


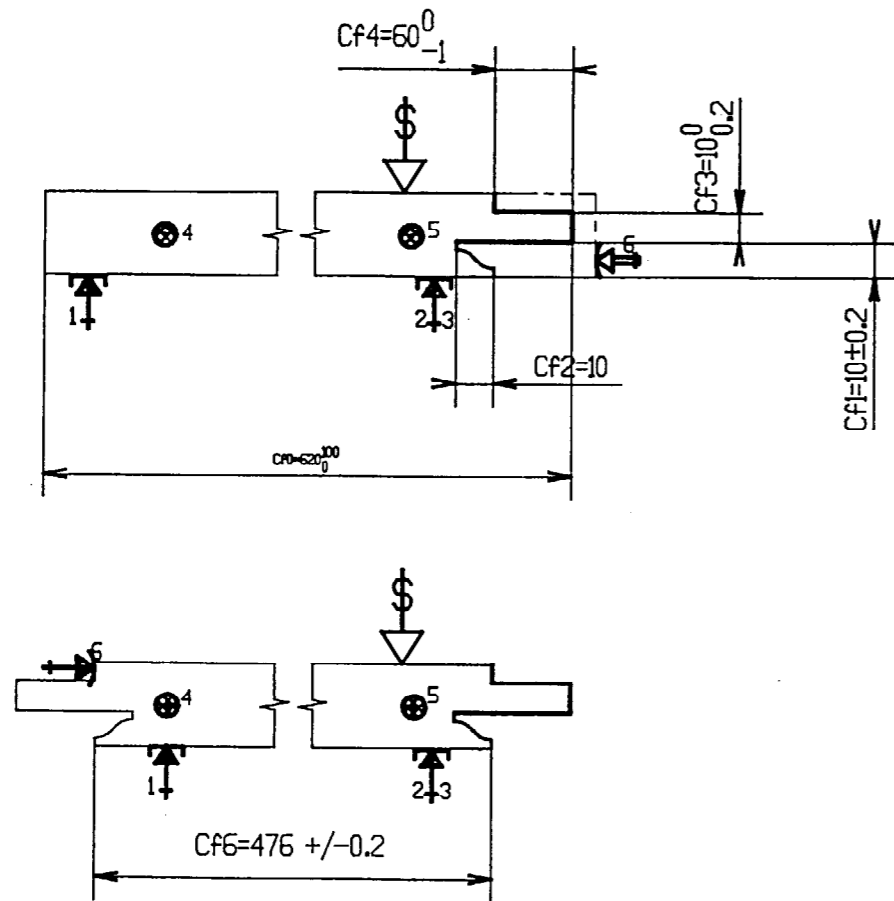
| 204 | 1 | MONTANT OUVRANT | NIANGON | 408*70*30 | |
|-------------------------|----|---|-------------------------|-------------|-----------|
| Rep | Nb | Désignation | Matière | Observation | Référence |
| | |  CHASSIS SOUPIRAIL A SOUFFLET MONTANT OUVRANT | | | |
| Format : A3 | | | | | |
| Ech. 1:1 | | | | | |
| Code examen 510 23401 C | | BEP B.M.A – CAP F.I.M.M. | EP.1 partie réalisation | S 2000 | DR 7/12 |



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|-------------------------------------|-------------------------------------|---------------------------|--------|
| CONTRAT DE PHASE PHASE N° 40 | Ensemble: CHASSIS SOUPIRAIL | Date: | DDMMTT |
| | Pièce: TRAVERSE HAUTE/BASSE OUVRANT | BUREAU DES METHODES | 1 1 |
| | Matière: NIANGON | | |
| NOM: | Programme: | | |

