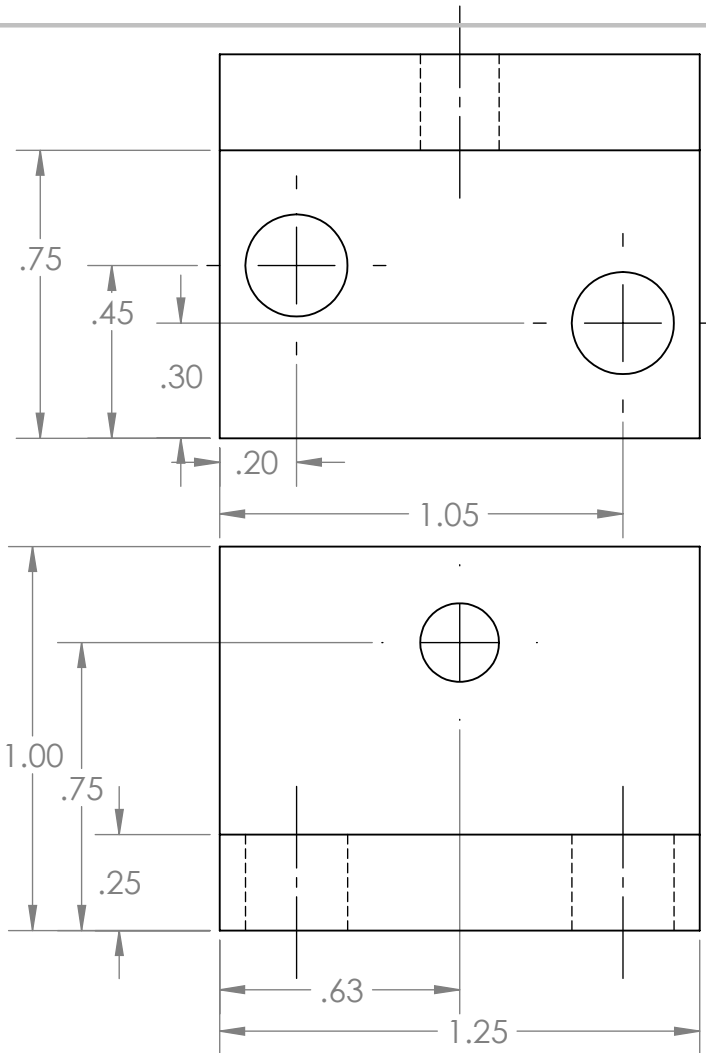
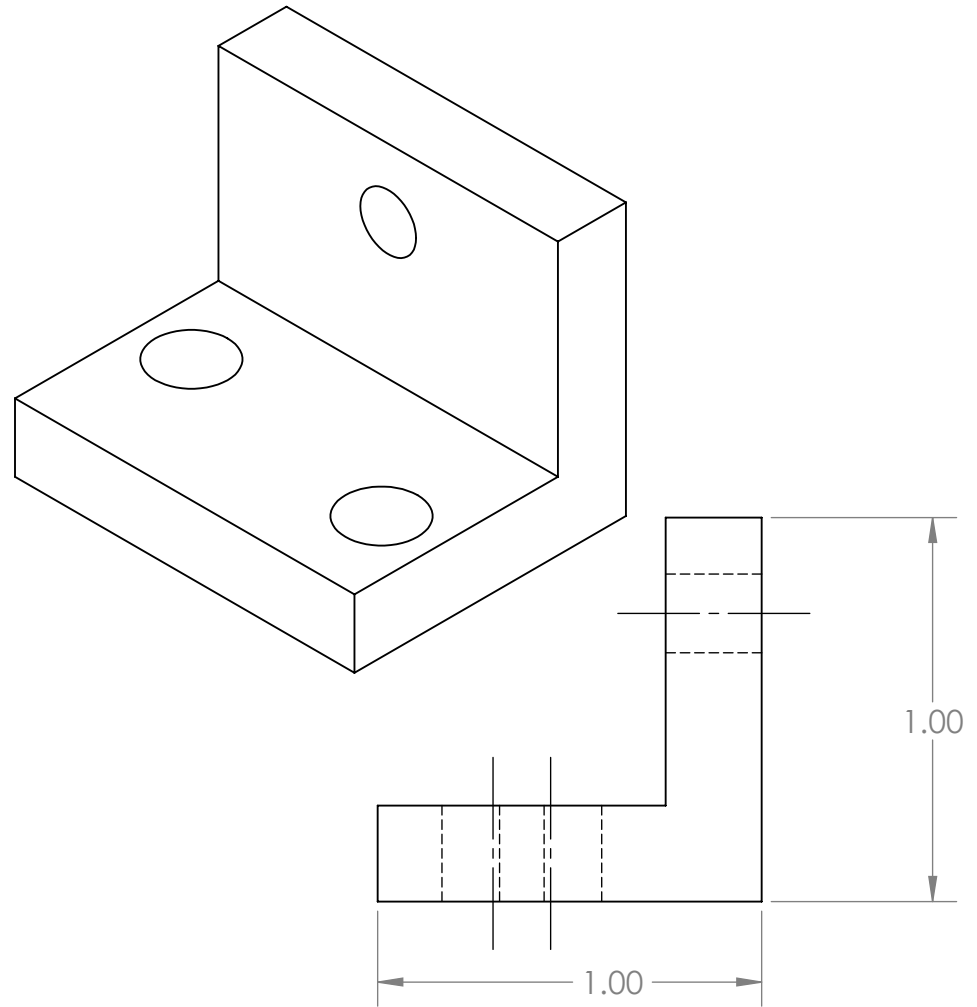


B



1



B

A

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

COMPLETE REDESIGN NGL

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

MACHINED ANGULAR: $\pm 1^\circ$
 BENT ANGULAR: $\pm 3^\circ$
 TWO PLACE DECIMAL: ± 0.01
 THREE PLACE DECIMAL: ± 0.005

INTERPRET GEOMETRIC
 TOLERANCES PER: ASME Y14.5-2009

MATERIAL

Aluminum

FINISH

BURR FREE

REVISION BLOCK

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

A

DWG. NO.

P103_07

REV

2

SCALE: 2:1

QUANTITY: 2

SHEET 1 OF 2

A

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 1.250"	Bandsaw	Bandsaw Vise	---	---
2	Deburr part	File		File	
3	Secure Angle stock in mill with the back edge on top and other edge on the outside of the parallels around .25" away from vice and use vice stop to constrain in X direction	Mill	Vise 1.5" parallels		
4	Find Center using the edge where the 90 degree angle occurs and the top edge	Mill	Vise 1.5" parallels	Edge Finder with Chuck	1000
5	centerdrill	Mill	Vise 1.5" parallels	Centerdrill with chuck	700
6	Drill .25" clearance hole through the material	Mill	Vise 1.5" parallels	.261 Drill Bit with chuck	700
7	centerdrill	Mill	Vise 1.5" parallels	Centerdrill with chuck	700
11	Rotate Part				
12	Part is already centered using the same vice stop location	Mill	Vise 1.5" parallels	Edge Finder	1000
13	centerdrill	Mill	Vise 1.5" parallels	Centerdrill with chuck	100
14	Drill the left .12" clearance hole through the material	Mill	Vise 1.5" parallels	#30 Drill Bit with chuck	700
15	centerdrill	Mill	Vise 1.5" parallels	Centerdrill with chuck	700
16	Drill the right .12" clearance hole through the material	Mill	Vise 1.5" parallels	#30 Drill Bit with chuck	700
17	Deburr part	file		file	