开缝衬套及开缝芯轴冷挤压工序描述 Split Sleeve And Split Mandrel Process Description

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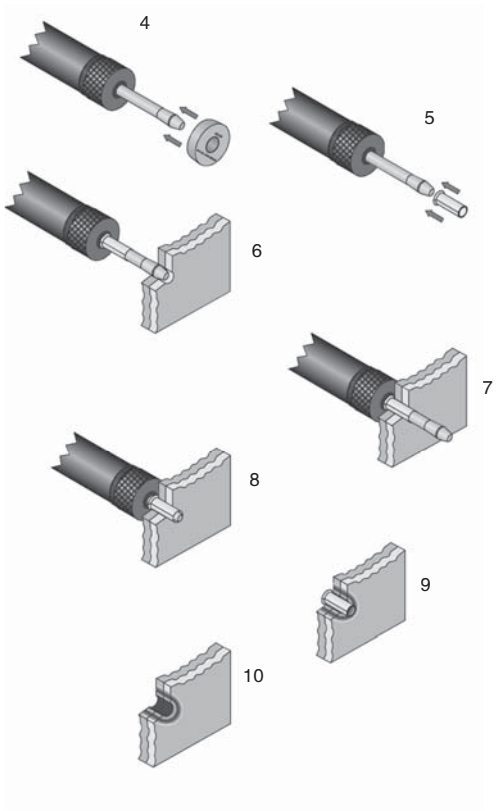
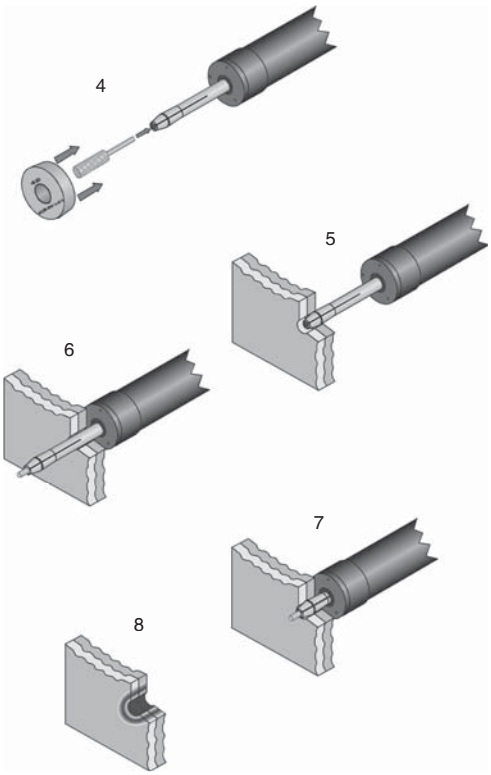


- 开缝衬套冷挤压工序
  1. 用初孔钻钻初孔。
  2. 用初孔铰刀铰孔至适当的初孔尺寸。
  3. 用量规检测初孔。
  4. 用通止环规检测芯轴。
  5. 将衬套套在芯轴上。
  6. 开始穿过初孔。
  7. 将前盖紧顶着工件放置。
  8. 通过从预润滑的开缝衬套中拉出心轴，对孔进行冷挤压。
  9. 去掉已变形的衬套。
  10. 孔的冷挤压完成。
  11. 用量规检查冷挤压后的孔。
  12. 用导向铰刀铰孔到最终尺寸。
  13. 用量规检查铰过的终孔，如果需要的话，进行锪窝。

- Split Sleeve Process
  1. Drill start hole with start drill.
  2. Ream hole to proper starting size with start hole reamer.
  3. Verify start hole with hole gage.
  4. Inspect mandrel with No-Go gage.
  5. Slide sleeve over the mandrel.
  6. Start pass-thru of hole.
  7. Place nosecap flush against workpiece.
  8. Coldwork hole by drawing the mandrel back through the sleeve and hole.
  9. Remove used sleeve and discard.
  10. The hole has been coldworked.
  11. Inspect coldworked hole with hole gage.
  12. Ream hole to final size with piloted reamer.
  13. Inspect final reamed hole with hole gage. Countersink if necessary.

- 开缝芯轴冷挤压工序
  1. 用初孔钻钻初孔。
  2. 用初孔铰刀铰孔至适当的初孔尺寸。
  3. 用量规检测初孔。
  4. 将检测销钉插入芯轴末端并用环规检查芯轴。
  5. 开始将可收缩的空心开缝芯轴穿过孔。
  6. 完成穿孔后，将前盖紧顶着工件材料放置。按下启动装置后，实心导杆穿过空心芯轴的中心。
  7. 当经充实的芯轴穿过工件材料拉回来时，孔的直径就扩大了。
  8. 冷挤压孔完成而不需要废弃衬套。
  9. 用量规检查冷挤压孔。
  10. 用导向铰刀铰孔到最终尺寸。
  11. 用量规检查铰过的终孔，如果需要的话，进行锪窝。

- Split Mandrel Process
  1. Drill start hole with start drill.
  2. Ream hole to proper starting size with start hole reamer.
  3. Verify start hole with hole gage.
  4. Inspect mandrel by inserting inspection pin in end of mandrel and checking mandrel with wear gage.
  5. Start pass-thru of hole. The hollow, split mandrel collapses.
  6. Pass-thru is complete. Nosecap is placed flush to material. After depressing trigger, the pilot extends through center of hollow mandrel, which solidifies.
  7. The hole diameter is expanded as the now solidified mandrel is pulled back through the material.
  8. With no sleeve to discard, the hole has been coldworked.
  9. Inspect coldworked hole with hole gage.
  10. Ream hole to final size with piloted reamer.
  11. Inspect final reamed hole with hole gage. Countersink if necessary.



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