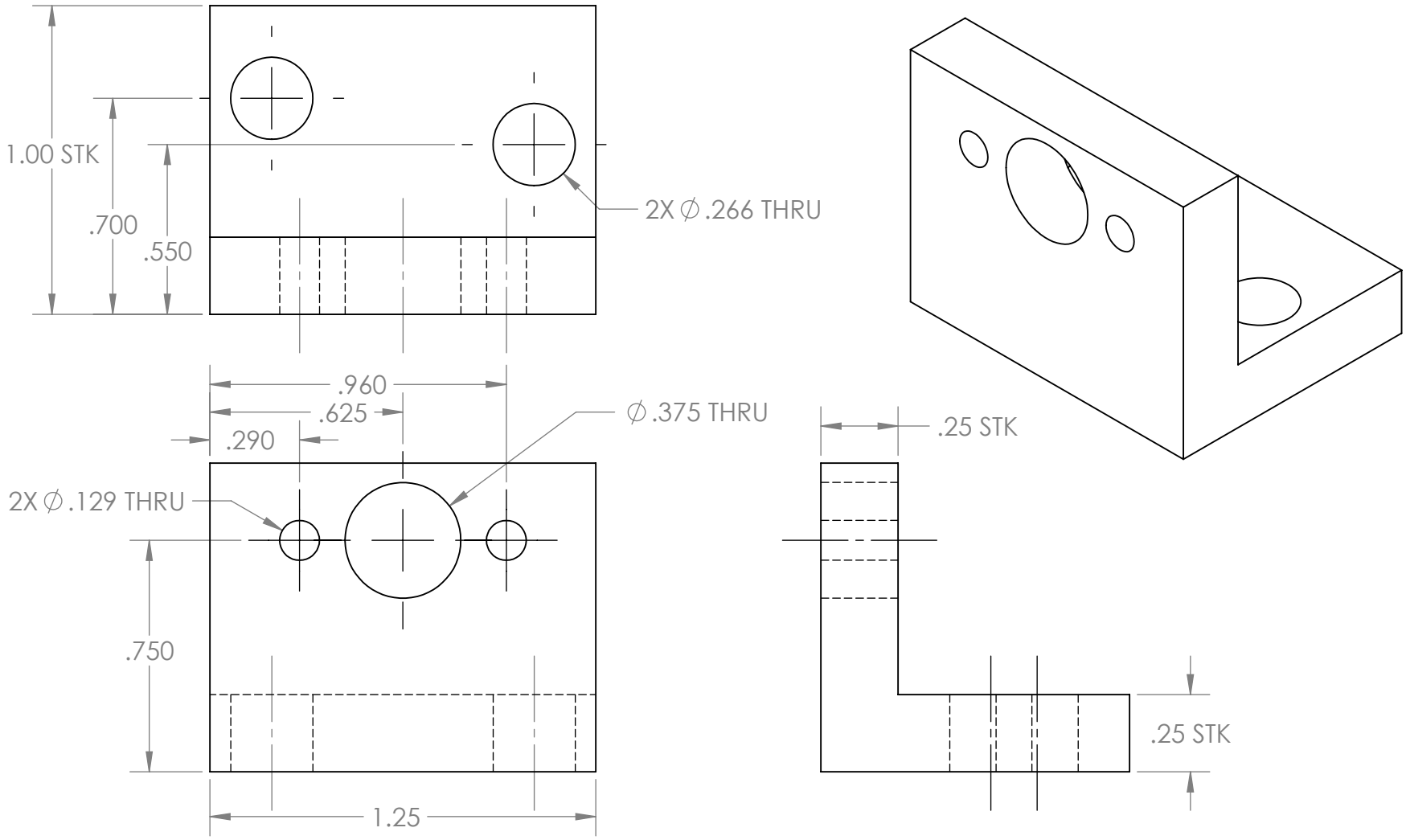

DRAWING & MANUF. PLAN CHECKS:
- PART FULLY DIMENSIONED
- APPROPRIATE DATUM LINES
- TOLERANCES SPECIFIED
- MATERIAL/QUANTITY SPECIFIED
- IF APPLICABLE, REAMER CALLED OUT
- APPROPRIATE TOOL SPEEDS
- APPROPRIATE DRILL/TAP SIZES
- SPECIFIED ALL NECESSARY TOOLS/SIZES NECESSARY
- RAW STOCK CUT OVERSIZED
-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

REV 1	INITIAL RELEASE
REV 2	FIXED DIMENTIONS

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" x 1/4" Aluminum

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:

MOTOR BRACKET

SIZE	DWG. NO.	REV
A	P103_07	2

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 1.250"	Bandsaw	Bandsaw Vise	---	---
2	Deburr part	File		File	
	Face off both sides and meausre with caliper	Mill	Vise L - stock Block	1/4" endmill with chuck	1000
3	Sercure 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 L - stock Block		
4	Find Center using the edge where the 90 degree angle occurs and the top edge	Mill	Vise L - stock Block	Edge Finder with Chuck	1000
5	centerdrill	Mill	Vise L - stock Block	Centerdrill with chuck	800
6	Drill center .375" clearance hole through the material	Mill	Vise L - stock Block	3/8 Drill Bit with chuck	800
7	centerdrill	Mill	Vise L - stock Block	Centerdrill with chuck	1600
8	Drill the left .129" clearance hole through the material	Mill	Vise L - stock Block	#30 Drill Bit with chcuk	1600
9	centerdrill	Mill	Vise L - stock Block	Centerdrill with chuck	1600
10	Drill the right .129" clearance hole through the material	Mill	Vise L - stock Block	#30 Drill Bit with chuck	1600
11	Rotate Part				
12	Part is already centered using the same vice stop location	Mill	Vise L - stock Block	Edge Finder	1000
13	centerdrill	Mill	Vise L - stock Block	Centerdrill with chuck	1400
14	Drill the left .266" clearance hole through the material	Mill	Vise L - stock Block	.266 Drill Bitt with chuck	1400
15	centerdrill	Mill	Vise L - stock Block	Centerdrill with chuck	1400
16	Drill the right .266" clearance hole through the material	Mill	Vise L - stock Block	.266 Drill Bit with chuck	1400
17	Deburr part	file		file	