Désignation: TENONNAGE C/PROFILAGE

Machine-Outil: TED

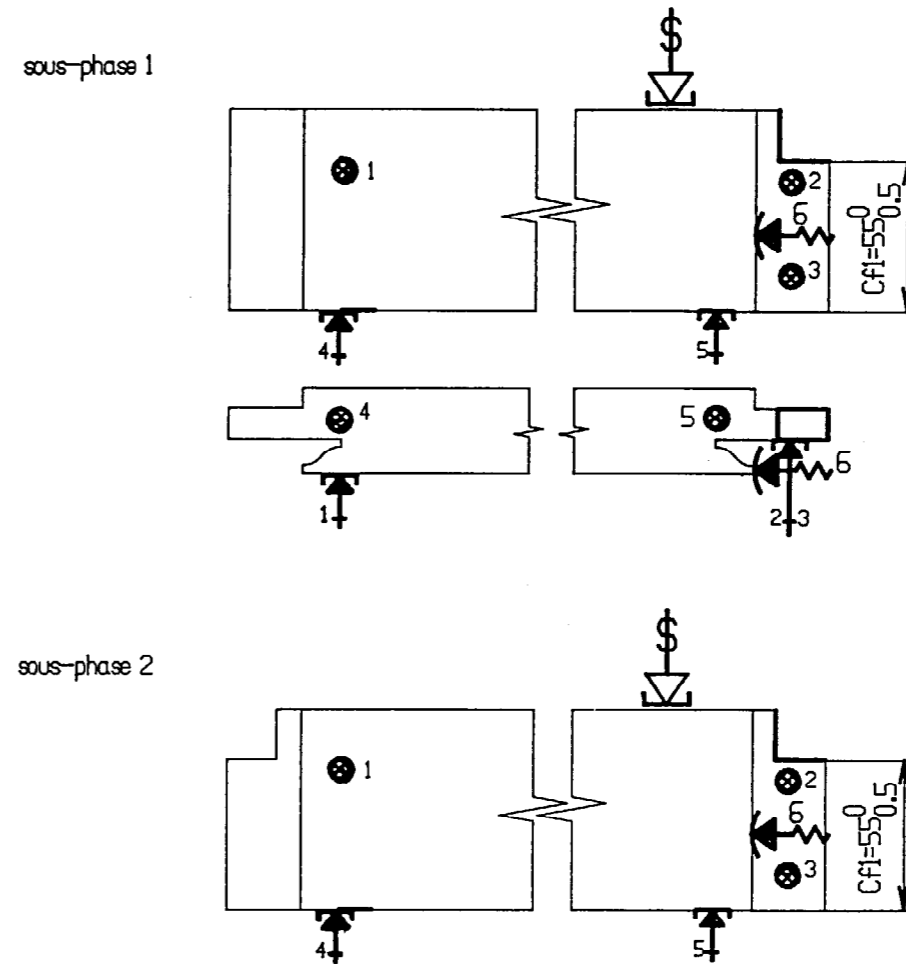


| DESIGNATION DES OPERATIONS | OUTILS | Vc m/s | n tr/mn | Vf mm/mn | a mm | Z |
|--|--------|-----------|------------|---------------|---------|---|
| sous-phase 1 | | | | | | |
| OP1: TRONCON 1° about 90°: Cf0=620 | SCT | | | | | |
| OP2: TENON 1° about: Cf1=10 | 806 C | 38 | 4500 | MANU | | 4 |
| | | | | Cf3=10 Cf4=60 | | |
| OP3: CONTRE-PROF.: Cf2=10 | 806 D | 38 | 4500 | MANU | | 4 |
| sous-phase 2 | | | | | | |
| OP1: TRONCON 2° about 90°: | SCT | | | | | |
| OP2: TENON 2° about: Cf1, Cf2, Cf3, Cf4=idem s/phase 1 | 806 C | 38 | 4500 | MANU | | 4 |
| OP3: CONTRE-PROF.: Cf6=476 | 806 D | 38 | 4500 | MANU | | 4 |

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| CONTRAT DE PHASE PHASE N° 50 | Ensemble: CHASSIS SOUPIRAIL | Date: | DDMMTT |
| | Pièce: TRAVERSE HAUTE/BASSE OUVRANT | BUREAU DES METHODES | 1 1 |
| | Matière: NIANGON | | |
| NOM: | Programme: | | |

