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MANUFACTURING PLAN

RAW MATERIAL STOCK: Aluminum plate, 1/4" thick

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut shape of arm	Water jet			
2	Secrure part in mill	Mill	Vise1.375" parallels		
3	Deburr part	file		file	
4	find datum using top and right side of part	Mill	Vise 1.375" parallels	Drill Chuck with Edge finder	1000
5	Drill holes 2X .188"	Mill	Vise 1.375" parallels	3/16" Drill bit with drill chuck	100
6	Drill hole 2X .19"	Mill	Vise 1.375" parallels	3/16" Drill bit with drill chuck	100
7	Drill hole .375"	Mill	Vise 1.375" parallels	3/8" Drill bit with drill chuck	100
8	Ream hole .375"	Mill	Vise 1.375" parallels	3/8" Ream wilth drill chuck	100
9	Deburr Part	File		File	

В

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