|  |  |  |  |
| --- | --- | --- | --- |
| Work preparation form | | | |
| Part name: 12112024-04-01-07-AxelCamToCam | | Date: 11/10/2024 | Sheet number: 1 |
| Belonging to drawing: 12112024-04-01-07 | | Made by: Samuel Pozdech | |
| Part no: 12112024-04-01-07 | Amount: 1 | Material: Steel | |
| Starting dimensions material: 36xØ8mm | | | |
| 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 |  |  |  |
| Turn piece around and clamp the stock in the chuck |  |  |  |
| Level face and cut down to 35mm |  |  | Measure beforehand to find out how much should be cut |
| Make center hole for drill | Center drill | N = 200rpm |  |
| Drill hole with diameter 2.4mm | Drill 2.4mm | N = 800rpm  T0= 7.5mm |  |
| Tap M3 hole | Tapping chuck | N = 50rpm  T0= 6mm |  |
| Turn piece around and clamp the stock |  |  |  |
| Make center hole for drill | Center drill | N = 200rpm |  |
| Drill hole with diameter 2.4mm | Drill 2.4mm | N = 800rpm  T0 = 7.5mm |  |
| Tap M3 hole | Tapping chuck | N = 50rpm  T0=6mm |  |