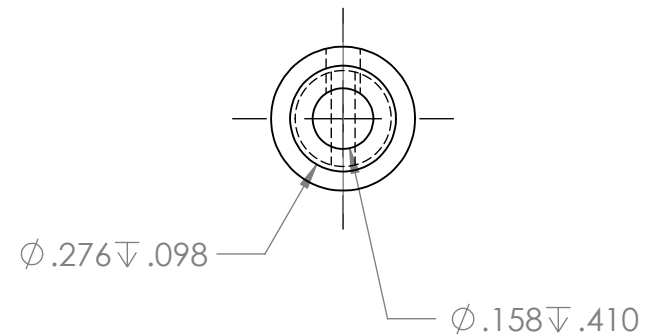
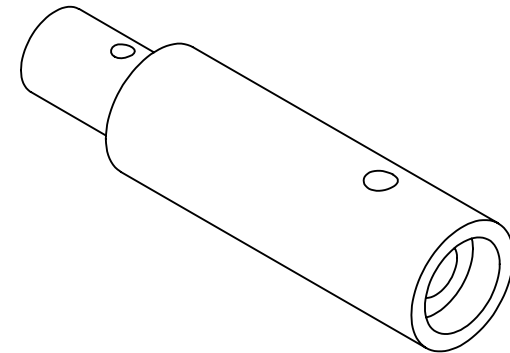
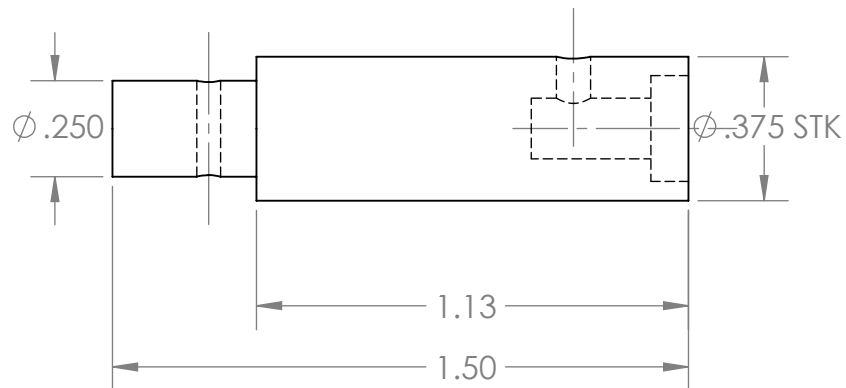
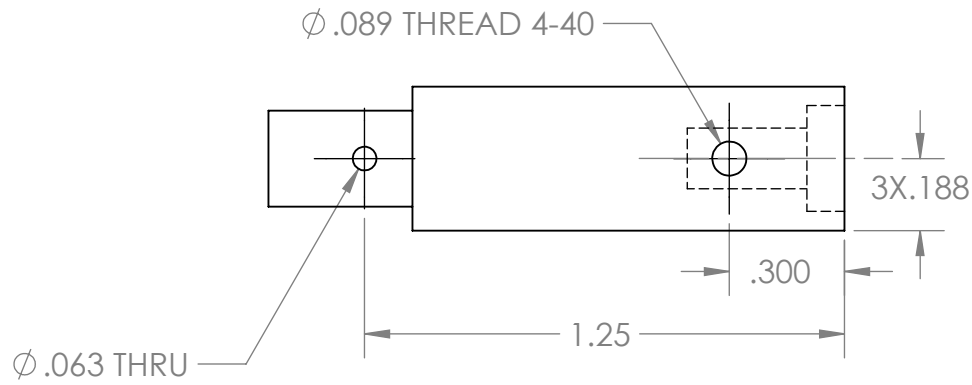


B



B

A

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REV 1	INITIAL RELEASE	UNLESS OTHERWISE SPECIFIED:  DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ±    BEND ± TWO PLACE DECIMAL    ± THREE PLACE DECIMAL    ±  INTERPRET GEOMETRIC TOLERANCING PER:  MATERIAL  FINISH	DRAWN	ABIRNB	10/26/21	ME 250 Team 103			
REV 2	FIXED DIMENTIONING		CHECKED	ABIRNB	10/2/21	TITLE:  Connecting shaft			
			ENG APPR.						
			MFG APPR.						
			Q.A.						
			COMMENTS:			SIZE    DWG. NO.    REV <b>A</b> P103_08    2			
NEXT ASSY	USED ON					SCALE: 2:1    WEIGHT:    SHEET 1 OF 2			
APPLICATION		DO NOT SCALE DRAWING							

**MANUFACTURING PLAN**

RAW MATERIAL STOCK:

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut out .625" of 3/8" aluminum stock	-	-	-	300 ft/min
2	Deburr the ends of the surfaces	Lathe	-	File	-
3	Place in lathe and face off to get a machined surface	Lathe	Collet	-	
4	Deburr the part	-	Collet	File	750
5	Remove part from lathe and flip	-	-	-	-
6	Repeat steps 3 and 4	Callipers	-	-	-
7	Remove part from lathe and measure with callipers	Lathe	-	-	-
8	touch off with parting tool and zero x. Cut to length taking passes of 0.050" or less	Lathe	Collet	Parting Tool	750
9	Trim the final .375 inches down to a 0.276" diameter	Lathe	Collet	Parting Tool	750
10	On the thicker side of the shaft, drill a .276" diamter hole .10" deep	Lathe	Collet	Size H drill	1200
11	Center Drill about the part	Lathe	-	-	-
12	Zero Out drill at the end of the big hole and drill in .21" with diameter .158"	-	Collet	Drill Chuck	1600
13	Deburr the part	Mill	-	File	-
14	Use edgefinder to locate X and Y coordinates of edges	Mill	-	Edge Flinder	1000
15	Use center drill Drill a thru hole .26" in from the thick end of the shaft with a major diameter of .089"	Mill	Vise 1	#43 Drill	1000
16	Drill a thru hole .38" off the thin end with a .062" diameter	Mill	Vise 1	1/16 Drill	1000
17	Deburr the THRU holes	-	-	-	-

SHEET 2 OF 2