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

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

ME 250 TEAM 103		
TITLE:		
Lever Motor Arm Axel		
SIZE	DWG. NO.	REV
A	P103_04	4
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	0 the x direction. Move tool towards part the thickness of the groove tool in the x direction and rezero the x direction. Move lathe distance to the groove in x and touch off in the z direction Move lathe an additional 0.03" in z direction to cut the groove	Lathe	Collet	Cutting Tool	700
6	Deburr	File		File	
7	Make center hole for drilling	Lathe	Collet	Centerdrill with drill chuck	700
8	Touch Off will drill bit head	Lathe	Collet	Cutting Tool	700
9	drill hole	Lathe	Collet	size 21 drill with drill chuck	700
10	Deburr	file		file	
11	place flat ends against ends of vice in mill with 1.375" parallels	mill	vise 1.375" parallels		
12	find X Y datums of part of part	mill	vise 1.375" parallels	edge finder will drill chuck	1000
13	Drill center hole	mill	vise 1.375" parallels	centerdrill with drill chuck	700
1	drill .062 hole spring pin	mill	vise 1.375" parallels	1/16" drill bit with drill chuck	700
15	Drill center hole	mill	vise 1.375" parallels	centerdrill with drill chuck	700
16	drill .062 hole spring pin	mill	vise 1.375" parallels	1/16" drill bit with drill chuck	700
17	Deburr	file		File	