WERKZEUGBAU CHINA

GROSSWERKZEUGE

GROSSWERKZEUGE

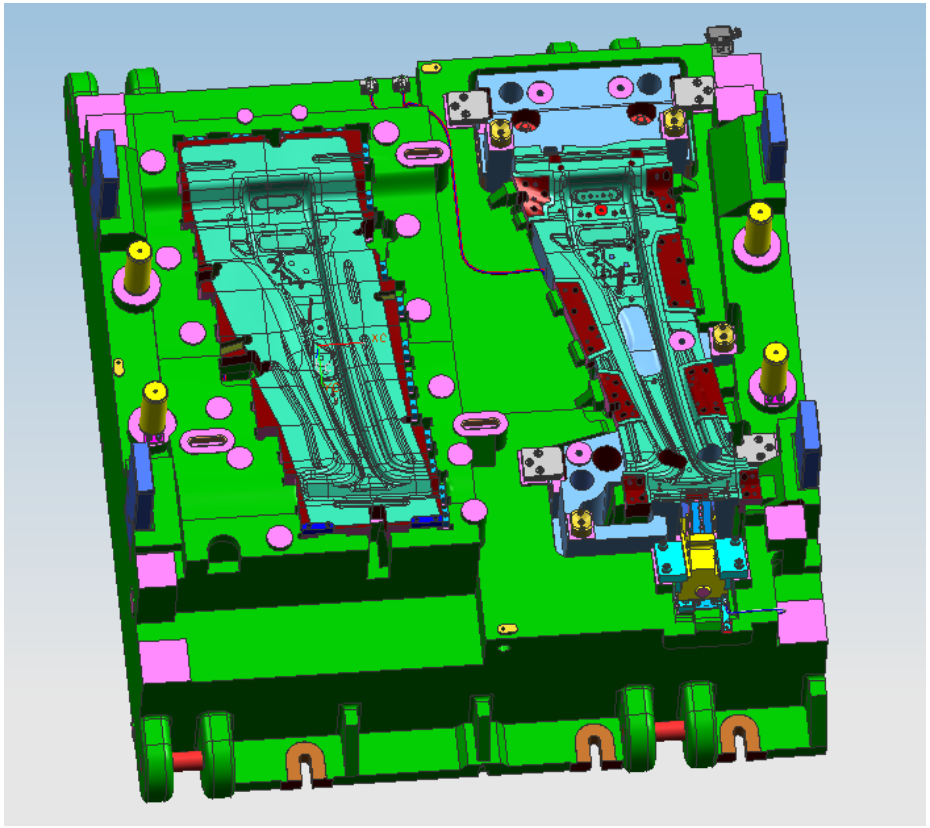
Beispiel 1: B- Säule

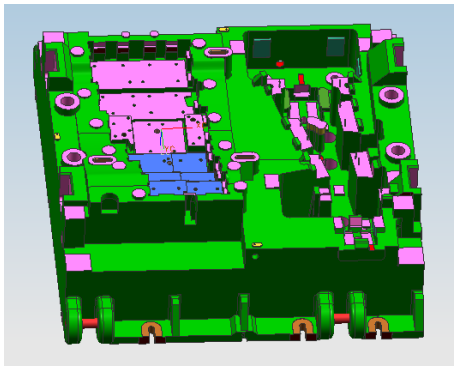
Methode:

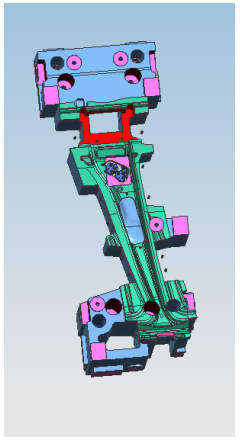
OP 10	ziehen (Werkzeugmaße 2.130 X 2.560 X 1.200mm)
OP 20	beschneiden und lochen (OP10 und OP 20 haben gemeinsames Gussgestell)
OP 30	kalibrieren
OP 40	lochen und beschneiden, teilweise mit Schieber

