| SERIALN                    | RO 系列号<br>SERIAL NO. RO-2020- |   | 车间<br>SHOP NO. |                   | 零件返工/返修指令      |                       |                | •         | MODEL   |                   | 关键工序号<br>KEY OPA.NO |                    |                          |          |            |                  |
|----------------------------|-------------------------------|---|----------------|-------------------|----------------|-----------------------|----------------|-----------|---------|-------------------|---------------------|--------------------|--------------------------|----------|------------|------------------|
| 零件图·<br>P/L                | 号                             |   |                | 成形工段<br>WORK SEC  |                | REWO                  | RK/REPA        | IR ORDE   | R       | 零件图号<br>P/N       |                     |                    |                          |          |            |                  |
| 派工 <sup>長</sup><br>COSTACO | i<br>i                        |   |                | 批次<br>LOT NO.     |                | 产品图号<br>ENG DWG NO    | ).             |           | 零件      | 表号 PL NO.         |                     |                    |                          |          |            |                  |
| 开工E<br>START D             | 期                             |   | 完工<br>COMP     | 完工日期<br>COMP DATE |                | 不合格品审理单<br>NONCONF NO | ·号             |           |         |                   |                     |                    |                          |          |            |                  |
| 任务数<br>TASK C              | <b>量</b>                      | 合本  |                | 合格数量<br>ACCE QIY  |                | 工作说明:<br>DESCRIPTION  | 1              |           | į.<br>Į | 支术文件:<br>OCUMENTS |                     |                    |                          |          |            |                  |
|                            | 放日期/计<br>S DATE/SCI           | / 计划员   |                |                   |                |                       |                |           | D       | OCCIVILATIO       |                     |                    |                          |          |            |                  |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
| 日期<br>DATE                 | 工序 <sup>」</sup><br>OPA N      | 号 分十<br>O. SPLI   | ⊨数量<br>IT QITY | 结余数量<br>BALANCE   | 计划员<br>SCHEMER |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
| 零件名称<br>PARTNAME           |                               | 外主  | 外主襟翼3号滑轮架本体    |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
| 材料間<br>MATL                | 早号<br>NO.                     | TC11  |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
| 热处理<br>HT                  |                               | 退火态   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
|                            |                               | ANICH CHICH   | CTALD.         |                   | ≂ DENIMAD      | v                     |                |           |         |                   |                     |                    |                          |          |            |                  |
| 零件标识  □                    |                               | □ 钢印 STEEL STAMP □ 笔标 PEN MARK □ 胶印 RUBBER STAMP □ 标签 TAG □ 漆墨印 INK PRINT |                | K                 |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
| 零件序                        |                               |   |                | A 05 000          |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
| PARTO                      |                               |   | HLJ23A         | 4.05.099          |                |                       |                |           |         |                   | 日期<br>DATE          | 材料批号<br>MATILLOT N | 类型/规<br>O. <b>TYP/SP</b> | l格<br>BC | 数 量<br>QTY | 发料员<br>DELIVERER |
| 编制<br>PREP'D               |                               | 审 核<br>REV' D   |                | 核 标 审 S A         |                | 工艺会签<br>PA            | 质 量 会 签<br>Q A | 会签<br>O A |         | 会签<br>O A         |                     | 批 准<br>APPVL       | 用户代<br>CUSTOMER          | 表        | 完成         | t后存档<br>TO FILE  |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          |            |                  |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          | 共第         | 4 页<br>1 页       |
|                            |                               |   |                |                   |                |                       |                |           |         |                   |                     |                    |                          |          | Ĩ.P.       | AGE OF           |

| RO系列号<br>SERIAL NO.    | RO-202         | ◎ 零件返工/返修指令                 | 机型<br>MODEL | 零件名称<br>PART NAME                                       | 零件图号<br>P/N |  | 零件序 <sup>-</sup><br>PART COD |                         |         |                                   |
|------------------------|----------------|-----------------------------|-------------|---|-------------|--|------------------------------|-------------------------|---------|-----------------------------------|
| 车间<br>SHOP NO.         |                | REWORK/REPAIR ORDER         |             | 外主襟翼3号滑轮架本体   |             |  | HLJ23A.05.09                 |                         | 9       |                                   |
| 工 种<br>KIND OF<br>WORK | 工序号<br>OPA.NO. | 工作内容<br>WORK DESCRIPTION    |             | 工艺装备、量具、设备 TOOLING、MEASURING、MACHINE (名称、图号)(NAME. NO.) |             |  | 准备<br>工时<br>STUP             | 完成<br>数量<br>QTY<br>COMP |         | /日期<br>P/DATE<br>检验员<br>INSPECTOR |
| 激光成形                   | 1              | 取出成形件,回收粉末并归还库房             |             |   |             |  |                              |                         |         |                                   |
| 激光成形                   |                |                             |             |   |             |  |                              |                         |         |                                   |
| 热处理                    | 5              | 对零件及岁炉料进行退火热处理              |             |   |             |  |                              |                         |         |                                   |
| 机械加工                   |                |                             |             |   |             |  |                              |                         |         |                                   |
| 机械加工                   | 10             | 对零件顶面及随炉料基材顶面进行机械加工         |             |   |             |  |                              |                         |         |                                   |
|                        |                | 零件加工各立柱至自基板上表面向上77±1mm高度    |             |   |             |  |                              |                         |         |                                   |
|                        |                | 随炉料基板自顶面向下加工1±0.5mm         |             |   |             |  |                              |                         |         |                                   |
|                        |                | 允许外协完成                      |             |   |             |  |                              |                         |         |                                   |
|                        | 15             | 零件各立柱高度符合77±1mm             |             |   |             |  |                              |                         |         |                                   |
|                        |                | 随炉料基板厚度符合39±0.5mm           |             |   |             |  |                              |                         |         |                                   |
| 除油                     | 20             | 对零件及随炉料按MPM-TY-GC-021进行除油处理 |             |   |             |  |                              |                         |         |                                   |
| 除油                     |                |                             |             |   |             |  |                              |                         |         |                                   |
| 打磨                     | 25             | 打磨零件各立柱顶面及边界外扩10mm范围        |             |   |             |  |                              |                         |         |                                   |
| 打磨                     |                | 打磨随炉料基板加工表面                 |             |   |             |  |                              |                         |         |                                   |
| 装夹                     |                |                             |             |   |             |  |                              |                         |         |                                   |
| 装夹                     | 30             | 将零件及随炉料装夹在成形工装上             |             |   |             |  |                              |                         |         |                                   |
|                        |                |                             |             |   |             |  |                              |                         |         |                                   |
| 工艺员                    |                | 更改标记/日期 REV.ID./DATE        |             |   |             |  |                              |                         | 定額      | <b></b>                           |
| PLANNER<br>陈博          |                | 划改页次 REV.PAGE               |             |   |             |  |                              |                         | BODGE   | TED BY                            |
|                        |                | 更改依据 REV.REASON             |             |   |             |  |                              |                         | Andre / | ) He                              |
| 2020.03.18             |                | 更改者 CHANGED BY              |             |   |             |  |                              |                         |         | 2 页<br>EOF                        |

