

ICS 65.160
CCS X 94

YC

**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

YC/T 12.1-2006

Replacing YC/T 12.1-1993

**Tobacco machinery. Products technological documentation.
Part 1: Completeness
(English Translation)**

Issued on: February 23, 2006

Implemented on: March 1, 2006

Issued by: State Tobacco Monopoly Administration

Table of Contents

Foreword	
1 Scope	
2 Normative references	
3 Terms and definitions	
4 Integrity	
5 MRPII routing card + + +	
6 Wood mold craft card + + +	
7 Sand casting craft card + + +	

Foreword

YC/T 12 "Tobacco Machinery Product Process Document" is divided into the following sections.

- Part 1. Integrity;
- Part 2. Process design;
- Part 3. Product structure process review;
- Part 4. Process design;
- Part 5. Process specification format;
- Part 6. Management process file format;
- Part 7. Numbering method;
- Part 8. Process quota preparation;
- Part 9. Change method.

This part is the first part of YC/T 12. This part replaces YC/T 12.1-1993 "Tobacco Machinery Product Process Document Complete Sex. The main changes in this section compared with YC/T 12.1-1993 are as follows.

- Changed the referenced document (Chapter 2 of the 1993 edition; Chapter 2 of this edition);
- Change "general requirements" to "integrity" (Chapter 3 of the 1993 edition; Chapter 4 of this edition) and remove the independence from "integrity" Content (3.1, 3.3 of the 1993 edition);

- Added "terms and definitions" (Chapter 3 of this edition);
- Added "MRPII Process Route Card", "Sand Casting Process Card" and "CNC Machining Tool Location Chart" (Table 1 of this edition) no. 5, 10 and 20), canceled the "CNC machining program card" (No. 16 of Table 1 of the 1993 edition);
- Combine product quality control point schedules and parts quality control point schedules into quality control point schedules (1993 edition table 1 Nos. 35 and 36; serial number 37 of this edition of Table 1);
- Change the list of outsourced parts to the list of process outsourcing parts and the list of overall outsourcing parts (No. 37 of Table 1 of the 1993 edition; this edition no. 38 and 39) of Table 1;
- Appropriate for the type of process documentation required at each stage of production and the degree of need (should be or determined according to actual conditions) Changes (Table 1 of the 1993 edition; Table 1 of this edition).

This part is proposed by the National Tobacco Monopoly Bureau.

This part is under the jurisdiction of the National Tobacco Standardization Technical Committee (TC144).

This section drafted by. Changde Tobacco Machinery Co., Ltd., China Tobacco Machinery Technology Center Co., Ltd.

1 Scope

This part of YC/T 12 specifies the integrity of the process documentation for each stage of production of tobacco machinery products.

This section applies to the process technology management of tobacco machinery products.

2 Normative references

The terms in the following documents become the provisions of this part by reference to this part of YC/T 12. For dated references, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, an agreement is encouraged under this section.

The parties are studying whether the latest version of these documents can be used. For undated references, the latest edition applies to this section.

JB/T 9165.1-1998 Process File Integrity

3 Terms and definitions

The terms and definitions established by JB/T 9165.1-1998 and the following terms and definitions apply to this part of YC/T 12.

Specify the sequence of parts processing operations, as well as the contents of each process, including the clamping method (fixture), processing location, process requirements and tools (Knife, quantity, auxiliary equipment), etc., for the implementation of MRPII documents on parts characteristics, tooling, processes, raw materials and other information.

Identify the documentation for the processing equipment, tooling, fixtures, and setup positions.

4 Integrity

The integrity of the process documentation should be different depending on the stage of production of the tobacco machinery product, and the common process document integrity requirements See Table 1.

Note: The production stage refers to prototype production, small batch trial production and formal production.

Table 1 Process File Integrity

No.	Process Document Name	Prototype	Trial Production	Small Batch	Prototype Production
1	Product structure processability review record	delta	delta	delta	
2	Process plan	delta	delta	delta	
3	Process plan review report +	delta	delta		
4	Product Zero (Part) Parts Routing Table + + +				