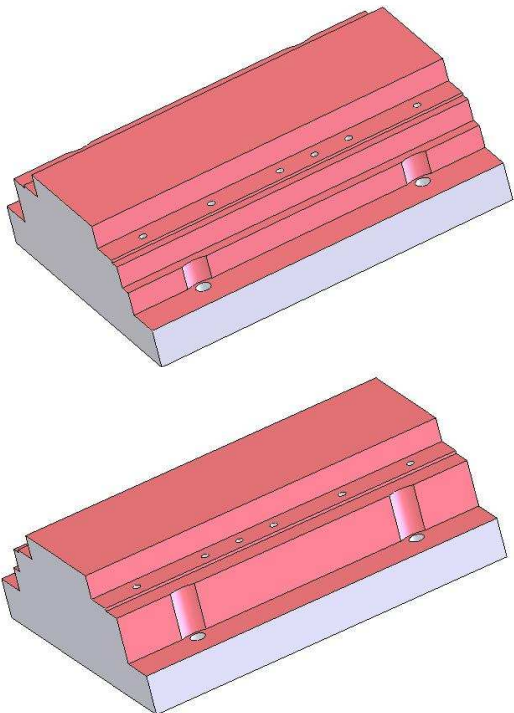
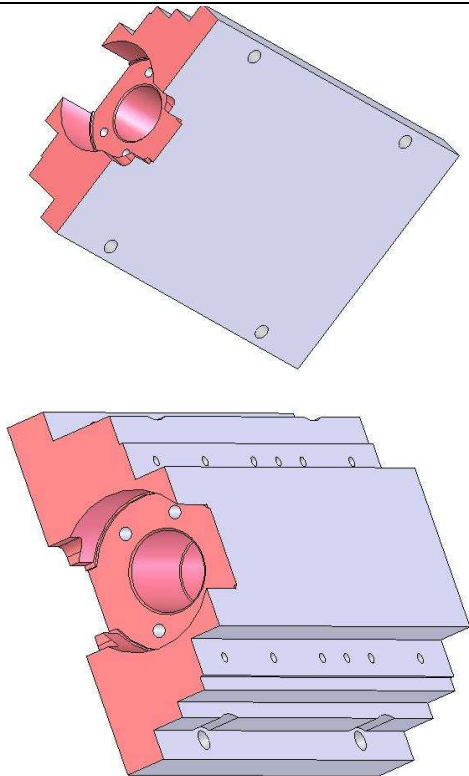
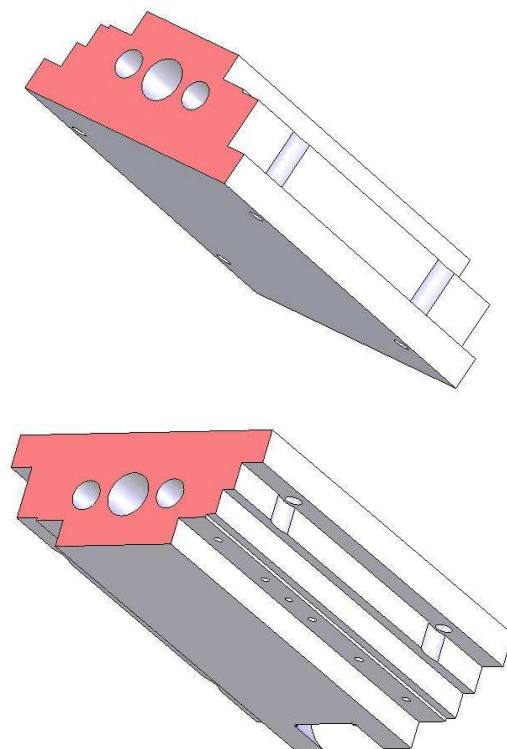
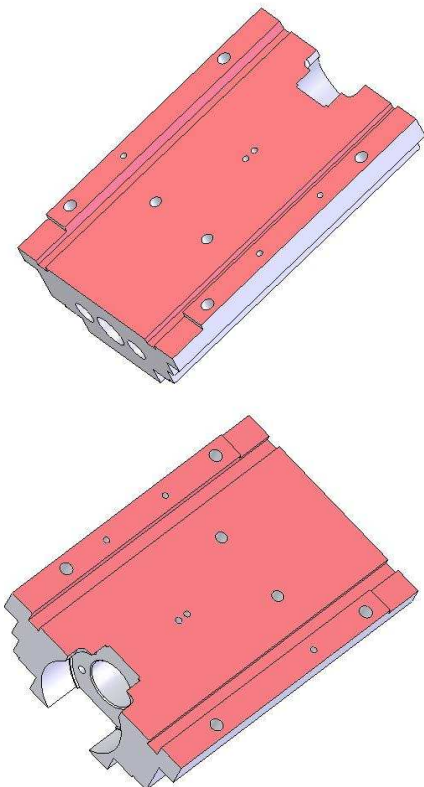
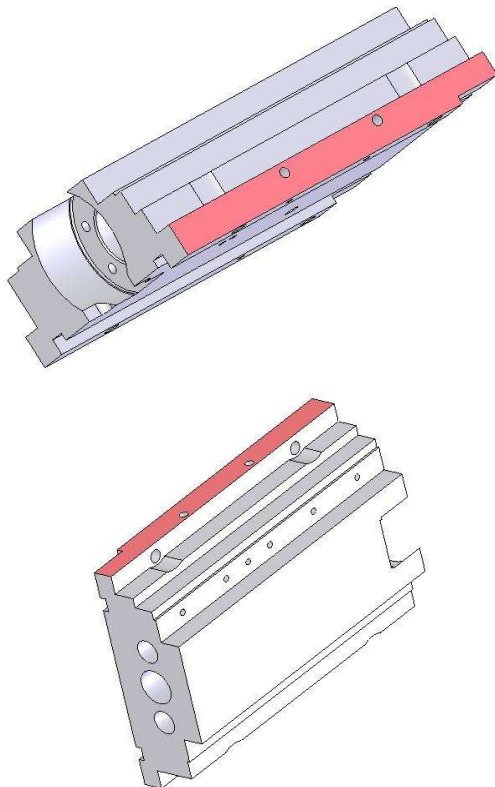
