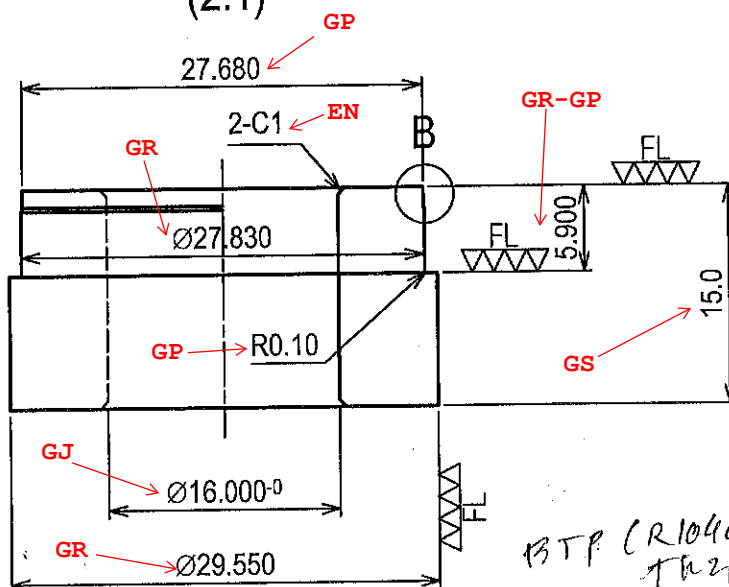
213 109 031A.

IP

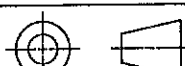
B (10:1)



(2:1)



BTP (R104420)
TH2P

DSGND.	CHKD.	TITLE		PARTS NAME
K.Kamakura	K.Indei	部品図		パンチ
QUENCH&TEMPER	SURFACE	PART DRAWING		PUNCH
HRC 0 ° ~ 0 °		部品図		沖頭
		部品図		冲头
MATERIAL	DATE	SCALE		DWG.No.
WC(D30/HIP)	2017/07/29	1:1		R104420

SNO: R104420	
SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:	
NGƯỜI THIẾT LẬP: 10197	
DIỄN GIẢI	THỜI GIAN CHUẨN 1P
1.VẬT LIỆU: BTP R104420 2.THỜI GIAN GIA CÔNG GS: -Lượt sáng 2 mặt 20 phút/pc GR: -Ø27.680=>OK -Ø29.550=>OK 90 phút/pc GS: -5.900=>5.8 -15.0=>ok 60 phút/pc GJ: -Ø16.000=>ok 120 phút/pc EN: -2-C1=>ok 60 phút/pc GP: -5.900=>ok -3-R0.10=>ok -15°=>ok -R0.07=>ok -Ø27.68=>ok 120 phút/pc AF: Đánh bóng=>ok 20 phút/pc	GS:20 GR:90 GS:60 GJ:120 EN:60 GP:120 AF:20 KT