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

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

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut part to 1/2"	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 drill	mill	vise 1.375" parallels	centerdrill with drill chuck	700
15	drill .089 hole for 4-40 tap	mill	vise 1.375" parallels	.089 drill bit with drill chuck	700
16	thread hole 4-40	mill	vise 1.375" parallels	4-40 tap with drill chuck	
17	Deburr	file		File	