

产品质量控制计划

INSPECTION AND TEST PLAN

产品类别：转盘轴承

PRODUCT CLASSIFICATION: SLEWING BEARING

应用领域：工程机械

APPLICATION: ENGINEERING MACHINES

3					
2					
1					
0	04/20/2010	首次发布 First issue			
版本 Rev.	实施日期 Issue date	内容 Description	编制 Prepared by	校对 Checked by	批准 Approved by
			版本 Revision 0		

	<p style="text-align: center;">产品质量控制计划 I.T.P.</p>			编号 Ref.	页码 Page 2/7
				版本 Rev. Rev.0	日期 Date : 04/20/2010
适用范围： 内部控制及第三方检测 Applications: internal controlling and the third part inspection.					
客户名称 CUSTOMER : 客户编码 CUSTOMER REF : 客户地址 ADDRESS/CONTACT :					
第三检验方 INSPECTION AGENCY : --- 地址: ADDRESS/CONTACT : ---					
产品应用描述 MAT./EQUIP.DESCRPTION : 应用于工程机械抓斗回转机构的转盘轴承 Apply to slewing bearing of engineering machine's slewing structure					
文件中常用符号解释 LEGEND : 说明:文件中的符号的含义与客户要求保持一致 Note : Put the applicable symbols on ITP in accordance with customer requirements			1: 抽样进行检验 Sample inspection 2: 100%进行检验 100% inspection C: 提供检测报告 Establishment of certificate R: 需审查项目 Review point W: 到现场验证项目 Witness point H: Hold point. Shall not proceed without witness from cust. or its representative N: 运输过程中注意 Release note for shipping TPI: 第三方检验 Third Party Inspection IP: 进行中 In Process		
客户确认 CUSTOMER APPROVAL : 姓名 NAME 日期 DATE :		编制 PREPARED BY QA/QC : 姓名 NAME 日期 DATE :		批准 APPROVED BY QA/QC : 姓名 NAME 日期 DATE :	
		Rev. 0	Rev.	Rev.	Rev.



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Rev. 0

日期 Date :
04/20/2010

产品类型 PART. or ASS. DESIGNATION : 带内齿交叉滚子型转盘轴承
cross roller slewing bearing with inner gear

产品型号 PART. or ASS. REFERENCE : RW20/573Y)

序号 PARTS	检查或试验内容 INSPECTION OR TEST DESCRIPTION	依据标准或接受要求 STANDARD/SPECIF. with ACCEPTANCE CRITERIA	文件 要求 CERT/ DOC	检验要求 INSPECTION REQUIRED				备注 NOTES
A-1.0	原材料 RAW MATERIAL							
A-1.0.1	锻件 Forging parts	转盘产品锻件订货技术要求 -ZD201004001 slewing bearing forging parts purchase technology requirement -ZD201004001	C				All documents shall be in english	
A-1.0.2	原材料 Raw material	原材料厂材质证书 Raw material factory material certificate	C					
A-1.0.3	热处理 Heat treatment	热处理炉温曲线 heat treatment furnace temperature curve	C					
A-1.0.4	可追溯性标识 Identification Traceability	材料编号及热处理炉号 material NO.and heattreatment furnace NO.	C	2H				
A-1.0.5	调质硬度检测 hardness test	转盘产品锻件订货技术要求 -ZD201004001 slewing products forging parts purchase technology requirement -ZD201004001	C	2H				
A-1.0.6	锻件尺寸检测报告 visual/ dimensional inspection	转盘产品锻件订货技术要求 slewing products forging parts purchase technology requirement -ZD201004001	C	2R				
A-1.0.7	超声波探伤报告 Ultrasonic examination	转盘产品锻件订货技术要求 slewing products forging parts purchase technology requirement -ZD201004001	C	2W				
A-1.0.8	材料性能测试及成分分析 material performance test and component analysis	转盘产品锻件订货技术要求 slewing products forging parts purchase technology	C					

A- 1.0.9	锻件证书 Material certificate	锻件厂锻件合格证书 forging factory forging qualified certificate	C	1W				
A- 1.0.a 1.0.a1	锻件进货验证 forging parts purchase test 锻件性能测试及成分 分析 material performance test and component analysis	转盘产品锻件订货技 术要求						
A- 1.0.a2	锻件进货调质硬度检 测报告 forging parts purchase quenching and tempering hardness inspection report	slewing products forging parts purchase technology requirement -ZD201004001						
A- 1.0.a3	锻件进货验证报告 forging parts purchase test report							
A-1.1	滚子 roller	products drawing						
A- 1.1.1	滚子材质证书 roller material certificate	GB/T18254						

