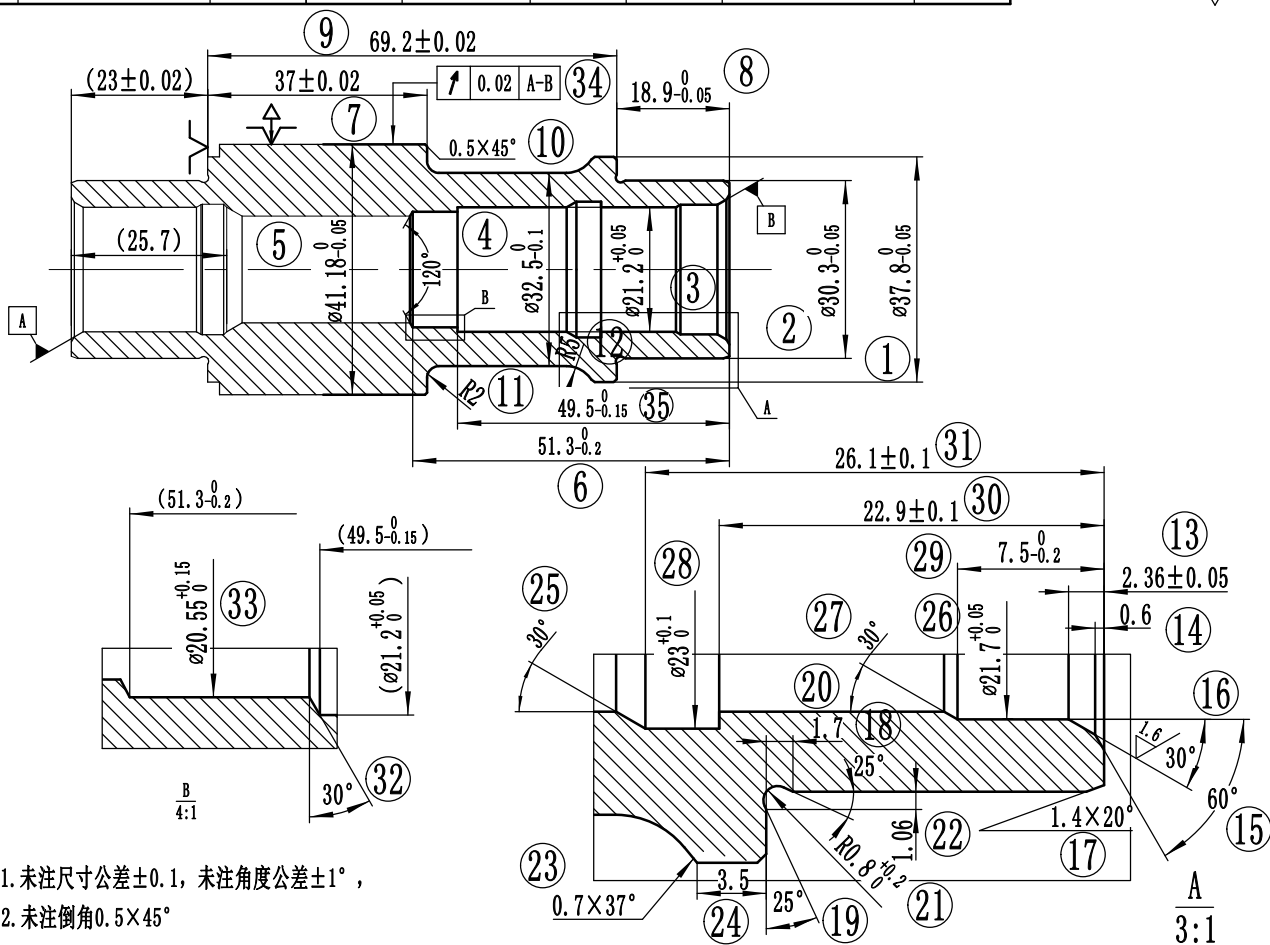


### 加工过程控制卡

|      |         |      |         |     |      |      |  |  |
|------|---------|------|---------|-----|------|------|--|--|
| 设备名称 | 设备型号    | 主轴转速 | 资产编号    | 切削液 | 单件工时 | 夹具编号 |  |  |
| 数控车床 | L250E-e |      | 001-177 |     |      |      |  |  |

