

## MANUFACTURING PLAN

В

RAW MATERIAL STOCK: 1" x 1" x 1/4" Aluminum Angle Stock

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut Raw Stock 1,250"	Bandsaw	Bandsaw Vise		
2	Deburr part	File		File	
3	Sercure Angle stock in mill with the back edge on top and other edge on the outside of the parallels around .25" away from vice and use vice stop to constrain in X direction	Mill	Vise 1.5" parallels		
4	Find Center using the edge where the 90 degree angle occurs and the top edge	Mill	Vise 1.5" parallels	Edge Finder with Chuck	1000
5	centerdrill all three holes	Mill	Vise 1.5" parallels	Centerdrill with chuck	700
6	Drill center .375" clearance hole through the material	Mill	Vise 1.5" parallels	13/32 Drill Bit/ 7/16" Collet	700
7	Drill the left .12" clearance hole through the material	Mill	Vise 1.5" parallels	#30 Drill Bit/ 1/4" Collet	700
8	Drill the right .12" clearance hole through the material	Mill	Vise 1.5" parallels	#30 Drill Bit/ 1/4" Collet	700
9	Rotate Part				
10	Part is already centered using the same vice stop location	Mill	Vise 1.5" parallels	Edge Finder	1000
11	centerdrill both holes	Mill	Vise 1.5" parallels	Centerdrill with chuck	100
12	Drill the left .12" clearance hole through the material	Mill	Vise 1.5" parallels	#30 Drill Bit/ 1/4" Collet	700
13	Drill the right .12" clearance hole through the material	Mill	Vise 1.5" parallels	#30 Drill Bit/ 1/4" Collet	700
14	Deburr part	file		file	

SHEET 2 OF 2

В