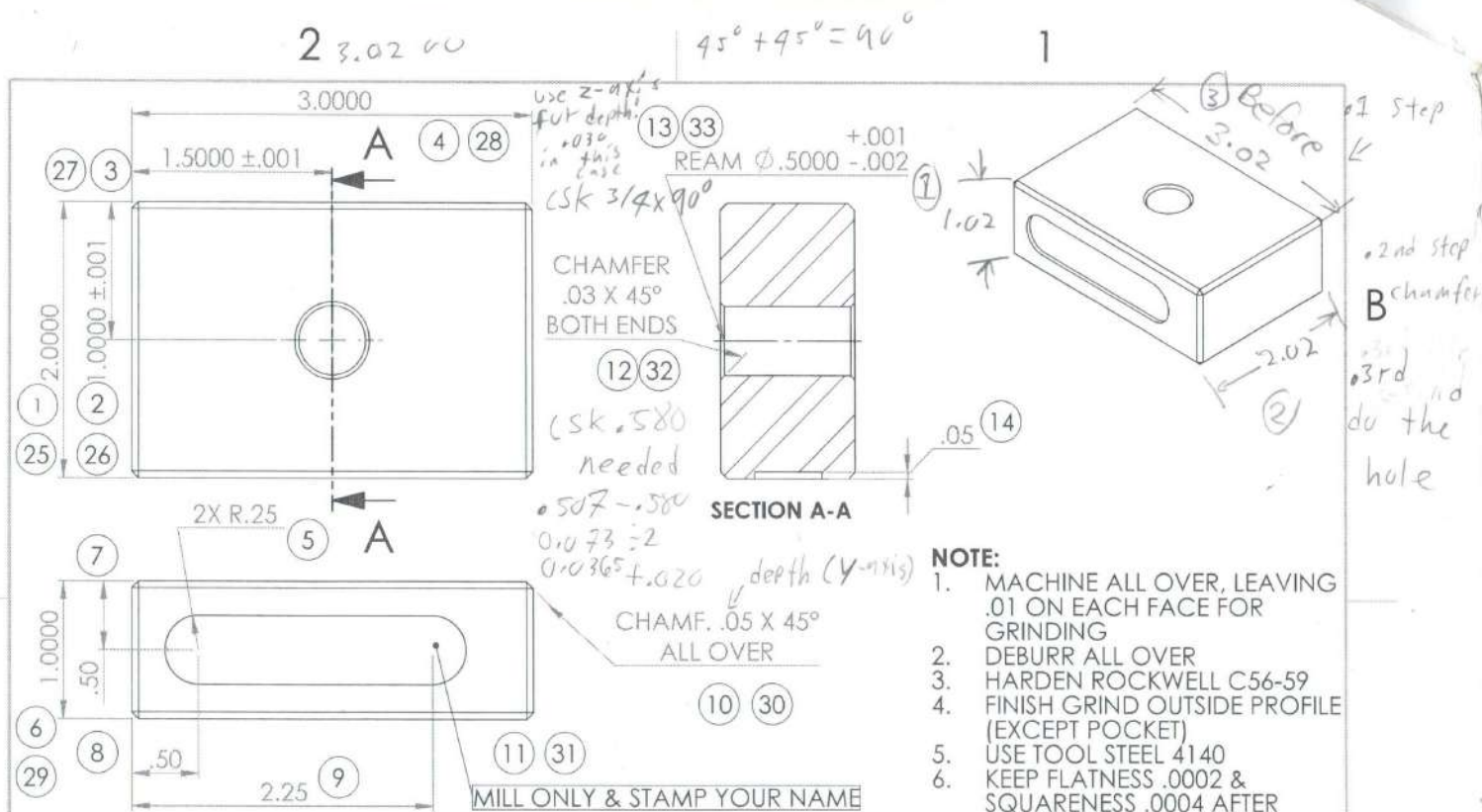


B



- A ④ *center drill
- B ③ *Drill
- C ③ *csk
- D ④ *Ream

PROPRIETARY AND CONFIDENTIAL
THE INFORMATION CONTAINED IN THIS
DRAWING IS THE SOLE PROPERTY OF
"INSERT COMPANY NAME HERE". ANY
REPRODUCTION IN PART OR AS A WHOLE
WITHOUT THE WRITTEN PERMISSION OF
"INSERT COMPANY NAME HERE" IS
PROHIBITED.