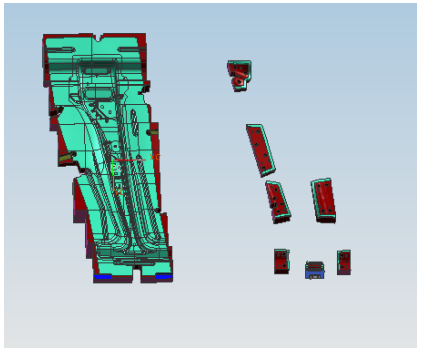
Oberteil

OP10: Ziehen & OP20
Beschneiden und Lochen



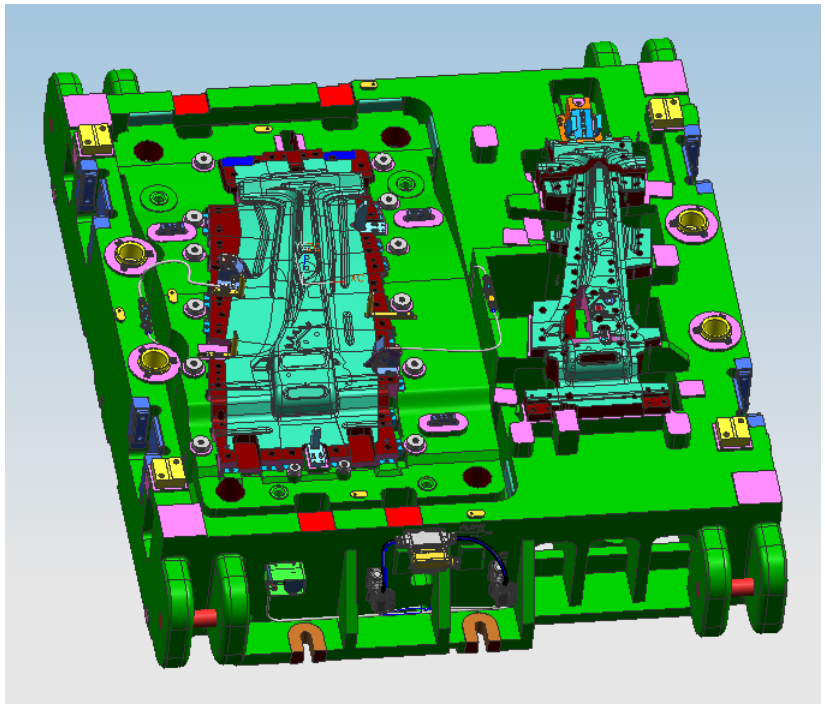


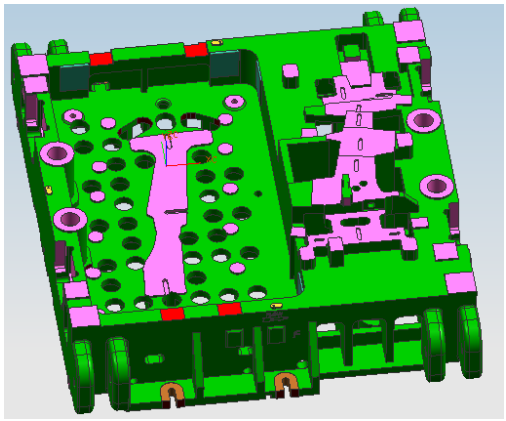


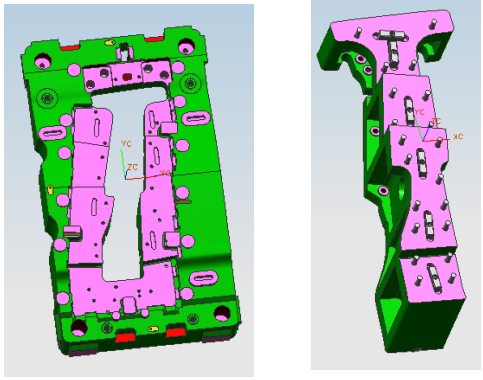


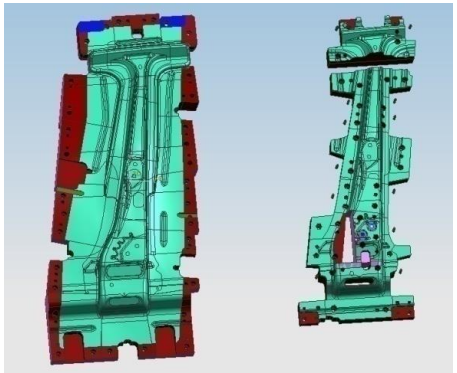
Unterteil

OP10: Ziehen & OP20
Beschneiden und Lochen



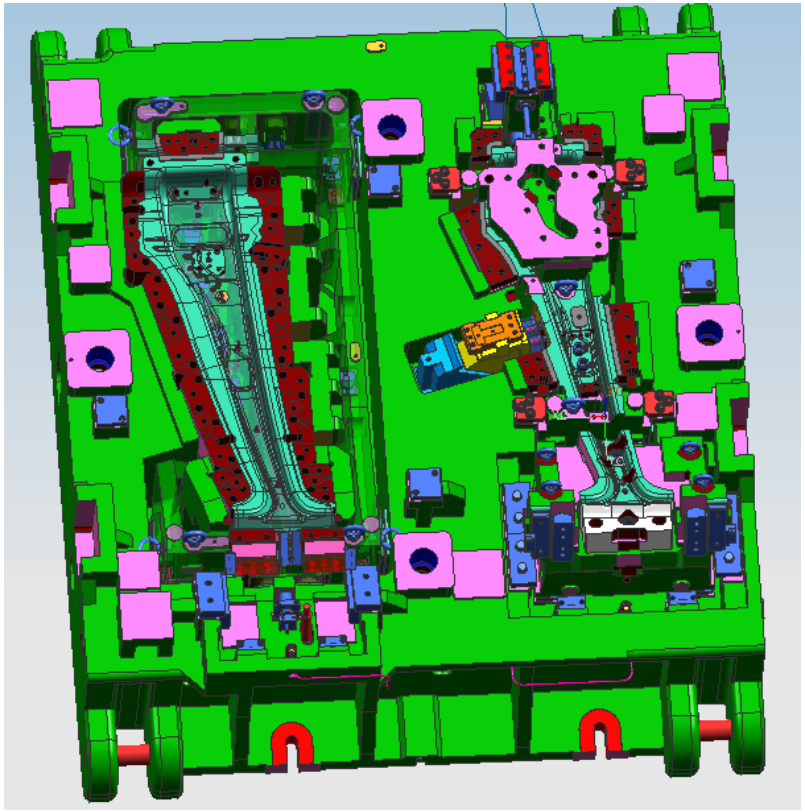


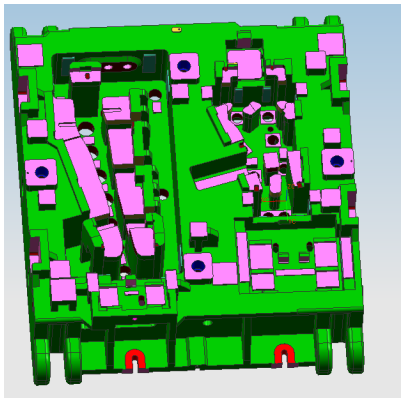


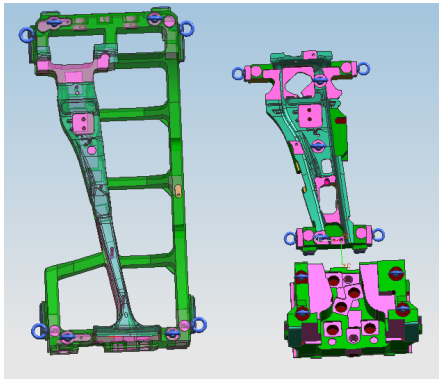


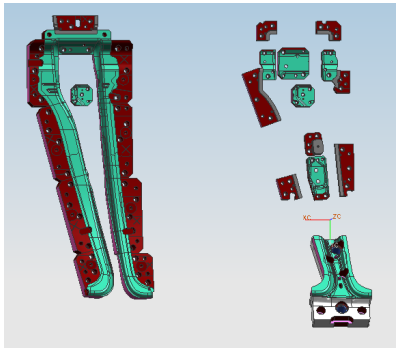
Oberteil

OP30: Kalibrieren; OP40 Lochen
und teilweise Beschneiden mit Schieber



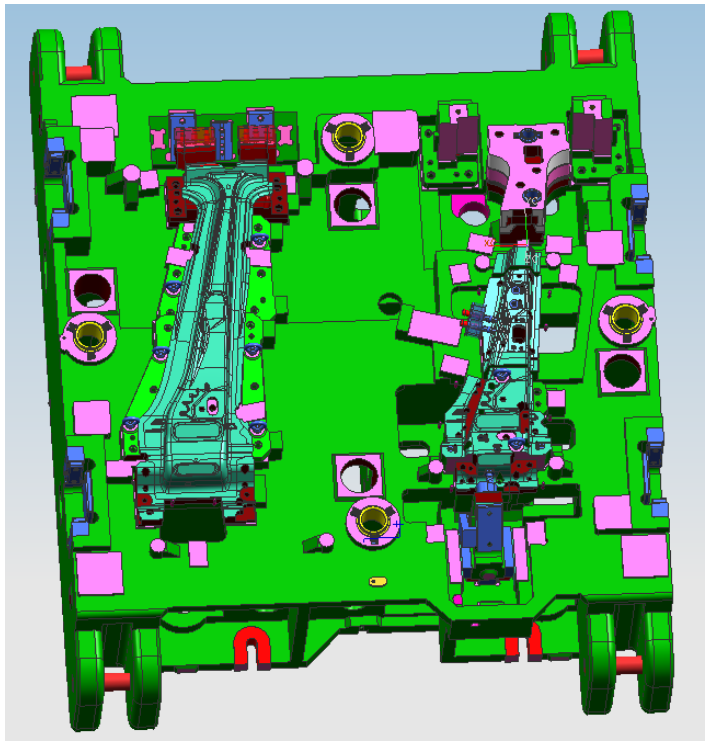


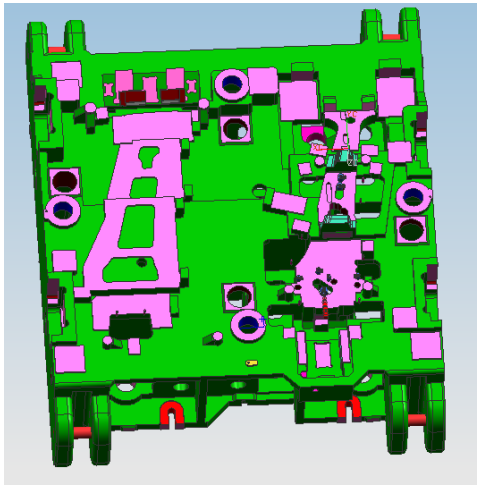


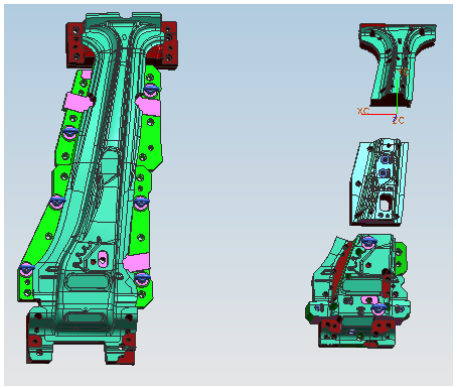


Unterteil

OP30: Kalibrieren und OP40 Lochen und Beschneiden teilweise mit Schieber







GROSSWERKZEUGE

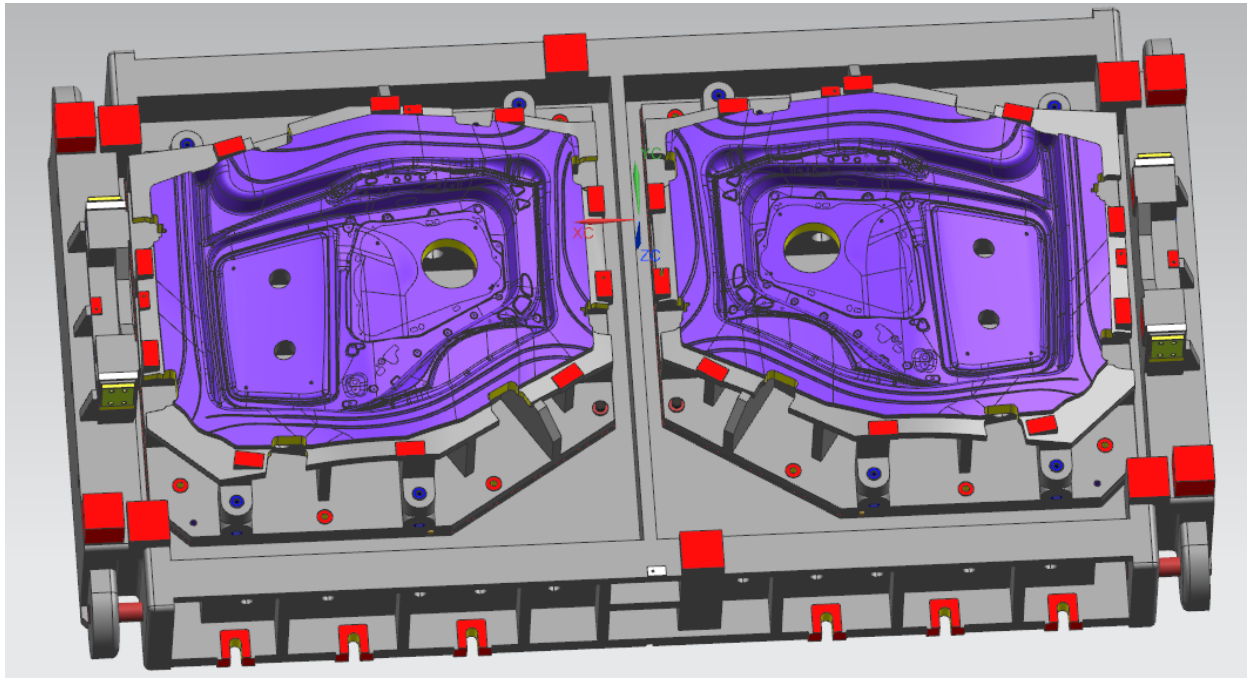
Beispiel 2: Hintertür- Innenblech

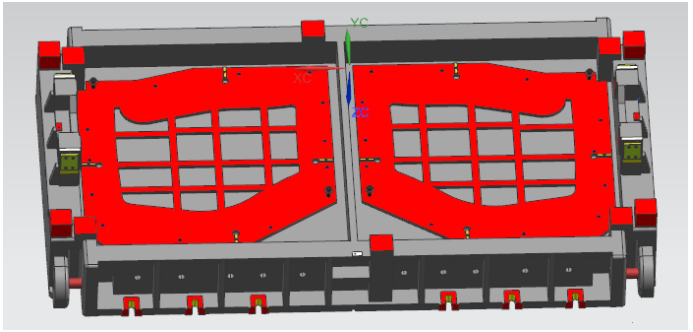
Methode:

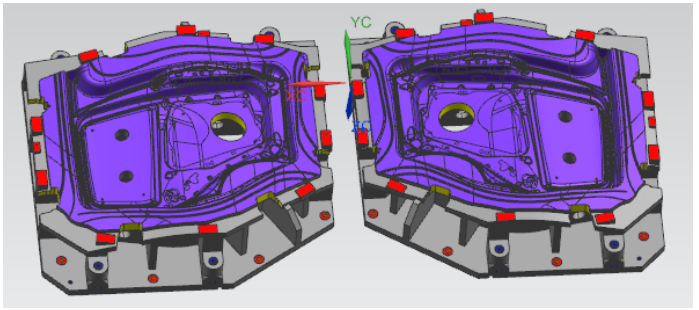
OP 10	ziehen (Werkzeugmaße 4.480 X 2.400 X 1.250mm)
OP 20	beschneiden und lochen
OP 30	lochen und beschneiden, teilweise mit Schieber
OP 40	abkanten und kalibrieren
OP 50	lochen und beschneiden

