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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Part number: **B04** | | Machine shop name: Taysons Industry | | | | | | Standard plan ID:**B** | | | |  |
| Drawing number: 09 | | Material: **Cast Iron** | | | | | | Part code: **78624** | | | | |
| Rev. number: 03 | | Classification code:02 | | | Unite cost: Rs.1600 | | |  | Machining time: 12 min | | | |
| Quantity: 180/day | |  | Mass: 24Kg. | | | |
| Instructions to operator:   * All dimensions are in “mm” * \*Tooling-Carbide (Indexable) insert type tools are used. * #Set up1-at the first fool proofing is done by using rest pads and horizontal milling fixture is used. * Horizontal milling fixture- it has been equipped with studs and vise. * #set up2-vertical milling fixture. | | | | | | | | Process planning Er.: A N Kendre | | | | |
| seq. No. | operations | | Machine | Cutting Tools | | Fixtures and setups | Speed  (rpm) | | | Feed  (mm/min ) | Depth of cut  (mm) | Operation time(min) |
| 1 | Face milling (rough) | | VMC | End mill cutter (carbide tip type) | | (#set up-1) | 1200 | | | 500 | 1.5 | 2.5 |
| 2 | Facing (finish) | | 1200 | | | 800 | 0.5 | 1 |
| 3 | Side face milling | | VMC | Side mill cutter | | (#set up-2) | 800 | | |  | 1 | 2 |
| 4 | Drilling | | VMC | Drill01  (carbide) | | (#set up-1) | 900 | | | 300-400 | 5 | 4 |
| 5 | Drilling | | VMC | Drill02 | | Set up-02 | 600 | | | 400 | 3 | 2.5 |

**Process plan for Oilpan-B04**