附件 4：



|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 2019年工业数字化产品设计与制造赛项 | | | | | | | 数控加工工艺过程卡 | | | | | 产品名称或代号 | | | 31sj1 | | 共 页 | |
| 零（部）件名称 | | | 软爪 | | 第（ ）页 | |
| 材料 | 7075 | | 毛坯种类 | 铝合金材质 | | | 毛坯尺寸 | | 120\*60\*30 | | 每毛坯可制件数 | | | 2 | | | 备注 | |
| 序号 | 工序 名称 | 工 序 内 容 | | | | | | | | | 设备 | | 夹具 | 刀具 | | 量具 | 工时 | |
| 准备 | 单件 |
| 1 | 43bc-sj1 | 加持位置开粗 | | | | | | | | |  | |  |  | |  |  |  |
| 2 | 43bc-sj2 | 加持位置精加工 | | | | | | | | |  | |  |  | |  |  |  |
| 3 | 43bc-sj3 | 整体开粗加工 | | | | | | | | |  | |  |  | |  |  |  |
| 4 | 43bc-sj4 | 整体精加工 | | | | | | | | |  | |  |  | |  |  |  |
| 5 | 43bc-sj5 | 软夹钳底部精加工 | | | | | | | | |  | |  |  | |  |  |  |
| 6 | 43bc-sj6 | 钻气管快换接头 | | | | | | | | |  | |  |  | |  |  |  |
| 7 | 43bc-sj7 | 攻丝气管快换接头 | | | | | | | | |  | |  |  | |  |  |  |
| 8 | 43bc-sj8 | 加工连接沉头 | | | | | | | | |  | |  |  | |  |  |  |
| 9 | 43bc-sj9 | 钻孔攻丝孔 | | | | | | | | |  | |  |  | |  |  |  |
| 10 | 43bc-sj10 | 攻丝 | | | | | | | | |  | |  |  | |  |  |  |
| 修改标记 | | （不填写） | | | 签字 | （不填写） | | 日期 | | （不填写） | 制定  （日期） | | （不填写） | | | 审核  （日期） | （不填写） | |