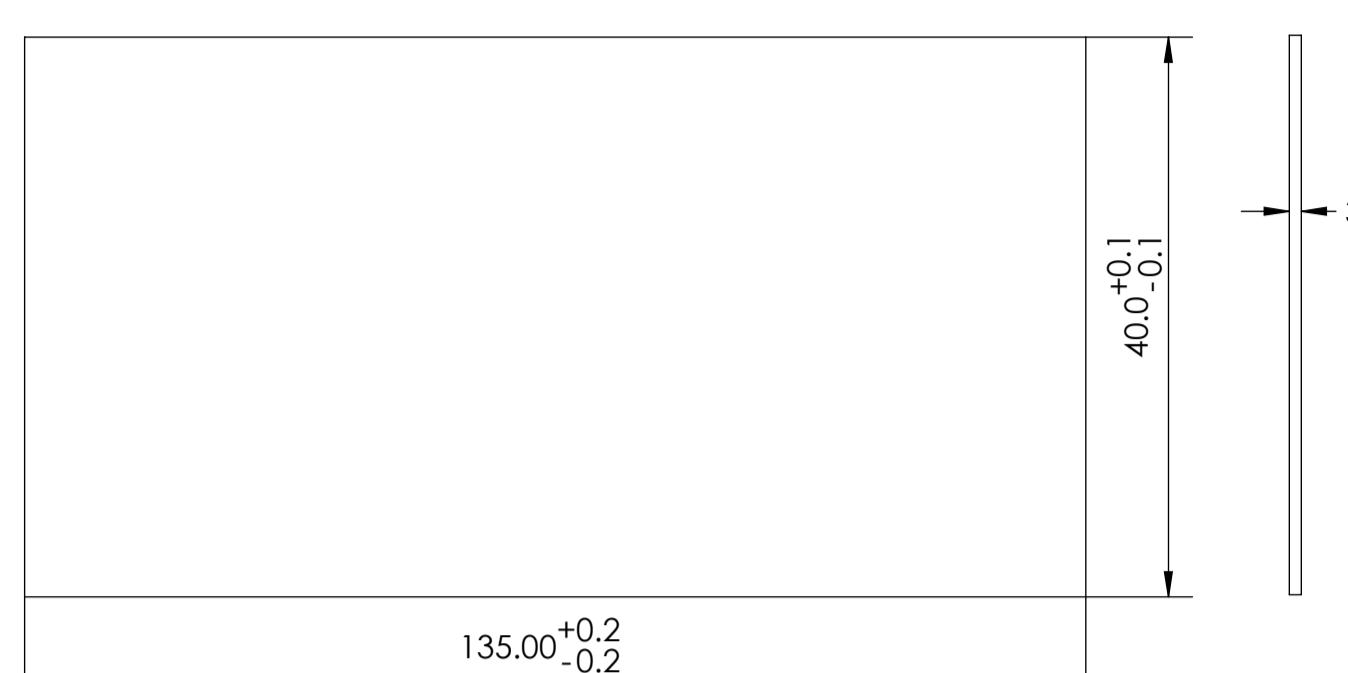
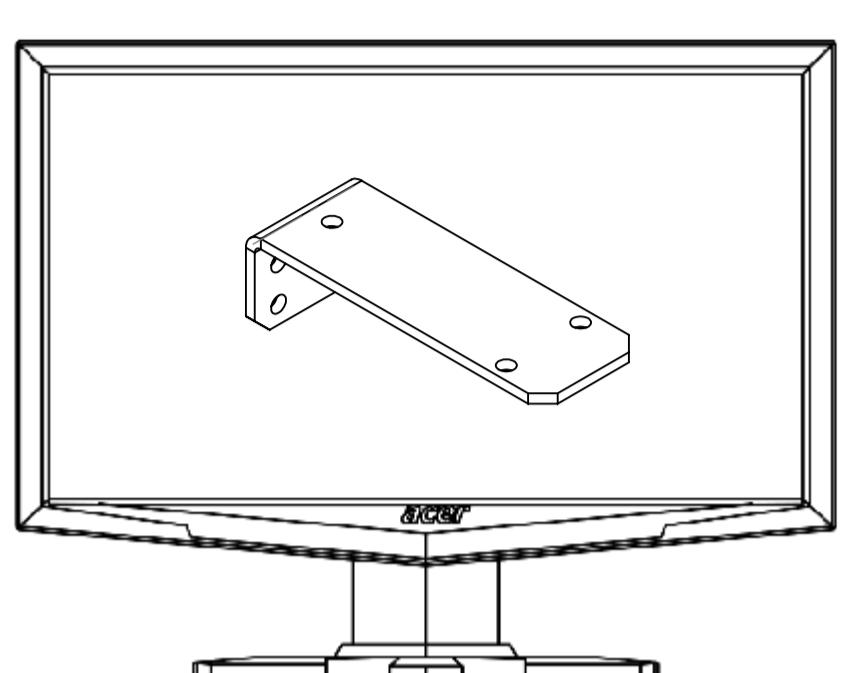


