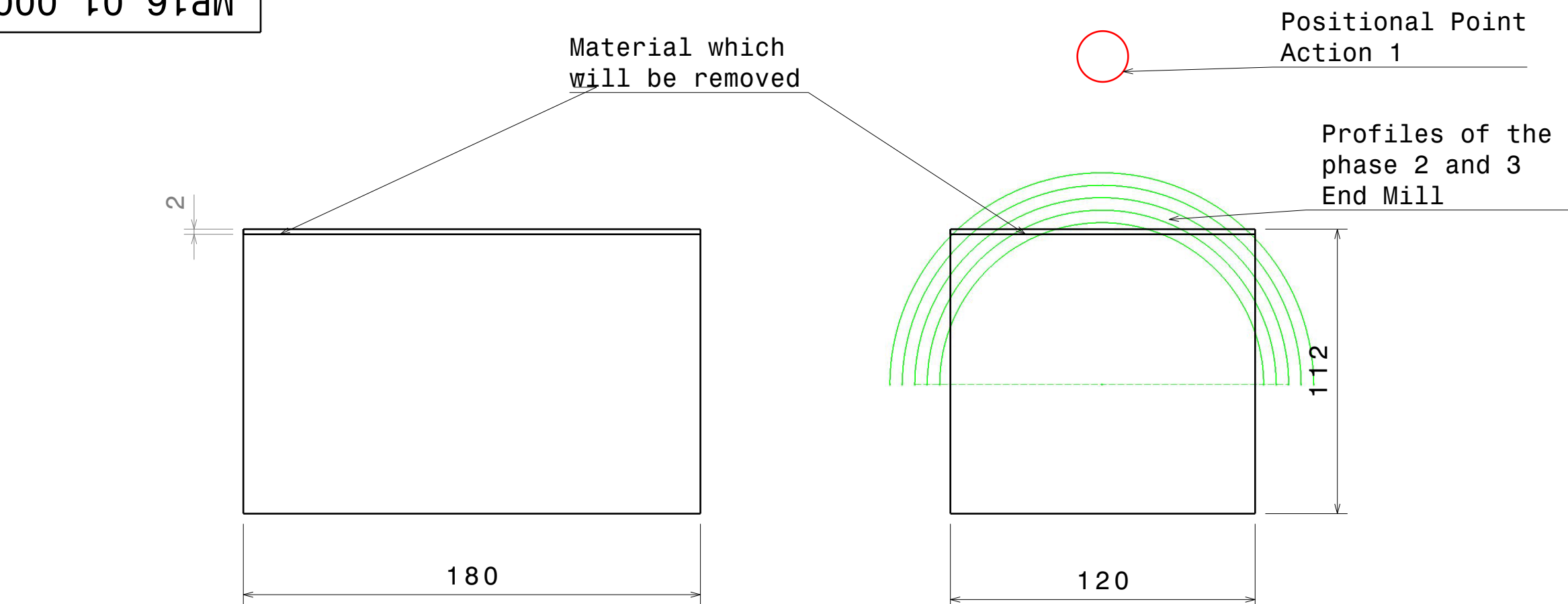
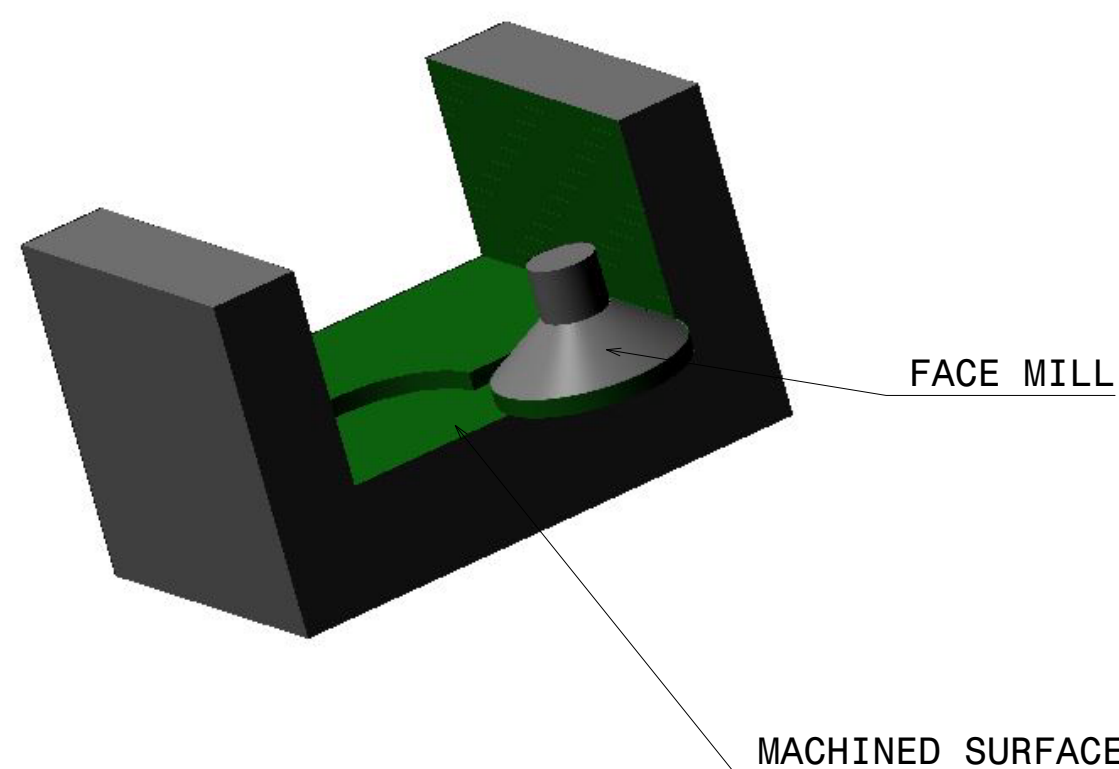


MANUFACTURING PROCESS

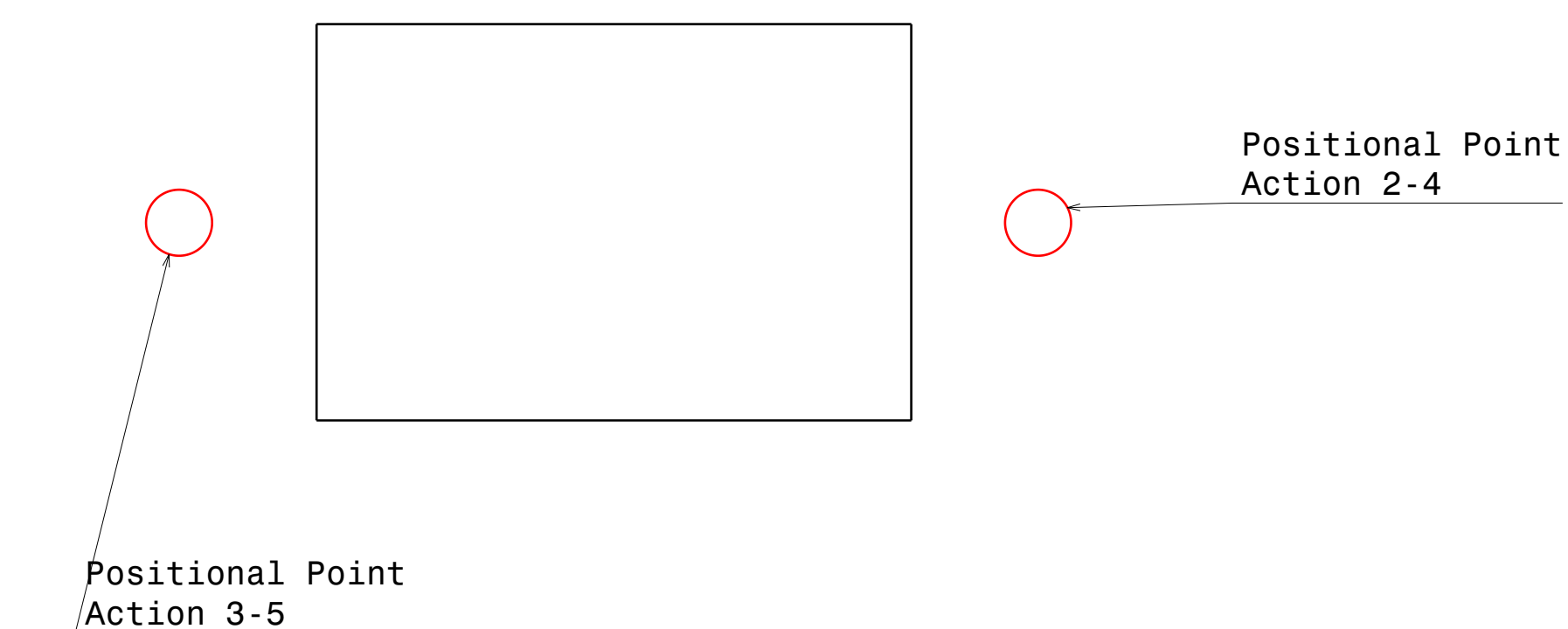
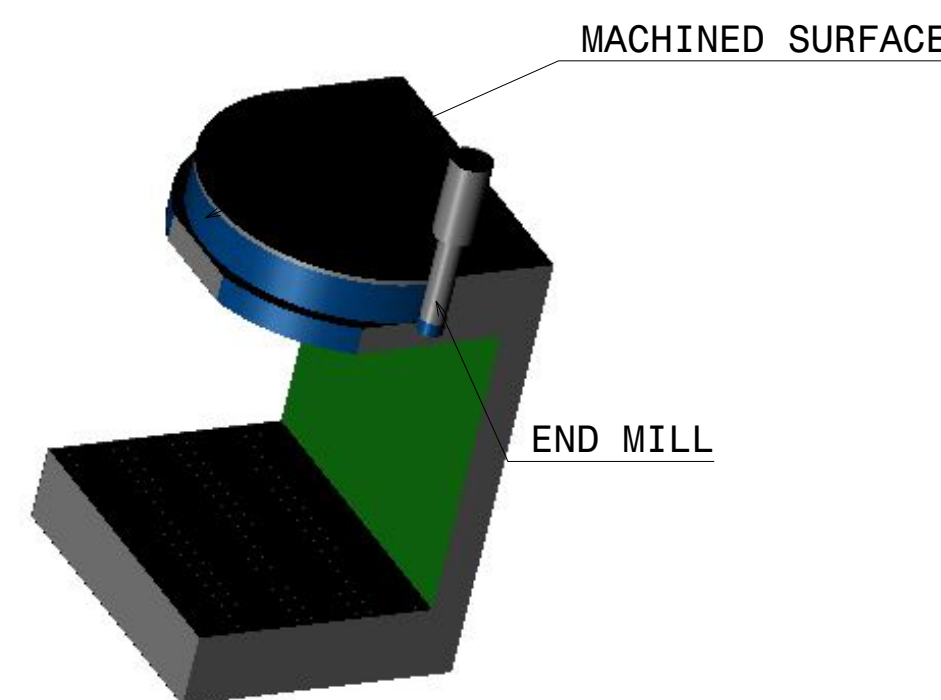
Ra 6.3



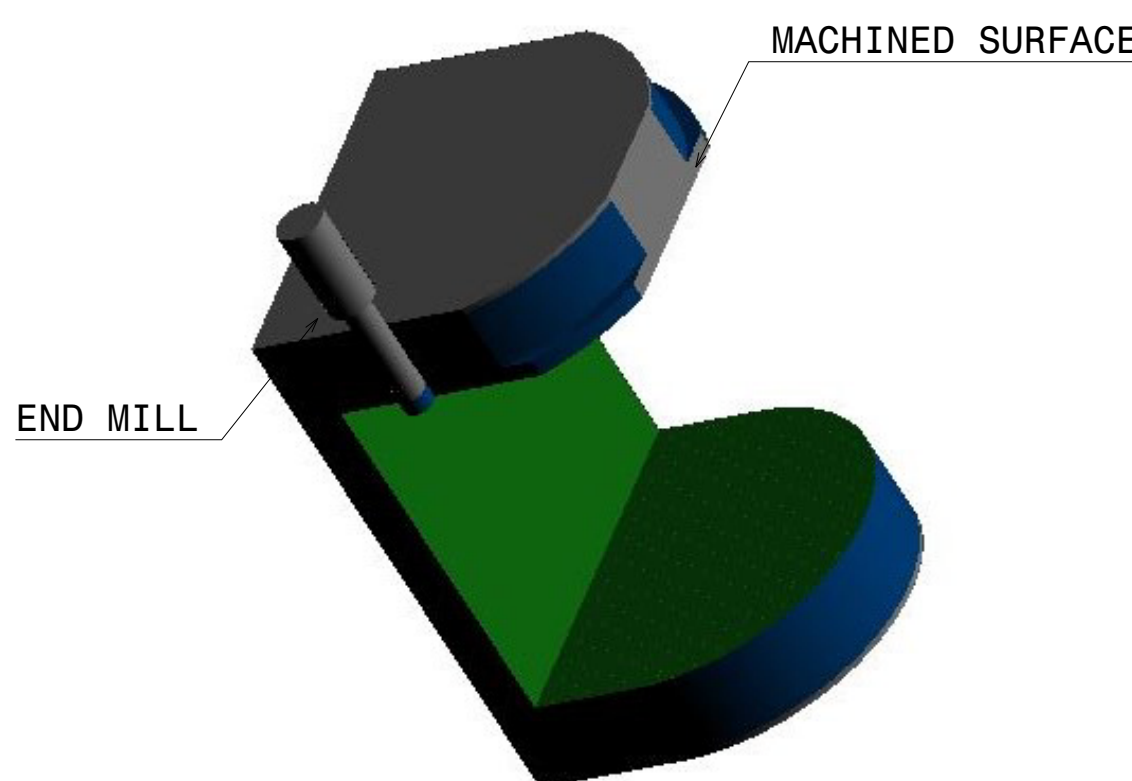
1 BOTTOM MILLING



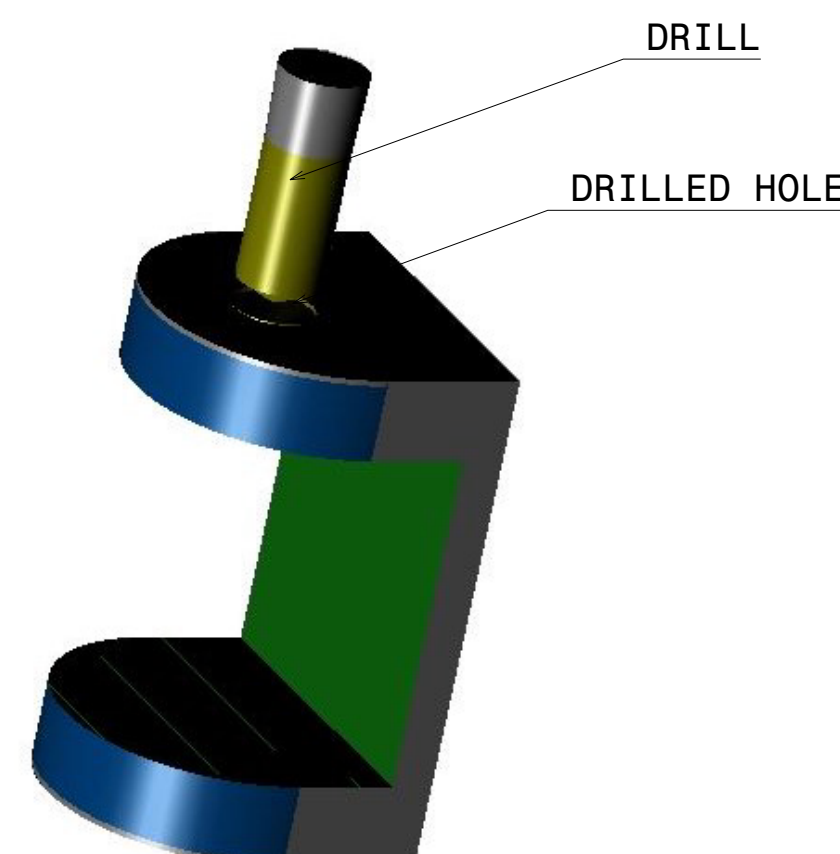