Désignation: EPAULEMENT

Machine-Outil: TED

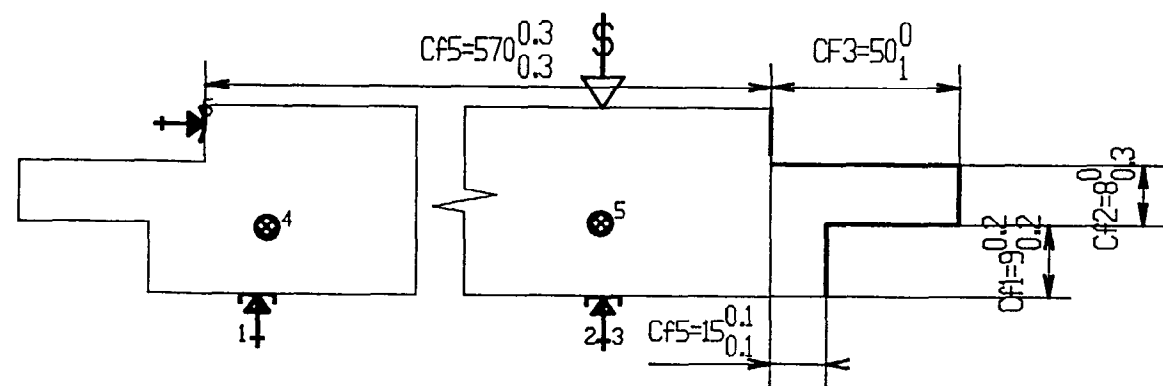
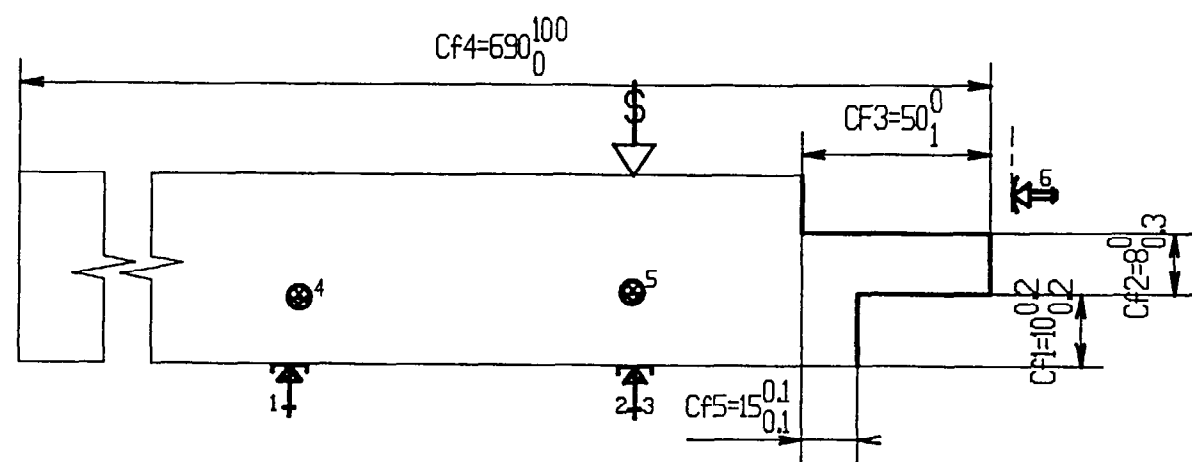


| DESIGNATION DES OPERATIONS | OUTILS | V m/mn | N tr/mn | f mm/tr | a mm | Z |
|----------------------------------|-----------|-----------|------------|------------|------------|----------|
| sous-phase 1 | | | | | | |
| OP1: EPAULEMENT 1° about: Cf1=55 | BEROULEUR | | | | | |
| sous-phase 2 | | | | | | |
| OP1: EPAULEMENT 2° about: Cf1=55 | BEROULEUR | | | | | |
| Cfx= | C.réglage | C.obtenu | Correction | C.obtenu | Correction | C.obtenu |
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| CONTRAT DE PHASE PHASE N° 40 | Ensemble: CHASSIS SOUPIRAIL | Date: . | DMIT 1/1 |
| | Plèce: TRAVERSE HAUTE/BASSE DORMANT | BUREAU DES METHODES | |
| NOM: | Matière: NIANGON | | |
| | Programme: | | |