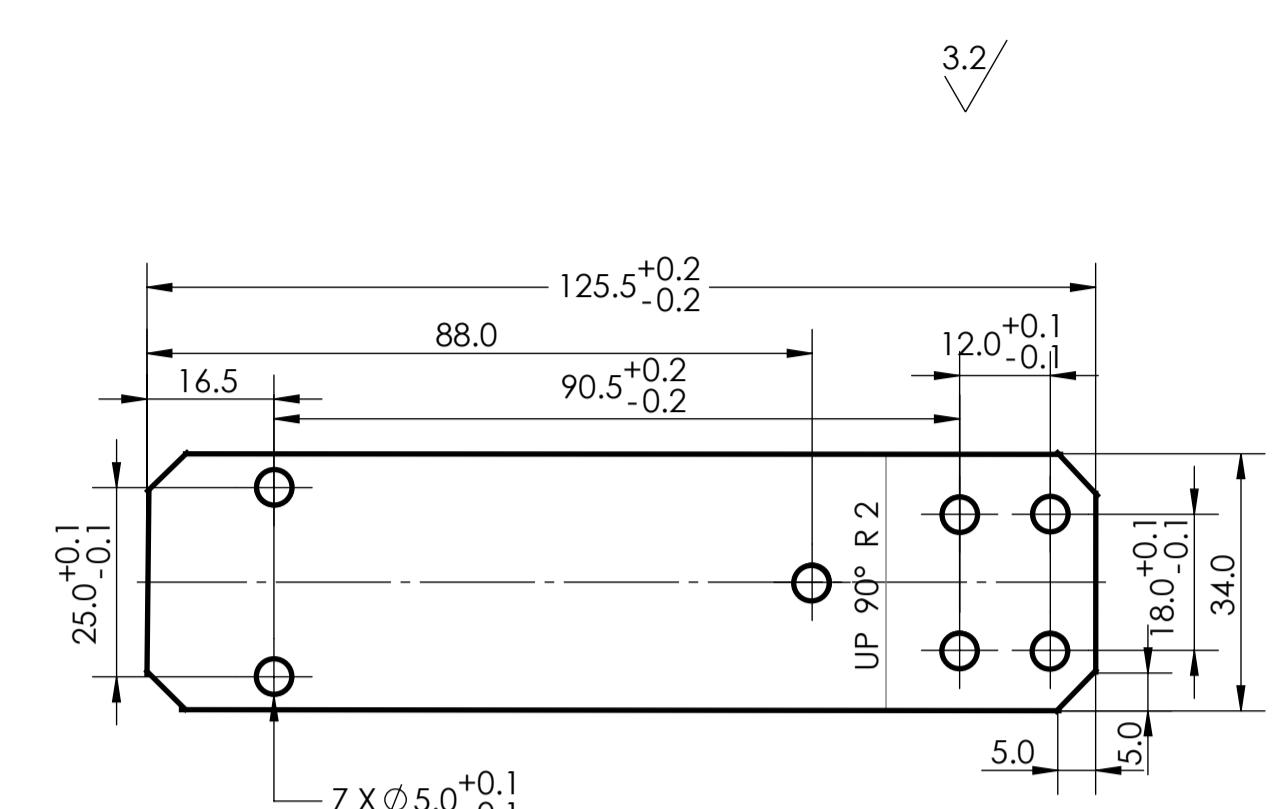
