

8/24

1215X0047

80
60
150
30
60
80
150
200
400
60
30

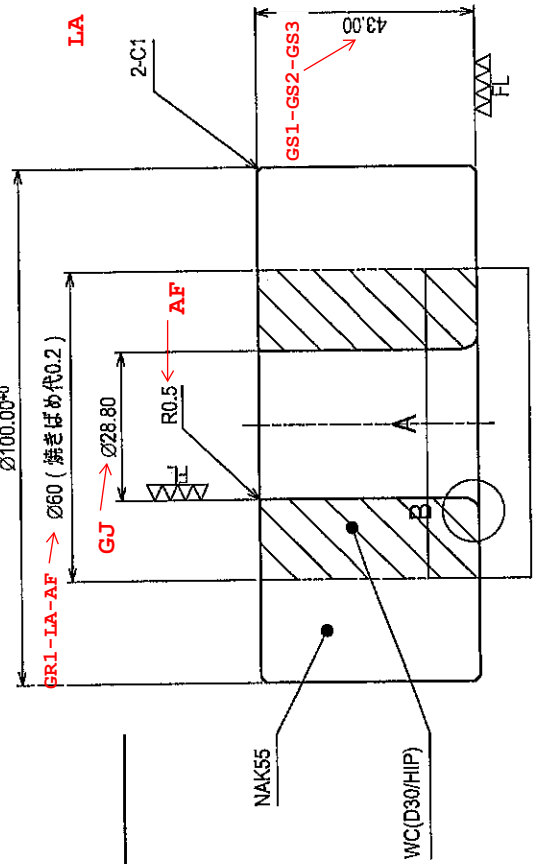
4141040519.R028175 - GIA CONG - 28/07/2021

Mat

7/1

REV.	DATE	DESCRIPTION	REF. No.	DWN.	CHKD.	CUTTING TOLERANCE
1	20/5/11/30	設計			K.Kamakura	±0.002
2						±0.005
3						±0.01
4						±0.01
5						±0.01
6						±0.01
7						±0.01
8						±0.01
9						±0.01
10						±0.01
11						±0.01
12						±0.01
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93						±0.01
94						±0.01
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97						±0.01
98						±0.01
99						±0.01
100						±0.01

LA-GR2

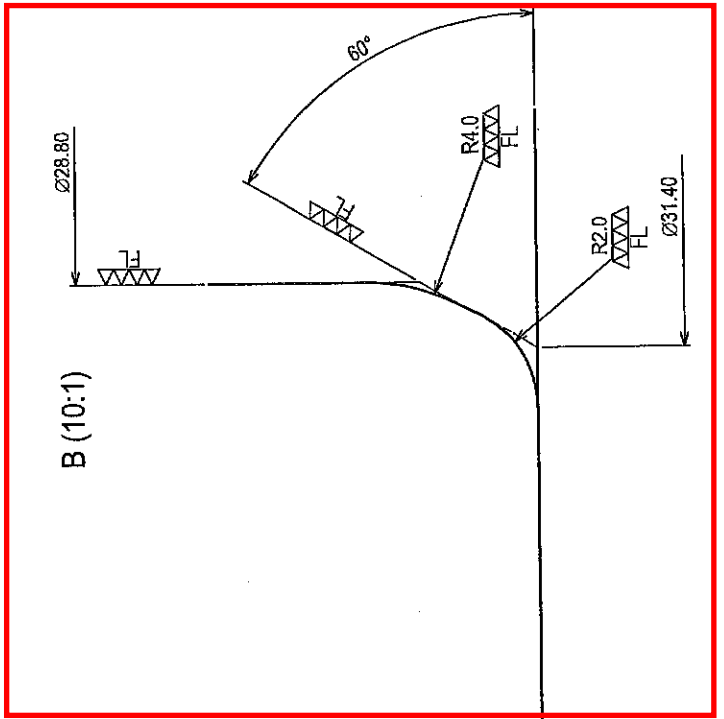
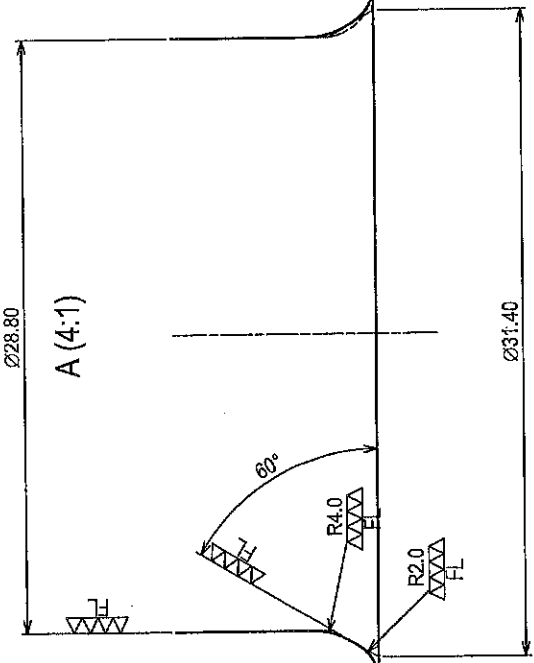


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(1P)

ATP R028175
NAK 110 X 63

EN-AF



DSGND.	CHKD.	TITLE	PARTS NAME
K.Kamakura	T.Yajima	部品図	ダイ
QUENCH&TEMPER	SURFACE	PART DRAWING	DIE
HRC 0° ~ 0°		部品図	下模
MATERIAL	DATE	SCALE	DWG.No.
NAK55-WC(D30HIP)	2015/11/30	1:1	

R028175

MARUCHI MOTOR CO., LTD.

414.1040519

1 2 NG ATP Co. (3)

SNO: R028175	
SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:	
NGƯỜI THIẾT LẬP: 10197	
DIỄN GIẢI	THỜI GIAN CHUẨN 1P
1.VẬT LIỆU: -BTP R028175(GS) -NAK55 Ø110 X 48(LA) 2.THỜI GIAN GIA CÔNG GS1:Gia công BTP Lướt sáng 2 mặt BTP => 30 phút/pc GR:Gia công BTP -Mài sáng Ø60 BTP (Ø60=A) => 60 phút/pc LA:Gia công NAK 55 -Ø100.00=>Ø100.3 -Ø60=A-0.18 -2-C1=>ok => 120 phút/pc AF:Ép nóng BTP vào NAK => 30 phút/pc GS2: -43.00=>43.10 => 60 phút/pc GJ: -Ø28.80=>ok => 200 phút/pc EN: -Phân vuốt=>ok => 250 phút/pc -KA:Kiểm tra phần vuốt => 1 phút/pc GS3: -43.00=>ok => 30 phút/pc AF: -Đánh bóng -R0.5 => 30 phút/pc	GS:30 GR1:60 LA:120 AF:30 GS2:60 GJ:200 EN:250 KA:1 GS3:30 AF:20 KT