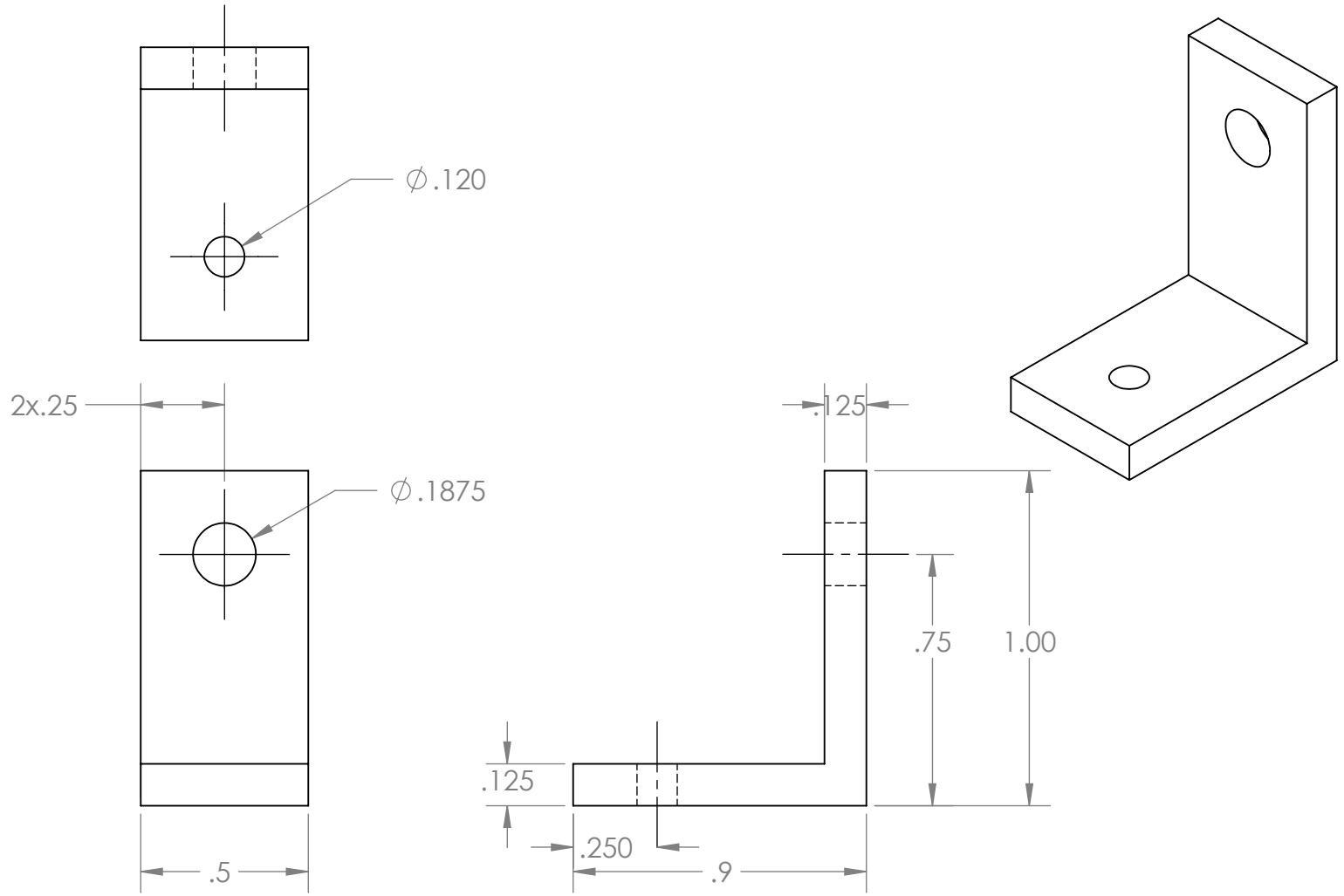

DRAWING & MANUF. PLAN CHECKS:
- PART FULLY DIMENSIONED
- APPROPRIATE DATUM LINES
- TOLERANCES SPECIFIED
- MATERIAL/QUANTITY SPECIFIED
- IF APPLICABLE, REAMER CALLED OUT
- APPROPRIATE TOOL SPEEDS
- APPROPRIATE DRILL/TAP SIZES
- SPECIFIED ALL NECESSARY TOOLS/SIZES NECESSARY
- RAW STOCK CUT OVERSIZED
- STEPS TO GET ALL ALL MACHINED/STOCK SURFACES

REV	
1	INITIAL RELEASE

REVISION BLOCK

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:
MACHINED ANGULAR: ± 1°
BENT ANGULAR: ± 3°
TWO PLACE DECIMAL: ± 0.01
THREE PLACE DECIMAL: ± 0.005

INTERPRET GEOMETRIC TOLERANCES PER: ASME Y14.5-2009

MATERIAL
Aluminum

FINISH
BURR FREE

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	DKFREELA	10/26/21
CHECKED	XX	XX/XX/XX
GSI/IA APPR.		
SHOP APPR.		
INSPECTED		

COMMENTS:

ME 250 TEAM 103

TITLE:

SMALL L BRACKET

SIZE	DWG. NO.	REV
A	P103_006	1

SCALE: 2:1 | QUANTITY: 1 | SHEET 1 OF 2

MANUFACTURING PLAN

RAW MATERIAL STOCK: Aluminum 1"x1" Angle Stock

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Cut Raw Stock	Bandsaw	Bandsaw Vise	---	---
2	Find Center	Mill	Vise 1.375"	Edge Finder with Chuck	100
3	centerdrill	Mill	Vise 1.375"	Centerdrill with chuck	100
4	Drill Bottom Hole	Mill	Vise 1.375"	#30 Drill Bit/ 1/4" Collet	700
5	Rotate Part				
6	Find Center (TOP)	Mill	Vise 1.375"	Edge Finder	100
7	centerdrill	Mill	Vise 1.375"	Centerdrill with chuck	100
8	Drill Top Hole	Mill	Vise 1.375"	13/64" Drill Bit, 3/8" Collet	700
9	Ream Top Hole	Mill	Vise 1.375"	3/8" Collet, 3/8" Ream	100
10	Face Front Side	Mill	Vise 1.375"	7/16" Endmill, 7/16" Collet	850