**Cylinder Head Cover process plan-A04**

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| Part number: A04 | | Machine shop name: Taysons industry | | | | | | Standard plan ID: A | | | |  |
| Drawing number: 04 | | Material: cast iron | | | | | | Part code: **99612** | | | | |
| Rev. number: 03 | | Classification code:01 | | | Unite cost: | | |  | Machining time:12.3 min | | | |
| Quantity: 150/day | |  | Mass: 14 kg. | | | |
| Instructions to operator:   * Note: all dimensions are in “mm”. * # Set up1-Location fixed by bore and reference taken from top face by using rest pads * Set up2-locate the bore from joint face by using T-slotted modular fixture * Set up3-drilling bushes are used. | | | | | | | | Process planning Er.: A N Kendre | | | | |
| seq. No. | operations | | Machine | Cutting Tools | | Fixtures and setups | Speed  (rpm) | | | Feed  (mm) | Depth of cut  (mm) | Operation time(min) |
| 1 | Facing (rough) | | VMC | Face tool (carbide tip type) | | (#set up-1) | 200 | | | 0.8 | 2 | 1.5 |
| 2 | Facing (finish) | | 250 | | | 0.4 | 0.5 | 1 |
| 3 | Boring (rough) | | VMC | BOR1  (carbide) | | (#set up-2) | 200 | | | 0.9 | 1.5 | 2.4 |
| 4 | Boring (finish) | | 250 | | | 0.4 | 0.5 | 1.6 |
| 5 | Threading | | Centre lathe | Special threading tool | | Set up 3 | 100 | | | 0.1 | 0.1 | 2 |
| 6 | Drilling | | RDM(#set up-3) | Drill01  (HSS) | | 1100-1500 | | | 0.8 | 9 | 2.8 |
| 7 | chamfering | |  | | 220-230 | | | 0.5 | 1 | 0.5 |
| 8 | Spot face | |  | | 150 | | | 0.2 | 1.5 | 0.5 |