

# 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**

<b>3</b>					
<b>2</b>					
<b>1</b>					
<b>0</b>	<b>04/20/2010</b>	首次发布 <b>First issue</b>			
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;"><b>产品质量控制计划</b> <b>I.T.P.</b></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 <b>Apply to slewing bearing of engineering machine's slewing structure</b>					
文件中常用符号解释 <b>LEGEND</b> :  说明:文件中的符号的含义与客户要求保持一致 <b>Note : Put the applicable symbols on ITP in accordance with customer requirements</b>			<b>1: 抽样进行检验      Sample inspection</b> <b>2: 100%进行检验      100% inspection</b> <b>C: 提供检测报告      Establishment of certificate</b> <b>R: 需审查项目      Review point</b> <b>W: 到现场验证项目      Witness point</b> <b>H:</b> <b>Hold point. Shall not proceed without witness from cust. or its representative</b> <b>N: 运输过程中注意 Release note for shipping</b> <b>TPI: 第三方检验 Third Party Inspection</b> <b>IP: 进行中 In Process</b>		
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.

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
<b>A-1.0</b>	<b>原材料 RAW MATERIAL</b>							
<b>A-1.0.1</b>	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						

**MetalMiracle®**

**产品质量控制计划  
I.T.P.**

编号 Ref.

页码 Page  
4 / 7

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Rev. 0

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**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)

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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				
<b>A-2.0</b>	<b>车加工</b> <b>PRE-MACHINING</b>					
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		
<b>A-3.0</b>	<b>滚道感应淬火</b> <b>HEAT TREATMENT</b>					
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				
<b>A-4.0</b>	<b>滚道淬火后机加工</b> <b>MACHINING AFTER</b> <b>HEAT TREATMENT</b>							
A-4.0.1	精车加工尺寸检测 Fine lathe machining dimension inspection	drawings	C	2H				

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<b>A-4.0.2</b>	滚道粗糙度检测 Raceway roughness inspection	图纸 <b>Ra1.25</b> drawing Ra1.25						
<b>A-4.0.3</b>	齿检测 Gear inspection	图纸 drawing						
<b>A-4.0.3</b>	齿加工合格证 Gear machining certificate of conformity							
<b>A-4.0.4</b>	安装孔精度检测 installing hole precision test	图纸 drawing	<b>C</b>	<b>2H</b>				
<b>A-4.0.5</b>	滚道无损检测 ( <b>PT</b> 或 <b>MT</b> ) raceway liquid penetrant inspection (PT or MT)	<b>requirement</b>	<b>C</b>	<b>2H</b>				<b>No defect indication</b>
<b>A-5.0</b>	成品检验 Assembly and testing							
<b>A5.0.1</b>	成品尺寸及精度检验 Finished products dimension and precision test	图纸 drawing						
<b>A5.0.2</b>	安装密封圈质量检验 Install seal quality inspection	图纸 drawing						
<b>A5.0.3</b>	注油脂 Filled grease	图纸 drawing						
<b>A5.0.4</b>	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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<b>A-6.0</b>	<u>最终文件 FINAL DOCUMENTATION</u> Data book with all certificates	提供 supply	C	2H				
<b>A-6.0.1</b>	材料证书 Material certificates							
<b>A-6.0.2</b>	热处理合格证 Heat treatment conformity certificate							
<b>A-6.0.3</b>	超声波探伤证书 Ultrasonic test certificates							
<b>A-6.0.4</b>	成品滚道渗透检测证书 Finished raceway penetrant testing certificate							
<b>A-6.0.5</b>	滚道表面硬度检测报告 Raceway surface hardness test report							
<b>A-6.0.6</b>	滚道表面粗糙度记录 Raceway surface roughness record							
<b>A-6.0.7</b>	成品检测证书 Finished products inspection certificate							
<b>A-6.0.8</b>	探伤人员资格证书 Flaw detection person's qualification certificate							
<b>A-7.0</b>	<u>包装和发货 PACKING AND SHIPMENT</u> -包装与标识 -packing and mark	客户要求 customer requirement		2H				