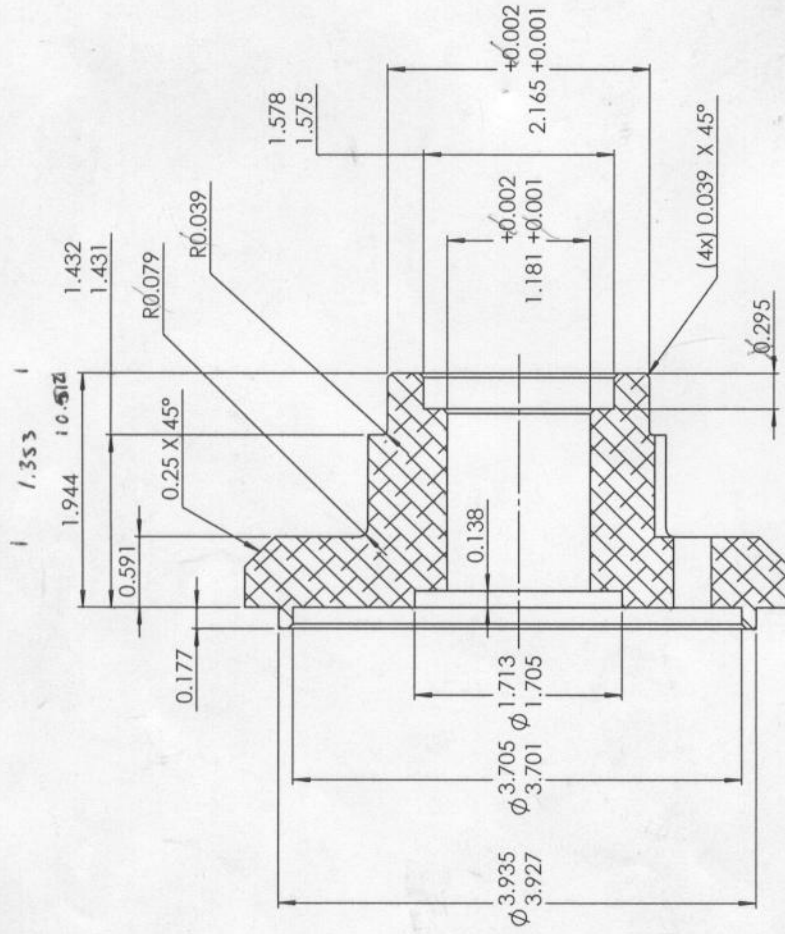
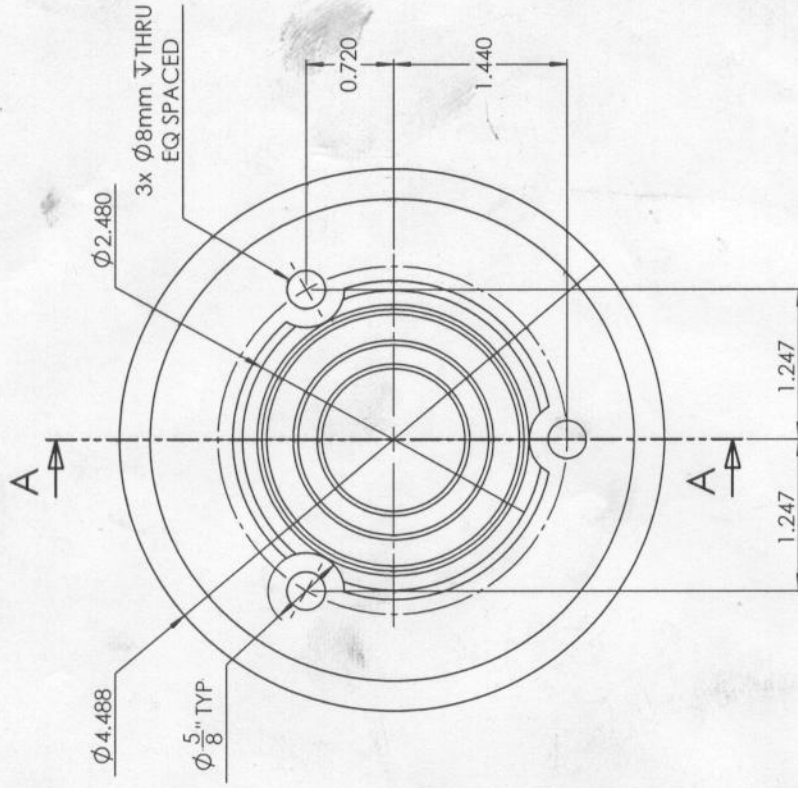
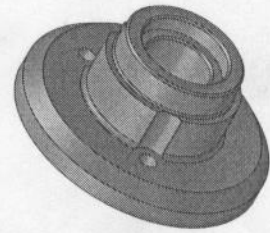


