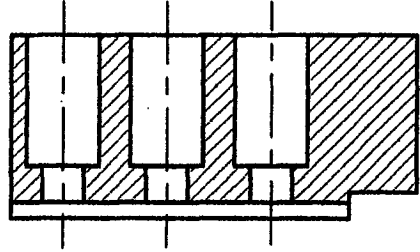
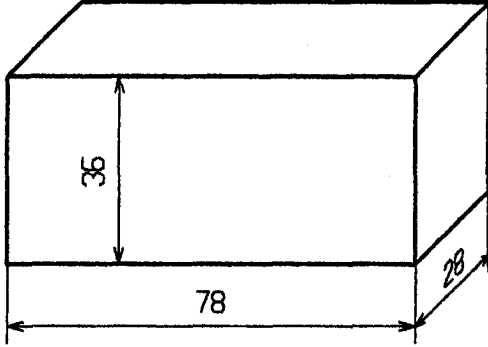
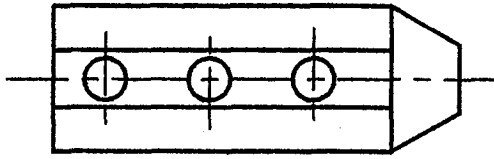
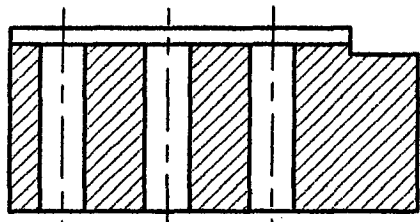
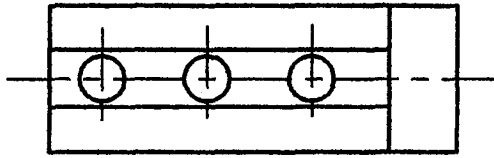


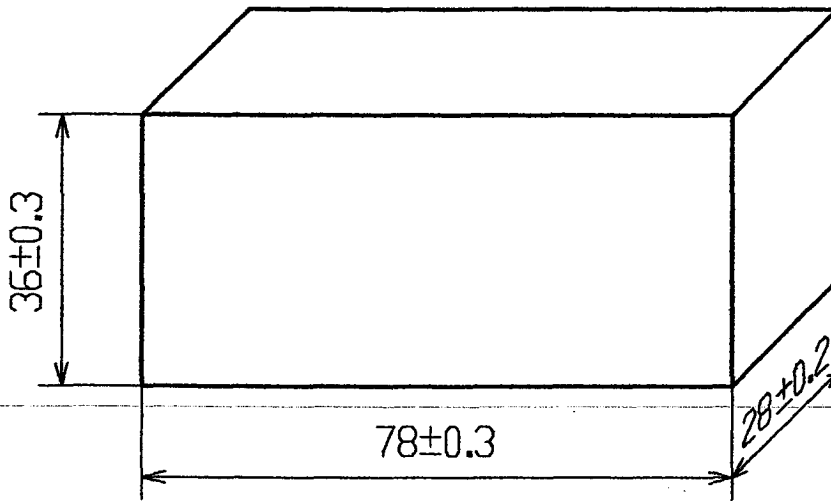
| | | | | | |
|---------------|----|-------------|---------|-------------|-----------|
| | | Mors doux | S300Pb | | |
| Rep | Nb | Désignation | Matière | Observation | Référence |
| | | MORS DOUX | | | |
| Format : A4 | | | | | |
| Ech. 1 : 1 | | | | | |
| Dessiné par : | | | | | |
| Le | N° | | | DT2 | |

| | | | | | | | |
|----------------------|-----------------------------------------------------------------------------------------------------------------------------|---------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|--------------------------------------------------------|---------------------|-------------------------------------------------------------------------------------|
| PIECE : MORS DOUX | | NOM : | | N° | DESIGNATION | POSTE DE TRAVAIL | CROQUIS |
| MATIERE S300Pb | NOMENCLATURE DES PHASES | | DATE : | 400 | PERCAGE Montage en étau Lamage de 15-15'-15" | PERCEUSE SENSITIVE |  |
| NOMBRE : 30 | | | FICHER : | | | | |
| BRUT : Etiré 30 x 40 | | | FOLIO : | | | | |
| N° | DESIGNATION | POSTE DE TRAVAIL | CROQUIS | | | | |
| 100 | DEBIT L:80 | | | | | | |
| 200 | FRAISAGE DU PRISME Montage en étau Fraisage de : 1-2-3-4-5-6 | Fraiseuse verticale |  | 500 | FRAISAGE Montage en étau Fraisage de 12-13 | FRAISEUSE VERTICALE |  |
| 300 | FRAISAGE Montage en étau Fraisier l'épaulement 7-8 Rainurer 9-10-11 Centrer 14-14'-14" Percer 14-14'-14" | FRAISEUSE VERTICALE |   | 600 | Controle final | | |

| | | |
|----------------------------|-------------------------------|---------------------------|
| CONTRAT DE PHASE N° 200 | Ensemble: Mandrin pneumatique | Date: / / |
| | Pièce: Mors doux | BUREAU DES METHODES |
| | Matière: S300Pb | |
| NOM: | Programme: | |

