

B

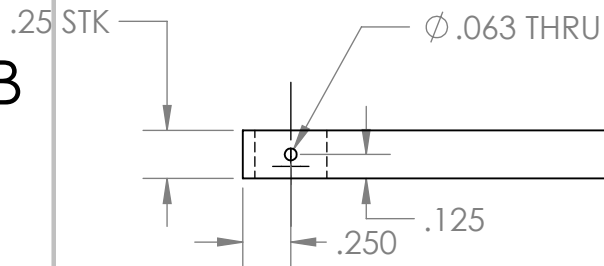
A

2

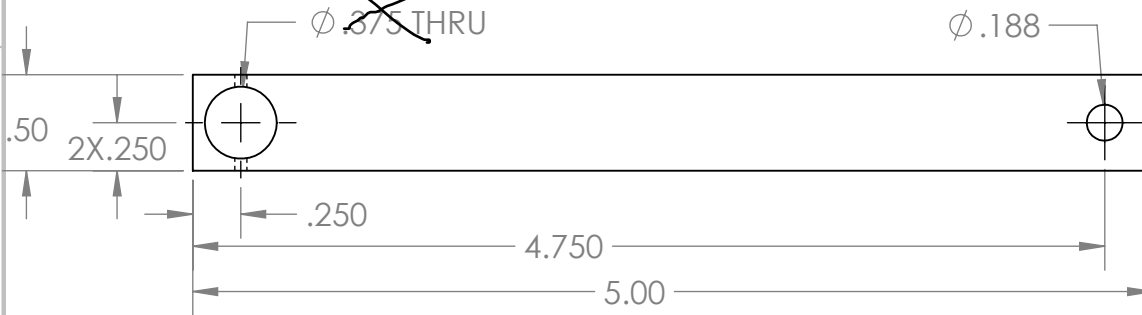
1

B

A



Measure OD of 3/8" bushing and drill and ream for interference fit of 0.001"



#### 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

FIXING DIMENTION

REV 3

FIXING MANUFACTURING PLAN

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

NAME DATE

DRAWN CHARLES RENZ 10/21/2021

CHECKED ABIRNB 10/27/21

GSI/IA APPR. pcproach 10/29

SHOP APPR. DW F21

INSPECTED 10/29/2021

COMMENTS:

ME 250 TEAM 103

TITLE:

LEFT\_LEVER\_ARM

SIZE

A

DWG. NO.

P103\_02

REV

03

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 <del>along with .188" hole</del>	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	<del>1200</del> 700
6	Drill Hole .375"	Mill	Vise 1.375" parallels	23/64" drill with chuck	700
8	Ream 3/8", center at X=.25" from left, Y = .25" <b>Center drill and drill 3/16 hole @ 1400 rpm</b>	Mill	Vise 1.375" parallels	3/8 ream with chuck	100
10	Remove part from Vise 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 with drill chuck	1000
12	Center drill for .063" hole center at X=.25" from left, Y= .06"	Mill	Vise 1.375" parallels	Centerdrill with chuck	<del>1200</del> 700
13	Drill for .063" hole	Mill	Vise 1.375" parallels	1/16" drill with chuck	<del>1600</del> 700
14	Deburr	file		file	