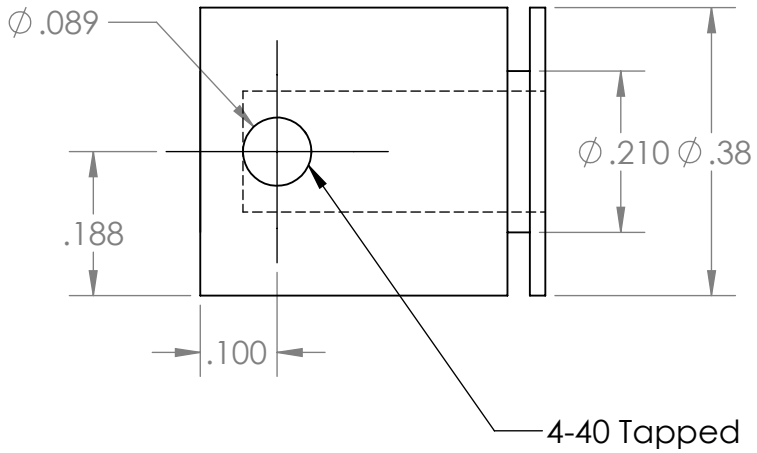

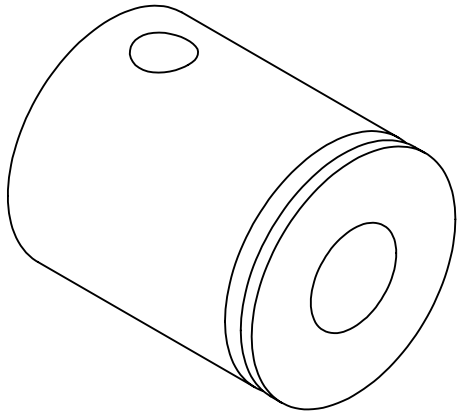

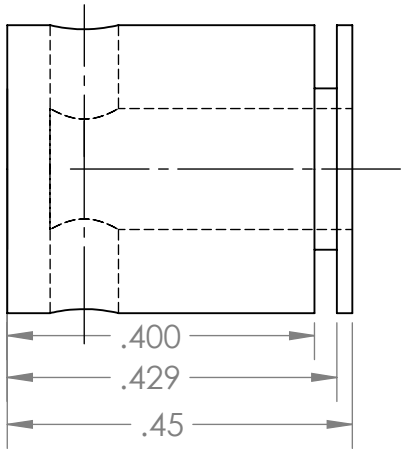

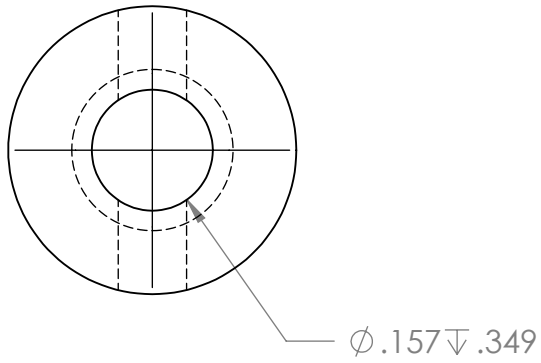

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	DRAWN	abirnb	10/22
			CHECKED		
			ENG APPR.		
			MFG APPR.		
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.		
		MATERIAL Aluminum	COMMENTS:		
NEXT ASSY	USED ON	FINISH			
APPLICATION		DO NOT SCALE DRAWING			

TITLE:

Lever Motor Arm

SIZE	DWG. NO.	REV
A	P103_04	1

SCALE: 4:1	WEIGHT:	SHEET 1 OF 2

MANUFACTURING PLAN

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

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut part to 1/2"	Band Saw			300 ft/min
2	Secure Part In lathe	Lathe	Collet		
3	Lathe both ends of part to provide fully machined ends	Lathe	Collet	Cutting Tool	700
3	Cut Down to .45"	Lathe	Collet	Cutting Tool	700
4	Create e clip slow with parting tool	Lathe	Collet	Parting Tool	100
5	Make center hole for drilling	Lathe	Collet	Centerdrill	700
6	drill hole	Lathe	Collet	3/8" Ream	100
7	find center of part	mill	vise	edge finder	100
8	Drill center hole for drill	mill	vise	centerdrill	700
9	drill .089 hole for 4-40 tap	mill	vise	.089 drill bit	700
10	thread hole 4-40	mill	vise	4-40 tap	