其余  $\frac{3.2}{\triangle}$



1. 未注尺寸公差 $\pm 0.1$ , 未注角度公差 $\pm 1^\circ$ ,  
2. 未注倒角 $0.5 \times 45^\circ$

| 工步号 | 工 步 内 容    | 刀具型号         | 切削速度      | 进给量  | 走刀次数 | 换刀频次   |
|-----|------------|--------------|-----------|------|------|--------|
| 1   | 粗车外圆、端面、内孔 | CNMG120408PR | 1200r/min | 0.25 | 2    | 120件/次 |
| 2   | 粗车外圆、端面、内孔 | CNMG120408PF | 1000r/min | 0.25 | 2    | 110件/次 |
|     |            |              |           |      |      |        |
|     |            |              |           |      |      |        |
|     |            |              |           |      |      |        |
|     |            |              |           |      |      |        |
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## 操作规范

1. 按要求领齐工艺装备, 并正确使用。
2. 工件定位面应干净, 无毛刺和碰伤。
3. 用气枪吹净卡爪, 目视无毛刺残留后再装夹产品。
4. 首件必须送检, 合格后方可生产。
5. 发现异常立即停止加工、隔离不良品, 报告班长。

| 序号     | 检查项目                                                                  | 量具名称编号 | 自检频次    | 自检记录频次 | 专检频次    | 专检记录频次 |        |        |        |
|--------|-----------------------------------------------------------------------|--------|---------|--------|---------|--------|--------|--------|--------|
| ①      | $\varnothing 37.8^{+0.05}_{-0.05}$                                    | 游标卡尺   | 1件/1小时  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ②      | $\varnothing 30.3^{+0.05}_{-0.05}$                                    | 千分尺    | 1件/10件  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ③      | $\varnothing 21.2^{+0.05}_0$                                          | 内孔摇表   | 1件/10件  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ④      | $\varnothing 32.5^{+0.1}_{-0.1}$                                      | 游标卡尺   | 1件/1小时  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ⑤      | $\varnothing 41.18^{+0.05}_{-0.05}$                                   | 千分尺    | 1件/10件  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ⑥      | $51.3^{+0.2}_{-0.2}$                                                  | 轮廓度仪   | 首、末件及换刀 |        | 首、末件及换刀 |        |        |        |        |
| ⑦      | $37 \pm 0.02$                                                         | 高度仪    | 1件/1小时  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ⑧      | $18.9^{+0.05}_{-0.05}$                                                | 高度仪    | 1件/1小时  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ⑨      | $69.2 \pm 0.02$                                                       | 高度仪    | 1件/1小时  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ⑩ ~ ③③ |                                                                       | 轮廓度仪   | 首、末件及换刀 |        | 首、末件及换刀 |        |        |        |        |
| ②⑥     | $\varnothing 21.7^{+0.05}_0$                                          | 内孔摇表   | 1件/10件  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
| ③③     | $\varnothing 20.55^{+0.15}_0$                                         | 轮廓度仪   | 首、末件及换刀 |        | 首、末件及换刀 |        |        |        |        |
| ③④     | <table border="1"><tr><td></td><td>0.02</td><td>A-B</td></tr></table> |        | 0.02    | A-B    | 偏摆仪     | 1件/2小时 | 1件/2小时 | 1件/4小时 | 1件/4小时 |
|        | 0.02                                                                  | A-B    |         |        |         |        |        |        |        |
| ③⑤     | $49.5^{+0}_{-0.15}$                                                   | 高度仪    | 1件/1小时  | 1件/2小时 | 1件/4小时  | 1件/4小时 |        |        |        |
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