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产品类型 PART. or ASS. DESIGNATION : 带内齿交叉滚子型转盘轴承 **cross roller slewing bearing with inner gear**

产品型号 PART. or ASS. REFERENCE : (RW20/573Y)

序号 PARTS	检查或试验内容 INSPECTION OR TEST DESCRIPTION	依据标准或接受要求 STANDARD/SPECIF. with ACCEPTANCE CRITERIA	文件 要求 CERT/ DOC	检验要求 INSPECTION REQUIRED			备注 NOTES
A- 1.1.2	滚子合格证 roller certificate of conformity	GB/T4661					
A- 1.1.a1	滚子进货验证 roller purchase test	GB/T4661					
A- 1.1.a2	滚子热处理金相 roller heattreatment metallographic	JB/T1255					
A- 1.1.a3	滚子磁粉探伤报告 roller magnetic particle testing report	GB/T24606					
A-1.2	密封圈 seal						
A- 1.2.1	密封圈合格证 seal certificate of conformity	products drawing					
A-	密封圈进货验证						

1.2.a1	seal purchase test	products drawing				
A-1.3	隔离块 spacer					
A-1.3.1	隔离块合格证 spacer certificate of conformity	products drawing				
A-1.3.a1	隔离块进货验证 spacer purchase test	products drawing				
A-1.4	润滑油脂 Lubrication grease					
A-1.4.1	润滑油脂合格证 Lubrication grease certificate of conformity	products drawing				
A-1.4.a1	润滑油脂进货验证记录 Lubrication grease purchase test record	products drawing				
A-2.0	车加工 PRE-MACHINING					
A-2.0.1	滚道淬火前机加工 before groove machining and drilling: 工序间尺寸检测 Visual/ dimensional check	drawing	C	2W		
A-2.0.2	验证编号 Identification		C	2H		
A-3.0	滚道感应淬火 HEAT TREATMENT					
A-3.0.1	滚道表面硬度测试 raceway surface hardness test	heat treatment instructions	C	2W		Heat treatment certificate
A-3.0.2	滚道表面渗透探伤 raceway surface penetrant testing					



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			C	2H				
A-4.0	滚道淬火后机加工 MACHINING AFTER HEAT TREATMENT							
A-4.0.1	精车加工尺寸检测 Fine lathe machining dimension inspection	drawings	C	2H				

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A-4.0.2	滚道粗糙度检测 Raceway roughness inspection	图纸 Ra1.25 drawing Ra1.25						
A-4.0.3	齿检测 Gear inspection	图纸 drawing						
A-4.0.3	齿加工合格证 Gear machining certificate of conformity							
A-4.0.4	安装孔精度检测 installing hole precision test	图纸 drawing	C	2H				
A-4.0.5	滚道无损检测 (PT 或 MT) raceway liquid penetrant inspection (PT or MT)	图纸 requirement	C	2H			No defect indication	
A-5.0	成品检验 Assembly and testing							
A5.0.1	成品尺寸及精度检验 Finished products dimension and precision test	图纸 drawing						
A5.0.2	安装密封圈质量检验 Install seal quality inspection	图纸 drawing						
A5.0.3	注油脂 Filled grease	图纸 drawing						
A5.0.4	成品旋转零活性及外 观检验 Finished products rotate flexibility and appearance testing	旋转零活, 无缺陷 Rotate flexibility, no defect						



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A-6.0	最终文件 FINAL DOCUMENTATION Data book with all certificates	提供 supply	C	2H				
A-6.0.1	材料证书 Material certificates							
A-6.0.2	热处理合格证 Heat treatment conformity certificate							
A-6.0.3	超声波探伤证书 Ultrasonic test certificates							
A-6.0.4	成品滚道渗透检测证书 Finished raceway penetrant testing certificate							
A-6.0.5	滚道表面硬度检测报告 Raceway surface hardness test report							
A-6.0.6	滚道表面粗糙度记录 Raceway surface roughness record							
A-6.0.7	成品检测证书 Finished products inspection certificate							
A-6.0.8	探伤人员资格证书 Flaw detection person's qualification certificate							
A-7.0	包装和发货 PACKING AND SHIPMENT -包装与标识 -packing and mark	客户要求 customer requirement		2H				