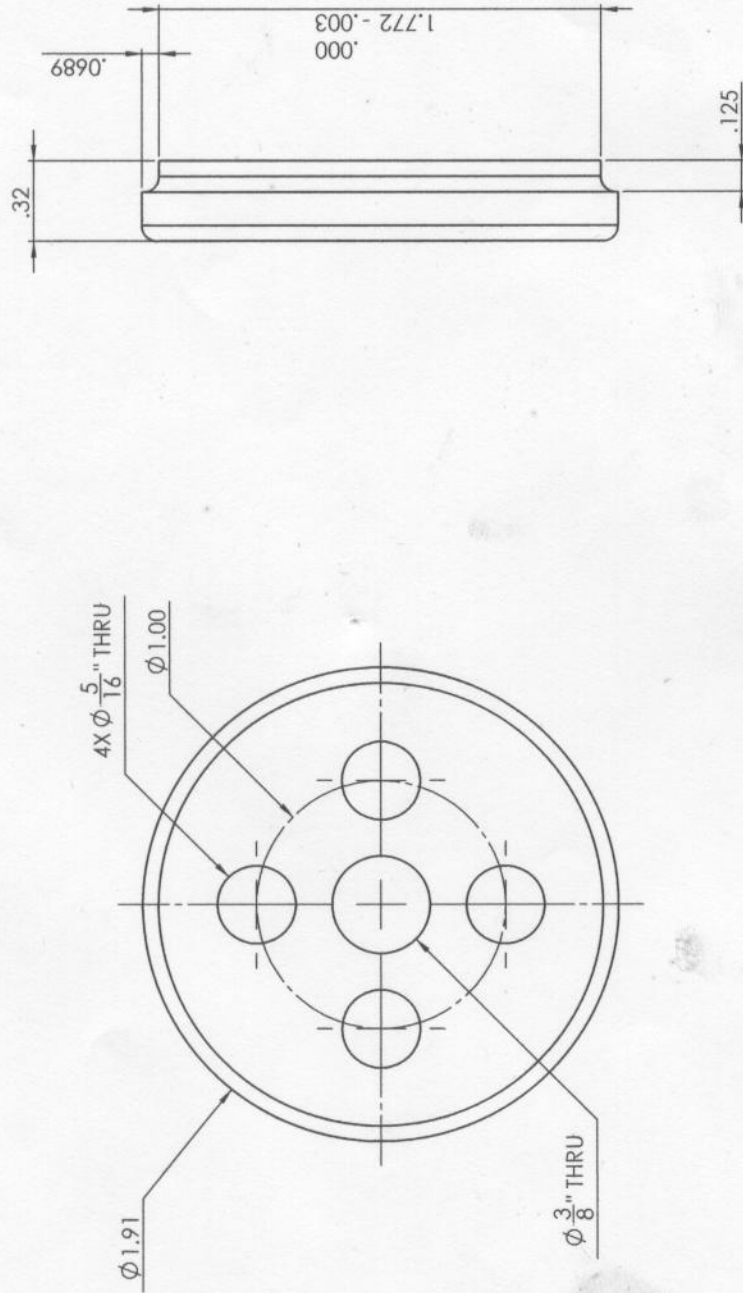
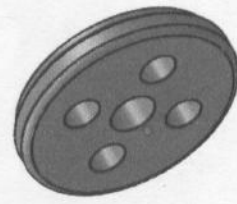


QTY: 2

- NOTES:
1. VERIFY FIT WITH BEARING
 2. BREAK ALL SHARP EDGES



32
 $\phi 1.25$
 .2



 MEMBERSHIP APPLICATION MUST BE RELEASED WITHOUT WRITTEN AUTHORIZATION FROM CONCORDIA SAE	MATERIAL	6061 T6 - ϕ 2" x 1/2"		 UNLESS OTHERWISE SPECIFIED	SURFACE ROUGHNESS	$\sqrt{63}$	TITLE 2010_FRONT_HUB_RETAINING_PLATE							
	FINISH	CLEAN			TOLERANCES	X $\pm$.1 XX $\pm$.05 XXX $\pm$.005 ANGLE $\pm$.5 $^{\circ}$	DWG NO.	0109180009	PART NO.	0109180009				
	DESIGNER	M.REMBACZ			ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED		PROJECT	FSAE 2010	DATE	1/12/2010				
	DRAFTER	M.REMBACZ	APPROVED		M.REMBACZ	B SIZE	SCALE	1:1	MANUFACTURED	O	REVISION NO.	01	SHEET	1 / 1

CASIN #18

CONCORDIA UNIVERSITY MANUFACTURING PROCESSES SHEET

Refers to Drawing Name or Number :

Date, TIME IN : Jan 14 9:30 - 10:30

Date, TIME OUT :

EIR APPROVAL :

Jan 14 9:30 - 10:30

ARZ

Front Hub Retaining Plate

Michael Rembacz

Daniel Elizov

NAME OF OPERATOR :

Name of Operator2 [assistant/supervisor/etc] :

Name of Staff Member Responsible :

OPTIONAL

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	Material Removal Rate	Expected Duration	ACTUAL Duration
1	Cut stock	Reciprocating saw	Saw Blade	As per Machine	As per Machine	As per Machine	Use guards and secure material properly	3	cut 4 pieces	-	10	15
2	Facing	Lathe	Facing and Turning Tool	400	Manual	.025 - .050	-	2	Face both sides to size	-	10	5
3	Turning	Lathe	Facing and Turning Tool	400	Manual	.069 in 3 steps	-	2	Check tolerance with bearing	-	5	5
4	Drilling	Lathe	3/8" Drill bit	2133.3333	Manual	THRU	-	2	Use coolant	-	3	2
5	Drilling	Mill	5/16" Drill	2560	Manual	THRU	-	2	Clamp with Parallels	-	15	20
6	Burr Removal	File	File	-	-	-	-	-	-	-	5	1