

MANUFACTURING PLAN

RAW MATERIAL STOCK: Aluminum Plate, 1/4" Thick

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Outside Shape has been waterjetted	Water Jet			
2	Secure part on vise	Mill	Vise		
3	Mill both ends of the part, just enough to provide a fully milled surface	Mill	Vise	7/16" endmill, 1/2" collet	850
4	Find X and Y datum	Mill	Vise	Edge finder	1000
5	Ream 3/8", center at X=.25" from left, Y = .25"	Mill	Vise	7/16" endmill, 3/8" collet	850
6	Ream .19", center at X=.25" from right, Y = .25"	Mill	Vise		850
7	Remove part from Vice and turn 90 degrees to Mill 1/4" edge	Mill	Vise		
8	Find X and Y datum	Mill	Vise	Edge finder	1000
9	Ream .09", center at X=.25" from left, Y= .06"	Mill	Vise		

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