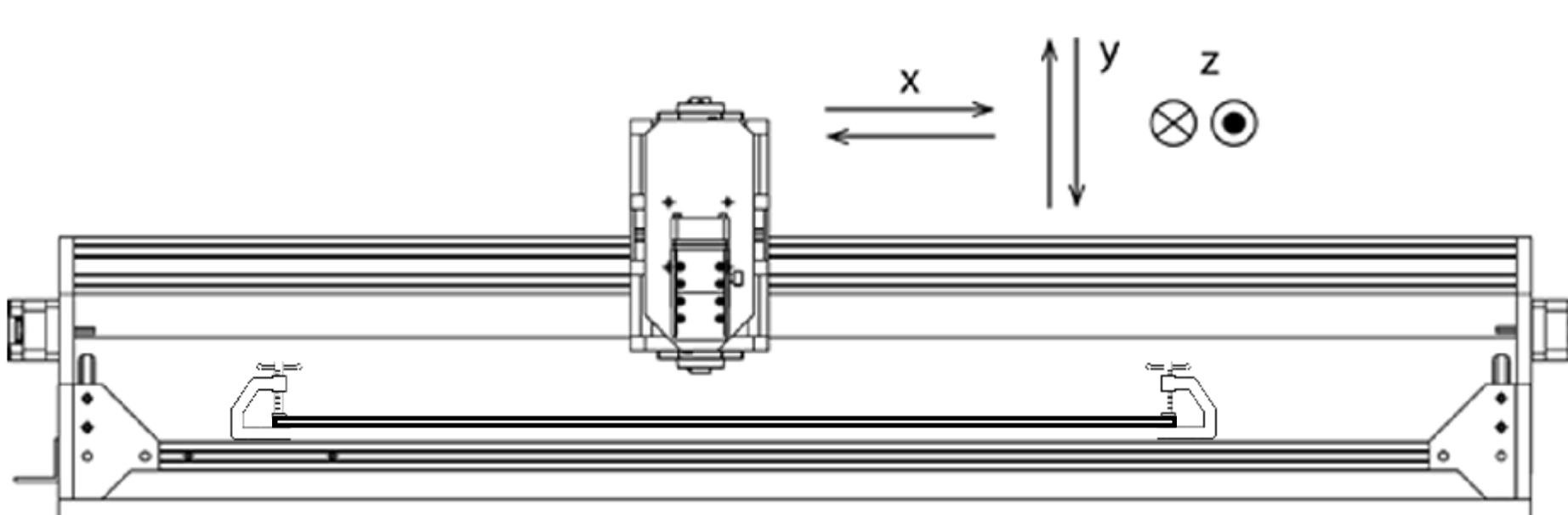
16 15 14 13 12 11 10 9 8 7 6 5 4 3 2 1

