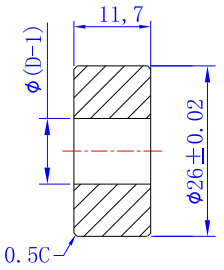
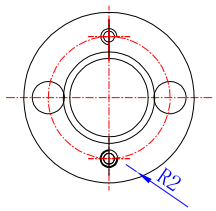
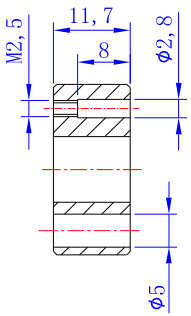
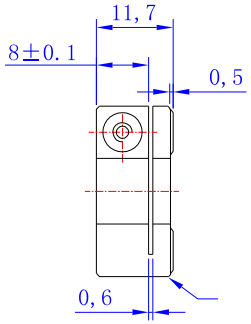
订单编号	
下单时间	
完成时间	
型号数 量	
型号数 量	
型号数 量	

新款U26粗车两端





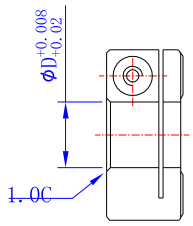




1. 车床确保外径 ⌀26±0.02
2. 粗车内孔为订单内孔 ⌀D-1
3. 车应外形倒角0.5X45°

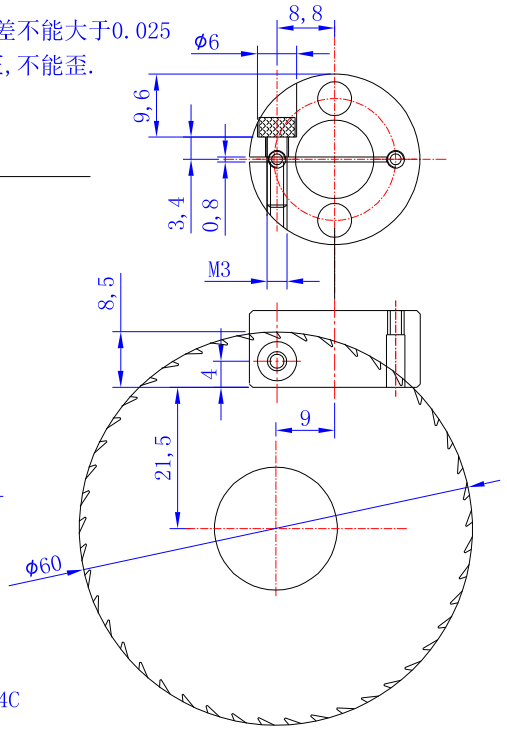
U26-30-8-14

新款U26精车两端



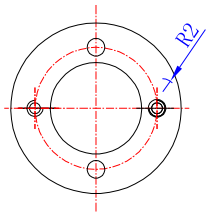
1、精车内孔，公差不能大于0.025
2、装夹工件装正，不能歪.

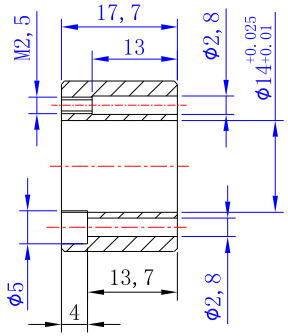
U26两端沉孔



1、夹紧孔：沉孔用⌀6铣刀，要光亮，过孔用⌀3.2钻头，
牙孔用⌀2.3钻头，确保打孔不偏，查看牙孔是否有烂牙
2. 装夹时力度不可过大，防止产品夹伤。
3. 直槽锯片用 0.8x⌀60

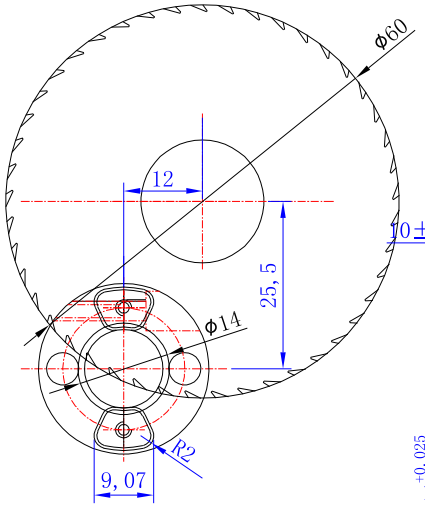
U26两端四分孔

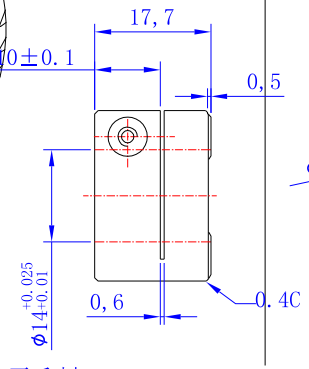




1、四分孔上牙孔用⌀2钻头，确保攻牙后孔不大于⌀2.1
生产中要测量四分孔是否有偏向
3. 查看牙孔是否有烂牙
4 装夹时力度不可过大，防止产品夹伤。
5 装夹时车光面朝上 切刀面朝下

U26两端铣台/锯横槽





1. 要确保台阶厚度一致，牙孔无毛刺。
2. 横槽锯片 0.8x60，锯槽时确保平行。
横槽尺寸厚度 8±0.1不能大小边
3. 装夹时力度不可过大，防止产品夹伤。