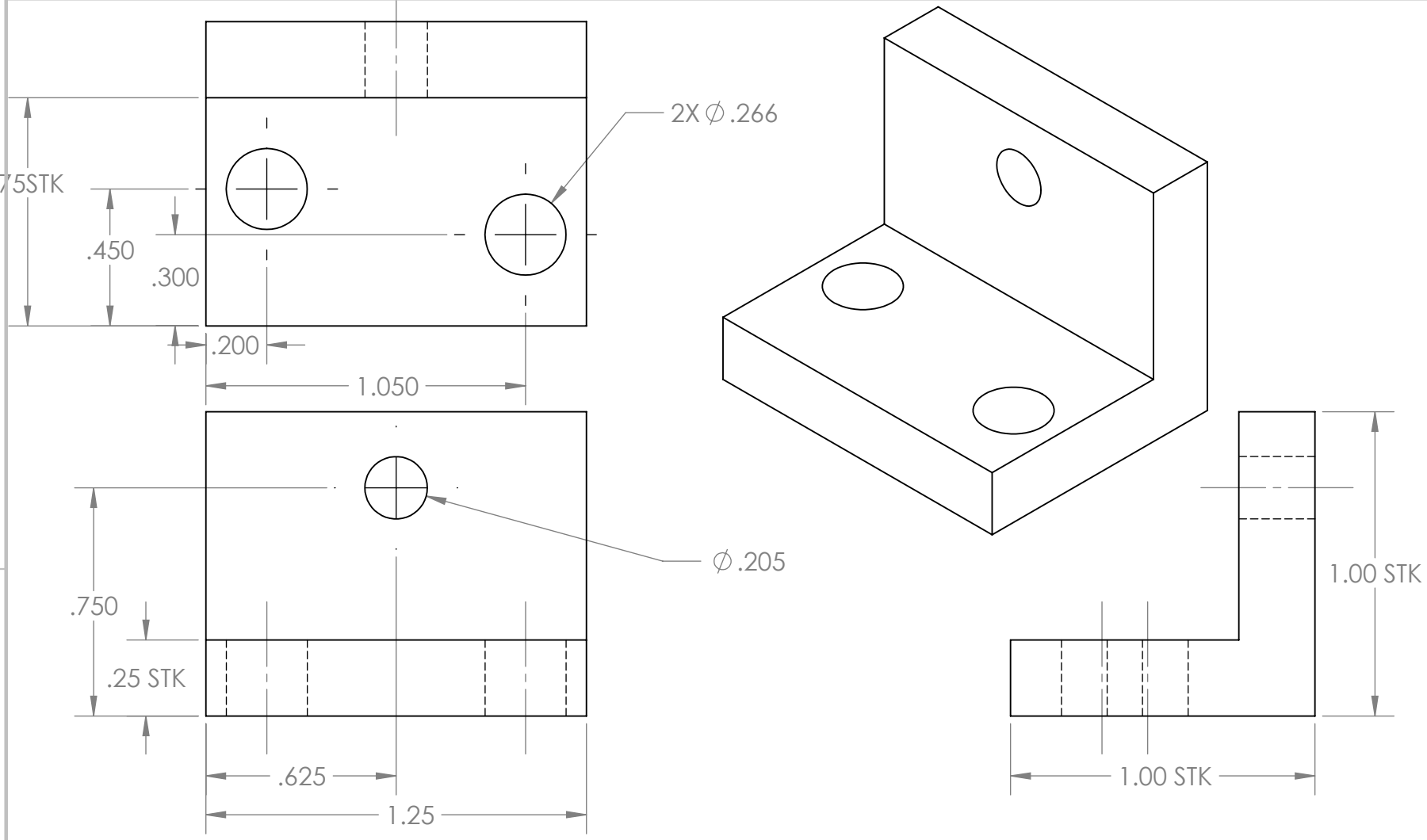

DRAWING & MANUF. PLAN CHECKS:

- 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
REV 2	COMPLETE REDESIGN NGL
REV 3	FIX FORMATTING OF MANUFACTURE PLAN

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
1" x 1" Aluminum angle stock

FINISH
BURR FREE

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	DKFREELA	10/26/21
CHECKED	CRENZ	10/27/21
GSI/IA APPR.		
SHOP APPR.		
INSPECTED		

COMMENTS:

ME 250 TEAM 103

TITLE:

SMALL L BRACKET

SIZE	DWG. NO.	REV
A	P103_06	3

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

MANUFACTURING PLAN

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	Face Both side and measure with caliper	Mill	Vise L-Stock Block	1/2" endmill with chuck	1000
4	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 L-Stock Block		
5	Find Center using the edge where the 90 degree angle occurs and the top edge	Mill	Vise L-Stock Block	Edge Finder with Chuck	1000
6	centerdrill	Mill	Vise L-Stock Block	Centerdrill with chuck	1000
7	Drill .250" clearance hole through the material	Mill	Vise L-Stock Block	.261 Drill Bit with chuck	700
8	Rotate Part				
9	Part is already centered using the same vice stop location	Mill	Vise L-Stock Block	Edge Finder	1000
10	centerdrill	Mill	Vise L-Stock Block	Centerdrill with chuck	1600
11	Drill the left .120" clearance hole through the material	Mill	Vise L-Stock Block	#30 Drill Bit with chuck	1600
12	centerdrill	Mill	Vise L-Stock Block	Centerdrill with chuck	1600
13	Drill the right .120" clearance hole through the material	Mill	Vise L-Stock Block	#30 Drill Bit with chuck	1600
14	Deburr part	file		file	