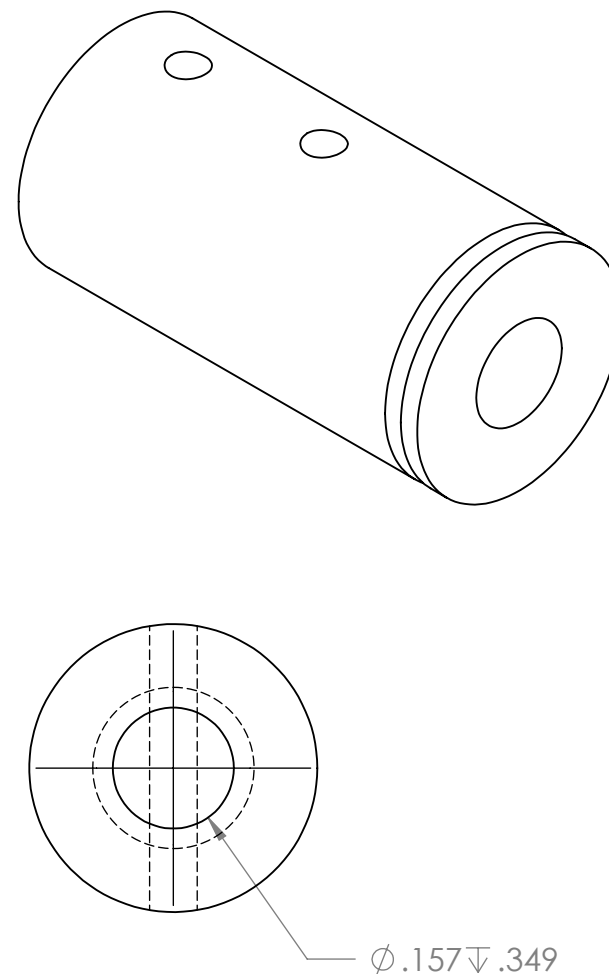


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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE: Lever Motor Arm		
		DIMENSIONS ARE IN INCHES	DRAWN	abirnb	10/24			
		TOLERANCES: FRACTIONAL ±	CHECKED					
		ANGULAR: MACH ± BEND ±	ENG APPR.					
		TWO PLACE DECIMAL ±	MFG APPR.					
		THREE PLACE DECIMAL ±						
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.					
		MATERIAL 1" round Aluminum	COMMENTS:					
		FINISH						
NEXT ASSY	USED ON	Burr Free				SIZE A	DWG. NO. P103_04	REV 2
APPLICATION		DO NOT SCALE DRAWING				SCALE: 4:1	WEIGHT:	SHEET 1 OF 2

TITLE:
Lever Motor Arm

SIZE A	DWG. NO. P103_04	REV 2
SCALE: 4:1	WEIGHT:	SHEET 1 OF 2

MANUFACTURING PLANRAW MATERIAL STOCK: **Aluminum Round Stock, 1/4" thick**

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut part to .8"	Band Saw			300 ft/min
2	Deburr	File		File	
3	Secure Part In lathe	Lathe	Collet		
4	Lathe both ends of part to provide fully machined ends	Lathe	Collet	Cutting Tool	700
5	0 the x direction. Move tool towards part the thickness of the groove tool in the x direction and rezero the x direction. Move lathe distance to the groove in x and touch off in the z direction Move lathe an additional 0.03" in z direction to cut the groove	Lathe	Collet	Cutting Tool	700
6	Deburr	File		File	
7	Create e clip slot with parting tool	Lathe	Collet	Parting Tool	100
8	Touch Off will drill bit head	Lathe	Collet	Cutting Tool	700
9	Make center hole for drilling	Lathe	Collet	Centerdrill	700
10	drill hole	Lathe	Collet	size 21 drill with drill chuck	100
11	Deburr	file		file	
12	place flat ends agianst ends of vice in mill with 1.375" parallels	mill	vise 1.375" parallels		
13	find X Y datums of part of part	mill	vise 1.375" parallels	edge finder will drill chuck	100
14	Drill center hole for both holes	mill	vise 1.375" parallels	centerdrill with drill chuck	700
15	drill .062 hole spring pin	mill	vise 1.375" parallels	.062 drill bit with drill chuck	700
16	Deburr	file		File	