2 RIGHT SIDE MILLING



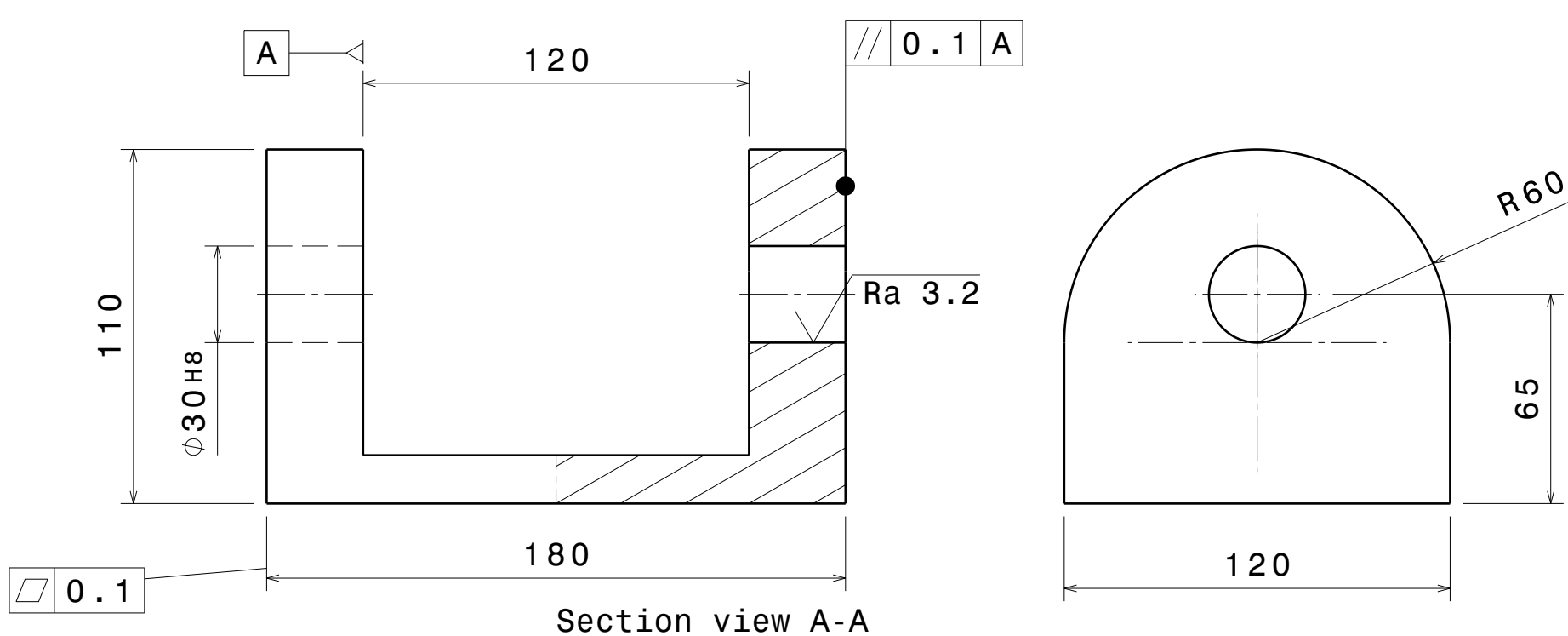
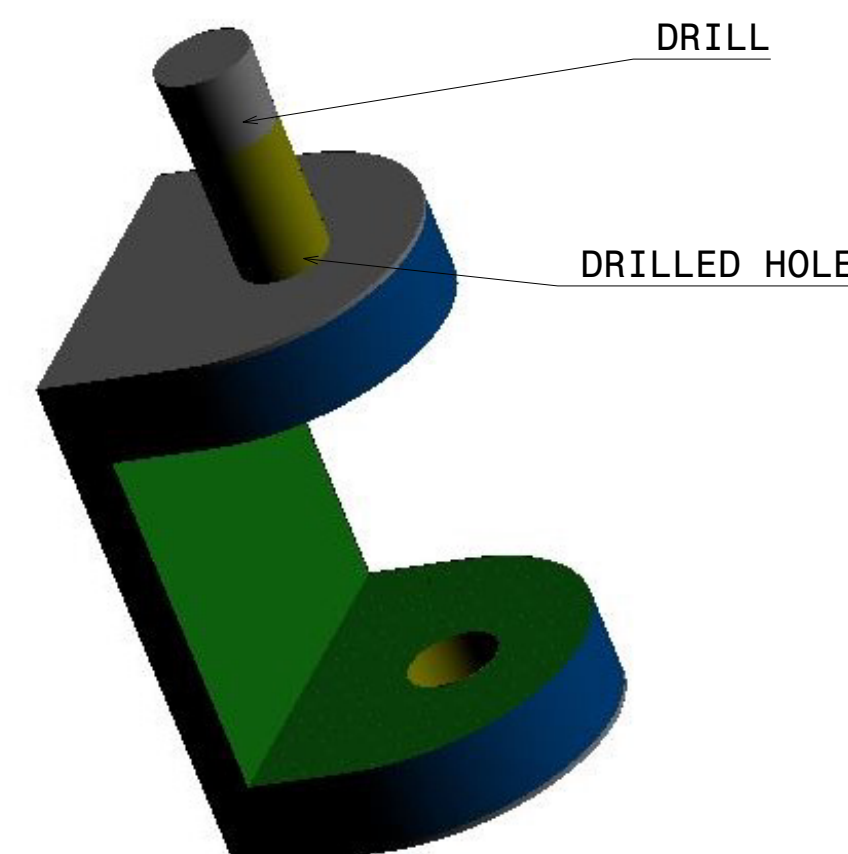
3 LEFT SIDE MILLING



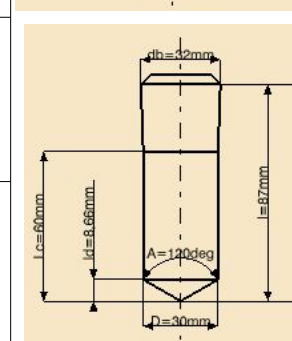
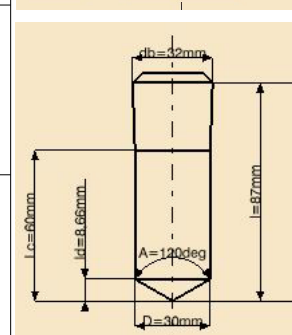
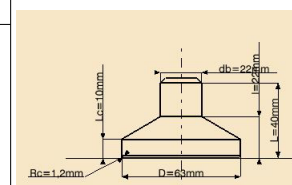