QTY: 1



SECTION A-A

315



QTY: 1

	6061 T6 - 5" x 3"		TITLE Diffend	
	MATERIAL	6061 T6 - 5" x 3"	DWG NO.	0109180903
	FINISH	NONE	PROJECT	FSAE 2010
	DESIGNER	A.KANINS	DATE	1/26/2010
APPROVED M. REMBACZ		SCALE	1:1	REVISION NO.
B SIZE		MANUFACTURED	O	01
		SHEET	1	1

22

CONCORDIA UNIVERSITY MANUFACTURING PROCESSES SHEET

Refers to Drawing Name or Number :

DIFF END 0109180903
ANDRIS KANJINS
D. Ruzar

Date, TIME IN : 01/22/10 15400
01/25/10 12430
03/02/10 15430

NAME OF OPERATOR :

Name of Operator2 [assistant/supervisor/etc] :

Name of Staff Member Responsible :

EIR APPROVAL : 

Operation #	Name Of Operation	Machine	Cutting Tool	Cutting Speed (RPM)	Feed (Inches / Rev or Manual)	Depth of Cut (Thou. of inch)	HAZARD DESCRIPTIONS	RISK ASSESSED LEVEL	Comments	OPTIONAL Material Removal Rate	Expected Duration	ACTUAL Duration
01	Stock Mat'l	Bandsaw									00:02.0	5
02	Stock Mat'l	Manual	File	na	na	na					00:01.0	2
03	Setup	Lathe									00:05.0	5
04	Turn Face	Lathe	MP Carbide	1600 880 400	0.005	0.025					00:01.0	2
05	Turn OD	Lathe	MP Carbide	880 400	0.005	0.005					00:02.0	4
06	Turn Step 1	Lathe	MP Carbide	1600 600	0.010/0.003	0.025/0.005					00:05.0	10
07	Turn Bearing	Lathe	MP Carbide	1600 600	0.010/0.003	0.025/0.005					00:04.0	12

CONCORDIA UNIVERSITY MANUFACTURING PROCESSES SHEET

Drawing Name or Number

0105/80903

Operation #	Name Of Operation	Machine	Cutting Tool	Cutting Speed (RPM)	Feed (Inches / Rev or Manual)	Depth of Cut (Thou. of inch)	HAZARD DESCRIPTIONS	RISK ASSESSED LEVEL	Comments	OPTIONAL	
										Material Removal Rate	Expected Duration
08	Center Drill	Lathe	#3 Center Drill	1750 800	Manual						00:00.5
09	Drilling Pilot Hole	Lathe	1/4" & 5/8" Drill	1600/1200 800/600	Manual						00:03.0
10	Boring Axle Bore	Lathe	Boring Bar (Carbide)	1200 600	0.008/0.003	0.015/0.005					00:05.0
11	Boring Seal Recess	Lathe	Boring Bar (Carbide)	1000 400	0.008/0.003	0.015/0.005					00:03.0
12	Setup	Lathe									00:05.0
13	Turn Face	Lathe	MP Carbide	880 400	0.005	0.025					00:01.0
14	Turn Outer Profile	Lathe	MP Carbide	880/1600 400	0.010/0.003	0.025/0.005					00:05.0
15	Turn Inner Profile	Lathe	Boring Bar (Carbide)	1000 400	0.008/0.003	0.015/0.005					00:05.0

CONCORDIA UNIVERSITY MANUFACTURING PROCESSES SHEET

Drawing Name or Number

0103/80503

Operation #	Name Of Operation	Machine	Cutting Tool	Cutting Speed (RPM)	Feed (Inches / Rev or Manual)	Depth of Cut (Thou. of inch)	HAZARD DESCRIPTIONS	RISK ASSESSED LEVEL	Comments	OPTIONAL Material Removal Rate	Expected Duration	ACTUAL Duration
16	Setup	Mill									00:05.0	20
17	Center Drill	Mill	#3 Center Drill	1600	Manual						00:02.0	10
18	Pilot Holes	Mill	5mm Drill	1600	Manual						00:03.0	10
19	Ream Holes	Mill	8mm Reamer	800	Manual						00:03.0	10
20	COUNTER BORE	"	5/8" END MILL	800	Manual							10
21												
22												
23												