生产工艺流程					
Appendix G-1 Production Process					
Step No.	**Production Description**	**Production Description**	**Machines Used**	**Material Input**	**Byproduct or waste**
编号	**工艺步骤**	**工艺步骤说明**	**设备名称**	**原材料及辅料投入**	**副产品或废品**
1	整平 Leveling	把圆盘料展开整平 Flatten the disc material	五辊整平机 Five-roller leveler	带钢 strip steel	氧化皮 oxide skin
2	切头尾 Cut the end	把不符合工艺的原料切掉 Cut out the raw materials that do not conform to the process	液压剪 Hydraulic shear		废料头 Waste material head
3	剪切对焊 Shearing butt welding	把两盘原料焊接头尾 Weld the ends of two plates of raw material	电焊机 Electric welding machine	电焊条 Welding electrode	焊条头 Electrode head
4	存料 Material stock	把原料存在水平活套上 Store ingredients in a horizontal loop	水平活套 Horizontal loop		
5	成型 molding	通过成型机组模具成型 Through the molding machine mold molding	成型机组 Forming unit	模具 mold	
6	焊接 welding	通过高频把管焊接好 Weld the tube by high frequency	固态高频焊机 Solid state high frequency welder		
7	去焊筋 Remove weld reinforcement	用圆弧刀具去掉焊筋 Remove weld bar with arc cutter	焊接的刀具	YT15刀头 YT15 cutter head	刨花条 Shavings
8	冷却 cool down	用循环水把焊管冷却 Cool the welded pipe with circulating water	离心水泵 Centrifugal water pump	水 water	
9	定径 Determine the diameter	通过模具使焊管外径达到要求 Make the outer diameter of the welded pipe meet the requirements through the mold	定径机组 Defined diameter unit	模具 Mold	

10	矫直 Straightening	通过矫直机调直焊管 Straighten the welded pipe with a straightener	矫直机组 Straightening unit	模具 Mold	
11	切断 cutting off	通过锯车把焊管切断 Cutting the welded pipe with a saw	飞锯 Flying saw	锯片 Saw blade	
12	压扁试验 Flattening test	把焊管压扁检查焊接是否牢固 Flatten the welded pipe to check whether the welding is firm	压力机 press machine		
13	修端 Repair the end	通过齐头机修整管两端 The ends of the pipe are trimmed by a machine	齐头机 The machine that repairs the ends of the pipe	刀具 The cutting tool	
14	水压试验 Hydrostatic test	通过打水压检测焊管是否漏水 Test whether the welded pipe is leaking by water pressure	水压机 Hydraulic press	水、密封圈 Sealing ring and water	
15	外观检验 Visual inspection	将不合格品挑出 Pick out nonconforming products			
16	打标记 marking	区分产品规格 Product specifications	模板 template		
17	包装入库 Packaging and warehousing	按要求打包 Pack as required	气泵、打包机 Air pump, baler	打包带、打包扣 Packing belt, packing buckle	