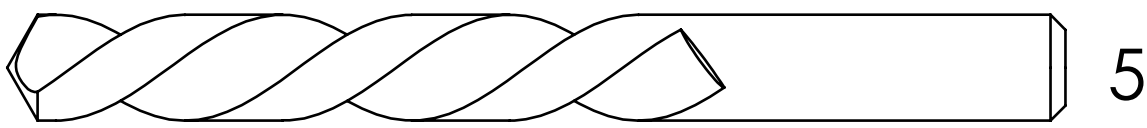
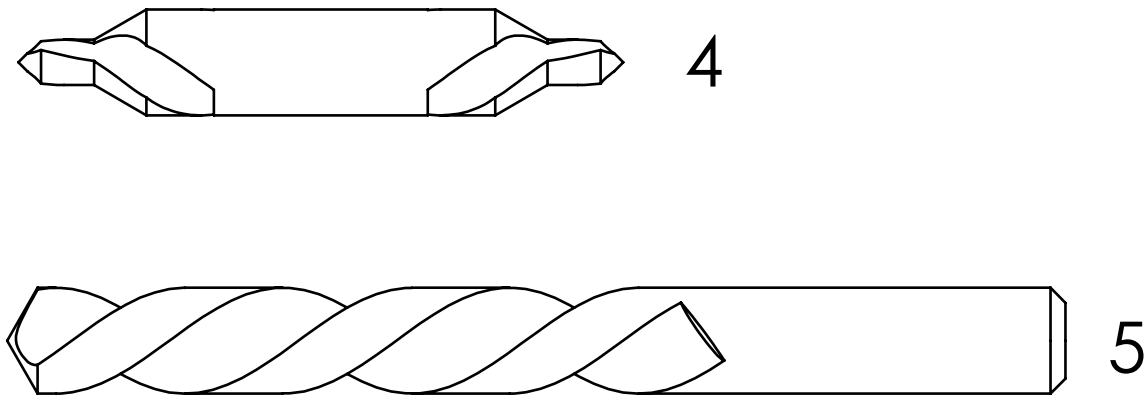
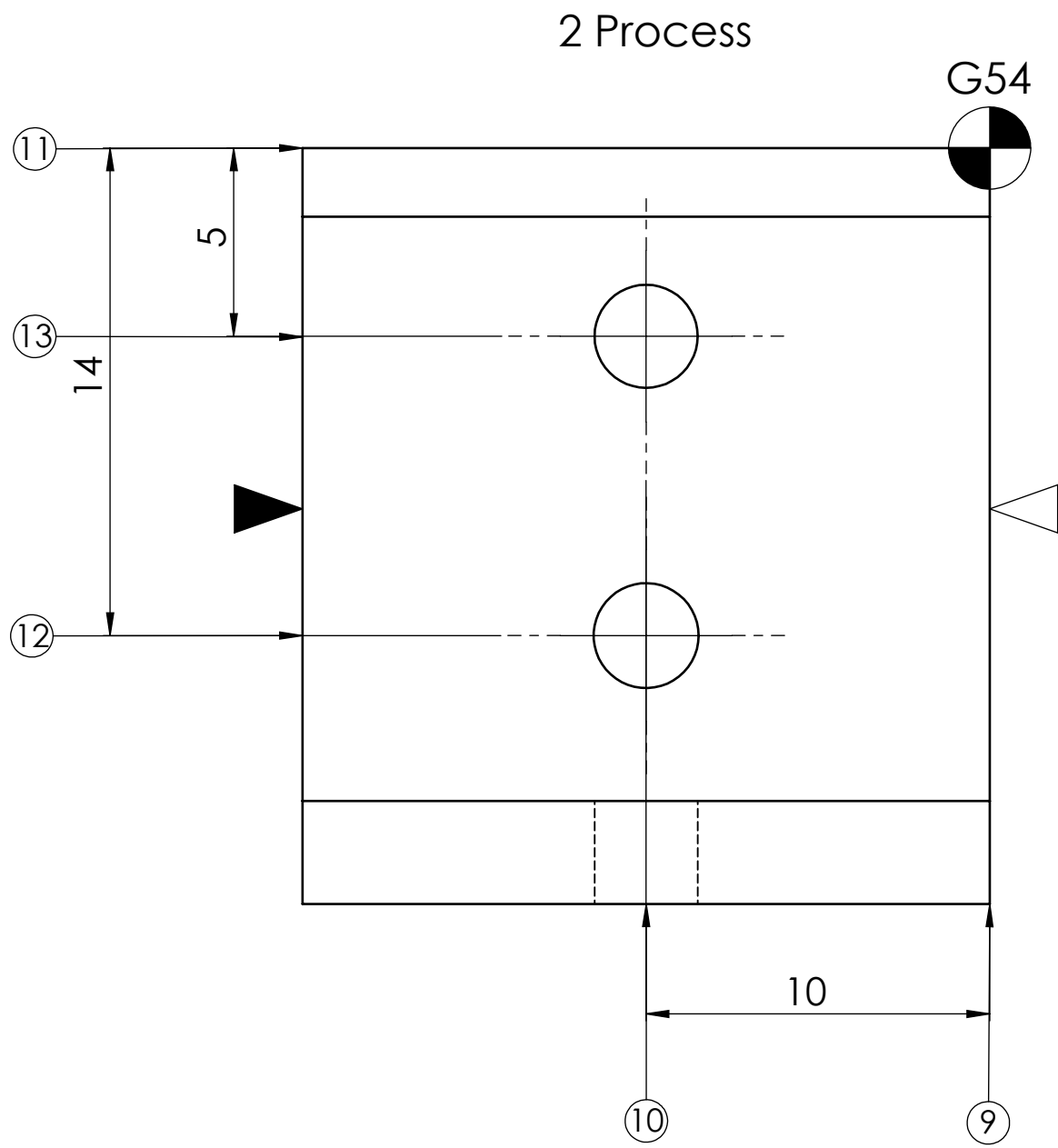
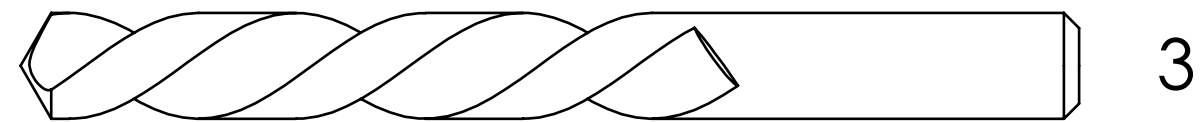
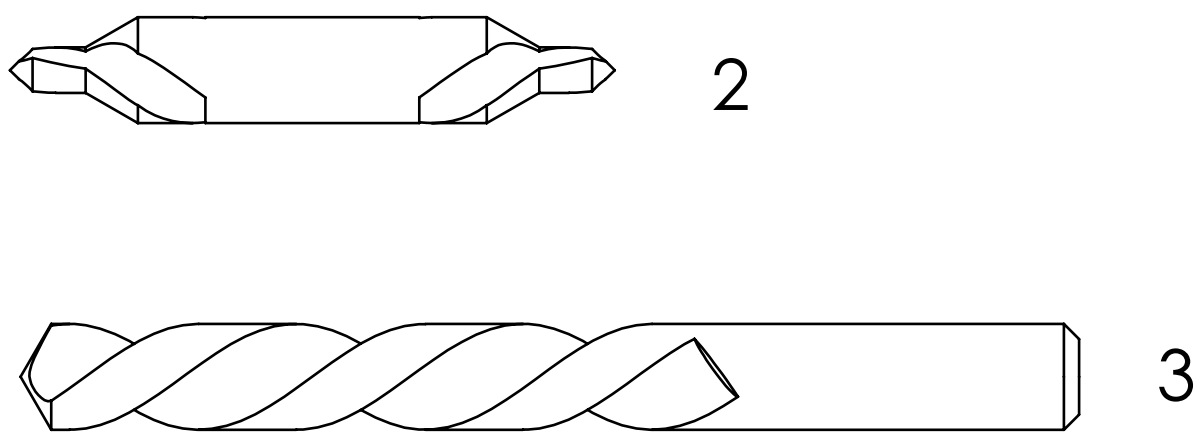
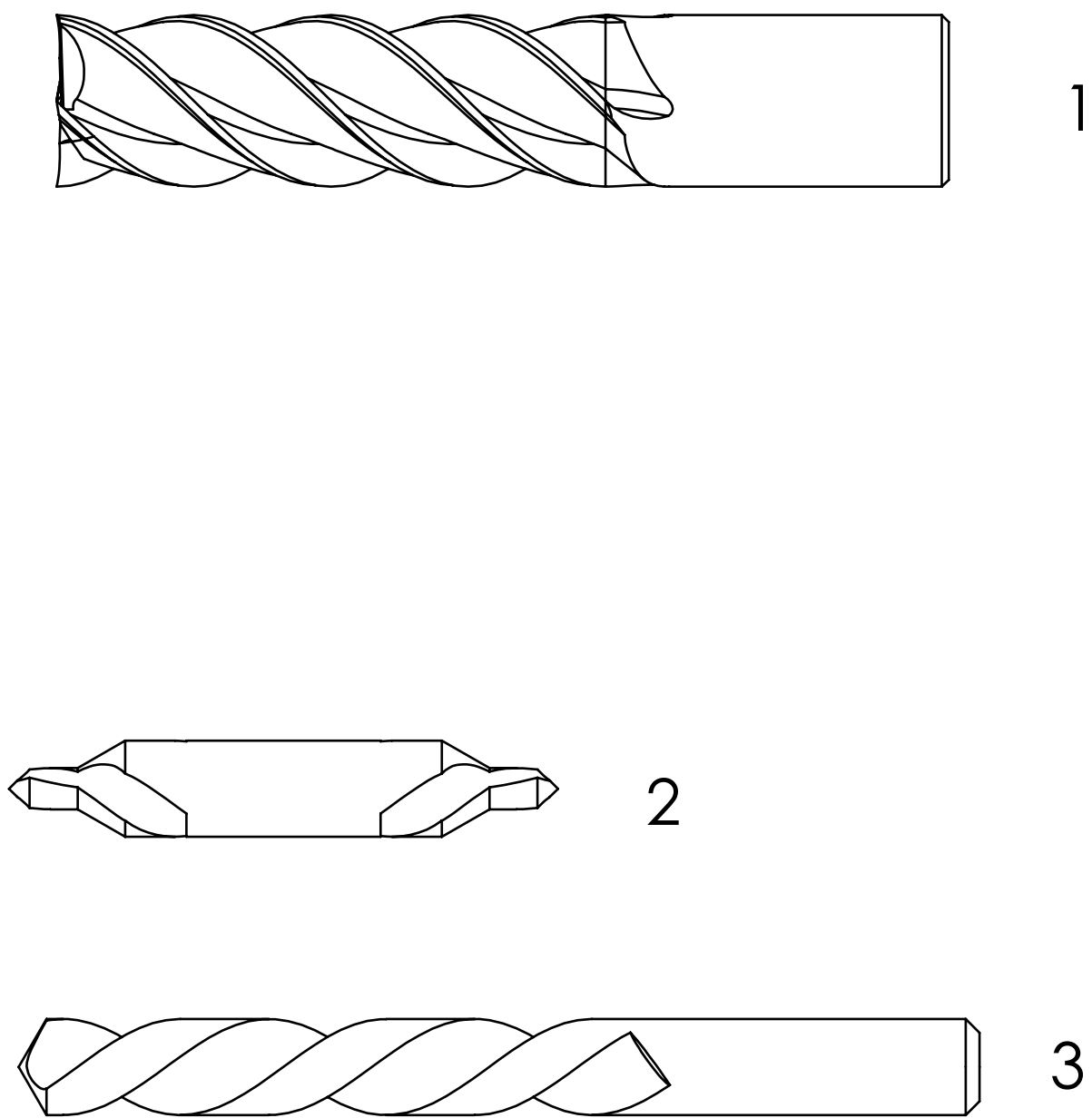
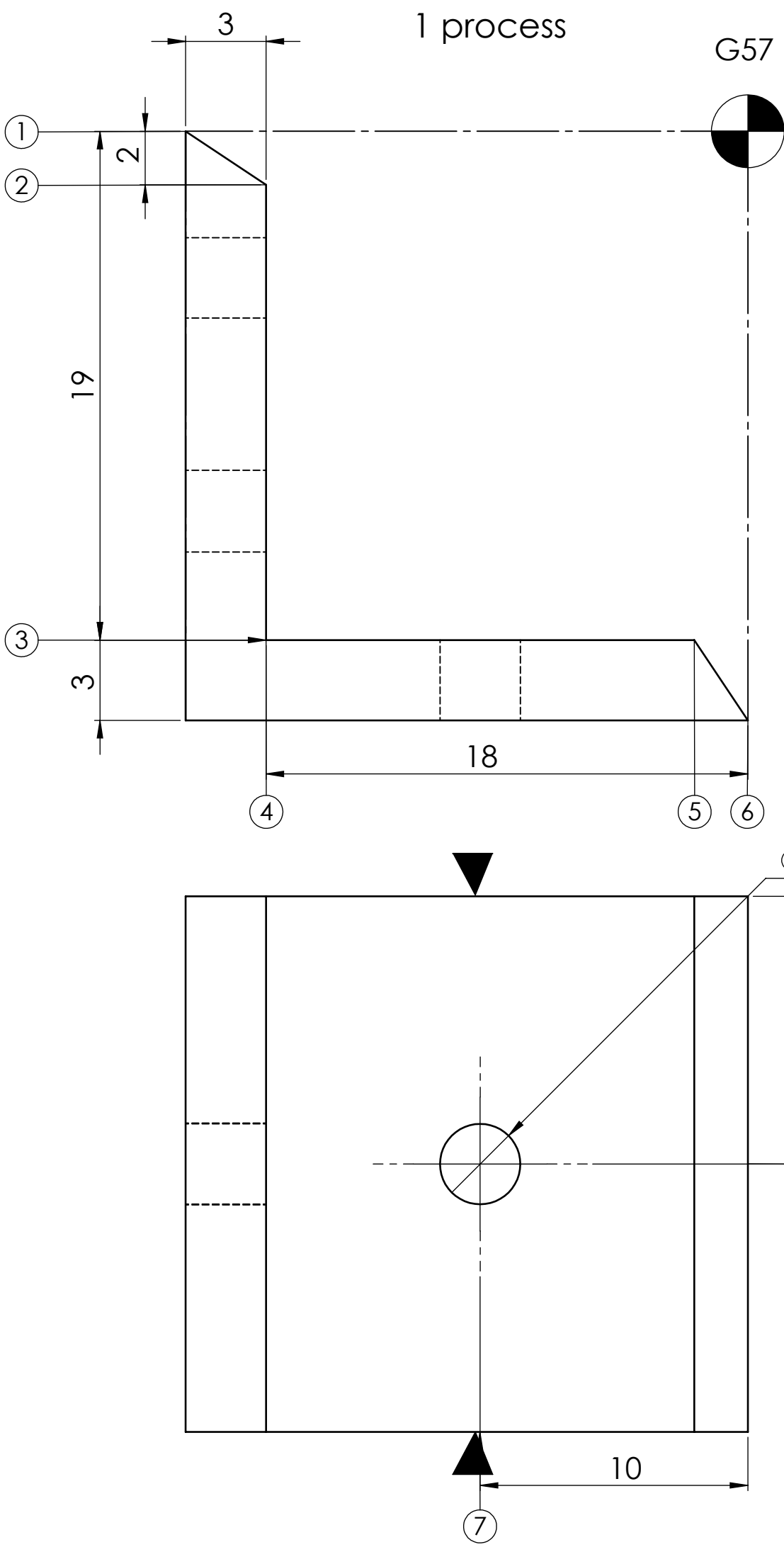


CNC Vertical milling center "HAAS Minimill" coordination sheet			