| RO系列号<br>SERIAL NO.    | RO-202         | 零件返工/返修指令                | 机型<br>MODEL | 零件名<br>PART NA | 称<br>ME | 零件图号<br>P/N                          |                  | 零件序号<br>PART CODE |                         |                                 |                                   |
|------------------------|----------------|--------------------------|-------------|----------------|---------|--------------------------------------|------------------|-------------------|-------------------------|---------------------------------|-----------------------------------|
| 车间<br>SHOP NO.         |                | REWORK/REPAIR ORDER      |             | 外主襟翼3号滑轮架本体    |         |                                      |                  |                   | HLJ23A.05.099           |                                 |                                   |
| 工 种<br>KIND OF<br>WORK | 工序号<br>OPA.NO. | 工作内容<br>WORK DESCRIPTION |             |                |         | 量具、设备<br>RING、MACHINE<br>(NAME. NO.) | 单件<br>工时<br>UNIT | 准备<br>工时<br>STUP  | 完成<br>数量<br>QTY<br>COMP | 印章。<br>STAMI<br>操作者<br>OPERATOR | /日期<br>P/DATE<br>检验员<br>INSPECTOR |
| 称重                     | 35             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 称重                     |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 焊工                     | 40             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 焊工                     |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 热处理                    | 45             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| (去应力退火)                |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 热处理                    |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| (去应力退火)                | )              |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 检验                     | 50             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| (理化检测)                 |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 检验                     |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 检验                     | 55             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| (力学性能)                 |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| (理化检测)                 |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 拍照                     | 60             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 拍照                     |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 检验                     | 65             |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| (超声波检测)                |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
|                        |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
|                        |                |                          |             |                |         |                                      |                  |                   |                         |                                 |                                   |
| 工艺员<br>PLANNER         |                | 更改标记/日期 REV.ID./DATE     |             |                |         |                                      |                  |                   | 定 箱<br>BUDGE            |                                 |                                   |
| 陈博                     |                | 划改页次 REV.PAGE            |             |                |         |                                      |                  |                   |                         | DODGE                           | 11001                             |
|                        |                | 更改依据 REV.REASON          |             |                |         |                                      |                  |                   |                         | <b>一</b>                        | 3 页                               |
| 2020.03.18             |                | 更改者 CHANGED BY           |             |                |         |                                      |                  |                   |                         |                                 | E OF                              |

| RO系列号<br>SERIAL NO.    | RO-202         | 零件返工/返修指令                | 机型<br>MODEL | 零<br>PA | 件名称<br>RTNAME   | 零件图号<br>P/N | \$<br>P. | ₹件序号<br>ART CODE |                         |              |                                   |
|------------------------|----------------|--------------------------|-------------|---------|---|-------------|----------|------------------|-------------------------|--------------|-----------------------------------|
| 车间<br>SHOP NO.         |                | REWORK/REPAIR ORDER      |             | 外主襟翼    | 3号滑轮架本体   | 号滑轮架本体      |          | HLJ23A.05.099    |                         | 9            |                                   |
| 工 种<br>KIND OF<br>WORK | 工序号<br>OPA.NO. | 工作内容<br>WORK DESCRIPTION |             |         | 工艺装备、量具、设备<br>TOOLING、MEASURING、MACHINE<br>(名称、图号)(NAME. NO.) |             |          | 准备<br>工时<br>STUP | 完成<br>数量<br>QTY<br>COMP | STAMI<br>操作者 | /日期<br>P/DATE<br>检验员<br>INSPECTOR |
| 检验                     | 70             |                          |             |         |   |             |          |                  |                         |              |                                   |
| (荧光)                   |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
| 标印                     | 75             |                          |             |         |   |             |          |                  |                         |              |                                   |
| 标印                     |                |                          |             |         |   |             |          |                  |                         |              |                                   |
| 检验                     | 80             |                          |             |         |   |             |          |                  |                         |              |                                   |
| (终检)                   |                |                          |             |         |   |             |          |                  |                         |              |                                   |
| (终检)                   |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         |              |                                   |
|                        |                |                          |             |         |   |             |          |                  |                         | , ,          |                                   |
| 工艺<br>PLANN            | 页<br>VER       | 更改标记/日期 REV.ID./DATE     |             |         |   |             |          |                  | 定着<br>  BUDGE           | 额员<br>TED BY |                                   |
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