Oberteil

OP10: Ziehen

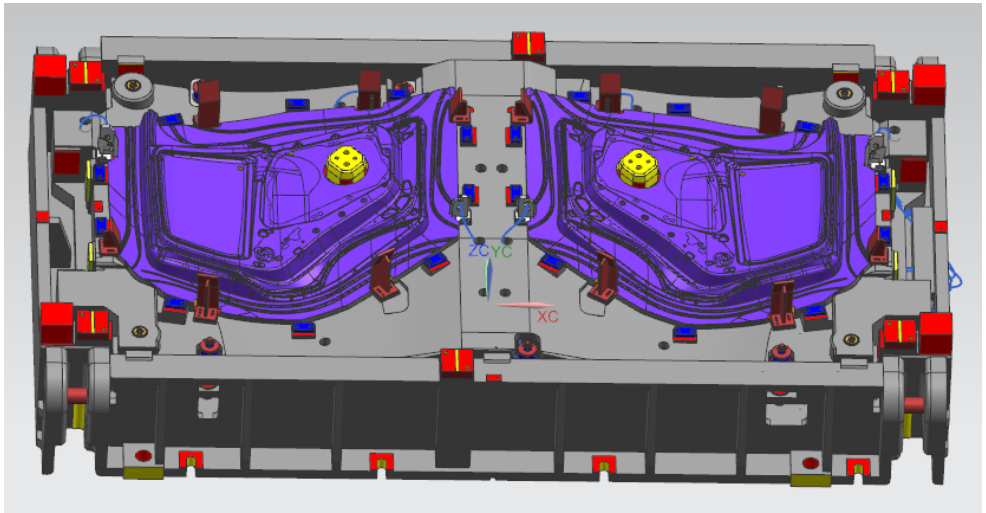


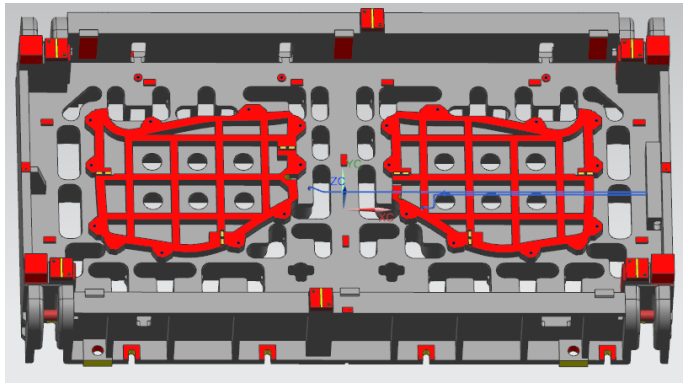


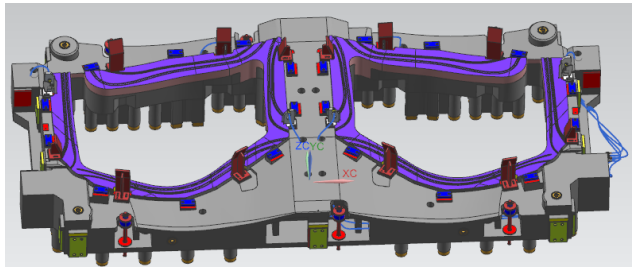


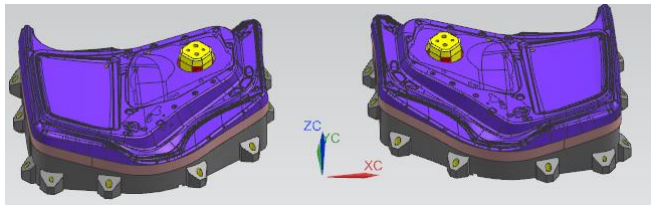
Unterteil

OP10: Ziehen



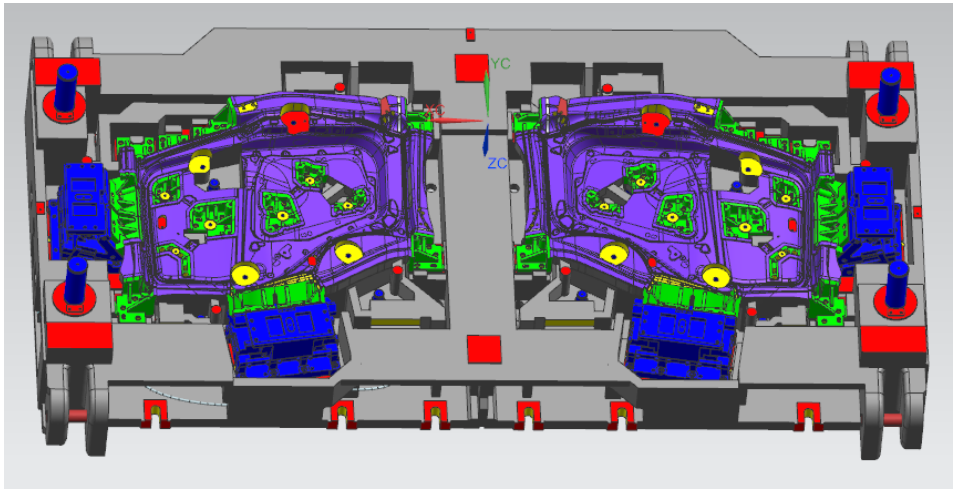


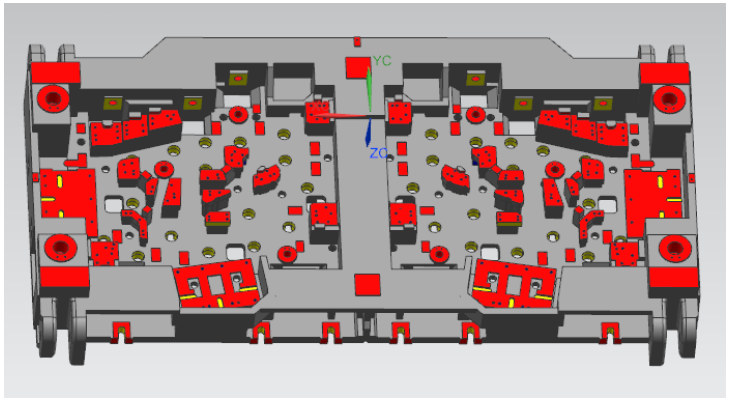


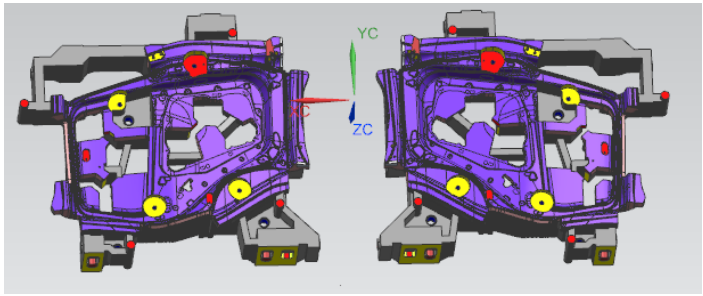


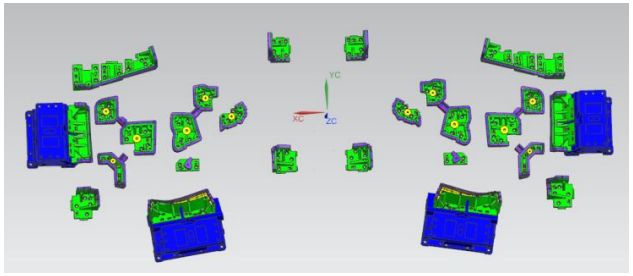
Oberteil

OP20: Beschneiden und Lochen



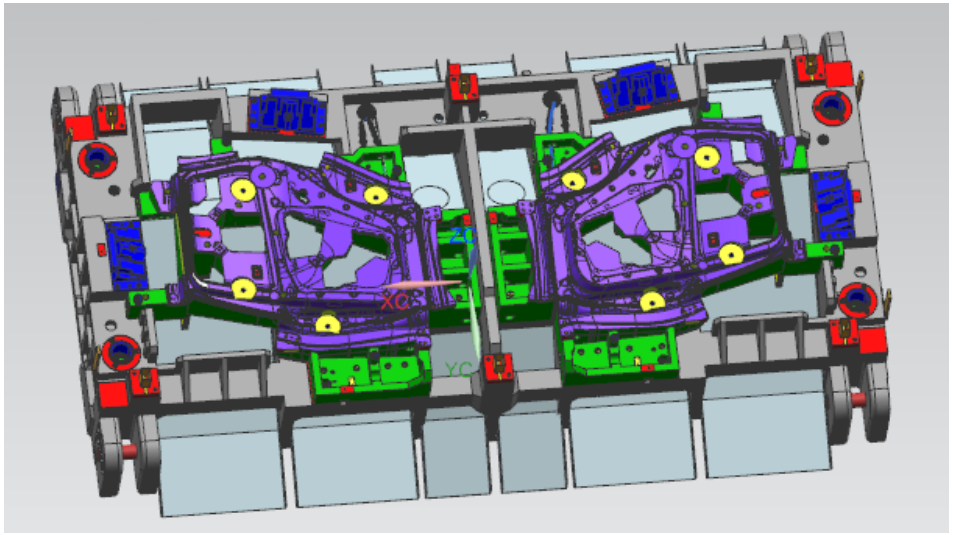


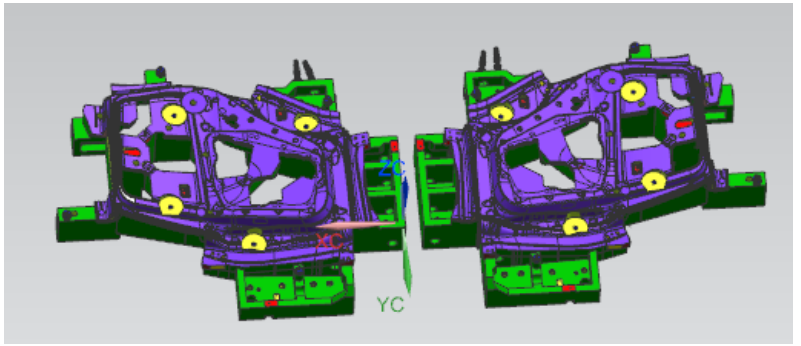




Unterteil

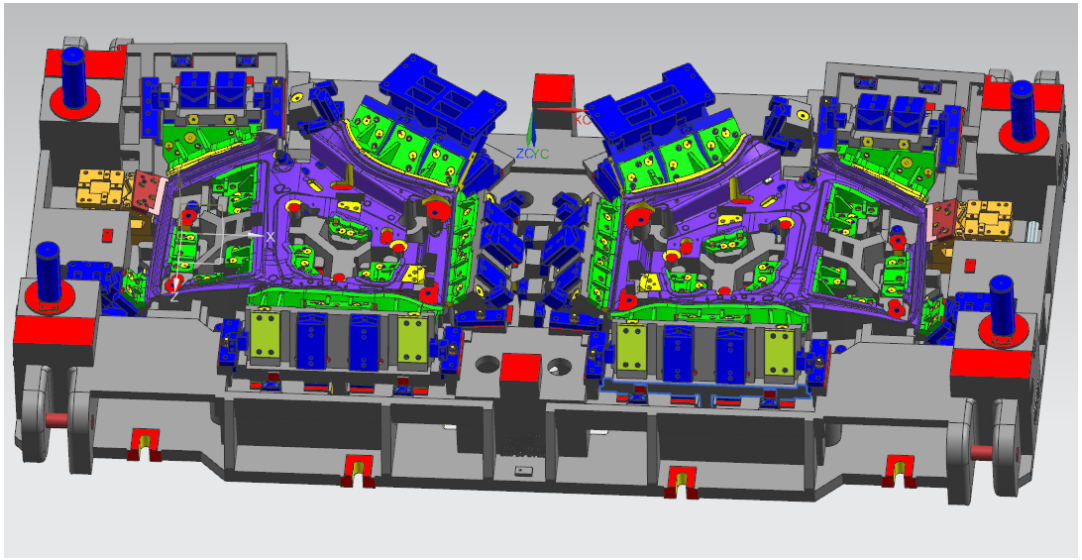
OP20: Beschneiden und Lochen

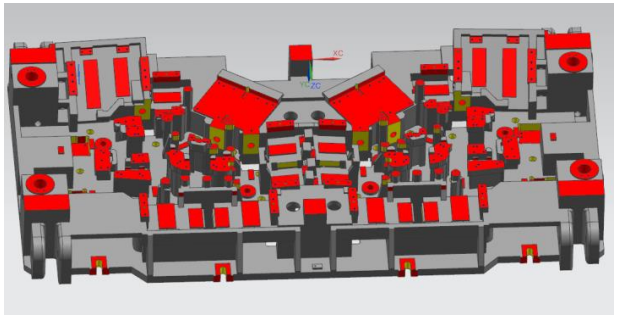


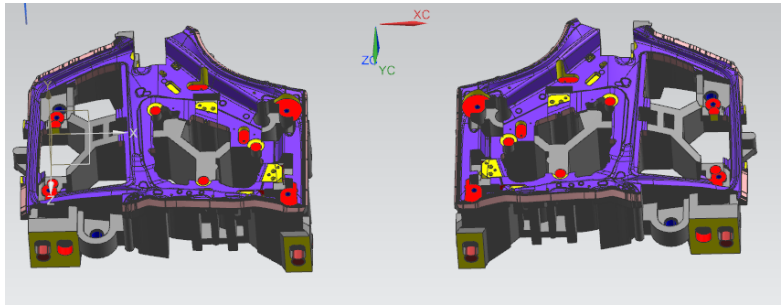


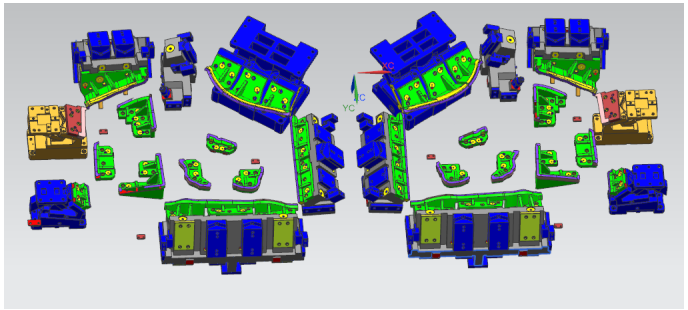
