

STANDARD REFERENCE

Matriks setting tool mesin RALC

Matrix Of Tool Setting RALC Machine

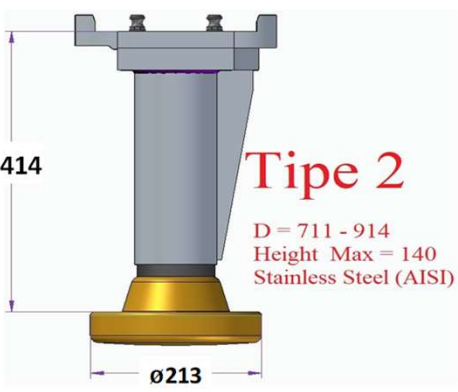


No : G-PAS-SR-IE-36

Date : 31 August 2023

Revision : 1

Diameter	Height	Thickness	Material	Flange Diameter	Internal Diameter	PREHOLE Diameter	Type Rollers (Top Tool)
GALVANIZED							
711	120	2	Galvanized DX51	784 ±1.5	711 ±1.5	453	
797	120	1.5	Galvanized DX51	870 ±4	797 ⁺² ₋₁	542	
914	140	2	Galvanized DX51	984 ⁺³ ₋₂	914.5 ±1.5	630	
914	210	2	Galv. DX54	982 ±4	913 ⁺² ₋₁	496	
Other Type : TBD							

STAINLESS STEEL							
711	120	1.5	SS	784 ±1.5	711 ±1.5	459	
914	140	1.5	SS	984 ⁺³ ₋₂	914,5 ±1.5	635	
Other Type : TBD							

NOTED : Pastikan Roller yang dipakai sesuai Tebal dan Jenis Material
Pengecekan ID pakai JIG/ Go No GO yang sesuai typenya

Reference Doc : **Work Instruction G-PAS-WI-P-665 Rev.0**

Prepared by	Checked by
IE Staff	IE SDH
Approved by	
IE Manangement	Prod Management

REVISION HISTORY

No	Revision	Date	Change
1	0	9-Jun-2023	Initial release
2	1	28-Aug-2023	Add Capability process