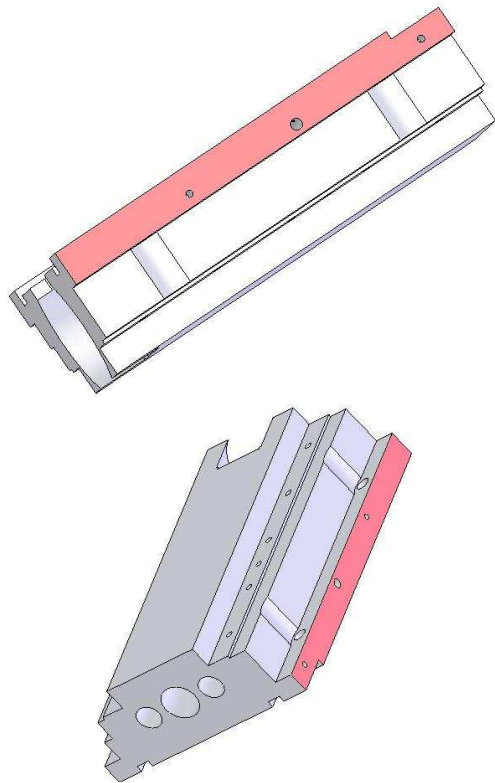
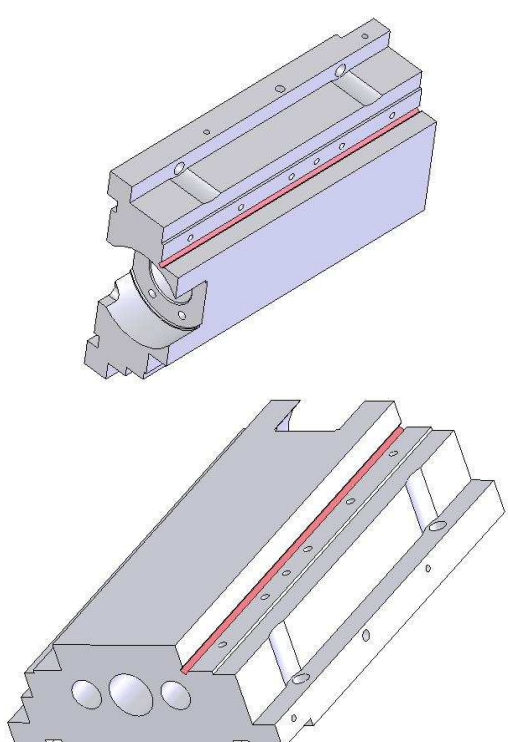
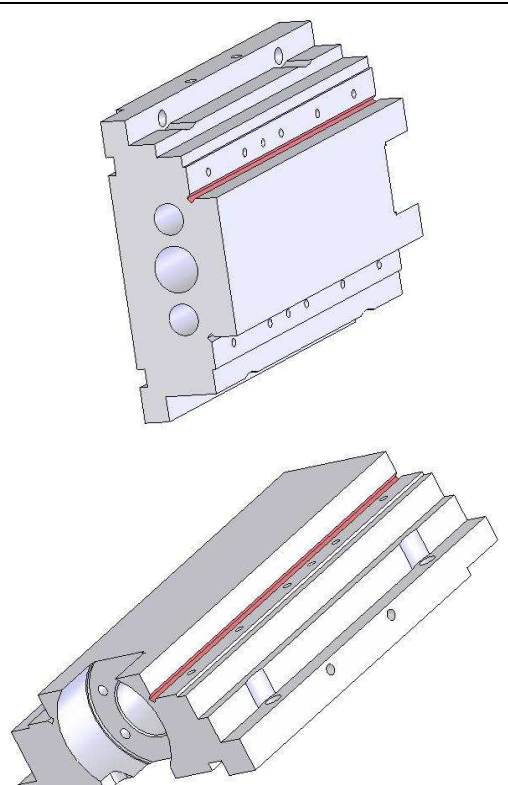
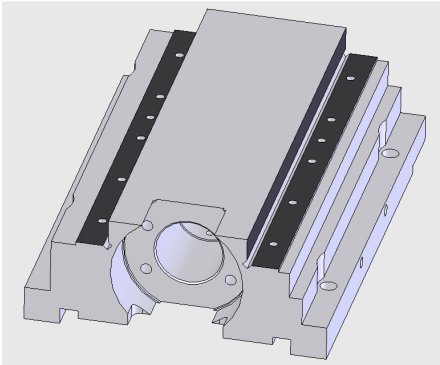
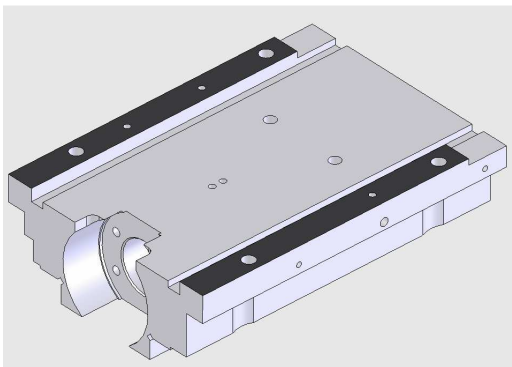