Oberteil

OP30: Lochen und Beschneiden,
teilweise mit Schieber



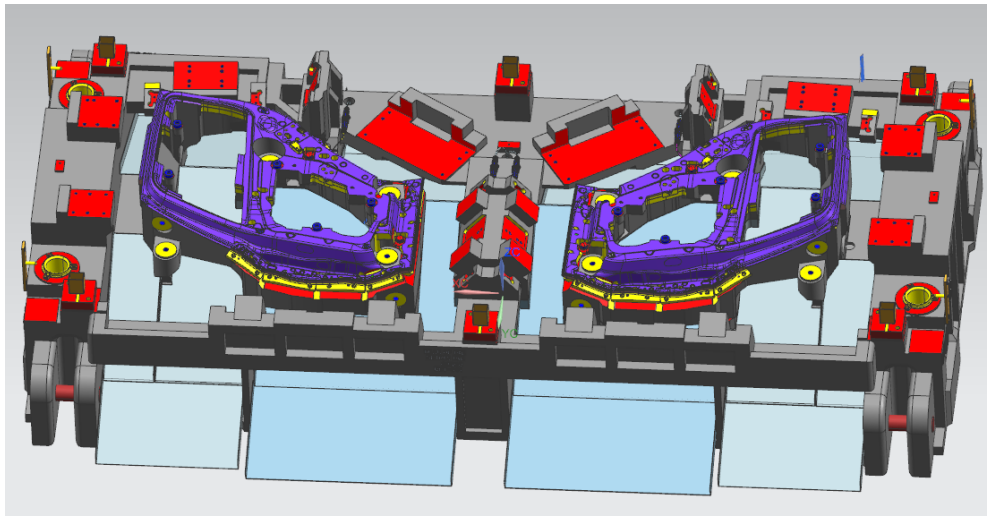


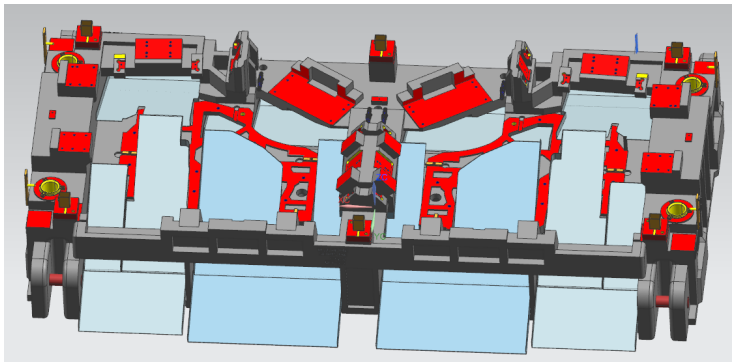


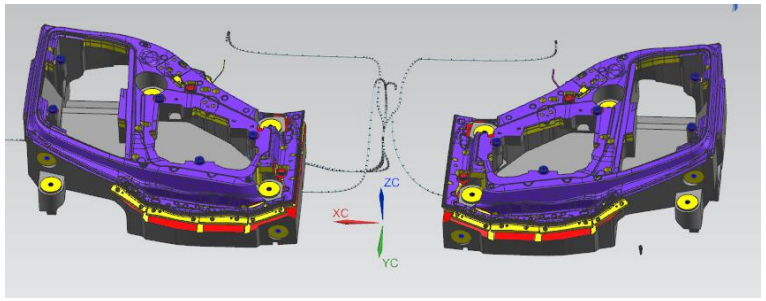


Unterteil

OP30: Lochen und Beschneiden,
teilweiser mit Schieber

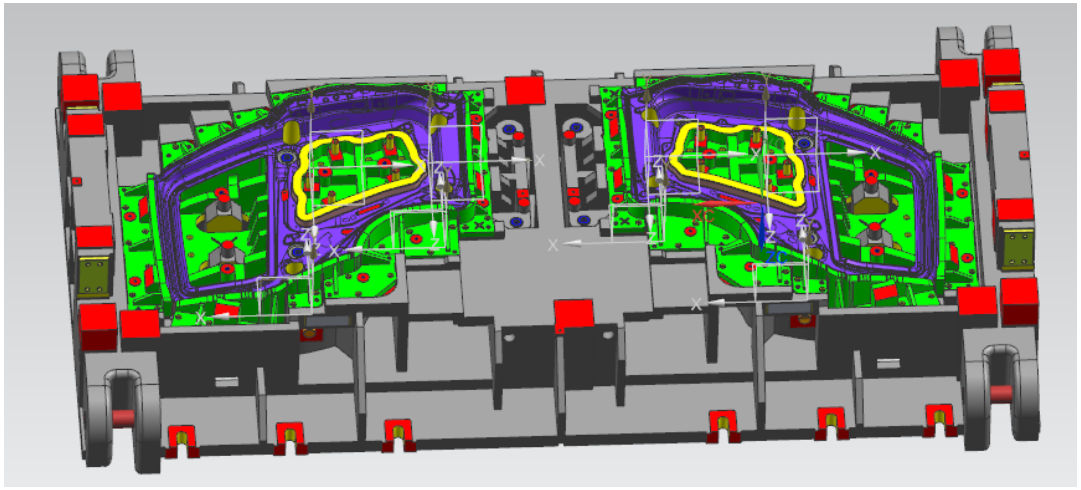


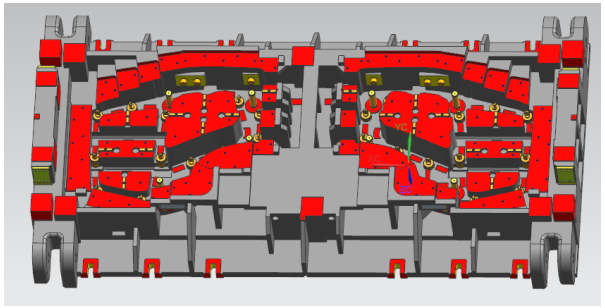


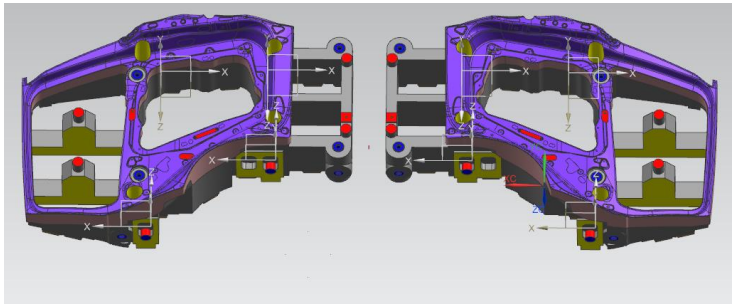


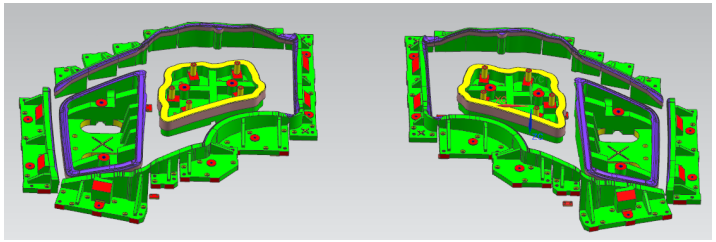
Oberteil

OP40: Abkanten und Kalibrieren



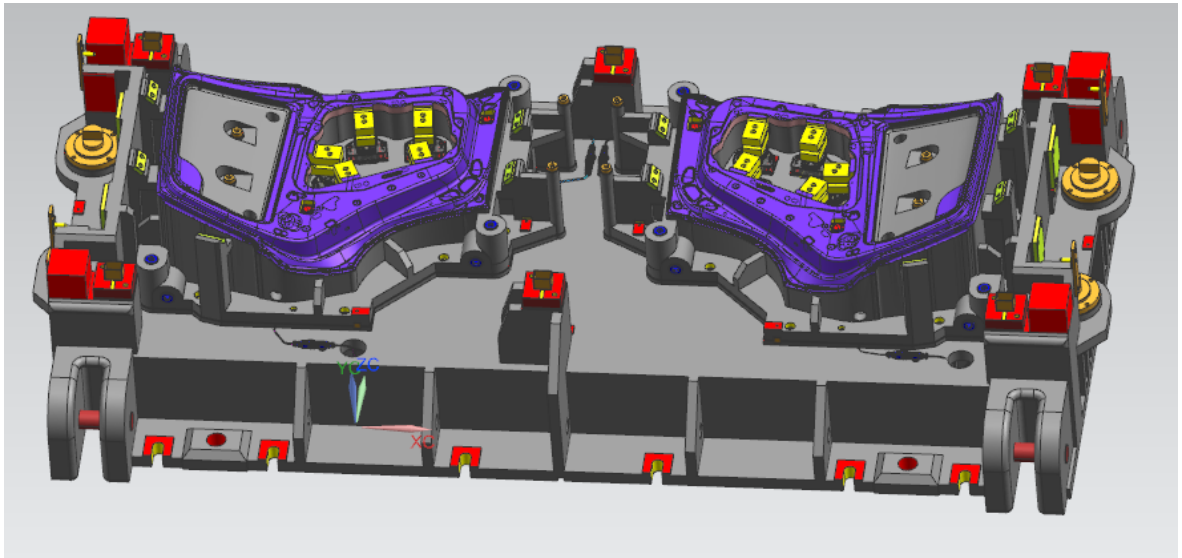


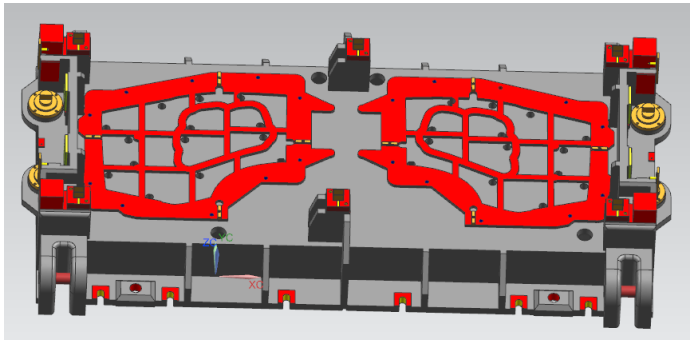


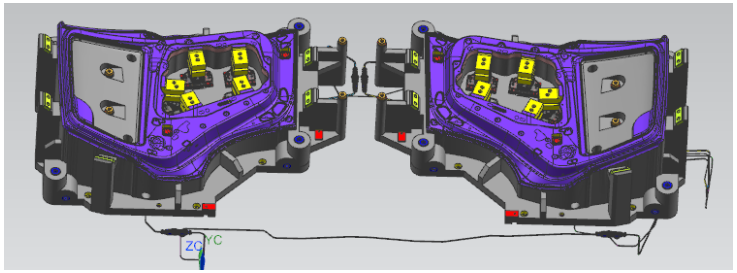


Unterteil

OP40: Abkanten und Kalibrieren

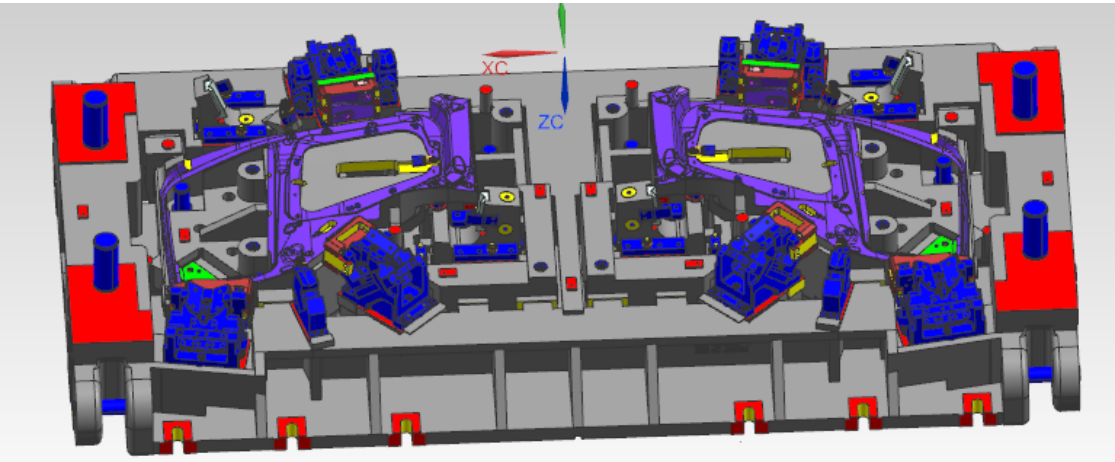


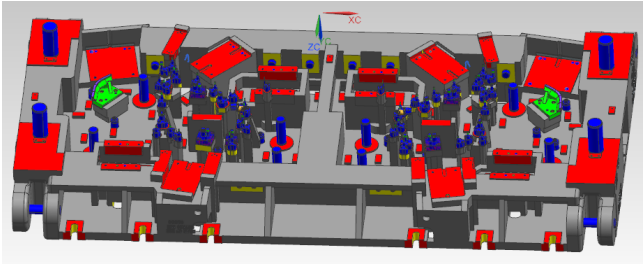


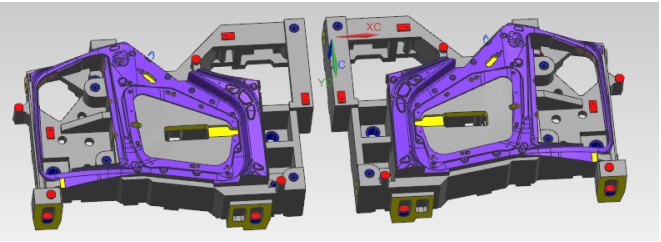


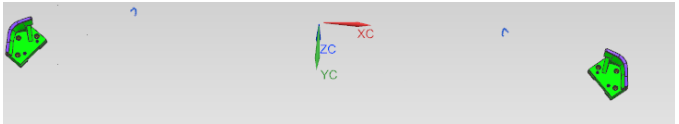
Oberteil

OP50: Lochen und Beschneiden



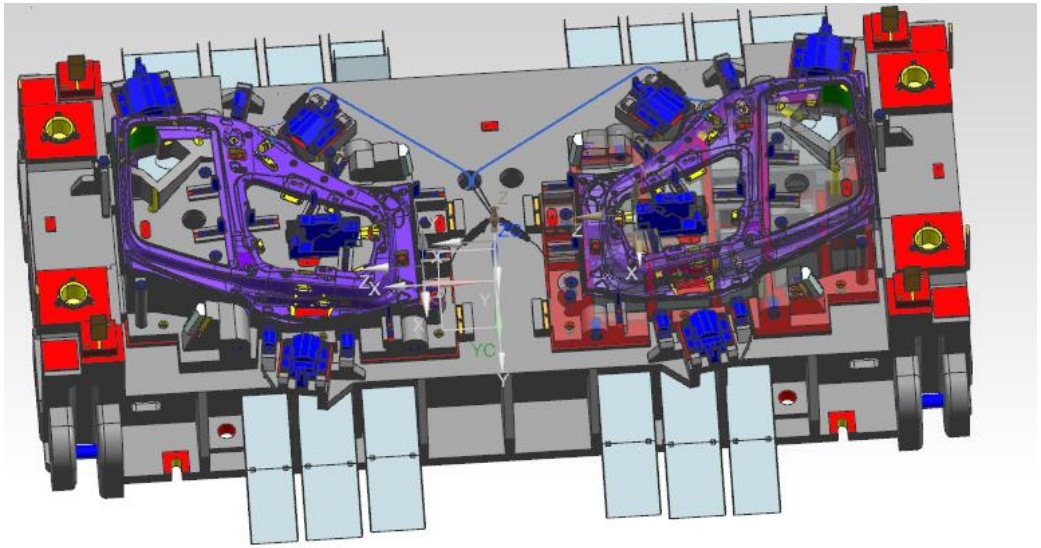


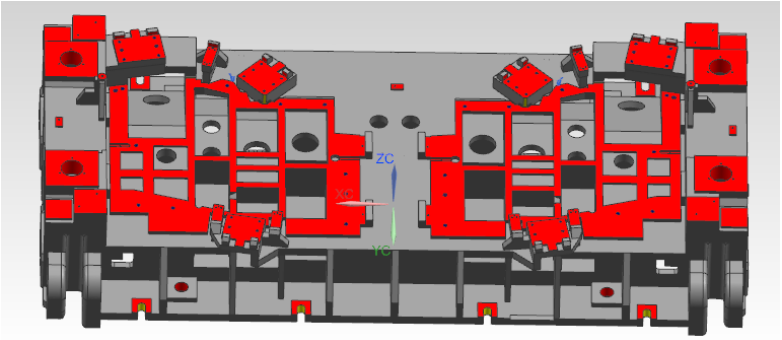


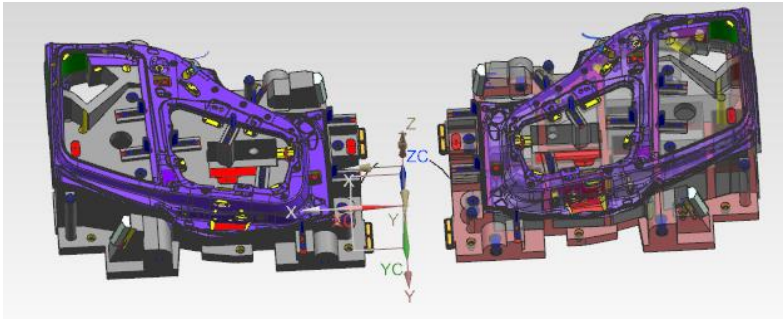


Unterteil

OP50: Lochen und Beschneiden







GROSSWERKZEUGE

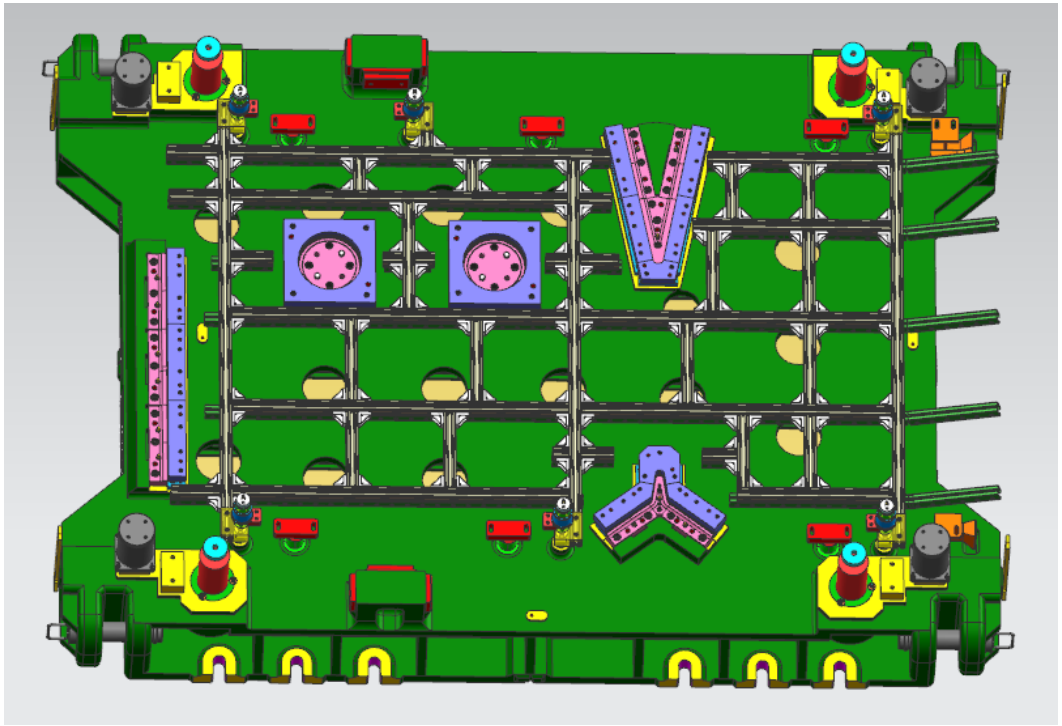
Beispiel 3: Kofferraumtür- Innenblech

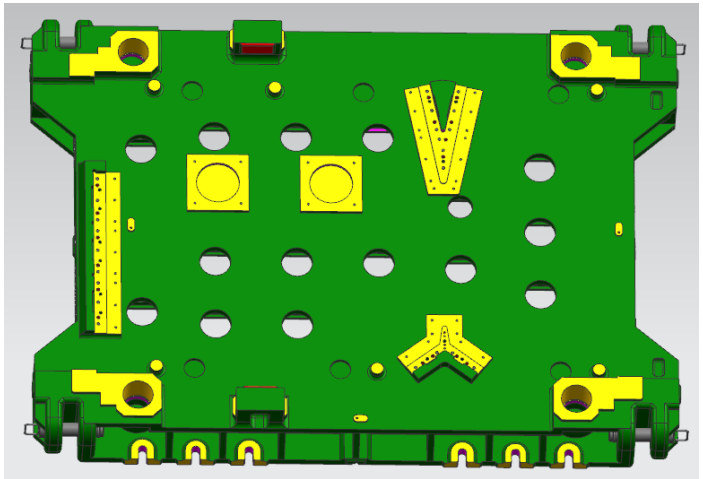
Methode:

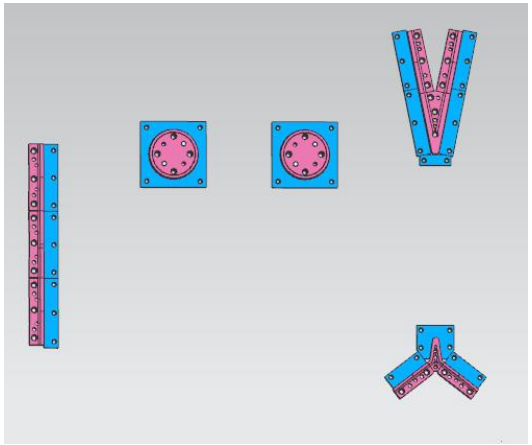
OP 05	Platine schneiden
OP 10	ziehen (Werkzeugmaße: 2.600 x 2.550 x 1.250)
OP 20	lochen und beschneiden, teilweise mit Schieber
OP 30	lochen und beschneiden
OP 40	hochstellen und kalibrieren
OP 50	lochen und beschneiden mit Schieber

Oberteil

OP05: Platine schneiden

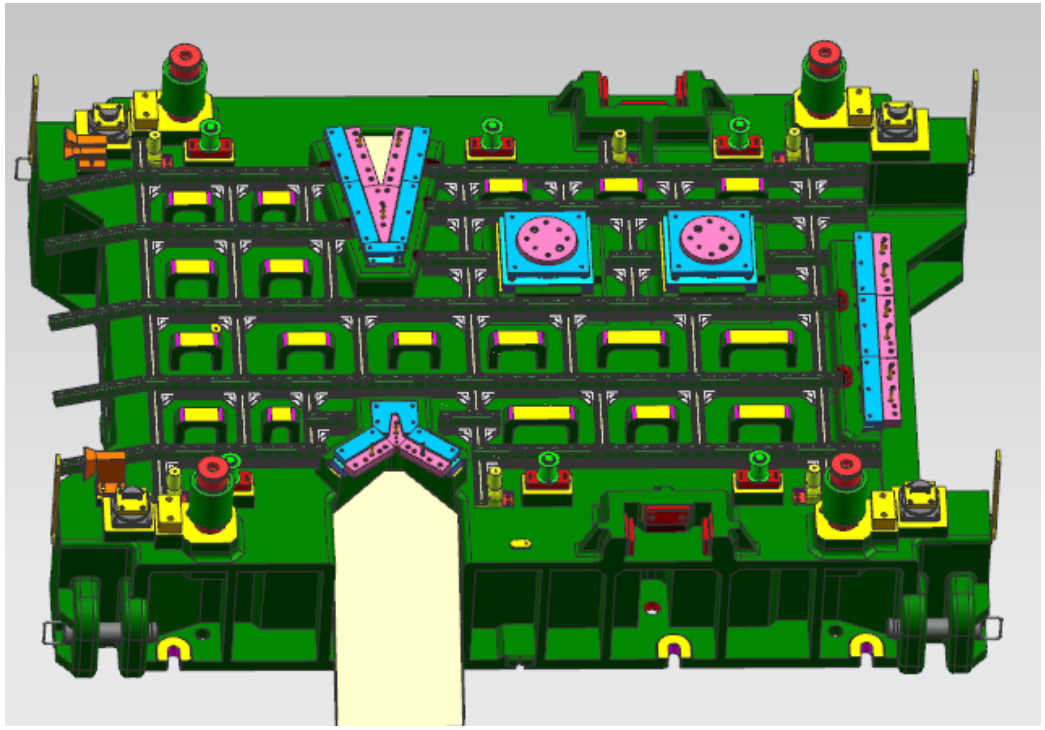


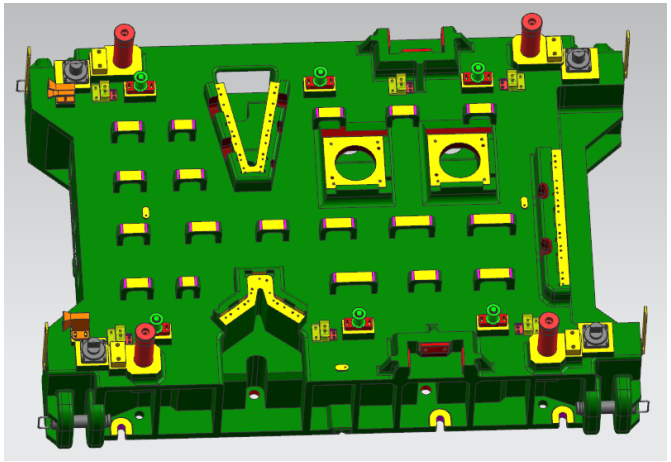


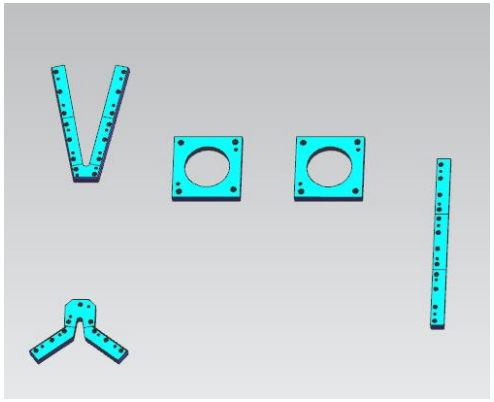


Unterteil

OP05: Platine schneiden

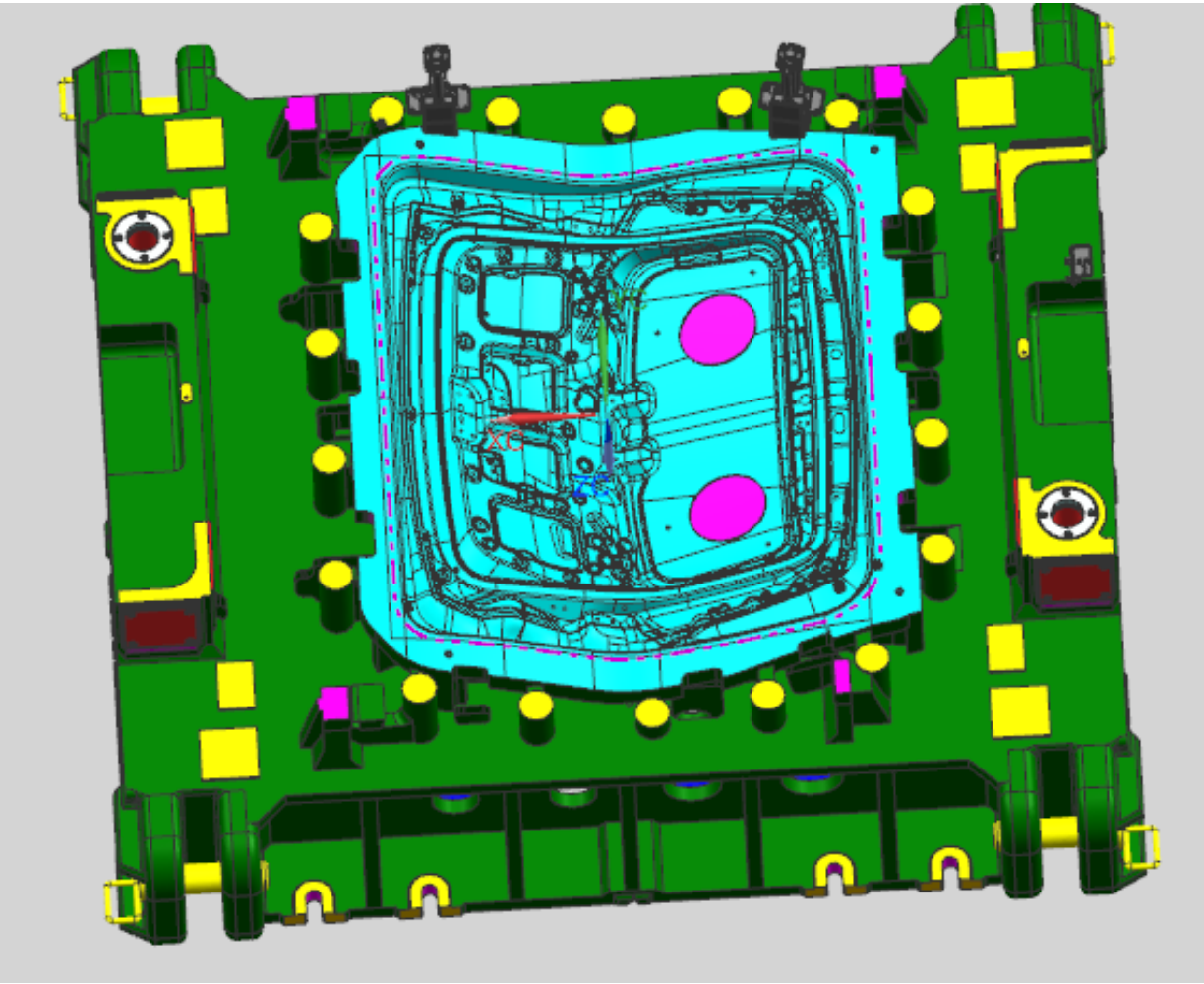






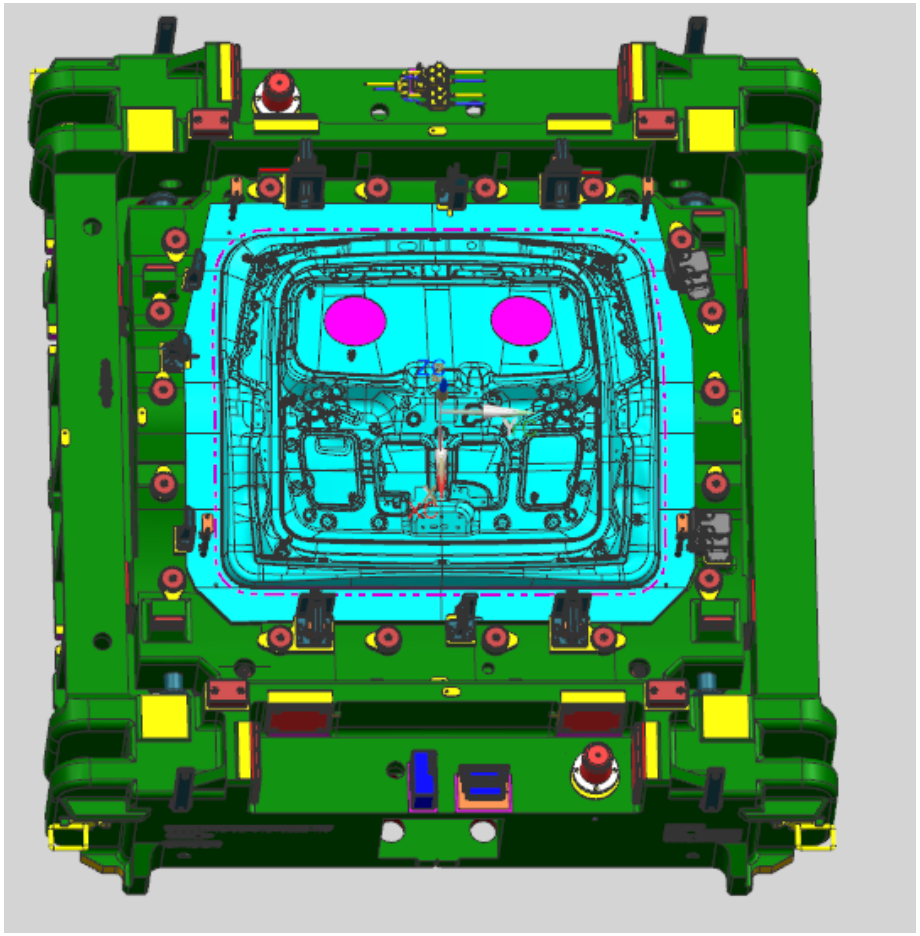
Oberteil

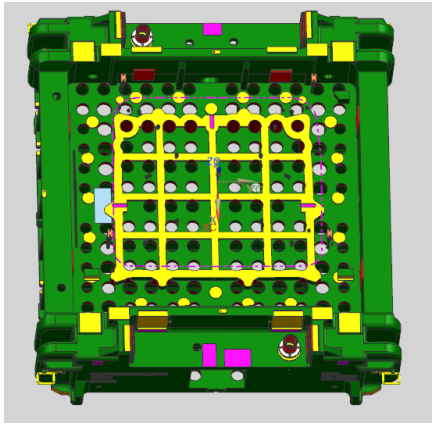
OP10: Ziehen

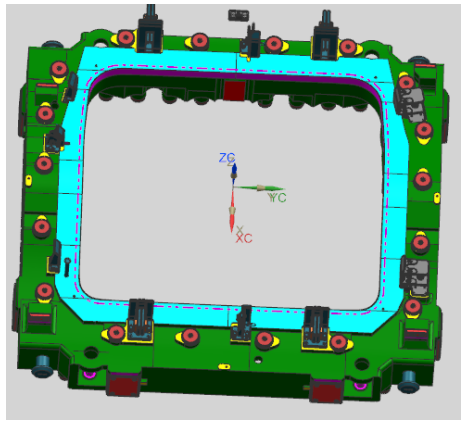


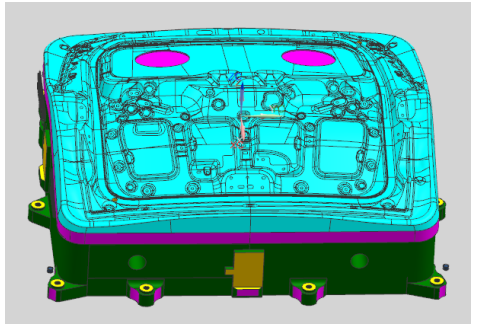
Unterteil

OP10: Ziehen



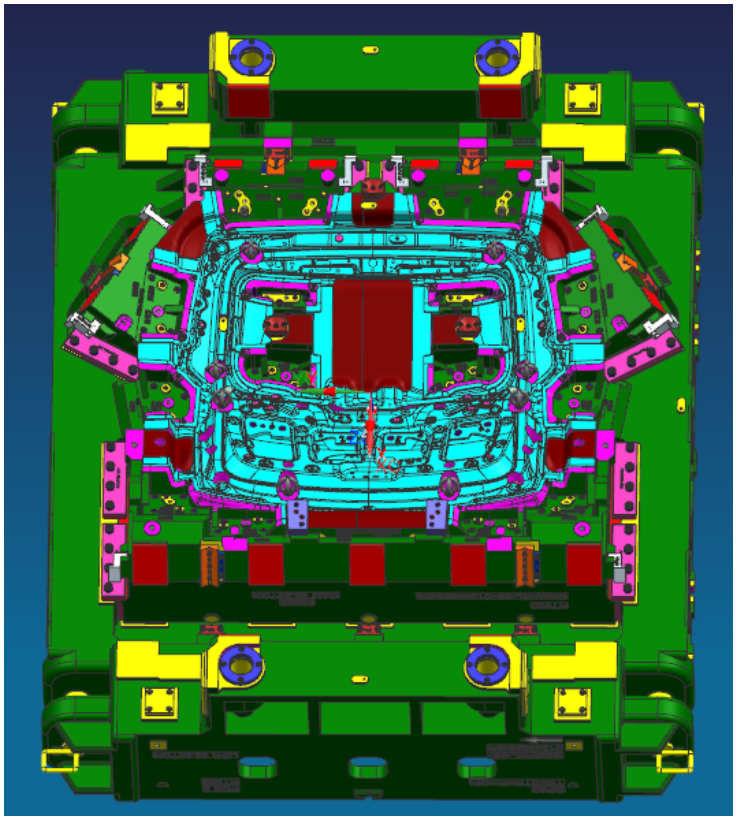


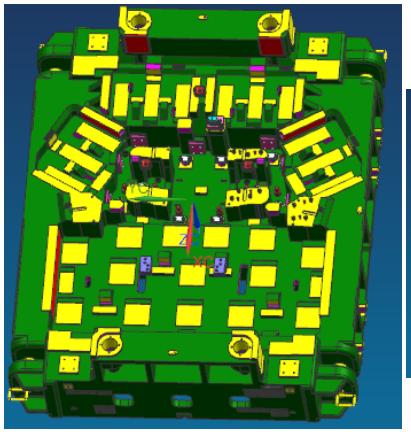


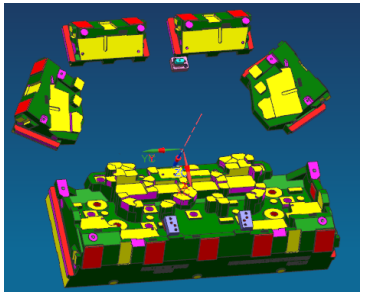


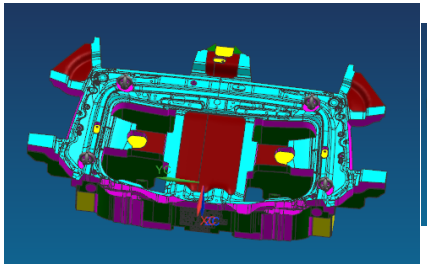
Oberteil

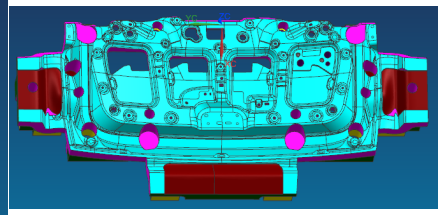
OP20: Beschneiden und Lochen,
teilweiser mit Schieber





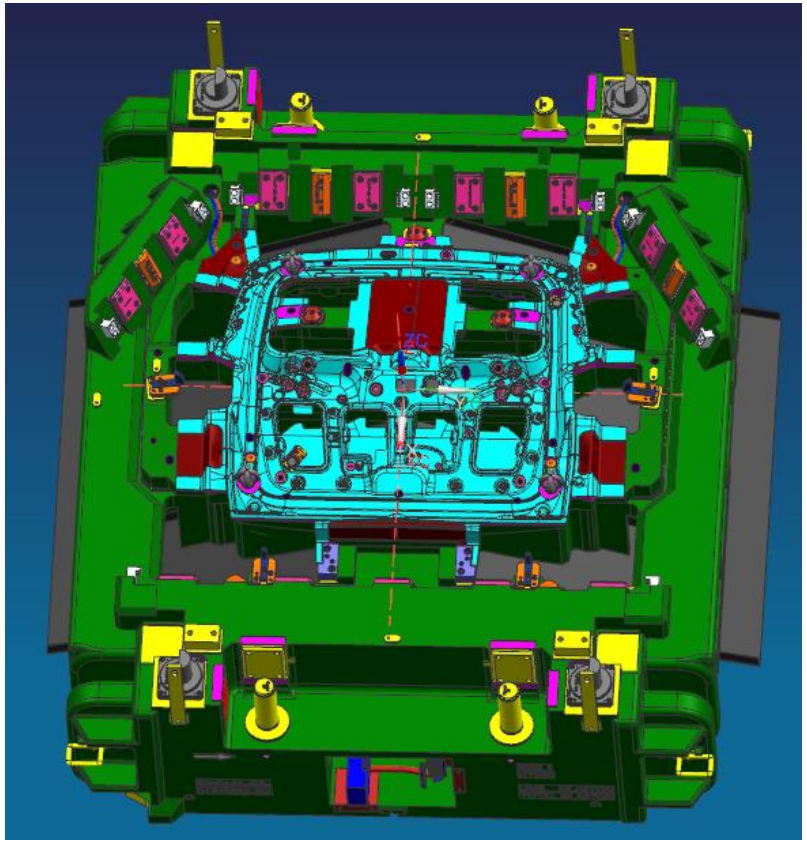


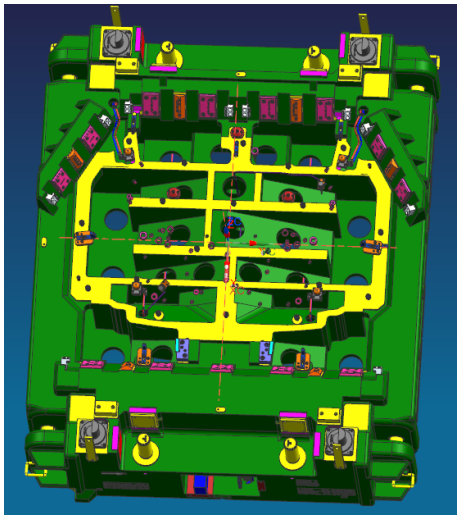


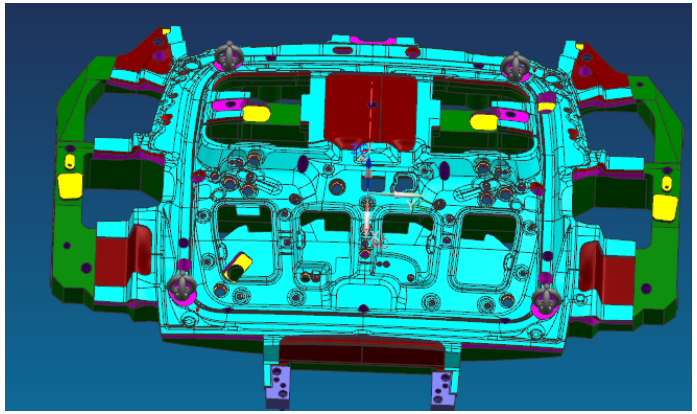


Unterteil

OP20: Beschneiden und Lochen, teilweiser mit Schieber UT

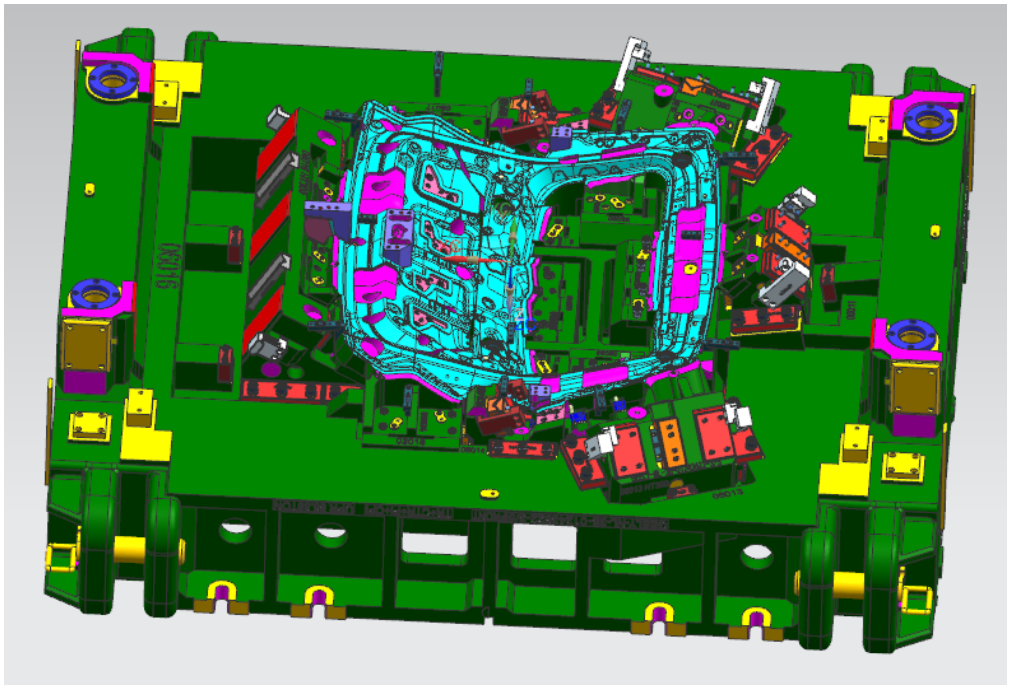


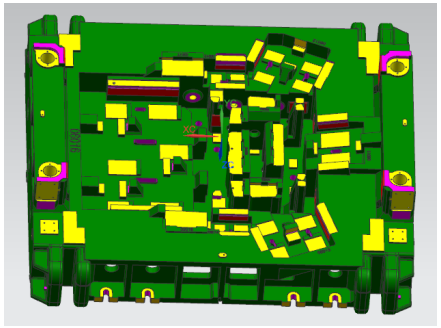


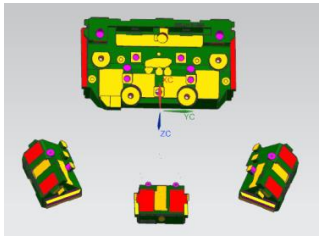


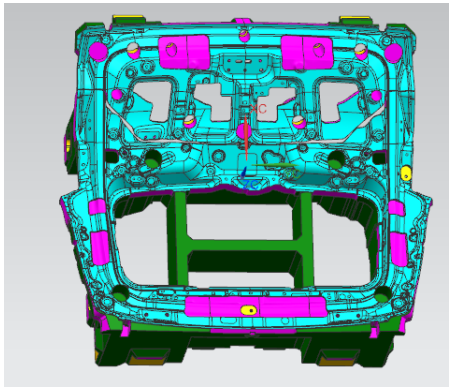
Oberteil

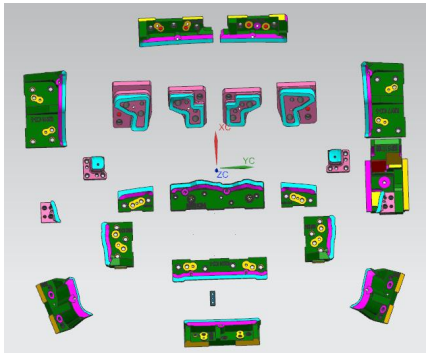
OP30: Beschneiden und Lochen
mit Schieber





