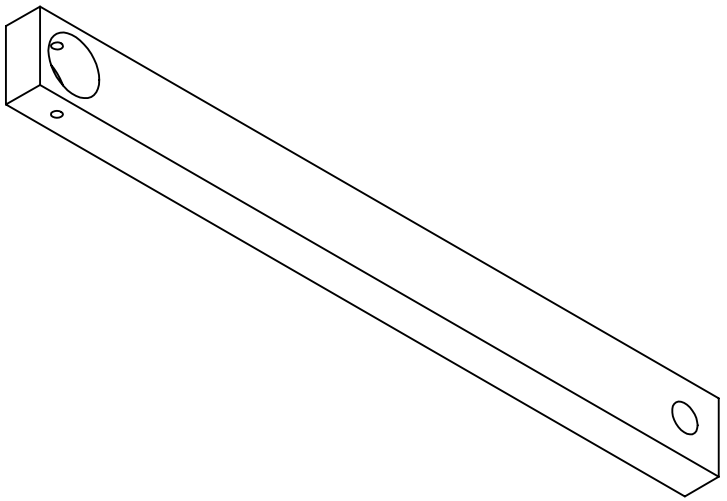

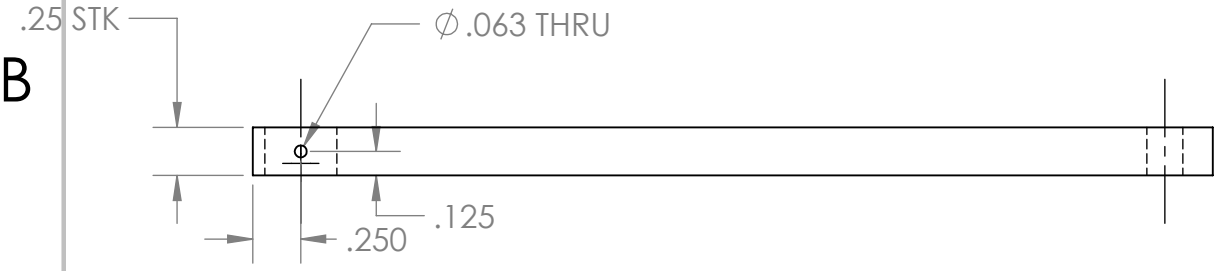

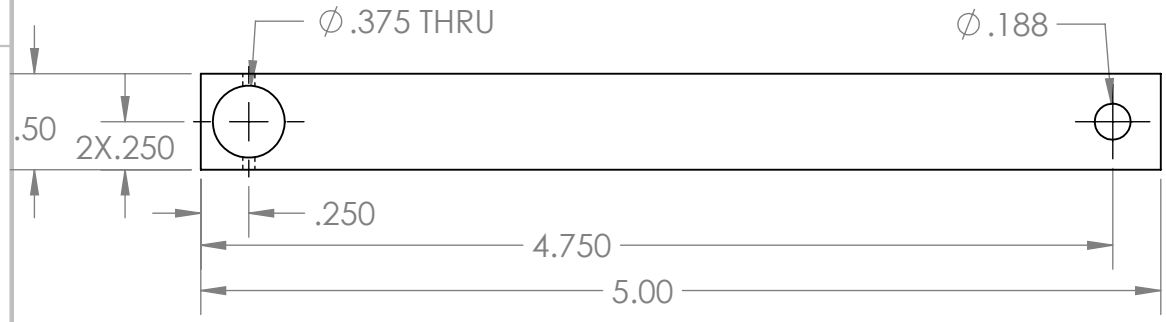

DRAWING & MANUF. PLAN CHECKS:
- PART FULLY DIMENSIONED
- APPROPRIATE DATUM LINES
- TOLERANCES SPECIFIED
- MATERIAL/QUANTITY SPECIFIED
- IF APPLICABLE, REAMER CALLED OUT
- APPROPRIATE TOOL SPEEDS
- APPROPRIATE DRILL/TAP SIZES
- SPECIFIED ALL NECESSARY TOOLS/SIZES NECESSARY
- RAW STOCK CUT OVERSIZED
- STEPS TO GET ALL ALL MACHINED/STOCK SURFACES

REV 1	INITIAL RELEASE	
REV 2	FIXING DIMENTION	
REV 3	FIXING MANUFACTURING PLAN	
REVISION BLOCK		

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:
MACHINED ANGULAR: ± 1°
BENT ANGULAR: ± 3°
TWO PLACE DECIMAL: ± 0.01
THREE PLACE DECIMAL: ± 0.005

INTERPRET GEOMETRIC TOLERANCES PER: ASME Y14.5-2009

MATERIAL
Aluminum Plate, 1/4"

FINISH
BURR FREE

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	CHARLES RENZ	10/21/2021
CHECKED	ABIRNB	10/27/21
GSI/IA APPR.		
SHOP APPR.		
INSPECTED		

COMMENTS:

ME 250 TEAM 103

TITLE:

LEFT_LEVER_ARM

SIZE	DWG. NO.	REV
A	P103_02	03

SCALE: 1:1 | QUANTITY: 1 | SHEET 1 OF 2

MANUFACTURING PLAN

RAW MATERIAL STOCK: Aluminum Plate, 1/4" Thick

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Outside Shape has been waterjetted along with .188" hole	Water Jet			
2	Deburr	File		File	
3	Secure part on vise	Mill	Vise 1.375" parallels		
4	Find X and Y datum	Mill	Vise 1.375" parallels	Edge finder with drill chuck	1000
5	Center drill	Mill	Vise 1.375" parallels	Centerdrill with chuck	700
6	Drill Hole .375"	Mill	Vise 1.375" parallels	23/64" drill with chuck	700
8	Ream 3/8", center at X=.25" from left, Y = .25"	Mill	Vise 1.375" parallels	3/8 ream with chuck	100
10	Remove part from Vice and turn 90 degrees to Mill 1/4" edge	Mill	Vise 1.375" parallels		
11	Find X and Y datum	Mill	Vise 1.375" parallels	Edge finder with drill chuck	1000
12	Center drill for .063" hole center at X=.25" from left, Y= .06"	Mill	Vise 1.375" parallels	Centerdrill with chuck	700
13	Drill for .063" hole	Mill	Vise 1.375" parallels	1/16" drill with chuck	700
14	Deburr	file		file	