

213 19 07 011

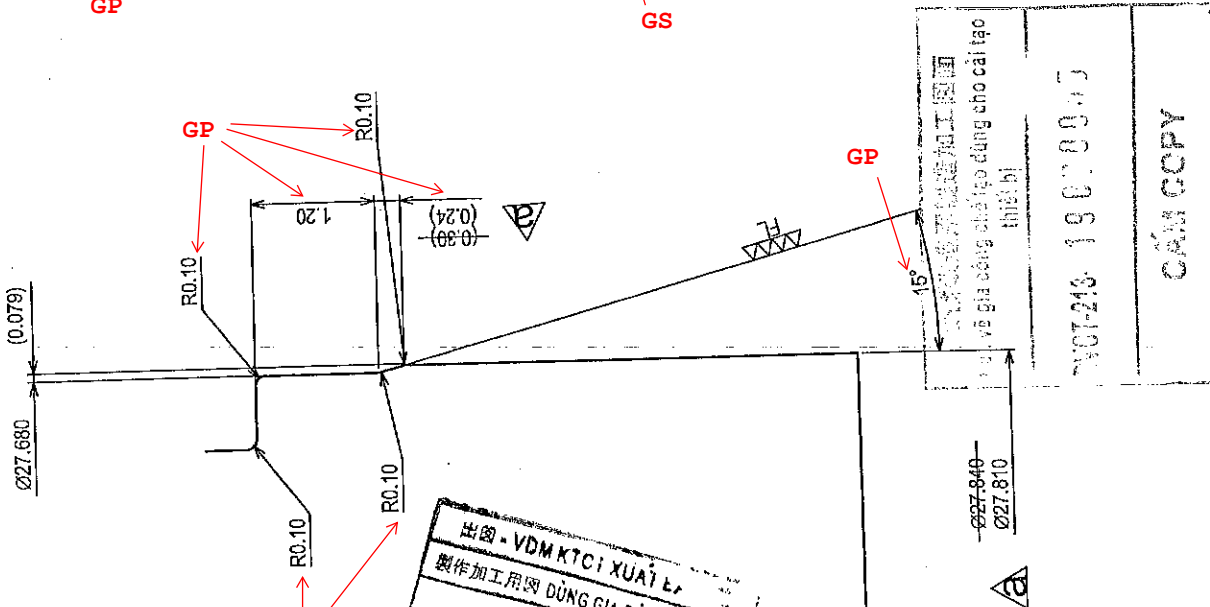
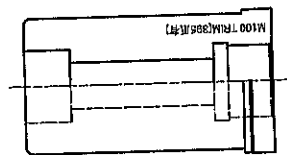
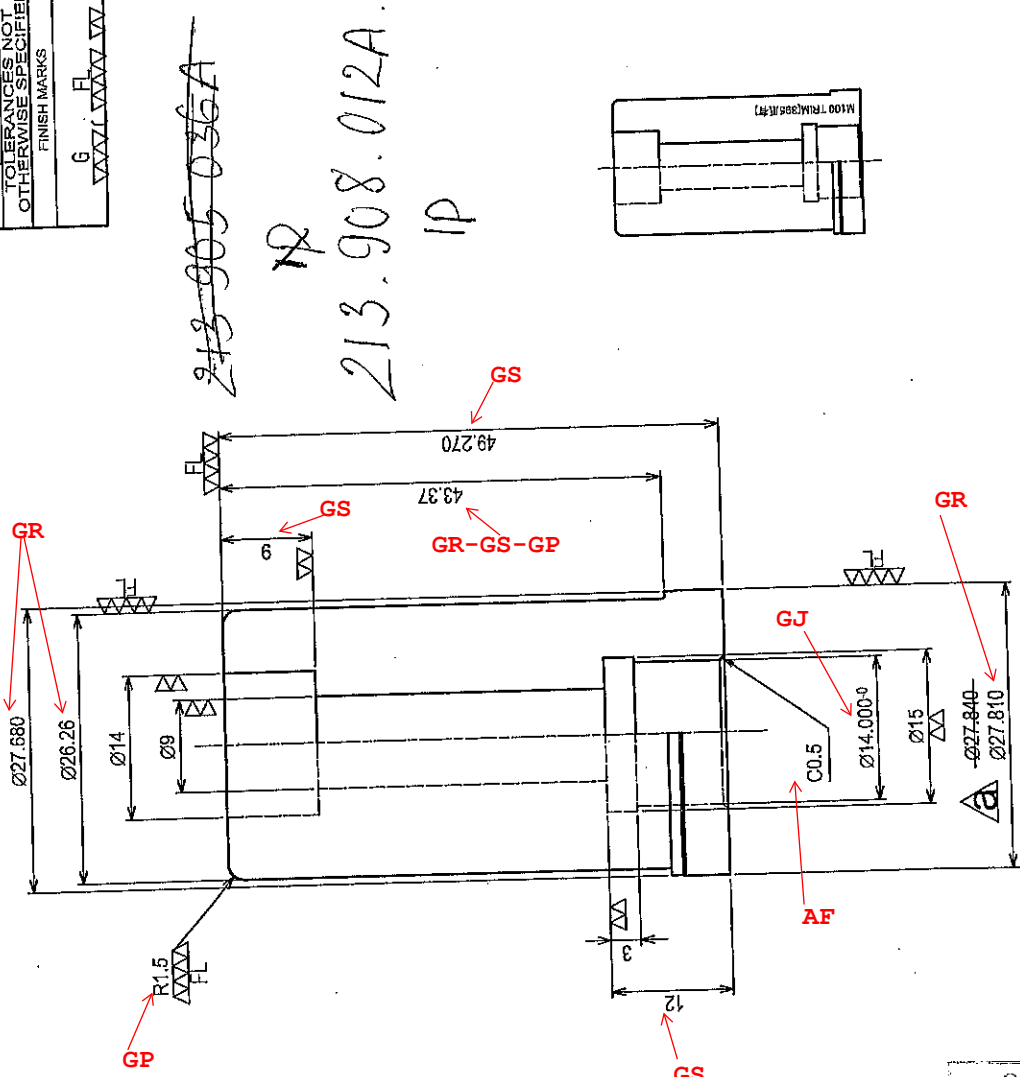
41 4. 2019 07. 091