4 RIGHT DRILLING



5 LEFT DRILLING



STEP	PROCESS	CODE	Ø	DEEP	Level	Vc(m/min)	n(r.p.m)	Vf(mm/min)	Time
1	Bottom Milling	Face Mill Coro Mill 245 R245-063Q22-12M	63 mm	6 mm	16	200	1010	1162	4min 52sec
2	Right Milling	End Mill Coro Mill 316 316-10HM350-10015P	10 mm	5.5 mm	6	140	4456	2674	2min 58sec
3	Left Milling	End Mill Coro Mill 316 316-10HM350-10015P	10 mm	5.5 mm	6	140	4456	2674	2min 58sec
4	Right Drilling	Drill Coro Drill 880 880-D3000L32-02	30 mm	-	-	150	1591	128	1min 46sec
5	Left Drilling	Drill Coro Drill 880 880-D3000L32-02	30 mm	-	-	150	1591	128	1min 46sec



- 1- Dimension tolerances: ISO 2768 medium class except otherwise specified
- 2- The material is ASTM A484 304 Stainless Steel
- 3- The parts do not present treatment post manufacturing
- 4- Red circles indicate the position from the machine work
- 5- Green lines indicate the positions that the end mill cover in order to mill the curve surface

DESIGNED BY: Francisco Renedo DATE: 15/05/2016	Cylinder Hitch		
CHECKED BY: Vadim Mokain DATE:	TECHNOLOGICAL SKETCHES		
UNIVERSITY VGTU	DEPARTMENT Mechanics		
SIZE A1	SCALE 1:2	Nº DRAWING MP16.01.000.TS	SHEET 1/1