M

Designing & material selection - Exporting flat pattern of the part, & select the sheet



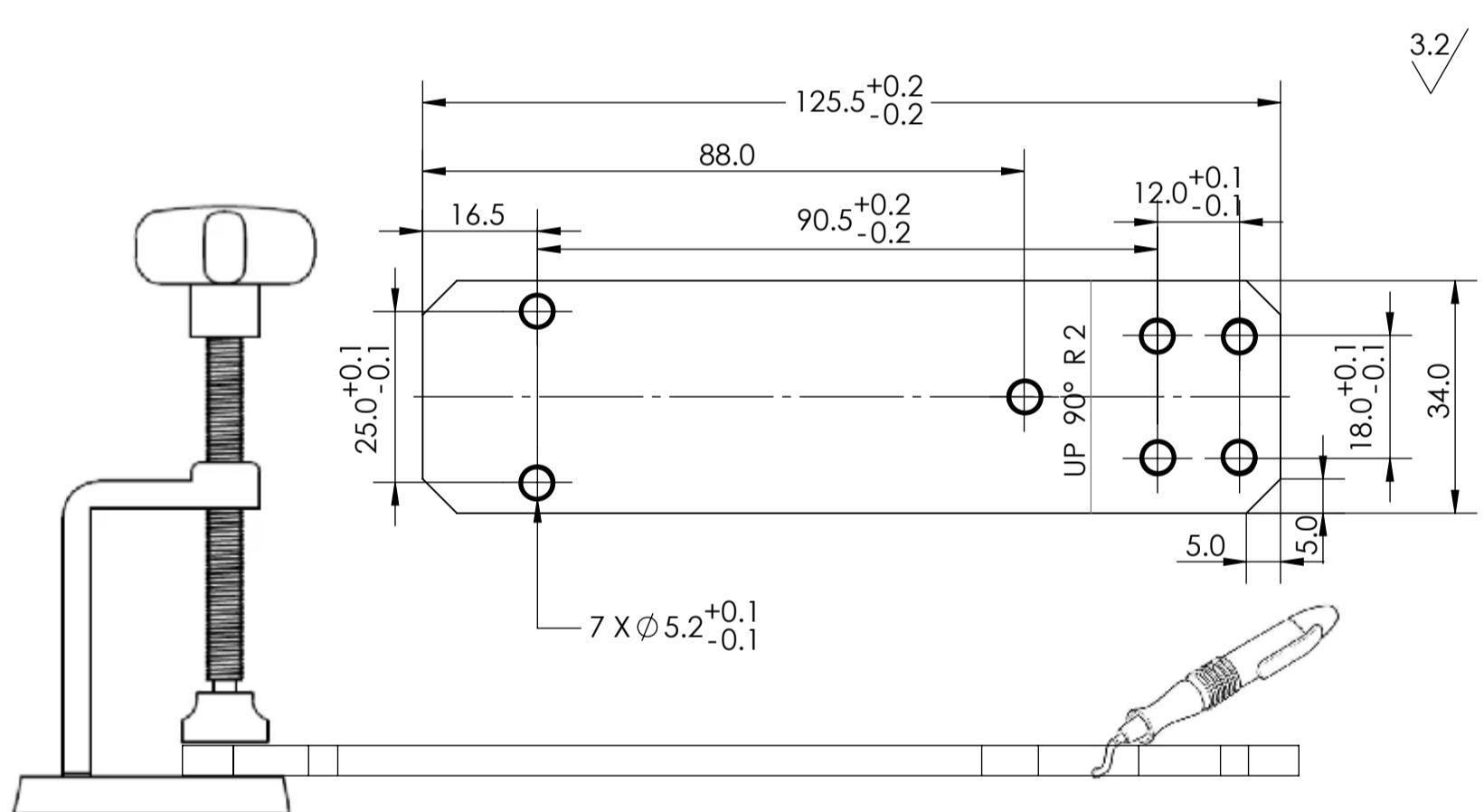
005 Laser cutting



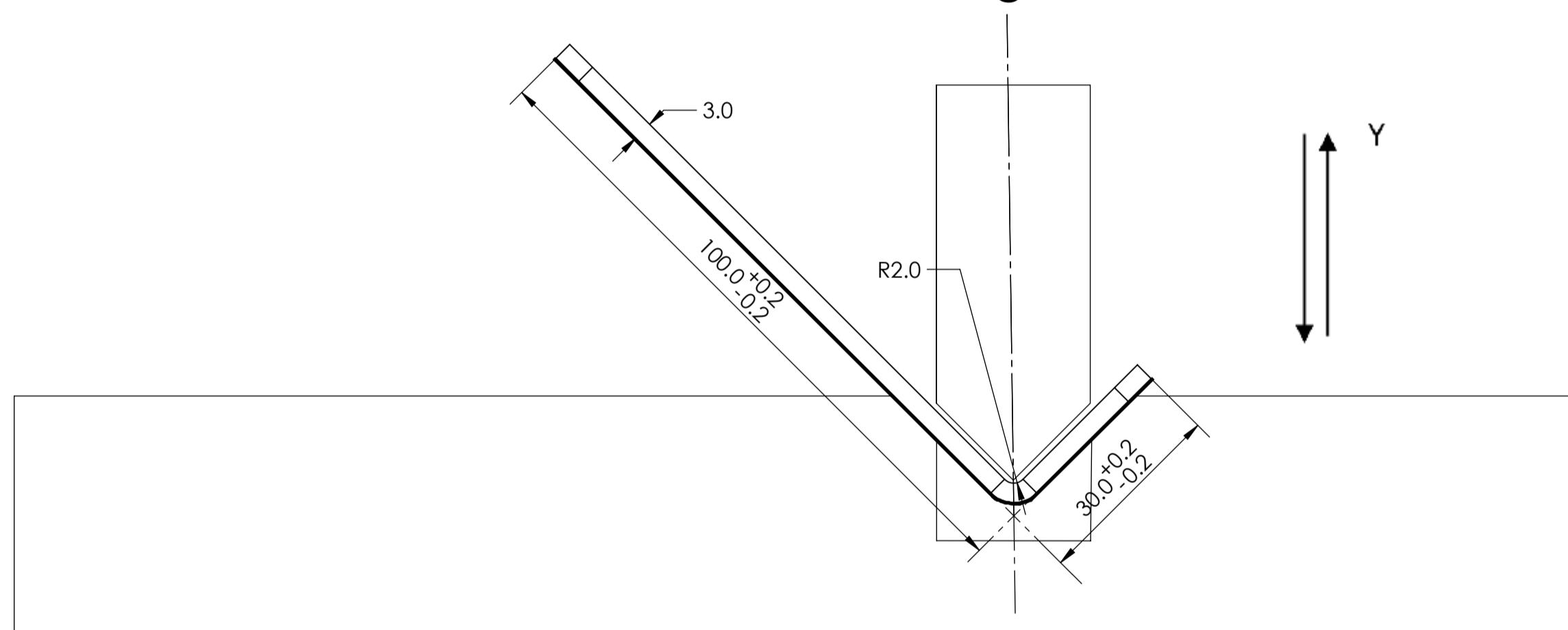
Operation No.	Operation Name	Step No.	Model No.	Equipment Name	Program for Model Preparation	K-Factor	Bend Allowance	Bend Radius	Sheet Metal Thickness	Tolerance	File Format
001	Designing & Material selection	1	IP.002	Core i7	Solidworks	0.4	4.24m	2.00 mm	3mm	± 0.1mm	.dxf

Operation No.	Operation Name	Step No.	Instrument	Material	Material Thickness	Laser Power	Nozzle standoff (mm)	Focus spot size	Assist gas pressure	Cutting speed (m/min)
005	Laser Cutting	2	Lm3015g3 Laser cutter	Stainless Steel 316	3mm	1500W	0.3-1.3	0.1mm	6-20 bar	0.5-1

