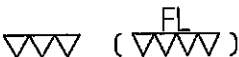
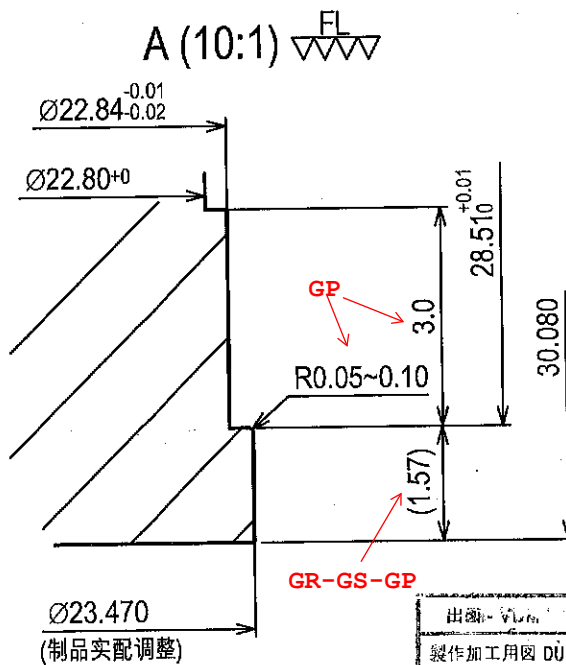
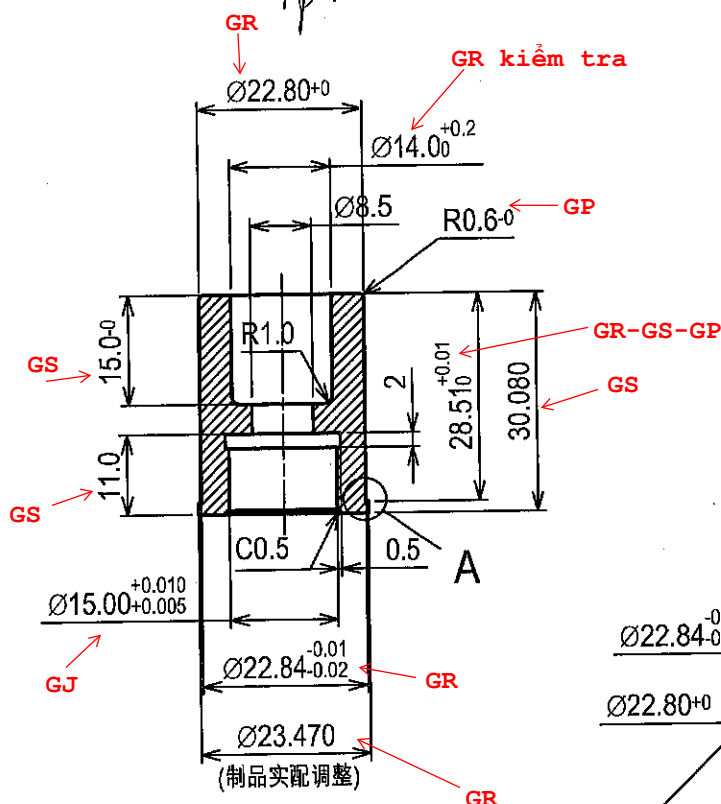


REV.	DATE	DESCRIPTION	REF. No.	OWN.	CHKD.	CUTTING TOLERANCE			
init.	2016/11/10	新规设计		涂永军	叶长敬	0.0000	±0.002	0.000 +0	+0 -0.005
△						0.0005	±0.005	0.000 -0	-0 +0.005
△						0.001	±0.01	0.00 +0	+0 -0.01
△						0.01	±0.1	0.00 -0	-0 +0.01
						0.1	±0.2	0.0 +0	+0 -0.1
								0.0 -0	-0 +0.1
TOLERANCES NOT OTHERWISE SPECIFIED									
FINISH MARKS									
									

213 906 119A.

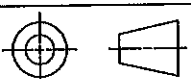
1p.



120
90
150
40
30.

213 19 06 262

出图: VLM	26-06-2019
製作加工用図 DUNG GIA CÔNG	
TRẢ VÉ SAU 3 THÁNG	
NO COPY	
CONFIDENTIAL	

DSGND.	CHKD.	TITLE		PARTS NAME	
涂永军	叶长敬	部品图		制品导件	
QUENCH&TEMPER	SURFACE				
HRC					
MATERIAL	DATE	SCALE		DWG.No.	
WC(D50/HIP)	2015/07/23	1:1		R069615	

BTP R069615 (TK 2P)

MABUCHI MOTOR CO., LTD.

SNO: R069615	
SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:	
NGƯỜI THIẾT LẬP: 10197	
DIỄN GIẢI	THỜI GIAN CHUẨN 1P
1.VẬT LIỆU: BTP R069615 2.THỜI GIAN GIA CÔNG GR: -Ø23.470 =>ok -Ø22.840=>ok/3.0=>2.9/1.57=>2.2 -Ø22.80=>ok => 150 phút/pc GS: -28.51=>28.4 -30.080=>ok => 40 phút/pc GJ: -Ø15.00=>ok => 12 phút/pc GP: -28.51=>ok -3.0=>ok -R0.6=>ok => 80 phút/pc -AF: Đánh bóng=> 20 phút/pc	GR:150 GS:40 GJ:12 GP:80 AF:20 KT