NOMENCLATURE DES PHASES		Ensemble : PLATINE DE TRANSLATION	BUREAU DES METHODES	1 5
		Elément : CHARIOT SUPPORT RAILS		
		Matière : X 20 Cr 13		
Phase S / Ph	DESIGNATION DES OPERATIONS	OUTILLAGE / MACHINES	SCHEMAS	
10	DEBIT	Scie mécanique	Dimensions du brut : 45 x 100 x 132	
20	FRAISAGE - Surfacier 1 (finition) - Epauler 8 et 10 (½ finition) - Contourner 7, 6, 11 et 9 (finition) - Epauler 30 et 31 (finition) - Percer et tarauder 32 - Percer et tarauder 12 - Percer 33 (finition)	CU Vertical 3 axes Arrow 750		
30	FRAISAGE - Surfacier 5 (finition) - Contourner 19 (finition) - Aléser 13 et 14 (finition) et surfacer 36 (finition), - Aléser 25 (finition) - Percer et tarauder 37	CU Vertical 3 axes Arrow 750		
DT4				

NOMENCLATURE DES PHASES		Ensemble : PLATINE DE TRANSLATION		BUREAU DES METHODES	2 <div>5</div>
		Elément : CHARIOT SUPPORT RAILS			
		Matière : X 20 Cr 13			
Phase S / Ph	DESIGNATION DES OPERATIONS	OUTILLAGE / MACHINES	SCHEMAS		
40	FRAISAGE - Surfacier 4 (finition) - Percer 26 (finition) - Percer 24 (finition)	CU Vertical 3 axes Arrow 750			
50	FRAISAGE - Surfacier 40 et 41 (½ finition) - Surfacier 15 (finition) - Epauler 18 (finition) - Percer 21 (finition) - Percer et tarauder 22 - Percer et tarauder 23 - Percer et tarauder 39 - Rainurer 16 et 17 (finition)	CU Vertical 3 axes Arrow 750			

NOMENCLATURE DES PHASES		Ensemble : PLATINE DE TRANSLATION		BUREAU DES METHODES	3 5
		Elément : CHARIOT SUPPORT RAILS			
		Matière : X 20 Cr 13			
Phase S / Ph	DESIGNATION DES OPERATIONS	OUTILLAGE / MACHINES	SCHEMAS		
60	FRAISAGE - Surfacier 3 (finition) - Percer et tarauder 28	CU Vertical 3 axes Arrow 750			
70	FRAISAGE - Surfacier 2 (finition) - Percer et tarauder 27 - Percer et tarauder 29	CU Vertical 3 axes Arrow 750			

NOMENCLATURE DES PHASES		Ensemble : PLATINE DE TRANSLATION		BUREAU DES METHODES	4 5
		Elément : CHARIOT SUPPORT RAILS			
		Matière : X 20 Cr 13			
Phase S / Ph	DESIGNATION DES OPERATIONS	OUTILLAGE / MACHINES	SCHEMAS		
80	FRAISAGE - Rainurer 34 (finition)	CU Vertical 3 axes Arrow 750			
90	FRAISAGE - Rainurer 35 (finition)	CU Vertical 3 axes Arrow 750			

NOMENCLATURE DES PHASES		Ensemble : PLATINE DE TRANSLATION		BUREAU DES METHODES	5 5
		Elément : CHARIOT SUPPORT RAILS			
		Matière : X 20 Cr 13			
Phase S / Ph	DESIGNATION DES OPERATIONS	OUTILLAGE / MACHINES	SCHEMAS		
100	RECTIFICATION PLANE - Finir en rectification les surfaces 8 et 10	Rectifieuse plane			
110	RECTIFICATION PLANE - Finir en rectification les surfaces 40 et 41	Rectifieuse plane			
120	CONTRÔLE FINAL				