Désignation: TENONNAGE C/PROFILAGE

Machine-Outil: TED

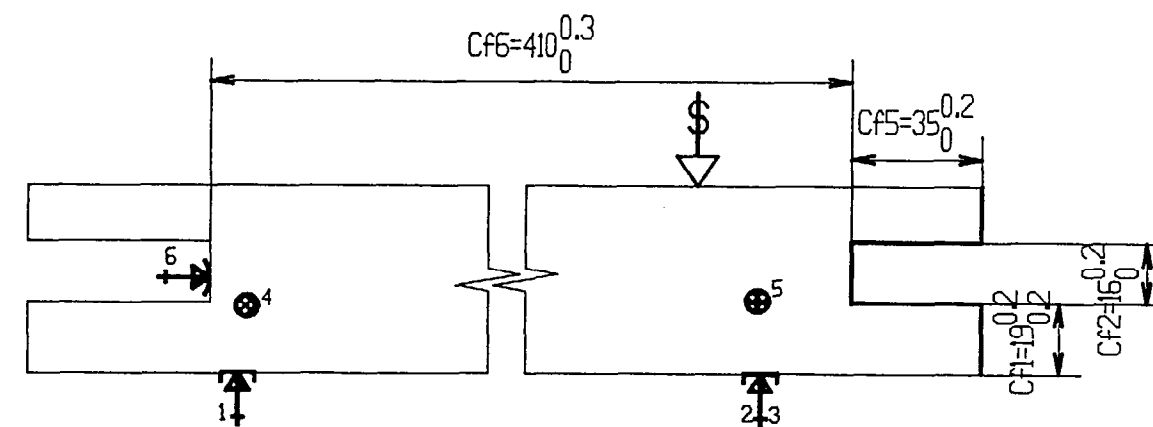
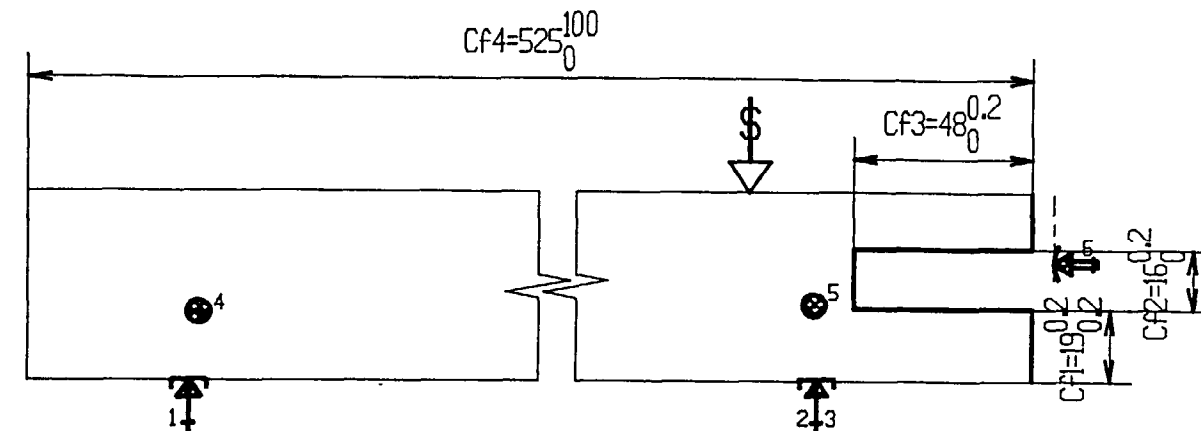


| DESIGNATION DES OPERATIONS | OUTILS | V _c m/s | n tr/mn | V _f m/mn | a mm | Z |
|-----------------------------------|--------|-----------------------|------------|------------------------|---------|---|
| sous-phase 1 | | | | | | |
| OP1:TRONCON.1°about 90°: Cf1=690 | SCT | | | | | |
| OP2:TENON. 1°about: Cf2=10 Cf4=50 | 806 C | 38 | 4500 | MANU | | 4 |
| Cf3=8 Cf5=15 | | | | | | |
| sous-phase 2 | | | | | | |
| OP1:TRONCON.2°about 90°: | SCT | | | | | |
| OP2:TENON. 2°about: | 806 C | 38 | 4500 | MANU | | 4 |
| Cf2,Cf3,Cf4,Cf5=idem s/phase 1 | | | | | | |
| Cf6=570 | | | | | | |

