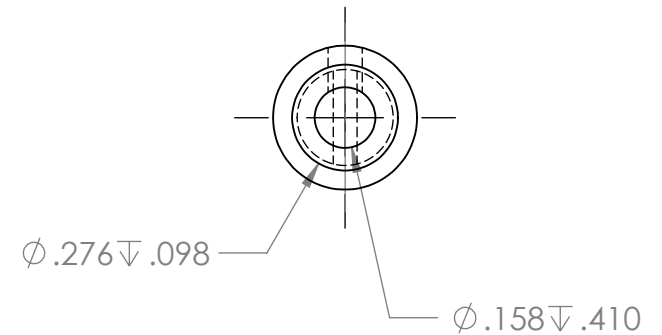
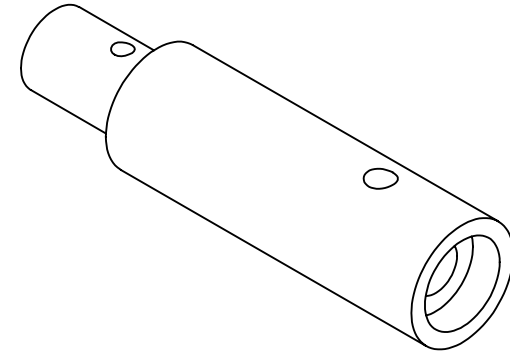
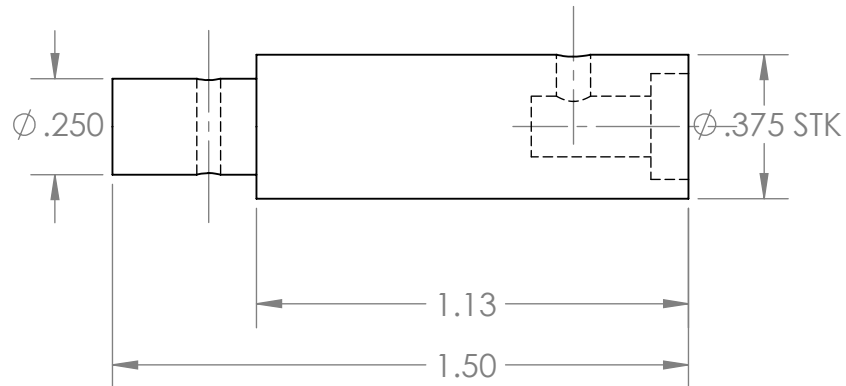
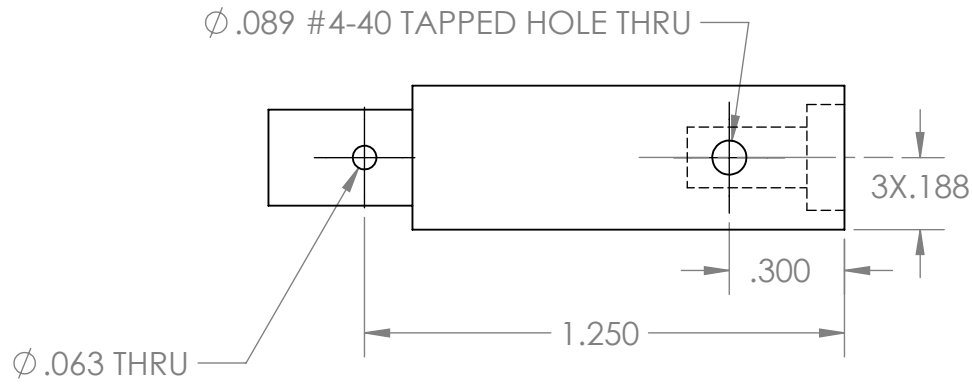


B



B

A

A

PROPRIETARY AND CONFIDENTIAL
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF <INSERT COMPANY NAME HERE>. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF <INSERT COMPANY NAME HERE> IS PROHIBITED.

REV 1	INITIAL RELEASE	UNLESS OTHERWISE SPECIFIED:
REV 2	FIXED DIMENTIONING	DIMENSIONS ARE IN INCHES
REV 3	Fix sheet format	TOLERANCES:
		FRACTIONAL \pm
		ANGULAR: MACH \pm BEND \pm
		TWO PLACE DECIMAL \pm
		THREE PLACE DECIMAL \pm
		INTERPRET GEOMETRIC TOLERANCING PER:
		MATERIAL
		1/2" Aluminum
NEXT ASSY	USED ON	FINISH
		Burr Free
APPLICATION		DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	ABIRNB	10/26/21
CHECKED	ABIRNB	10/2/21
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		
Quantity:1		

ME 250 Team 103

TITLE:

Connecting shaft

SIZE	DWG. NO.	REV
A	P103_08	3
SCALE: 2:1	WEIGHT:	SHEET 1 OF 2

MANUFACTURING PLAN

RAW MATERIAL STOCK:

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut out .625" of 3/8" aluminum stock	-	-	-	300 ft/min
2	Deburr the ends of the surfaces	Lathe	-	File	-
3	Place in lathe and face off to get a machined surface	Lathe	Collet	Cutting tool	File
4	Deburr the part	-	-	File	-
5	Remove part from lathe and flip	-	-	-	-
6	Repeat steps 3 and 4	Callipers	-	-	-
7	Remove part from lathe and measure with callipers	Lathe	-	-	-
8	touch off with parting tool and zero x. Cut to length taking passes of 0.050" or less	Lathe	Collet	Parting Tool	750
9	Trim the final .375 inches down to a 0.25" diameter	Lathe	Collet	Parting Tool	750
10	On the thicker side of the shaft, drill a .276" diamter hole .098 deep	Lathe	Collet	Size H drill	1000
11	Center Drill about the part	Lathe	-	-	-
12	Zero Out drill at the end of the big hole and drill in .410" with diameter .158"	-	Collet	Drill Chuck	1400
13	Deburr the part	Mill	-	File	-
14	Use edgfinder to locate X and Y coordinates of edges	Mill	-	Edge FINDER	1000
15	Use center drill Drill a thru hole .300" in from the thick end of the shaft with a major diameter of .089"	Mill	Vise 1	#43 Drill	1600
16	Drill a thru hole .38" off the thin end with a .062" diameter	Mill	Vise 1	1/16 Drill	1000
17	Tap 4-40 thread	Mill	Vise 1	Tap	-
17	Deburr the THRU holes	-	-	-	-

SHEET 2 OF 2