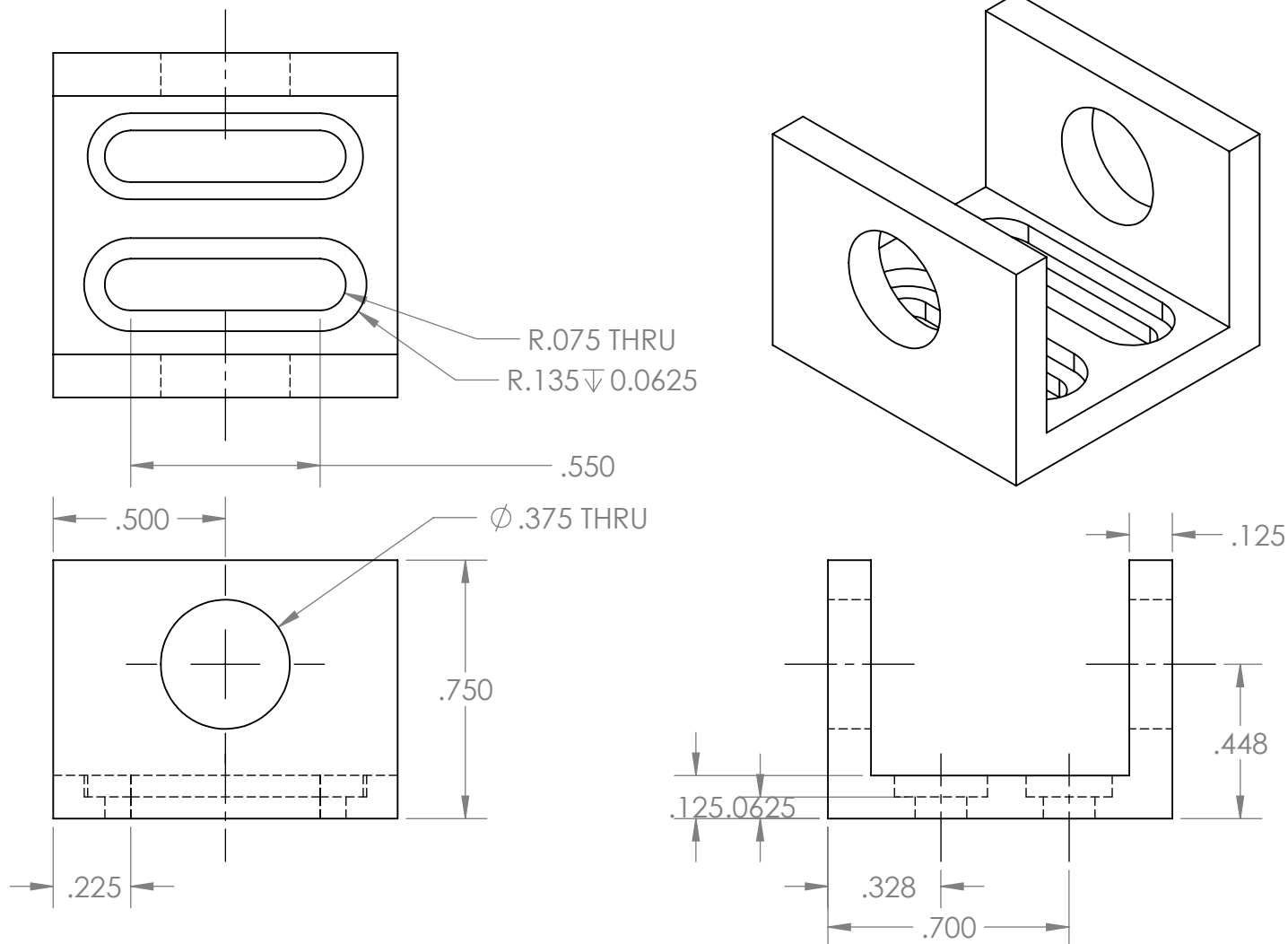


B

B

**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

**FINISH**

BURR FREE

REVISION BLOCK

DO NOT SCALE DRAWING

NAME DATE

DRAWN

DKFREELA 11/5/21

CHECKED

ABIRNB 11/5/21

GSI/IA APPR.

SHOP APPR.

INSPECTED

COMMENTS:

ME 250 TEAM 103

TITLE:

SQUARE BRACKET

SIZE

**A**

DWG. NO.

P103\_15

REV

**2**

SCALE: 2:1

QUANTITY: 2

SHEET 1 OF 2

2

1

**MANUFACTURING PLAN**

RAW MATERIAL STOCK:

| STEP | PROCESS DESCRIPTION                                      | MACHINE | FIXTURE                    | TOOL(S)                     | SPEED (RPM) |
|------|--|---------|----------------------------|-----------------------------|-------------|
| 1    | Cut down to 1.25" in bandsaw                             | bandsaw |                            |                             | 300 ft/sec  |
| 2    | place in vise  | Mill    | Vise with 1.375" parallels |                             |             |
| 3    | Cut down to 1.00"  | Mill    | Cutting tool               | Cutting Tool                | 700         |
| 4    | Centerdrill  | Mill    | Vise with 1.375" parallels |                             | 100         |
| 5    | Drill .375" hole thru                                    | Mill    | Vise with 1.375" parallels | Drill bith with drill chuck | 700         |
| 6    | Filp part  | Mill    | Vise with 1.375" parallels | -                           | -           |
| 7    | Cut off top of part with passes                          | Mill    | Vise with 1.375" parallels | Cutting tool with chuck     | 700         |
| 8    | Cut Counterbore with .137" cutting bit with .0625" depth | Mill    | Vise with 1.375" parallels | Cutting bit with chuck      | 700         |
| 9    | Cut hole thru with .075" cutting bit                     | Mill    | Vise with 1.375" parallels | cutting but with chuck      | 700         |
| 10   | Deburr   | file    | -                          | file                        |             |