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| CONTRAT DE PHASE PHASE N° 30 | Ensemble: CHASSIS SOUPIRAIL | Date: . | DMIT 1/1 |
| | Plèce: MONTANTS DORMANT | BUREAU DES METHODES | |
| NOM: | Matière: NIANGON | | |
| | Programme: | | |

Désignation: ENFOURCHEMENT

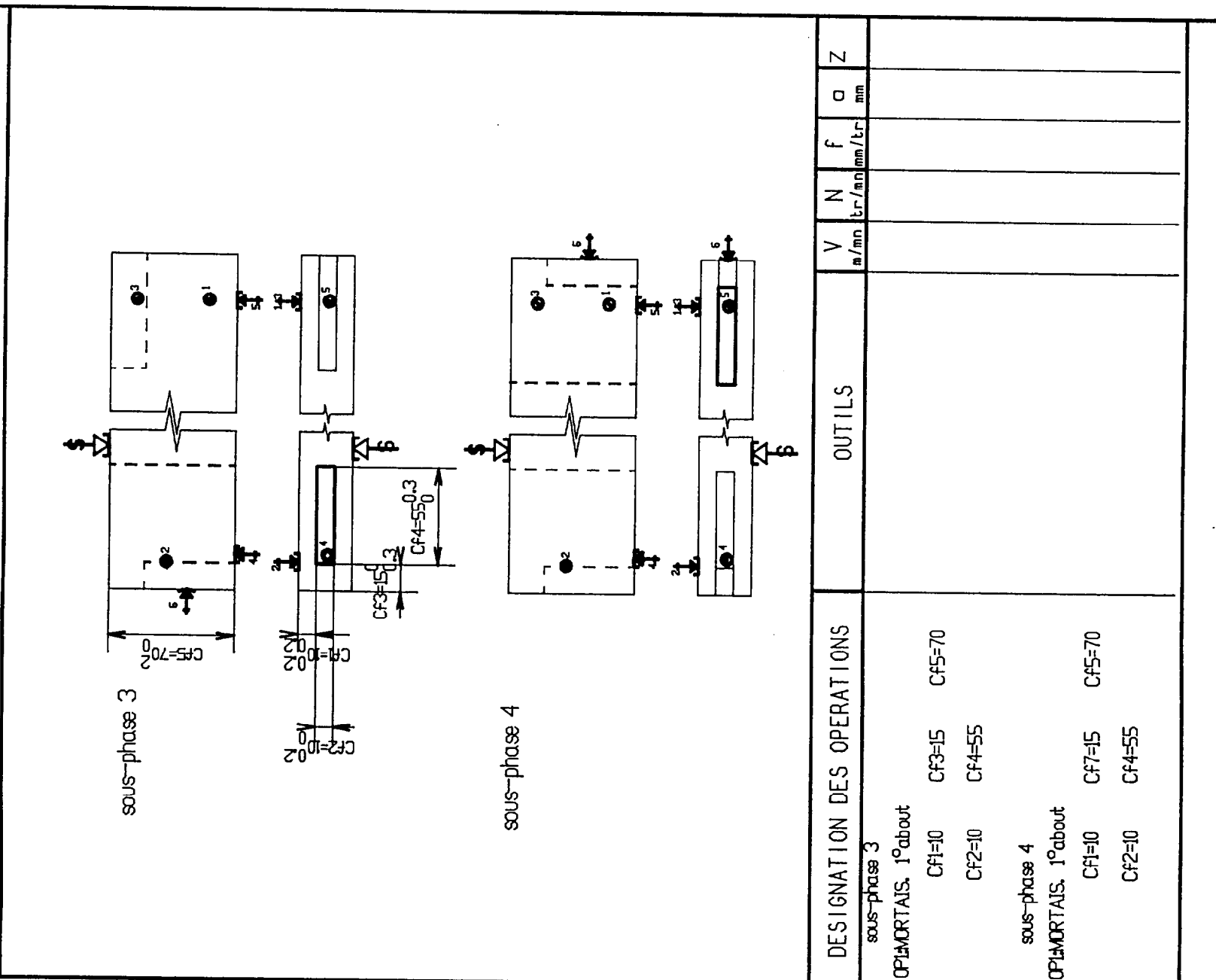
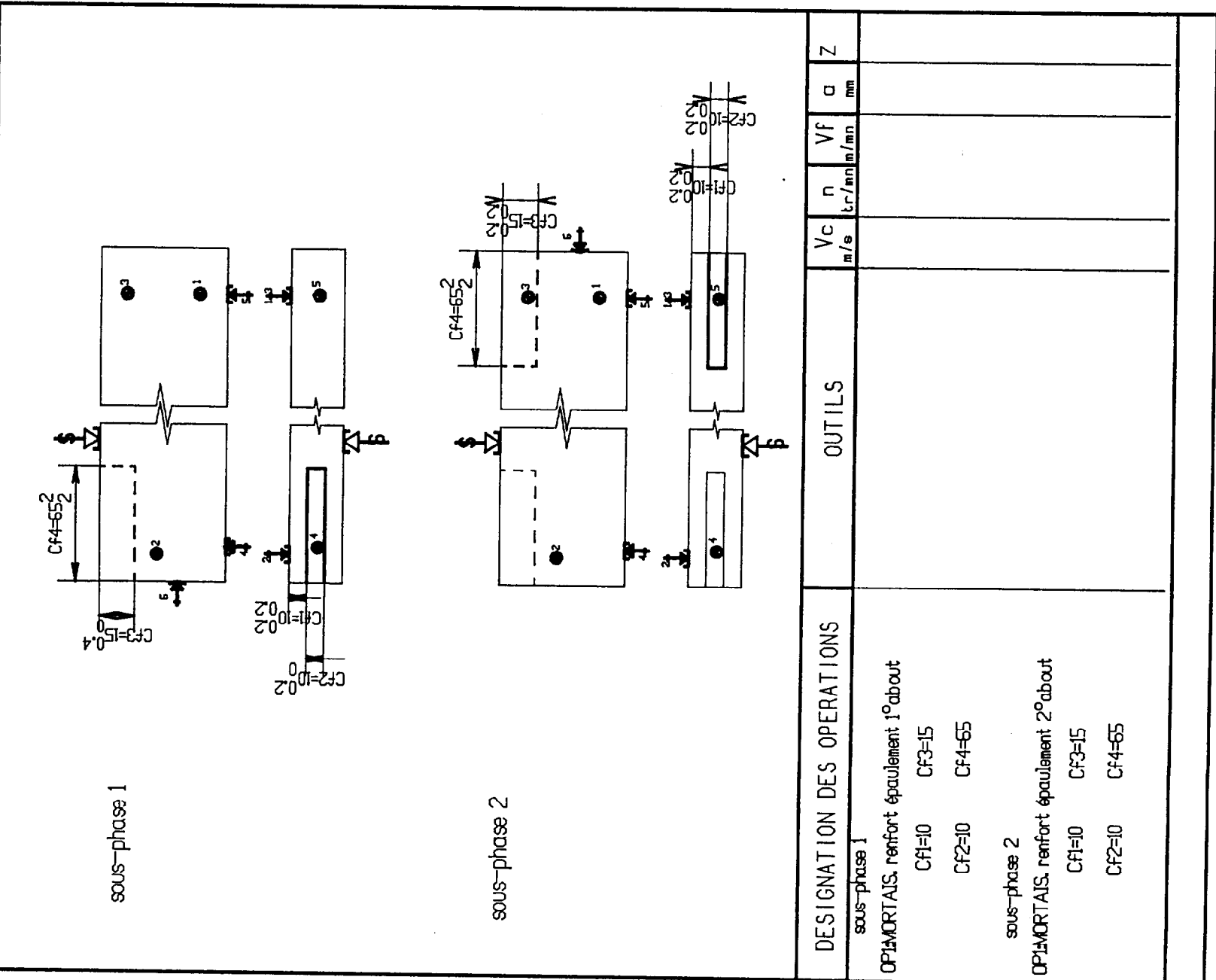
Machine-Outil: TED



