

Matriks setting tool mesin RALC

Matrix Of Tool Setting RALC Machine



No : G-PAS-SR-IE-36

Date : 26 Oct 2023

Revision : 01

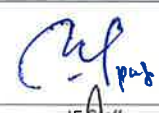
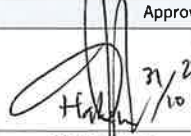
Diameter	Height	Material	Thickness	Flange Diameter	Internal Diameter	PREHOLE Diameter	RALC Program	RALC Setup		Type Roller
								Speed	Feed	
GALVANIZED & ALUMINUM										
634	120	Galv. DX51	1.5	707 ±1.5	634 ±1.5	380	D634_H120_SP15_1	100	100	 Type 1 D = 634 - 1000 Galvanized / Aluminum
711	120	Galv. DX51	2	784 ±1.5	711 ±1.5	453	D711_H120_SP2_1	100	100	
797	120	Galv. DX51	1.5	870 ±4	797 ⁺² ₋₁	542	D797_H120_SP15_R1	100	100	
	140	Galv. DX51	1.5	870 ⁺³ ₋₂	797 ±2	501	D797_H140_SP15_1	100	100	
		Galv. DX51	2	868.7 ⁺³ ₋₂	797 ±1.5	501	D797_H140_SP2	100	100	
	200	Galv. DX54	2	870 ⁺³ ₋₂	797 ±2	378	D797_H200_SP2_1	100	100	
914	140	Galv. DX51	2	984 ⁺³ ₋₂	914.5 ±1.5	630	D914_H140_SP2_1	100	100	
	210	Galv. DX54	2	982 ±4	913 ⁺² ₋₁	496	D914_H210_SP2	100	100	
STAINLESS STEEL										
711	120	SS304/316	1.5	784 ±3	711 ±1.5	459	D711_H120_AISI_R1	100	100	 Type 2 D = 711 - 914 Height Max = 140 Stainless Steel (AISI)
797	120	SS304	1.5	870±4	797 ⁺² ₋₁	550	D797_H120_AISI_1_R1	100	100	
	140	SS304	1.5	868.7 ⁺³ ₋₂	797 ±1.5	513	D797_H140_AISI_1	100	100	
914	140	SS304	1.5	984 ⁺³ ₋₂	914.5 ±1.5	635	D914_H140_AISI	120	80	

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** Ventilator Plate processing using RALC Machine

REVISION HISTORY

No	Rev.	Date	Change
1	0	9-Jun-2023	Initial release
2	1	26-Oct-2023	Add Capability & Parameter Process
3			
4			
5			

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

CONTROLLED