Désignation: Fraisage

Machine-Out il: Fraiseuse universelle



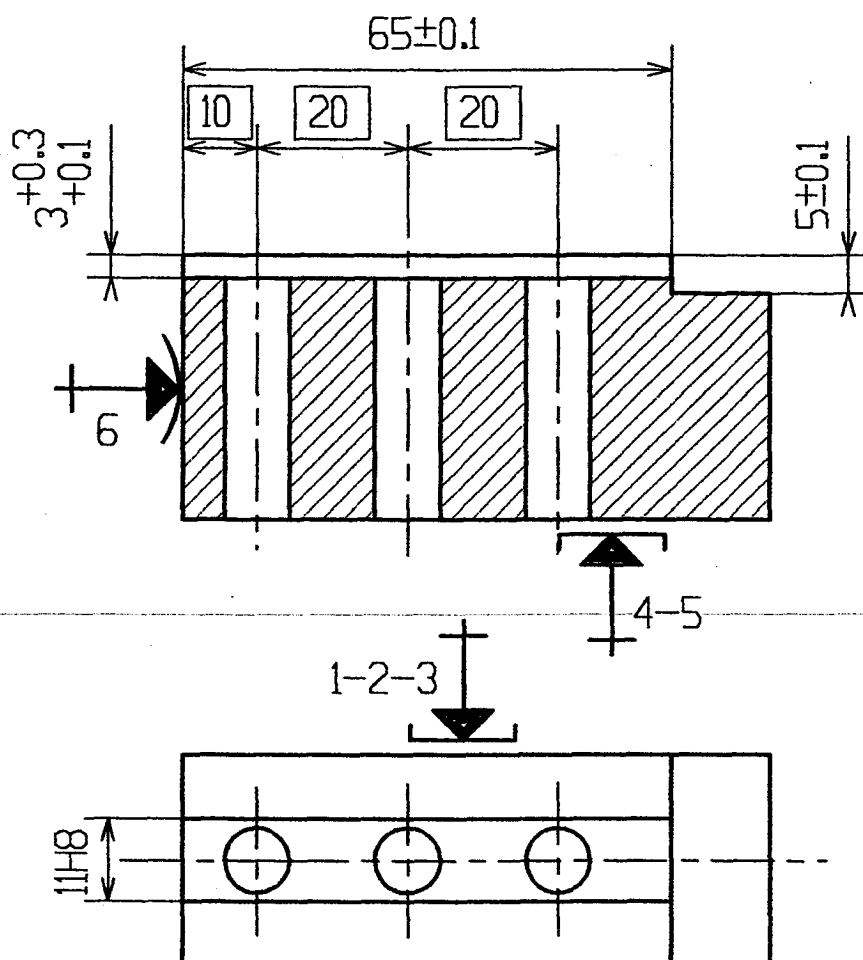
| DESIGNATION DES OPERATIONS | OUTILS | V m/mn | N tr/mn | fz mm/z | Vf mm/mn | Z |
|--------------------------------|-----------------------------------------------|-----------|------------|------------|-------------|---|
| Fraisage du prisme 1-2-3-4-5-6 | Fraise à surfacer $\varnothing 50$ carbure | 50 | 300 | 0.05 | 75 | 5 |

DT4

| | | |
|----------------------------|-------------------------------|---------------------------|
| CONTRAT DE PHASE N° 300 | Ensemble: Mandrin pneumatique | Date: / / |
| | Pièce: Mors doux | BUREAU DES METHODES |
| | Matière: S300Pb | |
| NOM: | Programme: | |

Désignation: Fraisage

Machine-Outil: Fraiseuse universelle



| DESIGNATION DES OPERATIONS | OUTILS | V | N | fz | Vf | Z |
|--------------------------------|---------------------|------|-------|------|-------|---|
| | | m/mn | tr/mn | mm/z | mm/mn | |
| Fraisage de l'épaulement 7-8 | Fraise 2T Ø20 ARS | 20 | 300 | 0.05 | 45 | 3 |
| Fraisage de la rainure 9-10-11 | Fraise 2T Ø10 ARS | 20 | 600 | 0.03 | 36 | 2 |
| Centrage 14-14'-14" | Foret à centre Ø3-8 | | 1000 | | manu | |
| Perçage 14-14'-14" | Foret Ø 8.5 | 20 | 700 | 0.05 | 35 | |

DT5