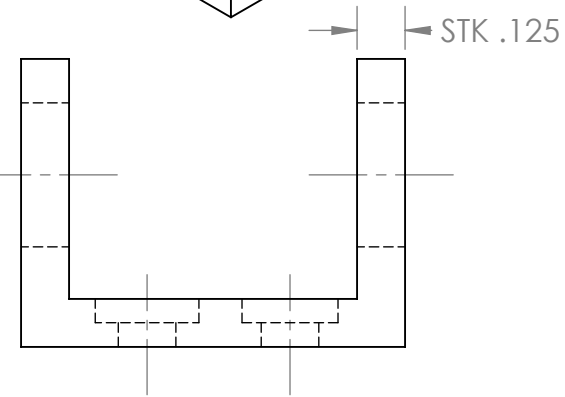
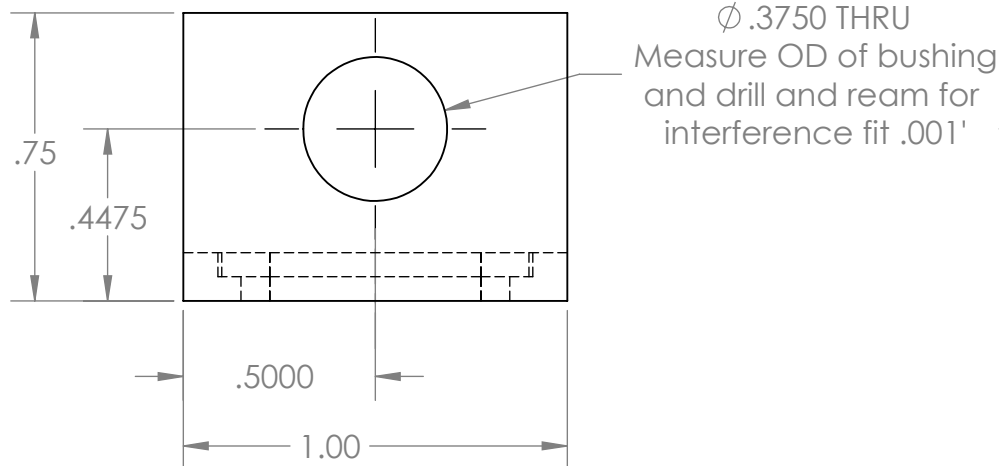
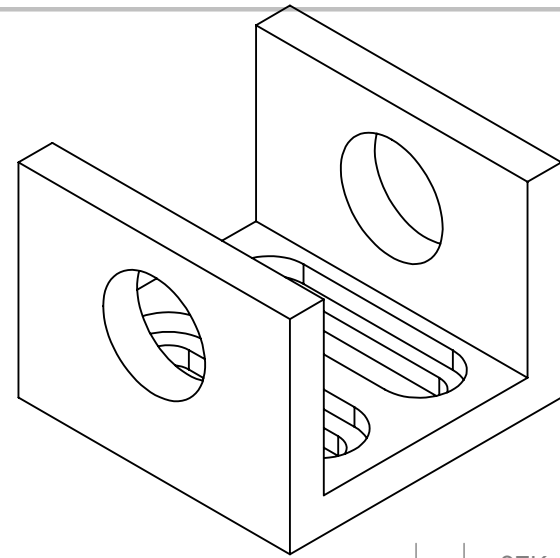
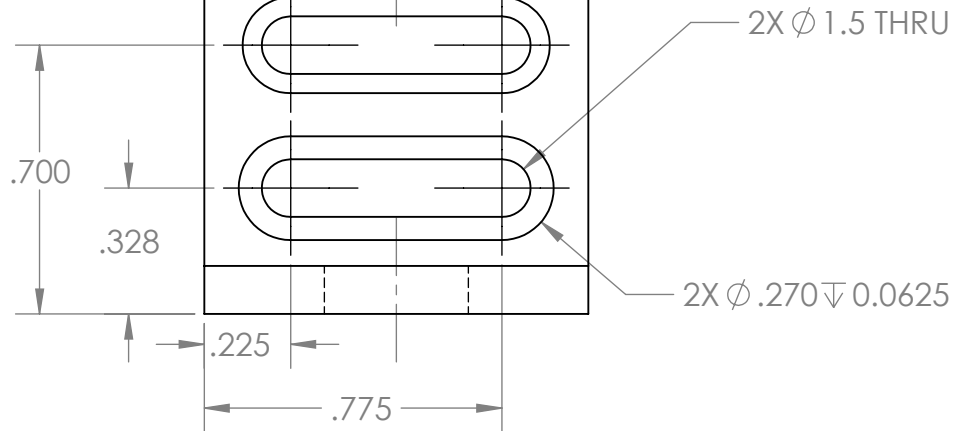


B

B

**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

MADE DOUBLE SIDED

REV 3

DIMENSIONED

**UNLESS OTHERWISE SPECIFIED:**

DIMENSIONS ARE IN INCHES

**TOLERANCES:**

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

INTERPRET GEOMETRIC  
 TOLERANCES PER: ASME Y14.5-2009

MATERIAL  
 1" x 1" x 1/8" Aluminum

FINISH

BURR FREE

REVISION BLOCK

DO NOT SCALE DRAWING

NAME DATE

DRAWN

DKFREELA 11/5/21

CHECKED

ABIRNB 11/5/21

GSI/IA APPR.

SHOP APPR.

INSPECTED

COMMENTS:

ME 250 TEAM 103

TITLE:

SQUARE BRACKET

SIZE

A

DWG. NO.

P103\_15

REV

3

SCALE: 2:1

QUANTITY: 2

SHEET 1 OF 2

**MANUFACTURING PLAN**

RAW MATERIAL STOCK: 1" x 1" x 1/8" Square Aluminum Tube

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut down to 1.25" in bandsaw	bandsaw			300 ft/sec
2	place in vise	Mill	Vise with 1.375" parallels		
3	Face Off	Mill	Vise with 1.375" parallels	1/4" endmill and collet	700
3	Cut down to 1.00"	Mill	Cutting tool	1/4" endmill and collet	700
4	Centerdrill	Mill	Vise with 1.375" parallels	Drill Chuck and centerdrill	100
5	Drill .375" hole thru	Mill	Vise with 1.375" parallels	H bit with drill chuck	700
6	Ream hole	Mill	Vise with 1.375" parallels	3/8" Ream	100
7	Filp part	Mill	Vise with 1.375" parallels	-	-
8	Cut off top of part with passes	Mill	Vise with 1.375" parallels	3/8" Endmill with collet	700
9	Cut Counterbore with H cutting bit with .0625" depth	Mill	Vise with 1.375" parallels	H bit with collet	700
10	Cut slot thru	Mill	Vise with 1.375" parallels	#25 Bit with collet	1100
11	Deburr	file	-	file	