010 Deburring



015 Bending

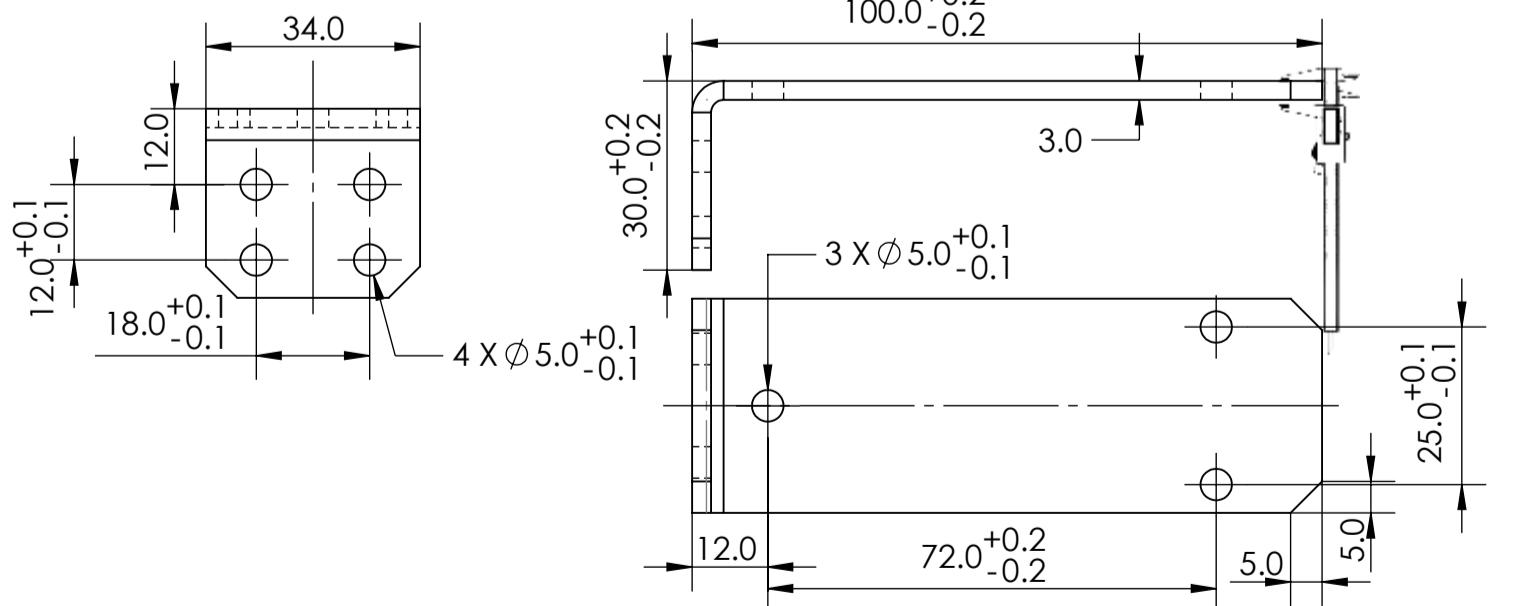


Operation No.	Operation name	Step No.	Instrument	Blade Material	Blade Length	Weight
010	Deburring	3	Noga NG1000 Deburring Tool	Tungsten Carbide	~45-60 mm	~100 g (tool + blade)

Tag	Direction	Angle	Inner Radius (mm)
1	Down	90	2

Operation No.	Operation Name	Step No.	Bending Tag No.	Instrument	Material	Thickness of the sheet	Die opening	Minimum flange length	Length of the sheet	Inside bend radius	Tonnage
015	Bending	4	1	WAD 110T/3200 Press Brake	Stainless steel 316	3mm	16mm	10mm	125.5mm	2.0mm	0.5-3.5kN

020 Quality checking and dimension checking



Operation No.	Operation name	Step no.	Instrument	Accuracy
020	Quality checking and dimension checking	5	Digital Caliper	0.1 mm

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS SURFACE FINISH: TOLERANCES: UNLESS ANGULAR:				FINISH:	DEBURR AND BRAKE SHARP EDGES
DRAWN: S. M. Jayaev-Chirbaev CHKD: Aleksejs Tolosovs CHKD: Hemonds Sonskis APVYD: Juris Denjars QA: Nicole Burtovega				NAME: _____	SIGNATURE: _____
				DATE: _____	_____
				TITLE: Manufacturing process of Actuator Mount (MP)	REVISION: _____
				DWG NO: IP.005.00.000.MP	
				WEIGHT: _____	SCALE: 1:1
				SHEET 1 OF 1	