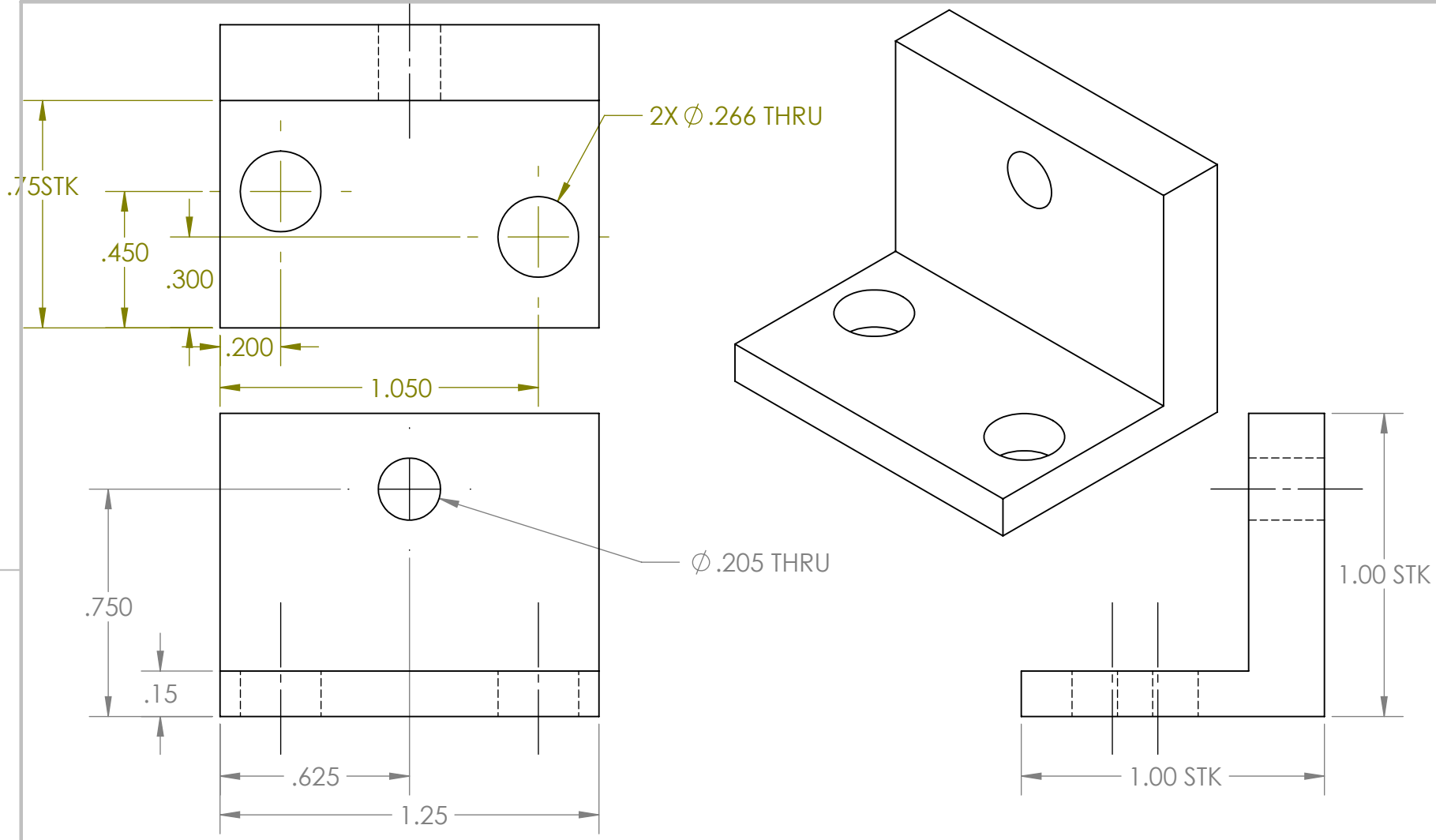

DRAWING & MANUF. PLAN CHECKS:

- 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	COMPLETE REDESIGN NGL
REV 3	FIX FORMATTING OF MANUFACTURE PLAN
REV 4	ADD FACMILL

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
1" x 1" Aluminum angle stock

FINISH
BURR FREE

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	DKFREELA	10/26/21
CHECKED	CRENZ	10/27/21
GSI/IA APPR.		
SHOP APPR.		
INSPECTED		

COMMENTS:

ME 250 TEAM 103

TITLE:

SMALL L BRACKET

SIZE	DWG. NO.	REV
A	P103_06	4

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

MANUFACTURING PLAN

RAW MATERIAL STOCK: 1" x 1" x 1/4" Aluminum Angle Stock

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut Raw Stock 1.30"	Bandsaw	Bandsaw Vise	---	---
2	Deburr part	File		File	
3	Face Both side and measure with caliper	Mill	Vise L-Stock Block	1/2" endmill with collet	800
4	Sercure Angle stock in mill with the back edge on top and other edge around .25" away from vice and use vice stop to constrain in X direction	Mill	Vise L-Stock Block		
5	Cut Down to size of 1.25"	Mill	Vice L-Stock Block	1/4" endmill with chuck	1000
6	Find Center using the edge where the 90 degree angle occurs and the top edge	Mill	1.375" parallels	Edge Finder with Chuck	1000
7	centerdrill	Mill	1.375" parallels	Centerdrill with chuck	1000
8	Drill .266" clearance hole through the material	Mill	1.375" parallels	H Drill Bit with chuck	1000
9	Repeat steps 6 and 7 for other 0.266 hole				
10	Rotate Part				
11	centerdrill	Mill	1.375" parallels	Centerdrill with chuck	1200
12	Drill the left .205" clearance hole through the material	Mill	1.375" parallels	#5 Drill Bit with chuck	1200
13	Facemill .25 STK down to .15	Mill	1.375" parallels	1/2" endmill with collet	800
13	Deburr part	file		file	