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Please use the ME 250 Drawing Template from canvas

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REV 1	Initial Release	UNLESS OTHERWISE SPECIFIED:
REV 2	Edit Dimetrnions	DIMENSIONS ARE IN INCHES
REV 3	Formating of sheet	TOLERANCES:
REV 4	Editing Manufacturing plan	FRACTIONAL ±
		ANGULAR: MACH ± BEND ±
		TWO PLACE DECIMAL ± 0.010
		THREE PLACE DECIMAL ± 0.005
		INTERPRET GEOMETRIC TOLERANCING PER:
		MATERIAL
		3/8" round Aluminum
		FINISH
		Burr Free
NEXT ASSY	USED ON	
APPLICATION		DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	abirnb	10/24
CHECKED	abirnb	10/27
ENG APPR.	pcproach	10/28
MFG APPR.	DW F21	
Q.A.	10/28/2021	
COMMENTS:		
Quantity = 1		

ME 250 TEAM 103		
TITLE:		
Lever Motor Arm Axel		
SIZE	DWG. NO.	REV
A	P103_04	4
SCALE: 4:1	WEIGHT:	SHEET 1 OF 2

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MANUFACTURING PLANRAW MATERIAL STOCK: **Aluminum Round Stock, 3/8" 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	1000 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	Make center hole for drilling	Lathe	Collet	Centerdrill with drill chuck	1200 700
8	Touch Off will drill bit head	Lathe	Collet	Cutting Tool	700
9	drill hole	Lathe	Collet	size 21 drill with drill chuck	1400 700
10	Deburr	file		file	
11	place flat ends against ends of vice in mill with 1.375" parallels	mill	vise 1.375" parallels		
12	find X Y datums of part of part	mill	vise 1.375" parallels	edge finder will drill chuck	1000
13	Drill center hole	mill	vise 1.375" parallels	centerdrill with drill chuck	1200 700
1	drill .062 hole spring pin	mill	vise 1.375" parallels	1/16" drill bit with drill chuck	1600 700
15	Drill center hole	mill	vise 1.375" parallels	centerdrill with drill chuck	1200 700
16	drill .062 hole spring pin	mill	vise 1.375" parallels	1/16" drill bit with drill chuck	1600 700
17	Deburr	file		File	