**Bullcage process plan-C01**

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Part name: Bullcage-C01 | | | Machine shop name: Taysons Industry | | | | | Standard plan ID: C | | | |
| Drawing number: 10 | | | Material: **cast iron** | | | | | Part code: **11211** | | | |
| Rev. number: 04 | | | Classification code:03 | | Unite cost: | | | Machining time:10.3 min | | | |
| Quantity: 200/day | | | Mass: 10Kg. | | | |
| 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 | Facing (rough) | Centre lathe | | Face tool (carbide tip type) | | (#set up-1) | 200 | | 3 | 1.5 | 2 |
| 2 | Facing (finish) | 250 | | 5 | 0.5 | 0.5 |
| 3 | Boring (rough) |  | | BOR1  (carbide) | | (#set up-2) | 200 | | 8 | 4,5,2 | 2 |
| 4 | Boring (finish) | Centre lathe | | Special threading tool | | Set up 3 | 250 | | 4 | 1 | 0.8 |
| 5 | Drilling | RDM-SPM(#set up-3) | | Drill01  (HSS) | | 600 | | 6 | 1.5 | 5 |