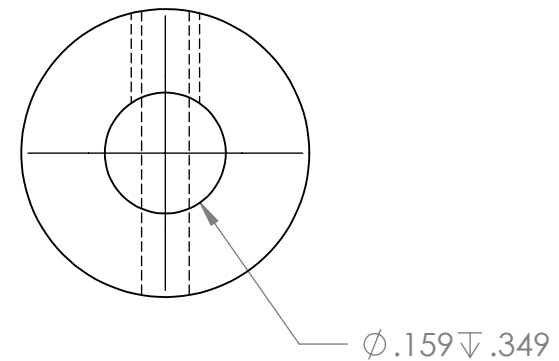
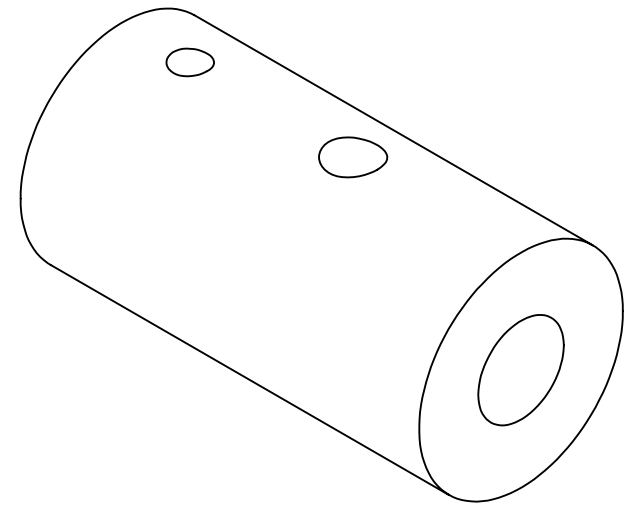
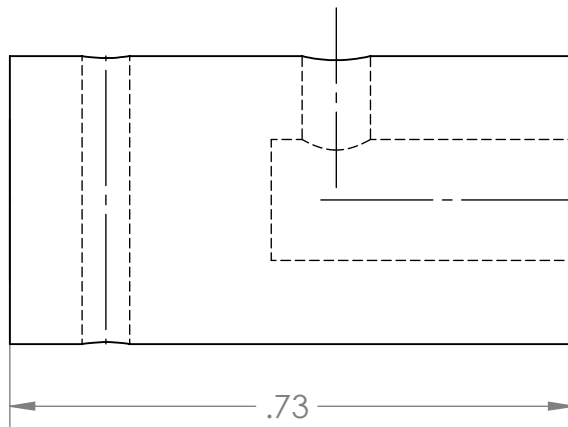
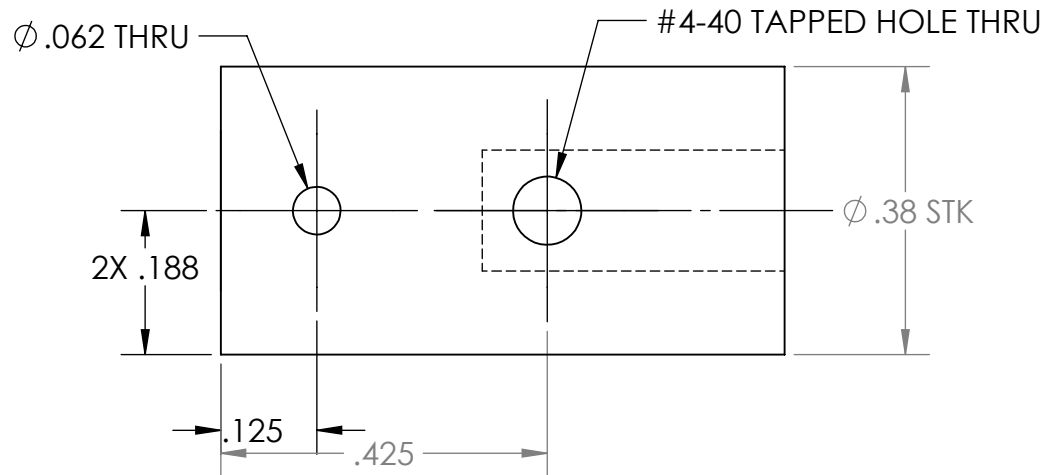


B

B



A

A

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REV 1	Initial Release	UNLESS OTHERWISE SPECIFIED:
REV 2	Edit Dimetnions	DIMENSIONS ARE IN INCHES
REV 3	Formating of sheet	TOLERANCES:
REV 4	Editiing Manufacturing plan	FRACTIONAL $\pm$
REV 5	Chanigng to set screw	ANGULAR: MACH $\pm$ BEND $\pm$
		TWO PLACE DECIMAL $\pm$
		THREE PLACE DECIMAL $\pm$
		INTERPRET GEOMETRIC TOLERANCING PER:
		MATERIAL
		3/8" round Aluminum
NEXT ASSY	USED ON	FINISH
		Burr Free
APPLICATION		DO NOT SCALE DRAWING

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

ME 250 TEAM 103

TITLE:

Lever Motor Arm  
Axel

SIZE	DWG. NO.	REV
<b>A</b>	P103_09	5
SCALE: 4:1	WEIGHT:	SHEET 1 OF 2

**MANUFACTURING PLAN**RAW 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	700
5	Deburr	File		File	
6	Make center hole for drilling	Lathe	Collet	Centerdrill with drill chuck	1400
7	Touch Off will drill bit head	Lathe	Collet	Cutting Tool	1400
8	drill hole	Lathe	Collet	size 21 drill with drill chuck	1400
9	Deburr	file		file	
10	place flat ends against ends of vice in mill with 1.375" parallels	mill	Collet blocks and vise		
11	find X Y datums of part of part	mill	collet blocks and vise	edge finder will drill chuck	1000
12	Drill center hole	mill	collet blocks and vise	centerdrill with drill chuck	1600
13	drill .062 hole spring pin	mill	collet blocks and vise	1/16" drill bit with drill chuck	1600
14	Use center drill Drill a thru hole .300" in from the thick end of the shaft with a major diameter of .089"	Mill	collet blocks and vise	#43 Drill with drill chuck	1600
15	Drill a thru hole .425" off the thin end with a .089" diameter	Mill	collet blocks and vise	#43 Drill with drill chuck	1600
16	Tap 4-40 thread	Mill	collet blocks and vise	4-40 Tap drill chuck, drill chuck tap fixture	-
17	Debur	File	-	File	-