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|  | ГОСТ 3.1105 – 84 Форма 2 *Формат А4* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Дубл. | |  | |  |  |  | | |  | | |  | |  |  | | |  |  | |  |  | |  | | | |  | | |
| Взам. | |  | |  |  |  | | |  | | |  | |  |  | | |  |  | |  |  | |  | | | |  | | |
| Подл. | |  | |  |  |  | | |  | | |  | |  |  | | |  |  | |  |  | |  | | | |  | | |
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| **ТЕХНОЛОГИЧЕСКИЙ ПРОЦЕСС**  ***МЕХАНИЧЕСКОЙ СБОРКИ*** | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |
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| Разработал | | | | | \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_/ Шершнев А.В. /  «\_\_\_\_»\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ 2011г. | | | | | | | | | | | | | | |
| Проверил | | | | | \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_/ Гоцеридзе Р.М. /  «\_\_\_\_»\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ 2011г. | | | | | | | | | | | | | | |
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| **ТЛ** | | | **ТИТУЛЬНЫЙ ЛИСТ** | | | | | | | | | | | | | | | | | | | | | | | | |  | | |

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|  | ГОСТ 3.1118 – 82 Форма 1 *Формат А4* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Взам. | | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | |
| Подл. | | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | |
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| Пров. | | | | |  | | | | | | | |  | | | |  | | |
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| Н.контр. | | | | |  | | | | | | | |  | | | |  | | |
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|  | | | Код | | | | | | | ЕВ | | МД | | | | ЕН | | | Н.расх. | | КИМ | | Код загот. | | | | | | | | Профиль и размеры | | | | | | | | | КД | | | | МЗ | | | |  | | | | | | | | | | |
| М 02 | | |  | | | | | | |  | |  | | | |  | | |  | |  | |  | | | | | | | |  | | | | | | | | |  | | | |  | | | |  | | | | | | | | | | |
| А | | | Цех | | | | Уч. | РМ | | | Опер. | | | Код, наименование операции | | | | | | | | | | | | | Обозначение документа | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | | Код, наименование оборудования | | | | | | | | | | | | | | | | | | | | | | | | СМ | | | Проф. | | Р | | УТ | | КР | КОИД | | | | | ЕН | | | ОП | | Кшт | | | | Тпз | | | Тшт | | | | |
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| А | | 03 | ***01 005 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | 04 | *Молоток, керн.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | | 05 | 1. *Кернить валы-шестерни 1, 2, 3, 4, 5 и соответствующие им колеса зубчатые* 2. *Установить штифты* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | | 06 | ***01 010 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | 07 | *Специальный инструмент.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | | 08 | 1. *Установить на вал-шестерню 5 кольцо стопорное* 2. *Установить подшипники на валы-шестерни 1, 2, 3, 4, 5 с помощью специального инструмента.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | | 11 | ***01 015 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | 12 | *Отвертка.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | | 13 | 1. *Установить муфты БПМ-2М (2 шт.) 7, 10 на корпус 20* 2. *Закрепить с помощью винтов* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | 14  15 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **МК** | | | | | | **МАРШРУТНАЯ КАРТА** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | *2* | | |

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|  | ГОСТ 3.1118 – 82 Форма 1 *Формат А4* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Дубл. | | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | |
| Взам. | | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | |
| Подл. | | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | |
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| Разраб. | | | | |  | | | | | | | |  | | | |  | | |  | | | | |  | | | | | | | | | |  | | | | | | | | | | | **ТП** | | | | | | | | | | | | |
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| Пров. | | | | |  | | | | | | | |  | | | |  | | |
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| Н.контр. | | | | |  | | | | | | | |  | | | |  | | |
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|  | | | Код | | | | | | | ЕВ | | МД | | | | ЕН | | | Н.расх. | | КИМ | | Код загот. | | | | | | | | Профиль и размеры | | | | | | | | | КД | | | | МЗ | | | |  | | | | | | | | | | |
| М 02 | | |  | | | | | | |  | |  | | | |  | | |  | |  | |  | | | | | | | |  | | | | | | | | |  | | | |  | | | |  | | | | | | | | | | |
| А | | | Цех | | | | Уч. | РМ | | | Опер. | | | Код, наименование операции | | | | | | | | | | | | | Обозначение документа | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | | Код, наименование оборудования | | | | | | | | | | | | | | | | | | | | | | | | СМ | | | Проф. | | Р | | УТ | | КР | КОИД | | | | | ЕН | | | ОП | | Кшт | | | | Тпз | | | Тшт | | | | |
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| А | | 03 | ***01 020 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | 04 | *Ключ гаечный.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | | 05 | 1. *Установить колеса зубчатые, крепежные элементы и шестерни на валы муфт* 2. *Закрепить с помощью гаек* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | 06 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | | 07 | ***01 025 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | 08 | *Ключ гаечный.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | | 09 | 1. *Установить шестерню 2 на вал двигателя 1, закрепить с помощью гайки* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | 10 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | | 11 | ***01 030 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | 12 | *Отвертка.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | | 13 | 1. *Закрепить двигатель 1 на корпусе с помощью винтов* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | 14 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| **МК** | | | | | | **МАРШРУТНАЯ КАРТА** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | *3* | | |

