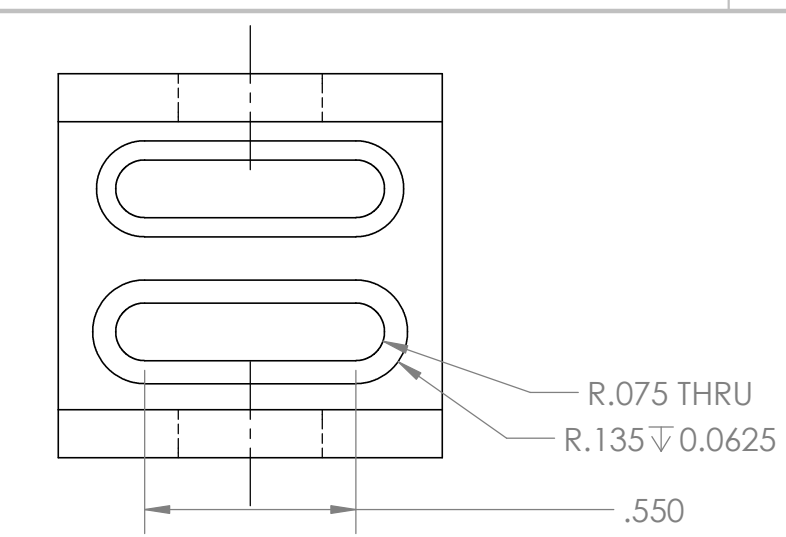

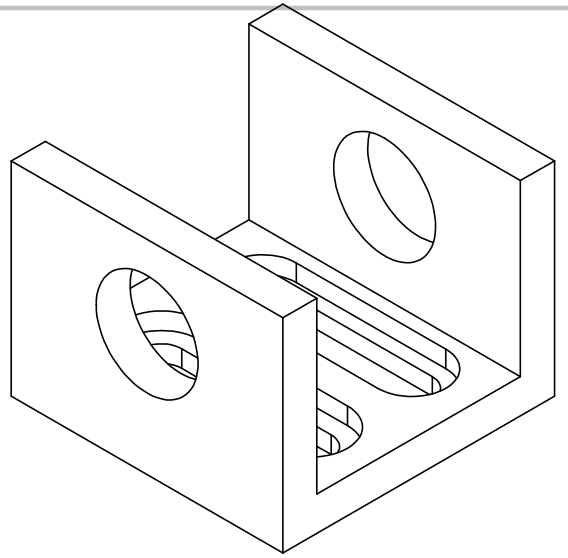

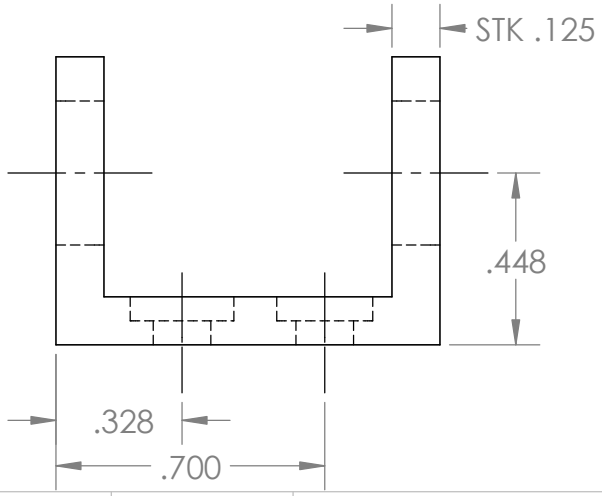

DRAWING & MANUF. PLAN CHECKS:

- 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	MADE DOUBLE SIDED
REV 3	DIMENSIONED

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

FINISH
BURR FREE

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	DKFREELA	11/5/21
CHECKED	ABIRNB	11/5/21
GSI/IA APPR.		
SHOP APPR.		
INSPECTED		

COMMENTS:

ME 250 TEAM 103

TITLE:

SQUARE BRACKET

SIZE	DWG. NO.	REV
A	P103_15	2

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

MANUFACTURING PLAN

RAW MATERIAL STOCK: 1" x 1" x 1/8" Square Aluminum Tube

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut down to 1.25" in bandsaw	bandsaw			300 ft/sec
2	place in vise	Mill	Vise with 1.375" parallels		
3	Cut down to 1.00"	Mill	Cutting tool	Cutting Tool	700
4	Centerdrill	Mill	Vise with 1.375" parallels		100
5	Drill .375" hole thru	Mill	Vise with 1.375" parallels	H bit with drill chuck	700
6	Ream hole	Mill	Vise with 1.375" parallels	3/8" Ream	100
7	Filp part	Mill	Vise with 1.375" parallels	-	-
8	Cut off top of part with passes	Mill	Vise with 1.375" parallels	3/8" Endmill with collet	700
9	Cut Counterbore with H cutting bit with .0625" depth	Mill	Vise with 1.375" parallels	H bit with collet	700
10	Cut slot thru	Mill	Vise with 1.375" parallels	#25 Bit with collet	1100
11	Deburr	file	-	file	