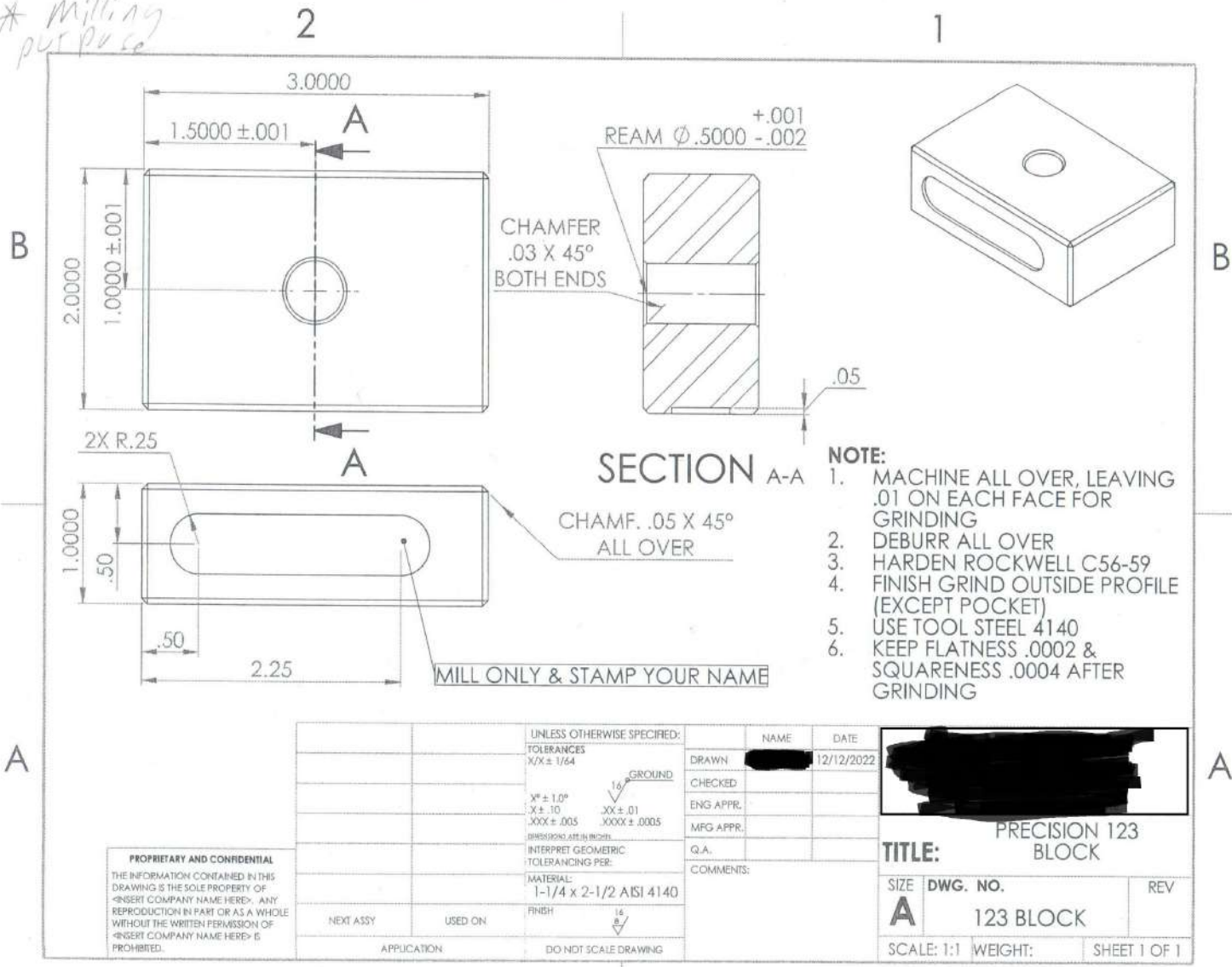
UNLESS OTHERWISE SPECIFIED:	
TOLERANCES	XX ± 1/64
FINISH	16
GROUND	16
XX ± 1.0"	XX ± .01
XX ± .10	XXXX ± .0005
XXXX ± .0005	XXXX ± .0005
INTERPRET GEOMETRIC	TOLERANCING PER:
MATERIAL:	1-1/4 x 2-1/2 AISI 4140
FINISH	16
DO NOT SCALE DRAWING	

