



Tonka

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October 27, 2017

Manufacturing Plan

Part Number: 1

Part Title: Connecting Shaft

Raw Material Stock: Aluminum Rod, 3/8"

Step #	Process Description	Machine	Fixtures	Tools	Speed (RPM)
1	Cut stock to 1.125"	Band Saw	Vise	File	300
2	Face one end of material	Lathe	Collet	Cutting Tool	750
3	Cut from other end down to 1.00"	Lathe	Collet	Cutting Tool	750
4	Turn down from 0.38" to 0.25"	Lathe	Collet	Cutting Tool	750
5	Mount on mill and find datum	Mill	V-Blocks	Drill chuck, edge finder	1000
6	Center drill and drill 0.06" diameter hole	Mill	V-Blocks	Drill chuck, center drill, 1/16" drill	1200
7	Debur part			Deburring tool, file	