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| Work preparation form | | | | |
| Part name: Lower angled square tube | | | Date: 11/01/2024 | Sheet number: 1 |
| Belonging to drawing: 12112024-02-07 | | | Made by: Heri Ng’eno | |
| Part no: 12112024-02-07 | Amount:2 | Material: Cold Rolled Steel | | |
| Starting dimensions material: 20x159 | | | | |
| 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 square tube |  |  | Use ground parallels | |
| Calibrate edge and center line | Probe | Edge finder and Centerline finder |  | |
| Mark hole center with center drill | 4mm drill bit | N=800rpm |  | |
| Pre-drill through all hole | 8mm drill bit with cutting fluid | N=800rpm |  | |
| Drill 13.8mm through all hole | 13.8mm drill bit with cutting fluid | N=450rpm |  | |
| Drill at next position a 6.6mm through all hole | 6.6mm drill bit with cutting fluid | N=800rpm |  | |
| Deburr both holes with file |  |  |  | |

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| Work preparation form | | | |
| Part name:  Frame to adapter square tube | | Date: 11/01/2024 | Sheet number: 2 |
| Belonging to drawing: 12112024-02-03 | | Made by: Heri Ng’eno | |
| Part no: 12112024-02-03 | Amount: 1 | Material: Cold rolled steel | |
| Starting dimensions material: 20x200 | | | |
| 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 square tube |  |  | Use ground parallels |
| Calibrate edge and center line | Probe | Edge finder and Centerline finder |  |
| Drill 6.6mm through all hole | 6.6mm drill bit with cutting fluid | N=800rpm |  |
| Drill at next position a 6.6mm through all hole | 6.6mm drill bit with cutting fluid | N=800rpm |  |
| Deburr all holes with file |  |  |  |

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| Work preparation form | | | |
| Part name:  Side frame square tube | | Date: 11/01/2024 | Sheet number: 3 |
| Belonging to drawing: 12112024-02-04 | | Made by: Heri Ng’eno | |
| Part no: 12112024-02-04 | Amount: 2 | Material: Cold rolled steel | |
| Starting dimensions material: 20x274 | | | |
| 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 square tube |  |  | Use ground parallels |
| Calibrate edge and center line | Probe | Edge finder and Centerline finder |  |
| Drill 9.8mm through all hole | 9.8mm drill bit with cutting fluid | N=800rpm |  |
| Realign and clamp square tube |  |  | Use ground parallels |
| Calibrate edge and center line | Probe | Edge finder and Centerline finder |  |
| Drill at next position a 6.6mm through all hole | 6.6mm drill bit with cutting fluid | N=800rpm |  |
| Deburr all holes with file |  |  |  |

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| Work preparation form | | | |
| Part name: Handcrank sqrtube extended | | Date: 11/01/2024 | Sheet number: 4 |
| Belonging to drawing: 12112024-02-06 | | Made by: Heri Ng’eno | |
| Part no: 12112024-02-06 | Amount: 1 | Material: Cold Rolled Steel | |
| Starting dimensions material: 20x145 | | | |
| 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 square tube |  |  | Use ground parallels |
| Calibrate edge and center line | Probe | Edge finder and Centerline finder |  |
| Mark hole center with center drill | 4mm drill bit | N=800rpm |  |
| Pre-drill through all hole | 8mm drill bit with cutting fluid | N=800rpm |  |
| Drill 13.8mm through all hole | 13.8mm drill bit with cutting fluid | N=450rpm |  |
| Deburr both holes with file |  |  |  |