NAME	DATE
DRAWN	12/12/2022
CHECKED	
ENG APPR.	
MFG APPR.	
Q.A.	
COMMENTS:	

TITLE:	
PRECISION 123 BLOCK	
SIZE	DWG. NO.
A	123 BLOCK
SCALE: 1:1	WEIGHT:
SHEET 1 OF 1	

reamer = use auto metric 1
csk = use z-axis feed

* Milling
put piece



MACHINING DEPARTMENT

Project: 123 black

Part # _____ Dwg. # _____

MANUFACTURING PROCESS SHEET

Pcs.	Thick / Ø	Width	Length	Material

Routines, Sub-routines Operations	Description and Remarks	Machines , Tools, Jigs, Fixtures, Attachments and Measuring Tools	rpm	Feed	Time	Sketch of the Work, Mounting, etc. (if applicable)
10	Bring down to size part 1					
A	prepare cutter tool					
a	Rough to 1.02		240			
b	Rough to 2.02					
c	Rough to 3.02					
20	Chamfer part 1					
A	prepare carbide cutter					
a	chamfer all over .07 x 95°		380			
30	Drilling the hole					
A	prepare drill 15/32					
B	prepare Center Drill	#4 center Drill				
C	prepare CSK					
D	prepare Reamer					
a	center Drill	#4 Center Drill	1280			

Prepared by: Lew's

Date: Feb 26 - March 1 2024 Page 1 of

KSC



MACHINING DEPARTMENT

*CSK

(5)

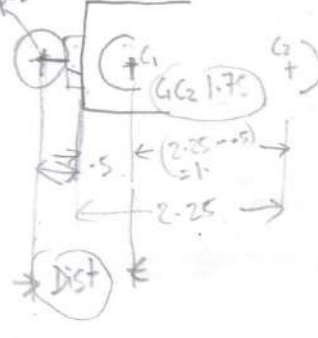
 $.552 - .580$
 $= 0.028 \div 2$
 $= 0.014$

MANUFACTURING PROCESS SHEET

Project:

Part # _____ Dwg. # _____

Pcs.	Thick / Ø	Width	Length	Material

Routines, Sub-routines Operations	Description and Remarks	Machines, Tools, Jigs, Fixtures, Attachments and Measuring Tools	rpm	Feed	Time	Sketch of the Work, Mounting, etc. (if applicable)
1b	Drill 15/32 THRU	Drill 15/32	853			$G1G2 = 2.25 - .5 = 1.75$ $Dist = R + Paper + Dim$ $\Rightarrow 1 + .01 + .5$ $\Rightarrow .610$ $\phi 2 (R.100) \Rightarrow .610$ 
Ac	CSK 3/4 X 90°	CSK 3/4 X 90°	213			
1d	Ream 1/2 THRU	Reamer 1/2	240			
30	Endmill Cutter					
A	Endmill cutter 1/2	1/2				
a	Endmill .05	1/2 end mill + 2 flutes	480			
40	CSK other side					
A	Flip the workpiece					
a	CSK same hole	CSK 3/4 X 90°	213			
50	Stamp your name					
A	Hammer, stamper					
a	look for L letter					
b	hammer it					

Prepared by: Lewis

Date: Feb 26 - March 7 2024

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