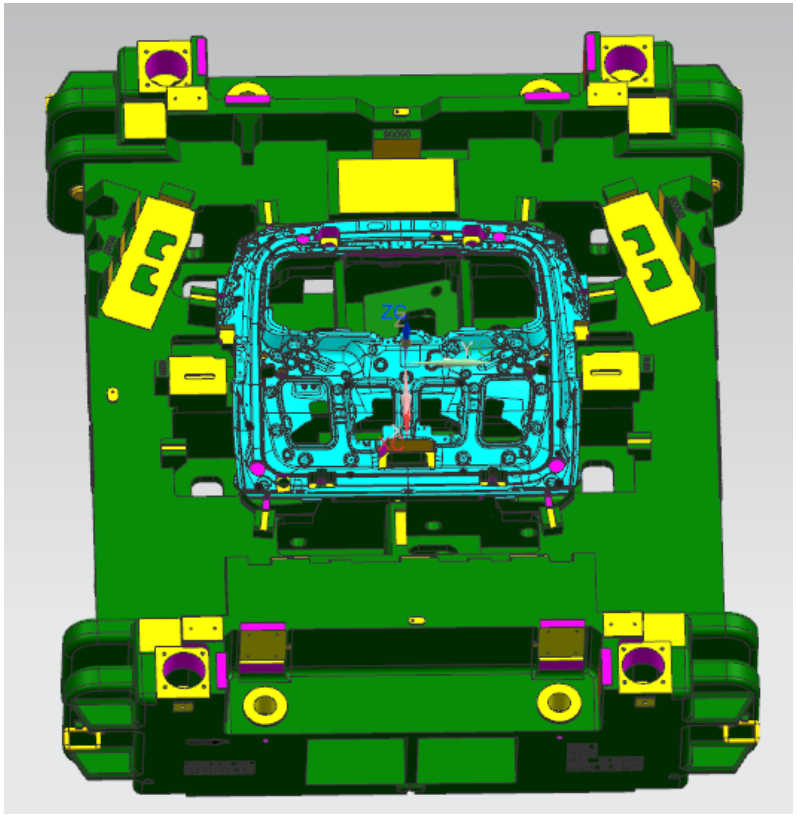


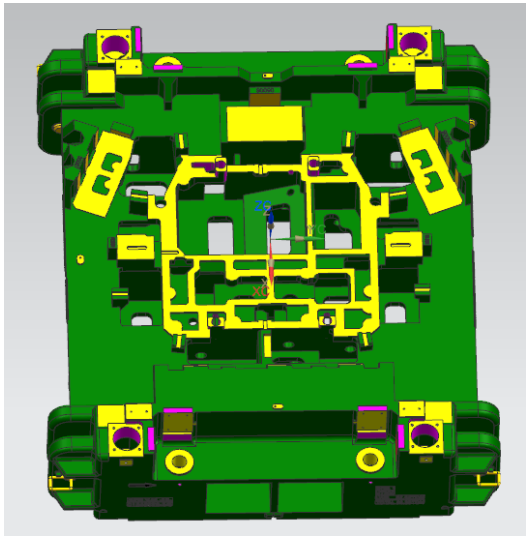


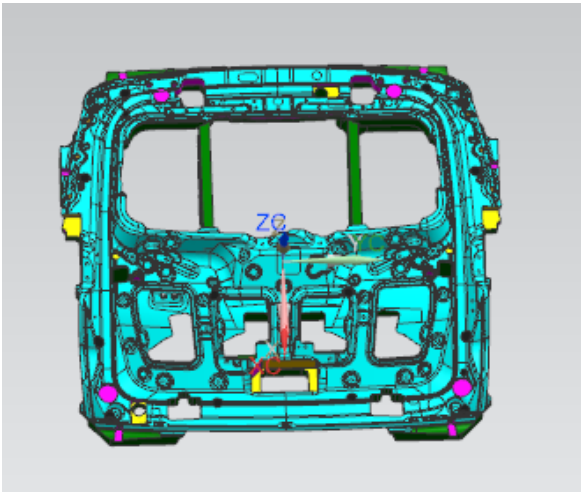


Unterteil

OP30: Beschneiden und Lochen
mit Schieber

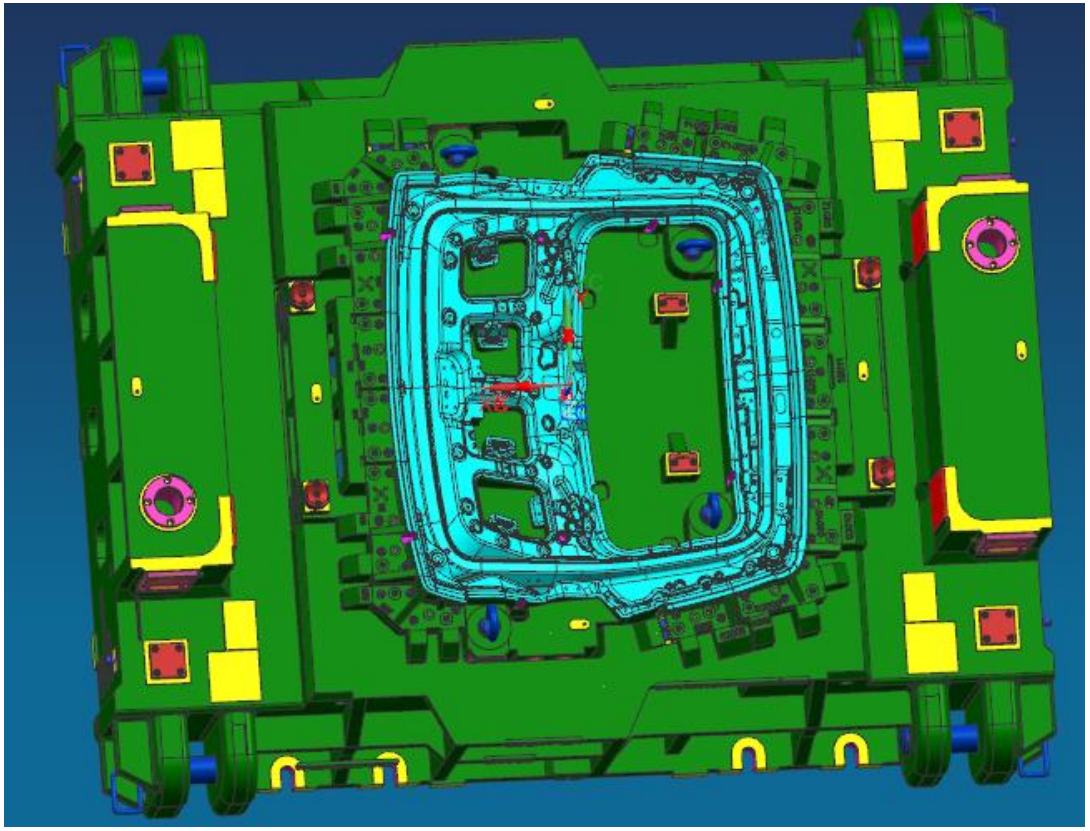


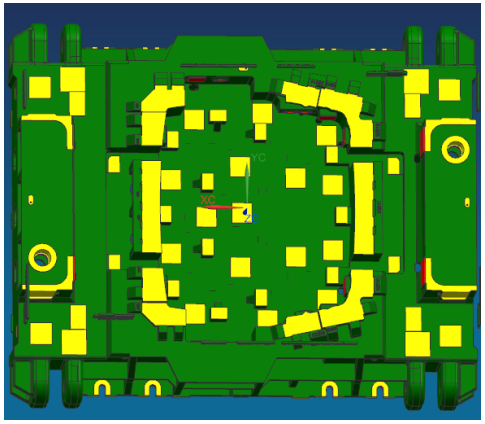


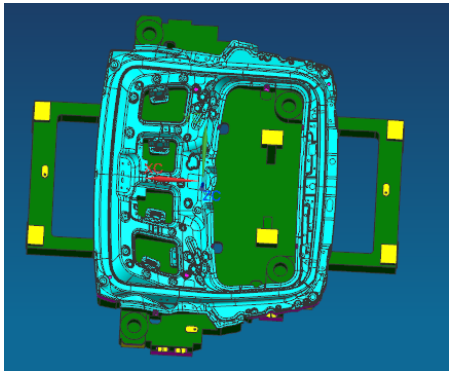


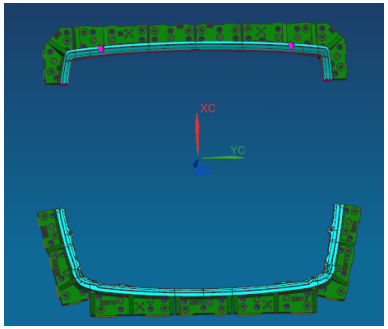
Oberteil

OP40: Hochstellen und Kalibrieren



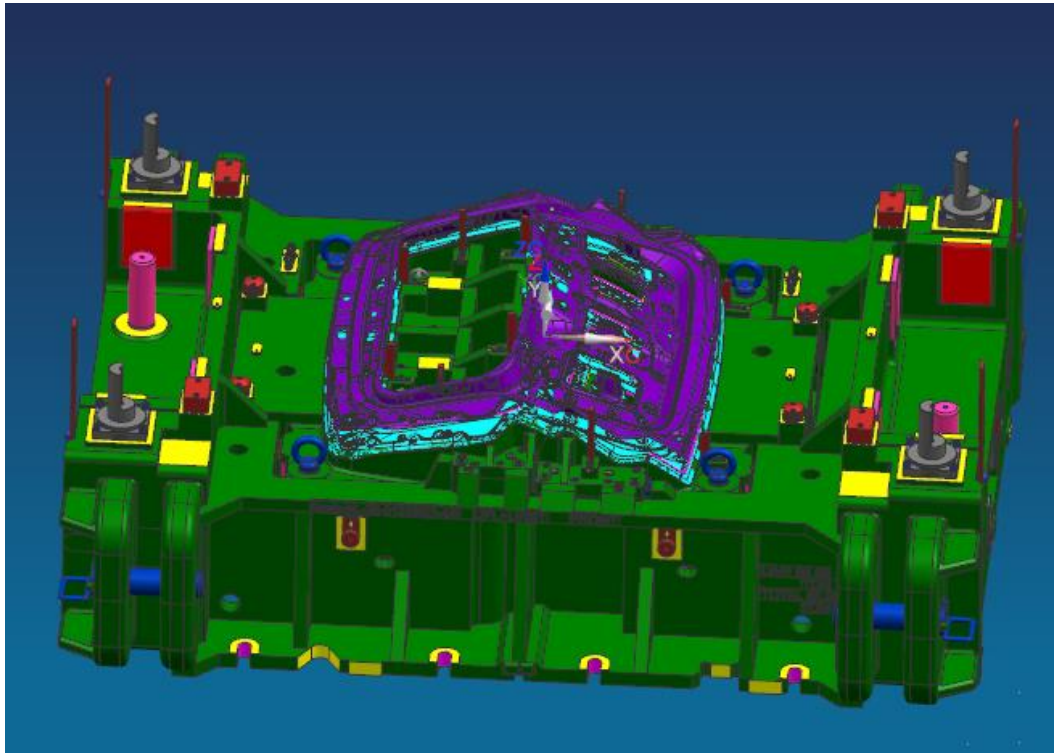


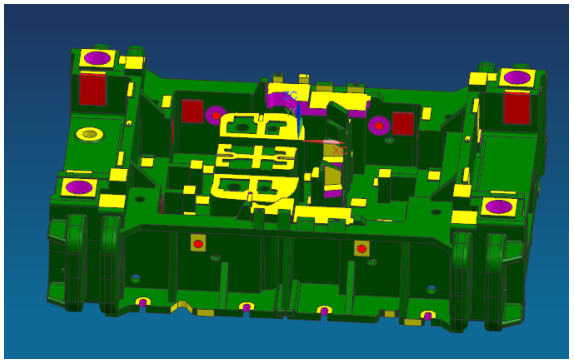


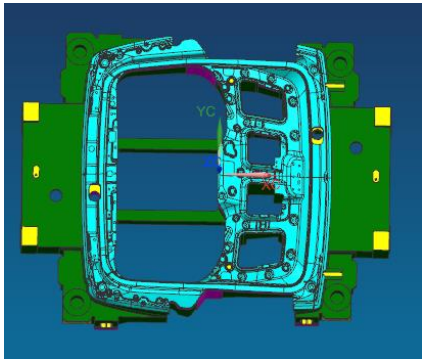


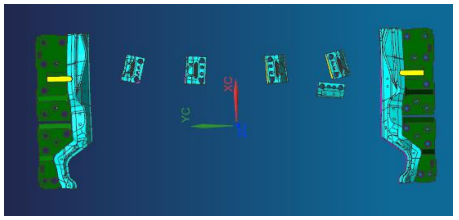
Unterteil

OP40: Hochstellen und Kalibrieren



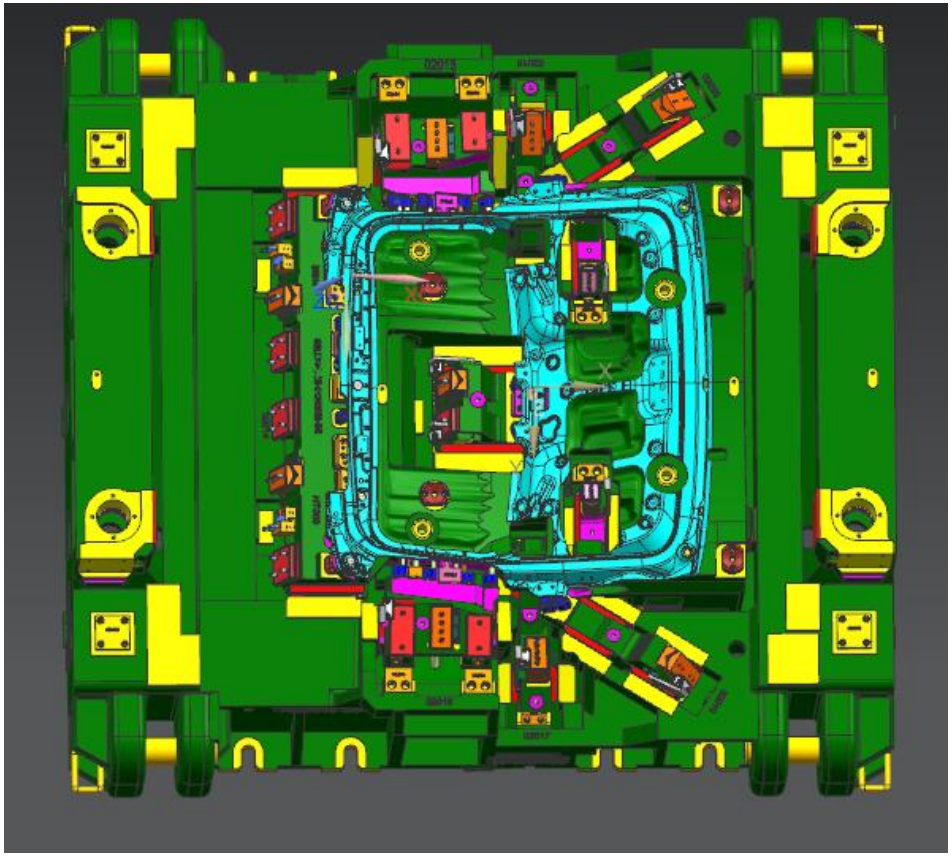


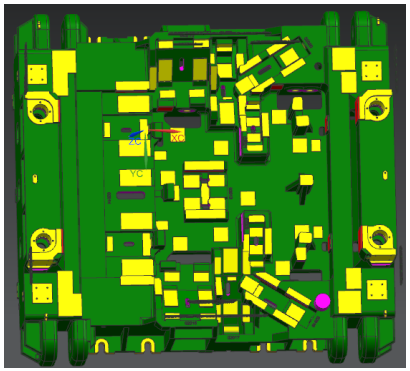


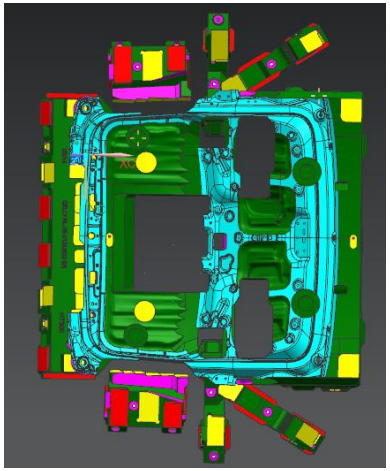


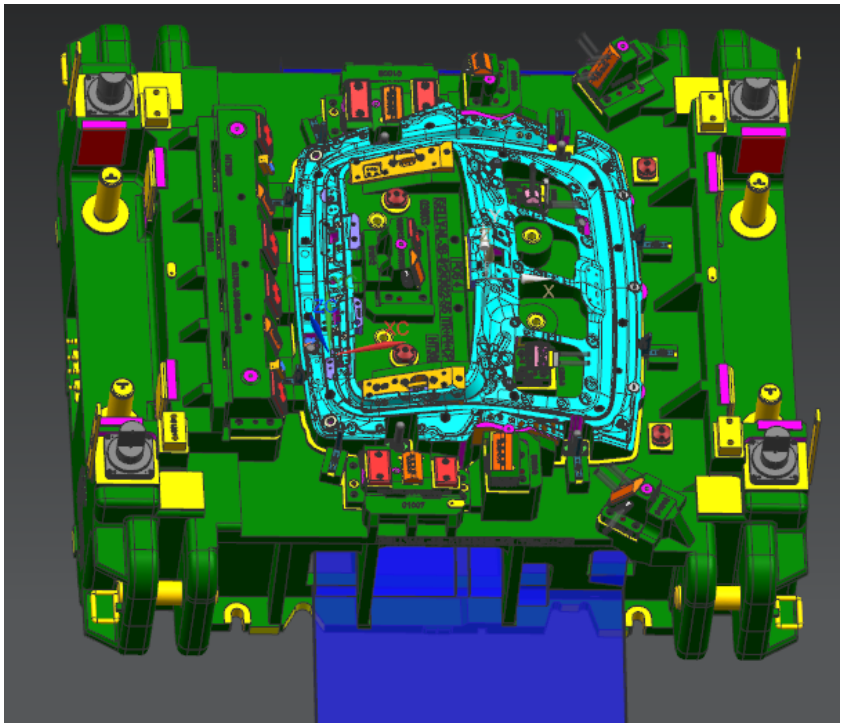
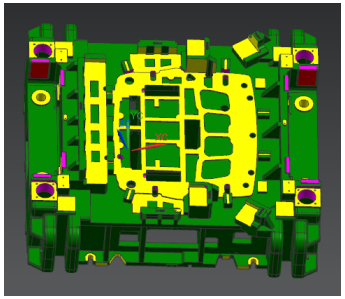
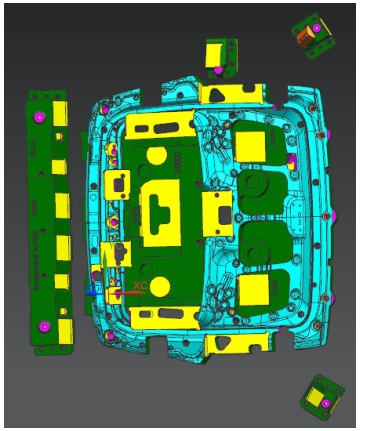
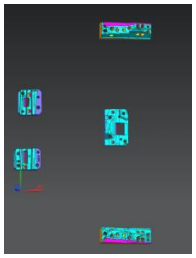
Oberteil

OP50: Lochen und Beschneiden
mit Schieber







Unterteil

OP50: Lochen und Beschneiden
mit Schieber