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MANUFACTURING PLAN

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

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

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