**（内孔车削案例）零件加工工艺卡**

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| 数控加工工序卡 | | | | | | | 产品名称 | | | | 零件名称 | | | | 零件图号 | | |
|  | | | | 台阶孔 | | | | 6 | | |
| 工序号 | 程序编号 | | 夹具名称 | | | | 夹具编号 | | | | 使用设备 | | | | 车间 | | |
| 001 | O0009 | | 三爪自定心卡盘 | | | |  | | | | 数控车 | | | | 数控车加工车间 | | |
| 工步号 | 工步内容 | | 切削用量 | | | | | | | | 刀具 | | | | 量具名称 | | 备注 |
| 主轴转速n（r/min） | | 进给速度F（mm/min） | | | 背吃刀量ap (mm) | | | 编号 | | 名称 | |
| 1 | 钻中心孔 | | 1000 | |  | | |  | | |  | | 中心钻 | |  | | 手动 |
| 2 | 钻孔 | | 400 | |  | | |  | | |  | | Φ27钻头 | |  | | 手动 |
| 3 | 车端面 | | 600 | |  | | | 1 | | | T02 | | 45°硬质合金车刀 | | 游标卡尺 | | 手动 |
| 4 | 粗车内孔 | | 600 | | 100 | | | 1 | | | T01 | | 镗孔刀 | | 千分尺 | | 自动 |
| 5 | 精车内孔 | | 1000 | | 80 | | | 0.5 | | | T01 | | 镗孔刀 | | 千分尺 | | 自动 |
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| 编制 | |  | | 审核 | |  | | | 批准 |  | | 年 月 日 | | 共1页 | | 第1页 | |