| DESIGNATION DES OPERATIONS | OUTILS | V _c m/s | n tr/mn | V _f m/mn | a mm | Z |
|-----------------------------------|--------|-----------------------|------------|------------------------|---------|---|
| sous-phase 1 | | | | | | |
| OP1:TRONCON.1°about 90°: Cf1=690 | SCT | | | | | |
| OP2:TENON. 1°about: Cf2=10 Cf4=50 | 806 C | 38 | 4500 | MANU | | 4 |
| Cf3=8 Cf5=15 | | | | | | |
| sous-phase 2 | | | | | | |
| OP1:TRONCON.2°about 90°: | SCT | | | | | |
| OP2:TENON. 2°about: | 806 C | 38 | 4500 | MANU | | 4 |
| Cf2,Cf3,Cf4,Cf5=idem s/phase 1 | | | | | | |
| Cf6=570 | | | | | | |

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| CONTRAT DE PHASE | | Ensemble: CHASSIS SOUPRAIL | | Date: | | IDMIT | |
| PHASE N° 40 | | Pièce: MONTANTS OUVRANT | | BUREAU DES METHODES | | 1/2 | |
| NOM: | | Matériau: NIANGON | | Programme: | | | |
| Désignation: MORTAISAGE | | | | Machine-Outil: MOV | | | |

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|-------------------------|--|-------------------------------------|--|---------------------|--|-------|--|
| CONTRAT DE PHASE | | Ensemble: CHASSIS SOUPRAIL | | Date: | | IDMIT | |
| PHASE N° 40 | | Pièce: TRAVERSE HAUTE/BASSE OUVRANT | | BUREAU DES METHODES | | 2/2 | |
| NOM: | | Matériau: NIANGON | | Programme: | | | |
| Désignation: MORTAISAGE | | | | Machine-Outil: MOV | | | |

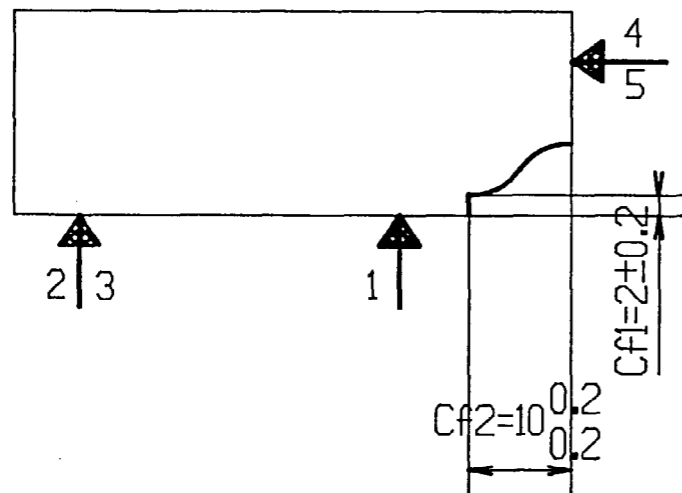


| DESIGNATION DES OPERATIONS | Vc m/s | n tr/mn | Vf mm/mn | a mm | Z |
|--|-----------|------------|-------------|---------|---|
| sous-phase 1 OP1MORTAIS. renfort épaulement 1°about CF1=10 CF3=15 CF2=10 CF4=65 | | | | | |
| sous-phase 2 OP2MORTAIS. renfort épaulement 2°about CF1=10 CF3=15 CF2=10 CF4=65 | | | | | |

| DESIGNATION DES OPERATIONS | V n/mn | N tr/mn | f mm/tr | a mm | Z |
|--|-----------|------------|------------|---------|---|
| sous-phase 3 OP3MORTAIS. 1°about CF1=10 CF3=15 CF5=70 CF2=10 CF4=55 | | | | | |
| sous-phase 4 OP4MORTAIS. 1°about CF1=10 CF7=15 CF5=70 CF2=10 CF4=55 | | | | | |

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| CONTRAT DE PHASE PHASE N°60 | Ensemble: CHASSIS SOUPIRAIL | Date: | DMT |
| | Pièce: MONTANT TRAVERSE OUVRANT | BUREAU DES METHODES | 1 1 |
| | Matière: NIANGON | | |
| NOM: | Programme: | | |

