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| Work preparation form | | | |
| Part name: 12112024-04-01-05-Axel35TeethToCam | | Date: 11/10/2024 | Sheet number: 1 |
| Belonging to drawing: 12112024-04-01-05 | | Made by: Samuel Pozdech | |
| Part no: 12112024-04-01-05 | Amount: 1 | Material: Steel | |
| Starting dimensions material: 51xØ8mm | | | |
| Machining sequence: | | | |
| **Operation** | **Tool**  fixtures, tools and other aids | **Settings**  speed (V), number of revolutions (N), feed (f), depth of cut (t0) etc. | **Remarks** |
| Clamp the stock in the chuck |  |  |  |
| Level face |  | N = 800rpm |  |
| Turn workpiece around |  |  |  |
| Level face and cut part down to 50mm in length |  | N=800rpm | Measure the part beforehand to find exact value that needs to be cut off |
| Create center Hole | Center Drill | N = 200rpm |  |
| Drill 7.5mm deep | Drill diameter 2.4mm | N = 800rpm  T0 = 7.5mm |  |
| Tap Hole m3 | Tapping chuck | N = 50rpm  T0= 6mm |  |