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| ГОСТ 3.1118 – 82 Форма 1 *Формат А4* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Дубл. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
| Взам. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
| Подл. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
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| Разраб. | | | |  | | | | | | | |  | | | |  | | |  | | | | |  | | | | | | | | | |  | | | | | | | | | | | **ТП** | | | | | | | | | | | | | |
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| Н.контр. | | | |  | | | | | | | |  | | | |  | | |
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|  | | Код | | | | | | | ЕВ | | МД | | | | ЕН | | | Н.расх. | | КИМ | | Код загот. | | | | | | | | Профиль и размеры | | | | | | | | | КД | | | | МЗ | | | |  | | | | | | | | | | | |
| М 02 | |  | | | | | | |  | |  | | | |  | | |  | |  | |  | | | | | | | |  | | | | | | | | |  | | | |  | | | |  | | | | | | | | | | | |
| А | | Цех | | | | Уч. | РМ | | | Опер. | | | Код, наименование операции | | | | | | | | | | | | | Обозначение документа | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | Код, наименование оборудования | | | | | | | | | | | | | | | | | | | | | | | | СМ | | | Проф. | | Р | | УТ | | КР | КОИД | | | | | ЕН | | | ОП | | Кшт | | | | Тпз | | | Тшт | | | | | |
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| А | 03 | ***01 035 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 04 | *Специальный инструмент.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 05 | 1. *Установить валы в сборе 1, 2, 3, 4 и 5 в корпусе 20* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 06 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | 07 | ***01 040 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 08 | *Отвертка.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 09 | 1. *Установить крышку корпуса 20* 2. *Закрепить крышку корпуса 20 с помощью винтов* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| А | 11 | ***01 045 Регулировочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 12 | *Регулировочно-измерительное устройство.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 13 | 1. *Регулировать положение валов с помощью набора прокладок.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 14 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 15 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **МК** | | | | | **МАРШРУТНАЯ КАРТА** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | *4* | | | |

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| ГОСТ 3.1118 – 82 Форма 1 *Формат А4* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Дубл. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
| Взам. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
| Подл. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
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| Разраб. | | | |  | | | | | | | |  | | | |  | | |  | | | | |  | | | | | | | | | |  | | | | | | | | | | | **ТП** | | | | | | | | | | | | | |
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| Пров. | | | |  | | | | | | | |  | | | |  | | |
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| Н.контр. | | | |  | | | | | | | |  | | | |  | | |
| М 01 | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
|  | | Код | | | | | | | ЕВ | | МД | | | | ЕН | | | Н.расх. | | КИМ | | Код загот. | | | | | | | | Профиль и размеры | | | | | | | | | КД | | | | МЗ | | | |  | | | | | | | | | | | |
| М 02 | |  | | | | | | |  | |  | | | |  | | |  | |  | |  | | | | | | | |  | | | | | | | | |  | | | |  | | | |  | | | | | | | | | | | |
| А | | Цех | | | | Уч. | РМ | | | Опер. | | | Код, наименование операции | | | | | | | | | | | | | Обозначение документа | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | Код, наименование оборудования | | | | | | | | | | | | | | | | | | | | | | | | СМ | | | Проф. | | Р | | УТ | | КР | КОИД | | | | | ЕН | | | ОП | | Кшт | | | | Тпз | | | Тшт | | | | | |
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| А | 03 | ***01 050 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 04 | *Отвертка.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 05 | 1. *Закрепить крышки для подшипников валов 1, 2, 3 и 4 с помощью винтов* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 06 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | 07 | ***01 055 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 08 | *Отвертка.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 09 | 1. *Закрепить крышку с сальником для подшипника вала 5* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 10 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 11 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | 12 | ***01 060 Сборочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 13 | *Отвертка.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 14 | 1. *Закрепить вилку штепсельную на уголке 21.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 15 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **МК** | | | | | **МАРШРУТНАЯ КАРТА** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | *5* | | | |

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| ГОСТ 3.1118 – 82 Форма 1 *Формат А4* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Дубл. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
| Взам. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
| Подл. | | |  | | | | |  | | | | | |  | | |  | | | | | |  | |  | | |  | | | |  | |  | | |  | | |  | |  | | | | | |  | | | | | |  | | | | |
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| Разраб. | | | |  | | | | | | | |  | | | |  | | |  | | | | |  | | | | | | | | | |  | | | | | | | | | | | **ТП** | | | | | | | | | | | | | |
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| Пров. | | | |  | | | | | | | |  | | | |  | | |
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| Н.контр. | | | |  | | | | | | | |  | | | |  | | |
| М 01 | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
|  | | Код | | | | | | | ЕВ | | МД | | | | ЕН | | | Н.расх. | | КИМ | | Код загот. | | | | | | | | Профиль и размеры | | | | | | | | | КД | | | | МЗ | | | |  | | | | | | | | | | | |
| М 02 | |  | | | | | | |  | |  | | | |  | | |  | |  | |  | | | | | | | |  | | | | | | | | |  | | | |  | | | |  | | | | | | | | | | | |
| А | | Цех | | | | Уч. | РМ | | | Опер. | | | Код, наименование операции | | | | | | | | | | | | | Обозначение документа | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | | Код, наименование оборудования | | | | | | | | | | | | | | | | | | | | | | | | СМ | | | Проф. | | Р | | УТ | | КР | КОИД | | | | | ЕН | | | ОП | | Кшт | | | | Тпз | | | Тшт | | | | | |
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| А | 03 | ***01 095 Регулировочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 04 | *Регулировочно-измерительное устройство.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 05 | 1. *Проверить продольный люфт валов относительно корпуса.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 06 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | 07 | ***01 100 Регулировочная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 08 | *Регулировочно-измерительное устройство .* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 09 | 1. *Проверить поперечный люфт валов относительно друг друга.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 10 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| А | 11 | ***01 105 Контрольная*** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Б | 12 | *Стенд для проверки* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| О | 13 | 1. *Проверка параметров и работы рулевой машины.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 14 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 15 |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **МК** | | | | | **МАРШРУТНАЯ КАРТА** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | *6* | | | |