
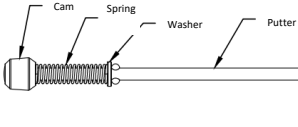
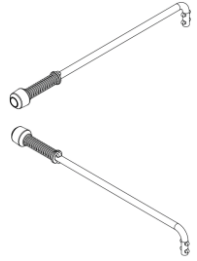





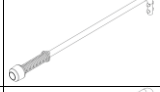



Research and Development of Parking Lever Processing Technology for Liuqi CTF25 Automatic Transmission.

Card No.

				Push rod assembly process		Product type	T3040029
				Product Name		Push rod assembly	
Part Name	Push rod assembly	Material	0	Category, Specifications and dimensions	Components	Assembly Weight (KG)	0.07177385
Part Name	Push rod	Material	SWRCH22A		Wire	Bar Weight (KG)	0.05224225
Part Name	Parking cam	Material	20CrMnTiH		$\varnothing 5.95 \pm 0.05$	Bar Weight (KG)	0.01526205
Part Name	Spring	Material	SWOSC-V		Bar	Bar Weight (KG)	0.0029466
Part Name	Spring gasket	Material	45 #		± 0.5	Bar Weight (KG)	0.00132295
					Wire		
				$\varnothing 1.0 \pm 0.03$	Sheet		
				$12 \pm 0.1 \times 2 \pm 0.1$			
							
Operation No.	Operation Name	Work steps	Operation step content	Device name model	Measuring tools	Shaping diagram	
1.	Pier head (outsourced)	Cold heading	Outsourcing	Cold heading machine	Inspection tools, calipers		
2.	Vibration grinding and polishing	Grinding	Put the product into a grinder and add grinding stones to grind and remove burrs and edges. Then polishing is carried out to remove scratches and fine defects on the surface of the product. (10X20 1 hour cylindrical, after treatment)	Grinder	The naked eye		
3.	Install parking cam	Assembly	Fit the parking cam into the specified position	Manual	The naked eye		
4.	Bend	Forming	Use the fixture to position the product accurately and bend it	Mold	Inspection tool		
5.	Install springs and gaskets	Assembly	Install the spring and gasket in the specified position	Manual	The naked eye		
6.	Flat position	Forming	Use the fixture to position the product accurately and flatten it	Mold	Inspection tool		
7.	Demagnetization	Degaussing	Remove the debris of the product due to magnetic adsorption during machining. .	Demagnetizer	Gaussian meter		
8.	Water degreasing and cleaning	Cleaning	Stain produced during removal	Cleaning machine			
9.	Clean and rust-proof	Rust prevention	Antirust treatment shall be carried out on the products	Manual			
10.	Over the base	Quality inspection	The selected outline is not up to standard	Manual	Inspection tool		
11.	Full inspection of appearance	Quality inspection	Select products with unqualified appearance. Scratches, depressions, cracks, etc. are defective products	Manual	The naked eye		
12.	Finished product inspection.	Quality inspection	Sampling inspection shall be carried out on the products to be put into storage	Manual			
13.	Packed and put into storage	Packaging	Package the qualified products as required and put them into storage	Manual			