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MANUFACTURING PLAN

В

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

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM
1	Cut shape of arm and clearence holes .188" and .19"	Water jet			
2	Deburr part	file		file	
3	Secrure part in mill	Mill	Vise1.375" parallels		
4	find datum using top and right side of part	Mill	Vise 1.375" parallels	Drill Chuck with Edge finder	1000
	Centerdrill hole	Mill	Vise	Centerdrill with drill chuck	700
7	Drill hole .375"	Mill	Vise 1.375" parallels	3/8" Drill bit with drill chuck	700
8	Ream hole .375"	Mill	Vise 1.375" parallels	23/64" Ream wilth drill chuck	100
9	Deburr Part	File		File	

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