|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
|  | 内圈 | 外圈 | 法兰 | 立柱 | 管件 | 连接件 |
| 原料仓库 | ① | ① | ① | ① | ① | ① |
| 下料车间 |  | ② |  | ② | ② | ② |
| 焊接车间 |  | ④ |  | ③ |  | ④ |
| 金加工车间 | ② | ③ | ② |  |  | ③ |
| 组装车间 | ③ | ⑤ | ③ |  | ③ | ⑤ |
| 喷漆车间 | ④ | ⑥ | ④ | ④ | ④ | ⑥ |
| 成品仓库 | ⑤ | ⑦ | ⑤ | ⑤ | ⑤ | ⑦ |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 序号 | 作业单位 |  |  |  |  |  |
| 1 | 原料仓库 | A/1 |  |  |  |  |
| 2 | 下料车间 | I/4 | O/3  I/2 |  |  |  |
| 3 | 焊接车间 | E/2 | E/2  O/2 | U/4  U/4 |  |  |
| 4 | 金加工车间 | E/2 | O/2  U/4 | U/4  U/4 | U/4  U/4 |  |
| 5 | 组装车间 | A/1 | I/3  U/4 | U/4  X/5 | U/4  U/4 | U/4  U/4 |
| 6 | 喷漆车间 | A/1 | U/4  U/4 | U/4  U/4 | X/5  X/5 | U/4 |
| 7 | 成品仓库 | U/4 | X/5  X/5 | U/4  U/4 | U/4 |  |
| 8 | 餐厅 | U/4 | U/4 | X/5 |  |  |
| 9 | 宿舍 | U/4 | U/4  U/4 |  |  |  |
| 10 | 办公 |  |  |  |  |  |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 序号 | 作业单位 |  |  |  |  |  |
| 1 | 原料仓库 | E |  |  |  |  |
| 2 | 下料车间 | I | U  I |  |  |  |
| 3 | 焊接车间 | O | U  O  O | U |  |  |
| 4 | 金加工车间 | I | O  I | U  U | U  U |  |
| 5 | 组装车间 | E | U  U | U  U | U  U | U  U |
| 6 | 喷漆车间 | A | U  U | U  U | U  U | U |
| 7 | 成品仓库 | U | U  U | U  U | U |  |
| 8 | 餐厅 | U | U  U | U |  |  |
| 9 | 宿舍 | U  U |  |  |  |  |
| 10 | 办公 |  |  |  |  |  |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 序号 | 作业单位 |  |  |  |  |  |
| 1 | 原料仓库 | A |  |  |  |  |
| 2 | 下料车间 | E | I  E |  |  |  |
| 3 | 焊接车间 | E | U  U  O | U |  |  |
| 4 | 金加工车间 | E | O  O | U  U | U  U |  |
| 5 | 组装车间 | A | U  U | X  U | U  U | U  U |
| 6 | 喷漆车间 | A | U  U | U  U | X  X | U |
| 7 | 成品仓库 | U | X  X | U  U | U |  |
| 8 | 餐厅 | U | U  U | X |  |  |
| 9 | 宿舍 | U  U |  |  |  |  |
| 10 | 办公 |  |  |  |  |  |

2.7天邦公司金加工车间设施布置分析

金加工车间主要生产旋转接头外圈，内圈，法兰，连接板，其工艺流程图如下图所示：

图2-3天邦公司鹤管金加工工艺流程图

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| 工艺 | 零件 | | | |
| 外圈 | 内圈 | 法兰 | 连接板 |
| 数控车 | ① | ① | ① |  |
| 钻床 | ② |  | ② | ② |
| 磨床 |  | ② |  | ① |
| 铣床 | ③ |  | ③ |  |