

威铝各工序时间宽放标准表

| 工作中心 | 工序           | 宽放率    | 部门签名 |
|------|--------------|--------|------|
| 压铸   | 压铸           | 12.50% | 区锦亮  |
|      | 压铸披锋         | 10.00% |      |
|      | 压铸振动         | 11.00% |      |
| 冲压   | 冲压           | 11.50% | 杨开井  |
|      | 焊接/铆接        |        |      |
|      | 冲压清洗         | 10.00% |      |
| 机加   | 锯切           | 11.50% | 汪从云  |
|      | CNC          |        |      |
|      | 数控车床班        |        |      |
|      | 披锋           | 10.00% |      |
|      | 机加镗雕         | 8.50%  |      |
|      | 机加清洗         | 10.00% |      |
| 研磨   | 打磨           | 13.50% | 贺泽华  |
|      | 拉丝           |        |      |
|      | 喷砂           | 12.50% |      |
|      | 研磨线检         | 10.00% |      |
|      | 数控打磨班        | 11.50% |      |
| 阳极氧化 | 阳极氧化         | 10.50% | 潘荣球  |
|      | 电泳           |        |      |
| 喷涂   | 喷漆           | 10.50% | 郭三星  |
|      | 脱漆           |        |      |
|      | 钝化/除油(自动)    | 10.00% |      |
|      | 钝化/除油/清洗（手动) | 12.00% |      |
| 丝印   | 丝印           | 10.00% | 肖如方  |
|      | 脱膜/除油        |        |      |
| 包装   | 包装           | 8.50%  | 李春梅  |
|      | 包装镗雕         |        |      |
|      | 包装清洗         | 10.00% |      |

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威铝各工序对应的人力工时宽放值

| 序号 | 工序名称         | 工序代码 | 工序工时 | 加工时间宽放标准 (h) |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
|----|--------------|------|------|--------------|----|----|----|------|-----|----|----|----|----|----|----|----|----|----|----|
|    |              |      |      | 压铸           | 冲压 | 机加 | 研磨 | 阳极氧化 | CNC | 喷涂 | 丝印 | 包装 | 其他 | 其他 | 其他 | 其他 | 其他 | 其他 | 其他 |
| 1  | 压铸           | 101  | 1.0  | 0.125        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 2  | 压铸披锋         | 102  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 3  | 压铸振动         | 103  | 1.0  | 0.11         |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 4  | 冲压           | 201  | 1.0  | 0.115        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 5  | 焊接/铆接        | 202  | 1.0  |              |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 6  | 冲压清洗         | 203  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 7  | 锯切           | 301  | 1.0  | 0.115        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 8  | CNC          | 302  | 1.0  | 0.115        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 9  | 数控车床班        | 303  | 1.0  | 0.115        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 10 | 披锋           | 304  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 11 | 机加镗雕         | 305  | 1.0  | 0.085        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 12 | 机加清洗         | 306  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 13 | 打磨           | 401  | 1.0  | 0.135        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 14 | 拉丝           | 402  | 1.0  | 0.135        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 15 | 喷砂           | 403  | 1.0  | 0.125        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 16 | 研磨线检         | 404  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 17 | 数控打磨班        | 405  | 1.0  | 0.115        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 18 | 阳极氧化         | 501  | 1.0  | 0.105        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 19 | 电泳           | 502  | 1.0  | 0.105        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 20 | 喷漆           | 601  | 1.0  | 0.105        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 21 | 脱漆           | 602  | 1.0  | 0.105        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 22 | 钝化/除油(自动)    | 603  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 23 | 钝化/除油/清洗（手动） | 604  | 1.0  | 0.12         |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 24 | 丝印           | 701  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 25 | 脱膜/除油        | 702  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 26 | 包装           | 801  | 1.0  | 0.085        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 27 | 包装镗雕         | 802  | 1.0  | 0.085        |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |
| 28 | 包装清洗         | 803  | 1.0  | 0.1          |    |    |    |      |     |    |    |    |    |    |    |    |    |    |    |

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