09-07-2019

180  
90  
120  
90  
30

| REV.  | DATE       | DESCRIPTION        | REF. No.    | DWN.         | CHKD.      | CUTTING TOLERANCE                   |
|-------|------------|--------------------|-------------|--------------|------------|-------------------------------------|
| init. | 2017/07/28 | 新機設計               |             | K Kamata     | K Indeli   | 0.0000<br>±0.002<br>0.000<br>±0.005 |
| 2/3   | 2017/07/30 | 增加不銹修              | YOUNG-17404 | FEI 何 2301   | 陳慶良 3304   | 0.00<br>±0.005<br>0.000<br>±0.001   |
| 3/3   | 2018/08/20 | 增加修改CAD檔圓形形狀, 增加上導 |             | HW Chan 1/56 | FEI 何 2301 | 0.0<br>±0.1<br>0.000<br>±0.2        |
| 4/3   |            |                    |             |              |            | 0<br>±0.2<br>0.0<br>±0.1            |

|               |            |              |         |                     |
|---------------|------------|--------------|---------|---------------------|
| DSGND.        | CHKD.      | TITLE        |         | PARTS NAME          |
| K.Kamakura    | K.Indei    | 部品図          |         | 製品ガイド               |
| QUENCH&TEMPER | SURFACE    | PART DRAWING |         | PROCESS GOODS GUIDE |
| HRC 0 ~ 0 °   |            | 部品図          |         | 製品導件                |
|               |            | 部品図          |         | 製品零件                |
| MATERIAL      | DATE       | SCALE        | DWG.No. |                     |
| WC(D30HP)     | 2017/07/28 | 1:1          | R104394 |                     |



| SNO: R104394   |  |
|--|--|
| SỐ PCS TỐI THIỂU/1 LẦN ĐẶT HÀNG:   |  |
| NGƯỜI THIẾT LẬP: 10197   |  |
| DIỄN GIẢI  | THỜI GIAN CHUẨN 1P                                 |
| <b>1.VẬT LIỆU:</b><br><b>BTP:R104394</b><br><br><b>2.THỜI GIAN GIA CÔNG</b><br><b>GR:</b><br>-Ø26.26=>ok,43.37=>43.4<br>-Ø27.680=>ok,1.20=>1.0<br>-Ø27.810=>ok<br>=> <b>150 phút/pc</b><br><b>GS:</b><br>-43.37=>43.2<br>-49.270=>ok<br>=> <b>60 phút/pc</b><br><b>GJ:</b><br>-Ø14.000=>ok<br>=> <b>120 phút/pc</b><br><b>GP:</b><br>-4-R0.10,15°=>ok<br>-43.37=>ok<br>-R1.5=>ok<br>=> <b>150 phút/pc</b><br><b>AF:</b><br>-C0.5<br>-Đánh bóng<br>=> <b>30 phút/pc</b> | GR:150<br>GS:60<br>GJ:120<br>GP:150<br>AF:30<br>KT |