Désignation: profilage moulure
Machine-Outil: toupie

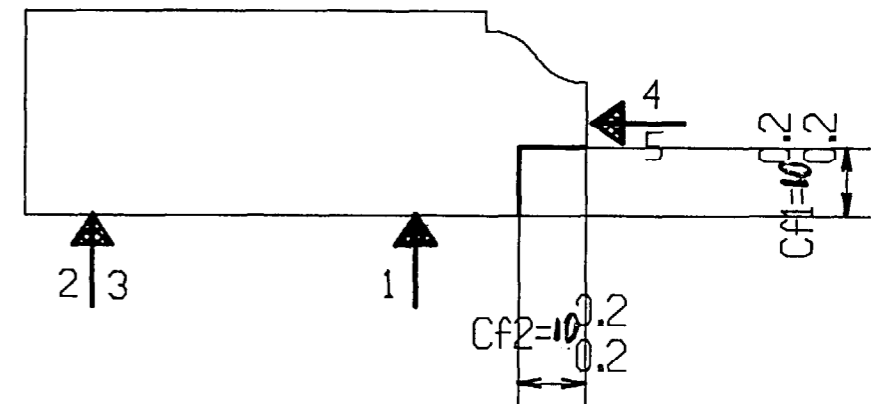


| DESIGNATION DES OPERATIONS | OUTILS | D mm | Vc m/s | n tr/mn | Vf m/mn | α mm | Z |
|----------------------------|--------|---------|-----------|------------|------------|---------|---|
| Opération 1mouler | 806 A | 30 | 50 | 8000 | 10 | 10 | 2 |

| Cfx= | C.réglage | C.obtenu | Correction | C.obtenu | Correction | C.obtenu |
|------|-----------|----------|------------|----------|------------|----------|
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| CONTRAT DE PHASE PHASE N°70 | Ensemble: CHASSIS SOUPIRAIL | Date: | DMT |
| | Pièce: MONTANT TRAVERSE OUVRANT | BUREAU DES METHODES | 1 1 |
| | Matière: NIANGON | | |
| NOM: | Programme: | | |

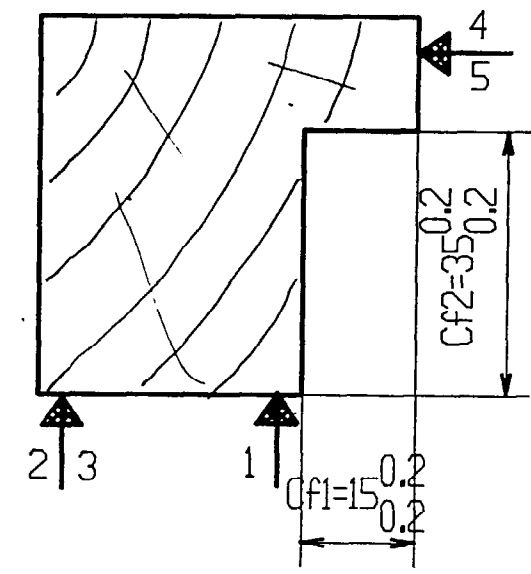
Désignation: profilage moulure
Machine-Outil: toupie



| DESIGNATION DES OPERATIONS | OUTILS | Vc m/s | n tr/mn | Vf m/mn | α mm | Z |
|----------------------------|--------|-----------|------------|------------|---------|---|
| Opération 1feullurer | XXX | 50 | 8000 | 10 | 10 | 4 |

| Cfx= | C.réglage | C.obtenu | Correction | C.obtenu | Correction | C.obtenu |
|------|-----------|----------|------------|----------|------------|----------|
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| CONTRAT DE PHASE PHASE N°50 | Ensemble: CHASSIS SOUPIRAIL | Date: | DMT |
| | Pièce: MONTANT TRAVERSE DORMANT | BUREAU DES METHODES | 1 1 |
| | Matériau: NIANGON | | |
| NOM: | Programme: | | |
| Désignation: profilage feuillure | | | |
| Machine-Outil: toupie | | | |



| DESIGNATION DES OPERATIONS | | OUTILS | | Vc | n | Vf | a | Z |
|----------------------------|-----------|----------|------------|----------|------------|----------|----|---|
| | | | | m/s | tr/mn | m/mn | mm | |
| Opération 1: feuillurer | | XXX | | 50 | 8000 | 10 | 10 | 4 |
| Cfx= | C.réglage | C.obtenu | Correction | C.obtenu | Correction | C.obtenu | | |
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