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| Work preparation sheet | | | |
| Name of part: Pusher | | Date: 12-10-2024 | Sheet No.: 1 OF 1 |
| Corresponding to drawing: 12112024-04-03-03 | | Made by: Ilya van den Brandt | |
| Part No.: 12112024-04-03-03 | Amount: 2 | Material: free-machining steel | |
| Starting dimensions material: 71,018mm x Ø4mm | | | |
| Machining sequence: | | | |
| **Process** | **Tools**  fixtures, tools and other aids | **Settings**  speed (V), number of revolutions (N), feed (f), depth of cut (t0) etc. | **Comments** |
| Clamp the stock in the chuck |  |  |  |
|  | Toolholder for 45 degrees insert | N=1000rpm  f=manual |  |
| Flip the stock |  |  |  |
| Chamfer the edges | Toolholder for 45 degrees | N=1000rpm  f=manual |  |
| Bend the long side: 41,09mm 32,95 degrees | Bend tool |  |  |
| Bend the short side: 20mm 32,95 degrees |  |  |  |
| Vile the “long side” so that a small filet starts to “exist” | Vile |  | Not really that accurate, but don’t know a better way of doing this. |