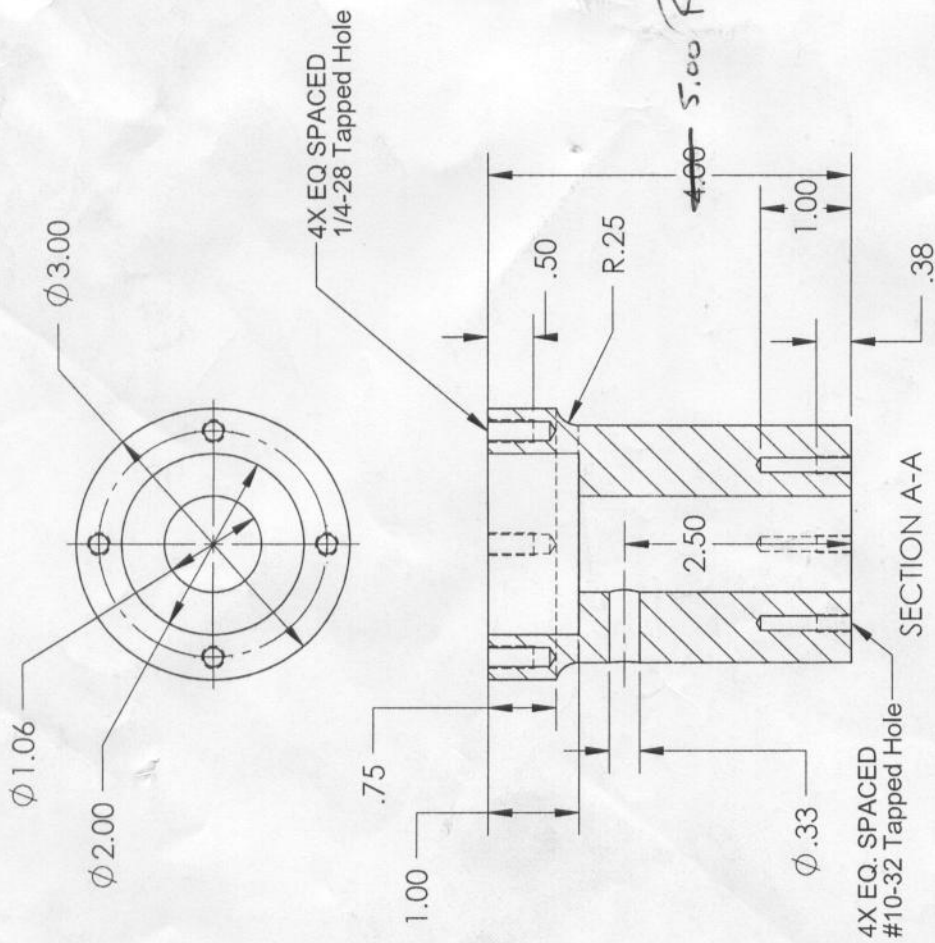


MATERIAL 6061-T6 3" SOLID ROD
ALUMINUM

FINISH	MACHINED		Concordia UNIVERSITY	
	ALL DIMENSIONS IN in		DESIGNED	TEAM 9
UNLESS OTHERWISE SPECIFIED	SURFACE ROUGHNESS $\sqrt{63}$		CHECKED	Antonio Lipardi
	TOLERANCES X $\pm$.1		APPROVED	
	X $\pm$.05		DATE	NOV 25, 2010
	XX $\pm$.010			
	XXX $\pm$.005			
	ANGLE $\pm$.5			
TITLE		PISTON HOUSING		
SCALE	SHEET	USED ON	DWG NO	REV
1:2	6 of 15	11009100	11009104	B

CONCORDIA UNIVERSITY MANUFACTURING PROCESSES SHEET

Date, TIME IN :
 Date, TIME OUT :
 EIR APPROVAL : *Elly for EIR*

Refers to Drawing Name or Number : 11009104
 NAME OF OPERATOR : Saba Fattahi
 Name of Operator2 [assistant/supervisor/etc] : Rocco Portaro
 Name of Staff Member Responsible :

Operation #	Name Of Operation	Machine	Name	Cutting Tool Cutting Speed, V	Tool Feed	Max Dia. Rot. Tool Comp	Spindle Speed (RPM)	Machine Feed	D.O.C (Thou. of inch)	HAZARD DESCRIPTIONS	RISK ASSESSED LEVEL	OPTIONAL		ACTUAL Duration
												Comments	MRR	
1	facing	Lathe	cutting facing tool	1000	manual		1000	Manual	0.015	tool chip	medium	/	/	10
2	Turning 2.63 dia	Lathe	turning tool	1000	manual		1000	Manual	0.03	Rotation	medium	/	/	10
3	Facing to length	Lathe	facing tool	1000	manual		1000	manual	0.015	tool chip	medium	/	/	10
4	Centre Drill ed-tap Hole	Lathe	1/2 CD	200	Manual		1500	manual	0.030	Heat	medium	/	/	10
5	Drilling	Lathe	Drill 5/8"	200	Manual		1250	manual	thru	Heat medium Part 1800	medium	/	/	10
6	Boring	Lathe	1.06" 2.00	200	manual		1500	manual	0.030	Heat	medium	/	/	10
7	Centre Drill	Milling	.125 CD	200	manual		1500	manual		Heat	medium	/	/	10
8	Drill	Milling	.201" 0.154"	200	manual		3500 4800	manual		Heat	med	/	/	10