附件 4：



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| 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 | | |  | | 共 页 | |
| 零（部）件名称 | | |  | | 第（ ）页 | |
| 材料 | 铝合金 | | 毛坯种类 | 7075铝合金 | | | 毛坯尺寸 | | 120\*60\*30 | | 每毛坯可制件数 | | | 1 | | | 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 |
|  | 粗铣 | 用d10刀5粗加工深度15余量0.2 | | | | | | | | | 数控铣床 | |  | D10 | | 游标卡尺 |  |  |
|  | 精铣 | 用d10的刀精铣底面余量0 | | | | | | | | | 数控铣床 | |  | D10 | | 游标卡尺 |  |  |
|  | 精铣 | 用d8r4的刀精加工侧壁余量0 | | | | | | | | | 数控铣床 | |  | D8r4 | | 游标卡尺 |  |  |
|  | 粗铣 | 用d10刀5粗加工深度15余量0.2 | | | | | | | | | 数控铣床 | |  | D10 | | 游标卡尺 |  |  |
|  | 精铣 | 用d10的刀精铣底面余量0 | | | | | | | | | 数控铣床 | |  | D10 | | 游标卡尺 |  |  |
|  | 精铣 | 用d8r4的刀精加工侧壁余量0 | | | | | | | | | 数控铣床 | |  | D8r4 | | 游标卡尺 |  |  |
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| 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） | |