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YC

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

YC/T 12.8-1993

Replacing YC/T 12.8-1993

**Tobacco machinery. Products technological documentation.
Part 8: Preparation of norm of the total material consumption
(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 eighth part of YC/T 12. This part replaces YC/T 12.8-1993 "Tobacco Machinery Product Process Document Process Quota preparation. The main changes in this section compared with YC/T 12.8-1993 are as follows.

- Increased the working time quota for program debugging of CNC machine tools, and the calculation method for debugging program working hours (see 3.5.2);
- Increase the specific method of revision of labor quota when raw materials or blanks are changed (see 3.6).

Appendix A, Appendix B and Appendix C of this part are informative annexes.

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 Group Corporation Technology Center.

1 Scope

This part of YC/T 12 specifies.

- a) the compilation principles, preparation methods, preparation procedures and revision of material quotas for the process quotas for tobacco machinery products;
- b) The scope, form, principle, basis, method and revision of the labor quota for the labor consumption process quota.

This section applies to tobacco machinery products material consumption process quota (hereinafter referred to as material quota) and labor consumption process quota (the following simple the preparation of the labor quota).

2.1 Material quota principle

2.1.1

The raw materials and auxiliary materials required for the production process shall be prepared with a fixed amount of materials.

2.1.2

When preparing the material quota, the material should be fully considered economically and reasonably under the premise of ensuring product quality and process requirements.

Limit material utilization and material consumption.

2.1.3

When preparing the material quota, the following technical data should be used as the basis.

- a) product parts list and product drawings;
- b) part process specification;
- c) Relevant material standards, manuals and blanking standards.

2.2.1 Formula calculation

According to the product part structure and process requirements, the net weight of the part and the process loss in the manufacturing process are obtained by the formula calculation method.

2.2.2 Actual measurement method

Determine the material rating for each part using the actual weighing method.

2.2.3 Empirical statistical analysis

According to the actual consumption statistics of similar parts and materials, after analysis and comparison, determine the material consumption process quota of the parts.

2.3.1 Procedure for the preparation of mechanical parts and forging material quotas

The procedure for the machining of machined parts and forgings is as follows.

- a) Calculate the blank of the part based on the net part weight in the product part list or product drawing or the blank size in the process specification quality;
- b) Determine the quota of the material of each part of the various parts, see Appendix A for the determination method;
- c) Calculate the material utilization rate of the parts according to formula (1).

100% (1)

In the formula.

K---Part material utilization rate, %;

- d) prepare a schedule of material consumption schedules;