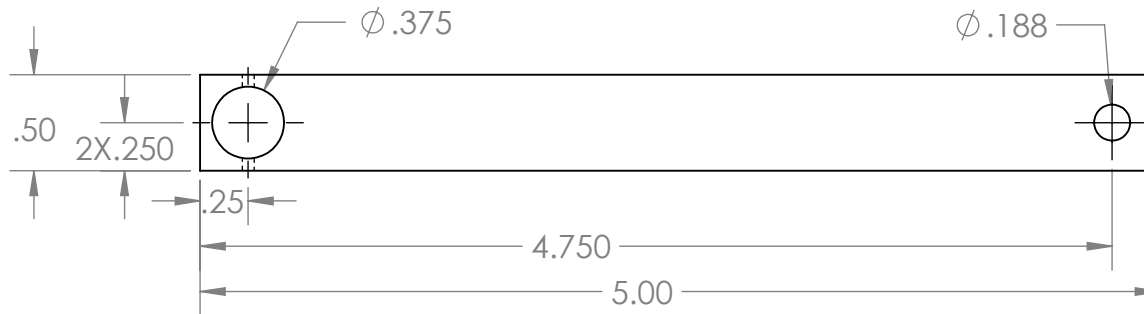
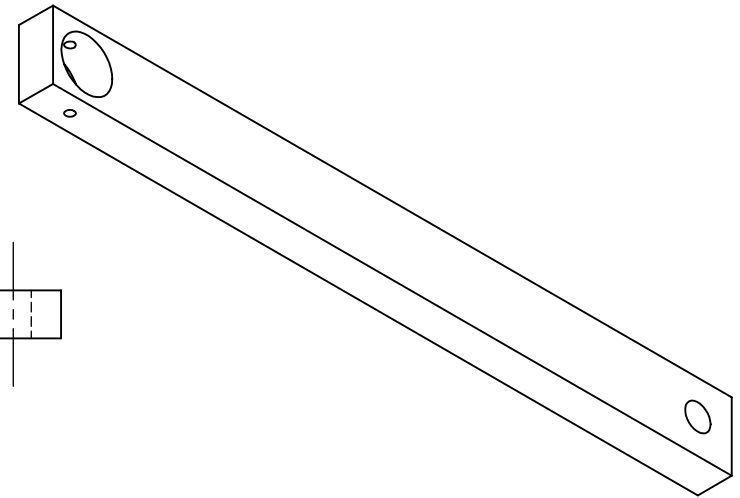
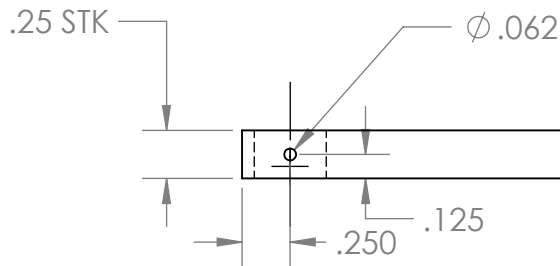


B

B



A

A

**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

**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  
Aluminum Plate, 1/4"

FINISH

BURR FREE

REVISION BLOCK

DO NOT SCALE DRAWING

DRAWN

NAME DATE

CHARLES RENZ 10/21/2021

CHECKED

XX XX/XX/XX

GSI/IA APPR.

SHOP APPR.

INSPECTED

COMMENTS:

ME 250 TEAM 103

TITLE:

LEFT\_LEVER\_ARM

SIZE

A

DWG. NO.

P103\_02

REV

02

SCALE: 1:1

QUANTITY: 1

SHEET 1 OF 2

**MANUFACTURING PLAN**

RAW MATERIAL STOCK: Aluminum Plate, 1/4" Thick

STEP	PROCESS DESCRIPTION	MACHINE	FIXTURE	TOOL(S)	SPEED (RPM)
1	Outside Shape has been waterjetted	Water Jet			
2	Deburr	File		File	
3	Secure part on vise	Mill	Vise 1.375" parallels		
4	Find X and Y datum	Mill	Vise 1.375" parallels	Edge finder with drill chuck	1000
5	Center drill	Mill	Vise 1.375" parallels	Centerdrill with chuck	700
6	Drill Hole .375"	Mill	Vise 1.375" parallels	3/8" drill with chuck	700
7	Drill hole .188"	Mill	Vise 1.375" parallels	.188 drill with chuck	700
8	Ream 3/8", center at X=.25" from left, Y = .25"	Mill	Vise 1.375" parallels	3/8 ream with chuck	100
9	Ream .188", center at X=.25" from right, Y = .25"	Mill	Vise 1.375" parallels	.188" ream with chuck	100
10	Remove part from Vice and turn 90 degrees to Mill 1/4" edge	Mill	Vise 1.375" parallels		
11	Find X and Y datum	Mill	Vise 1.375" parallels	Edge finder	1000
12	Center drill for .062" hole center at X=.25" from left, Y= .06"	Mill	Vise 1.375" parallels	Centerdrill with chuck	700
13	Drill for .062" hole	Mill	Vise 1.375" parallels	.062 drill with chuck	700
14	Deburr	file		file	