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YC

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

YC/T 12.5-2006

Replacing YC/T 12.5-1993

**Tobacco machinery. Products technological documentation.
Part 5: Form of procedure
(English Translation)**

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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 fifth part of YC/T 12. This part replaces YC/T 12.5-1993 "Tobacco Machinery Product Process Document Process Procedure format. The main changes in this section compared to YC/T 12.5-1993 are as follows.

- Removed the "product model" and "product name" in the header of the process specification format, adding "process importance" and "responsible unit" (1993 edition 4.2; this edition 4.2);
- Removed the provisions of the "CNC processing program card" format (1993 version 3.1.11, 4.2.11);
- Added "Sand casting process card", "CNC machining program tool position map", "MRPII process route card file" format Provisions (format 6, format 14, format 26 in this edition 3.1);
- Change the "equipment" in the process specification format to "work center" (1993

version 4.1.4; this version of 4.1.4);

--- In order to adapt to the information construction of the enterprise, the items in the process specification format such as parts, materials, blanks, work centers, and process equipment are specified.

The code is filled in (4.1.4, 4.1.5, 4.2 of the 1993 edition; 4.1.4, 4.1.5, 4.2 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 format of the process specifications for tobacco machinery products and the basic requirements and methods for their filling.

This section applies to the preparation of the technical regulations for 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.

GB/T 14689 technical drawing format and format (GB/T 14689-1993, eqv ISO 5457. 1980)
JB/T 5061-1991 Machining positioning, clamping symbol YC/T 12.1-2006 Tobacco machinery products - Process documentation - Part 1. Integrity YC/T 12.7-2006 Tobacco machinery product process documentation - Part 7. Numbering method

3 Format

3.1

According to the provisions of YC/T 12.1-2006, this section specifies the following process specification format.

---Format 1. header, footer and additional columns;

- Format 2. Wood Mold Craft Card;
- Form 3. Sand casting process card;
- Form 4. investment casting process card;
- Form 5. Pressure casting process card;
- Form 6. sand casting process card;
- Format 7. Forging Craft Card;
- Format 8. welding process card;
- Format 9. Cold stamping process card;
- Format 10. () process card;

Note: The contents of () are customized according to the needs, such as mechanical processing, cold work, clamp processing and other process cards.

- Form 11. Mechanical processing card;
- Format 12. CNC machining process card;
- Format 13. CNC machining tool adjustment card;
- Format 14. CNC machining program tool position map;
- Format 15. heat treatment process card;
- Form 16. Induction heating heat treatment process card;
- Format 17. Electroplating process card;
- Format 18. Surface treatment process card;
- Format 19. Assembly process card;
- Format 20. electrical assembly process card;
- Format 21. painting process card;
- Format 22. () check card;

Note: The contents of () are customized according to the needs, such as process key parts, assembly and other inspection cards.

- Format 23. Process drawings;
- Format 24. Craft Code;
- Format 25. Product zero (part) piece routing table;
- Format 26. MRPII routing card.