Part number:	Frame holder	Operator:	Ariharasudhan.M
Part material:	Aluminium 1060 alloy	Date of issue:	2019-05-05
part drawing marking:	MBP.122.434.005.004	Due date:	2019-06-04
Operation number:		Part count:	1
Operation name:	Milling, drilling, tapping		
Program name:	O08041		
Dimensions:	300 X 500 X10		
Holding device:	Vise		
Operation content			
Step no.	Step details		
1	End milling of point 1 to 6		
2	Center drilling of point 7 and 8 dimensions		
3	Drilling of dia 3mm of dimensions 7 and 8		
4	Center drilling of point 9 to 13 dimensions		
5	Drilling of dia 3mm for points 9 to 13 dimesions		



Tool no.	Step no.	Depth,mm
4	9 to 13	-0.5
5	9 to 13	-5

Tool No.	Points	Drilling depth, mm
1	3 to 15	-19
2	3 to 15	-0.5
3	3 to 15	-5

Note
1. All the edges should be chamfered 2 x 45 deg

	File No.	Additional information	Material	Scale 1:5
Resp. Departm. Dprt. of Mech	Consulted by	Document type Technological sketches	Document status Educational	
Owner VG TU Mpfuc-15	Drawn by Mathivanan Periyasamy Approved by Prof., Sigitas petkevicius	Title Frame holder	VG TU .IG.02.02	Edit Date 20/1/19
			Lang En	Page 1/1