

NAME:

# PROCESS PLAN

DATE:

**MACHINING**

UNSPECIFIED TOLERANCES:

X.X +/- .015

X.XX +/- .010

X.XXX +/- .005

X.XXXX +/- .0005

DRILLED HOLES: +/- .005

ANGLES: +/- 1'

FRACTIONS: +/- 1/64

MATERIAL: ALUMINUM 6061

INSTRUCTOR: KELLY OSWALD

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SCALE:

2:1

PART NAME:

STEP SERIES

NO. REQUIRED:

1

ENGINEERED: *C. Kruger / K. Oswald*

TMCC MTT 105B - MACHINE SHOP I



PROCESS NO.	TOOL	RPM	WORK HOLDING	DESCRIPTION OF OPERATION
1	HSS TURNING TOOL	1200	3 JAW CHUCK	FACE
2	HSS TURNING TOOL	1280	3 JAW CHUCK	TURN 15/16" DIA. BY 2" LENGTH
3	HSS TURNING TOOL	1500	3 JAW CHUCK	TURN .800" DIA. BY .900" LENGTH
4	HSS TURNING TOOL	1920	3 JAW CHUCK	TURN .625" DIA. BY .750" LENGTH
5	HSS TURNING TOOL	2000	3 JAW CHUCK	TURN .500" DIA. BY .600" LENGTH
6	HSS TURNING TOOL	2000	3 JAW CHUCK	TURN .350" DIA. BY .450" LENGTH
7	HSS TURNING TOOL	2000	3 JAW CHUCK	TURN .200" DIA. BY .300" LENGTH
8	HSS TURNING TOOL	2000	3 JAW CHUCK	TURN .062" DIA. BY .150" LENGTH
9	PART-OFF BLADE	250	3 JAW CHUCK	PART-OFF 1.925" LONG
10	HSS TURNING TOOL	1200	COLLET CHUCK	FACE TO 1.900" LENGTH
11	DEBURRING TOOL	N/A	N/A	BREAK ALL SHARP EDGES .010" - .015"

$$\text{RPM} = \frac{4 \times \text{SURFACE SPEED}}{\text{DIAMETER}}$$

ATTACH ADDITIONAL SHEETS IF NECESSARY INSTRUCTOR APPROVAL: