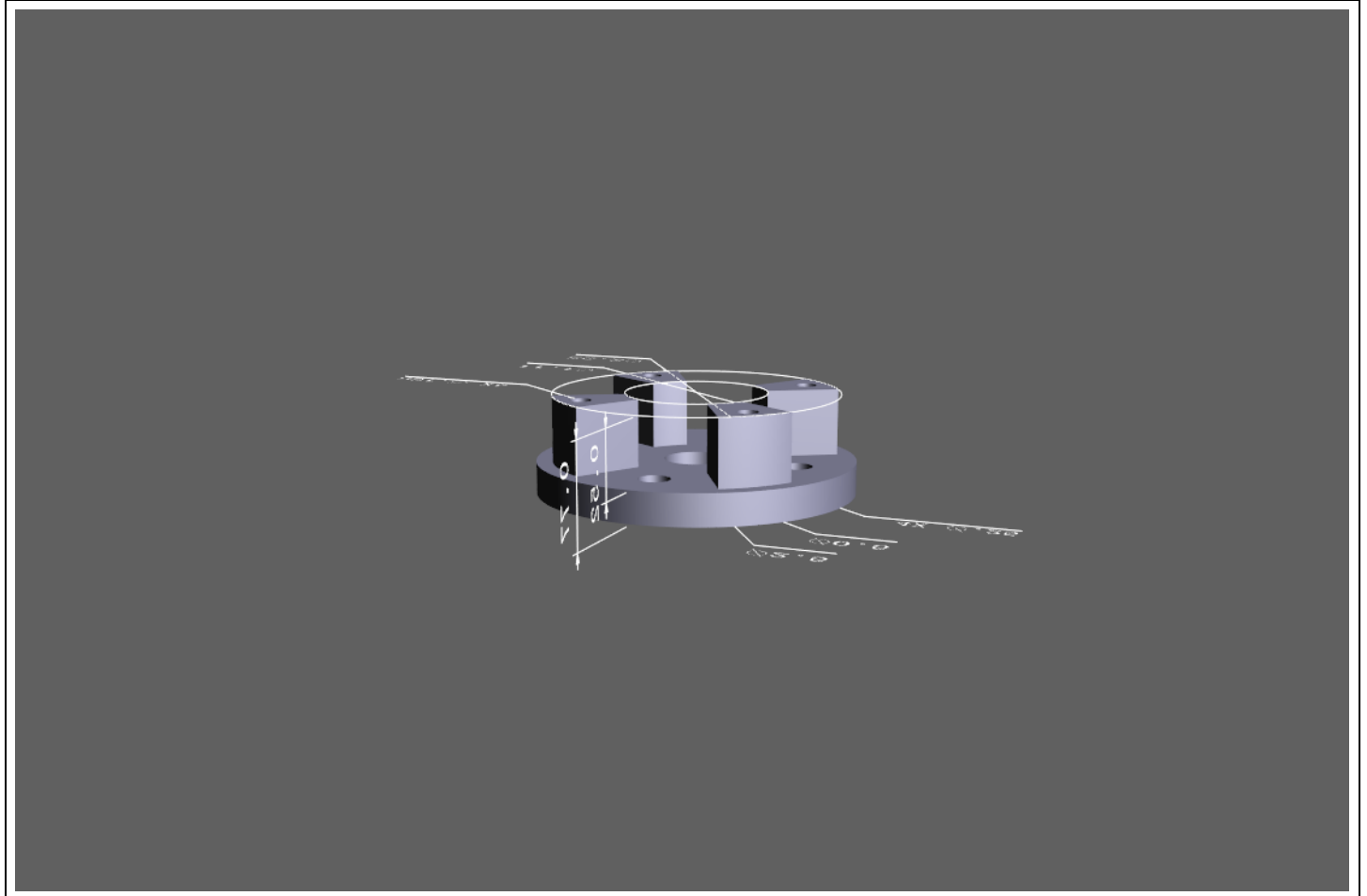


Part Number: 4	Quantity: 1	Material: 6061 ALUMINUM	Release Date: 12/2/2008
Part Name: 4 PLANET CARRIER		Stock: 3"X3"X1.5" BAR	Required By: 12/5/2008
Bar Code:		File Path: T:\Catia Course\Fall 2008\Student Submission\Troy Vandenbark\Synthesis Project	
Part Description: PLANET CARRIER FOR MINIATURE PLANETARY GEAR DRIVE			
Designer: JASON SAGEN	Draftsman: JASON SAGEN	Date Drawn: 9/10/2008	Release Number: 2008-09-10-0000-A
		Released by: Abraham Shryock	Contact Number: Extension 335

Operation #	Machine #	Machine Description	Operation Description
<u>1</u>	1	HAAS CNC	FACING, DRILLING, MILLING
2	2	MANUAL LATHE	PARTING OFF



Part Number: 4	Fixture: Vise	Quantity: 1	Extra Parts: N/A	Operation #: 1
Part Name: 4 PLANET CARRIER	File Datum Path:			

Tool Position:	Tool:	Tool Holder:	Tool Stick Out:	Notes:
1	1.5 in Facing mill	¾ in Hard Holder	Standard	
2	#3 Center Drill	¼ in Collet	>.625 in	
3	#27 Drill	Chuck	>.75 in	
4	8-32 Tap	Chuck	>.5 in	
5	Letter 'A' Drill	Chuck	>1.0 in	
6	¼ in Reamer	¼ Collet	>1.0 in	
7	15/32 in Drill	Chuck	>1.0 in	
8	.498 in Reamer	½ in Collet	>1.0 in	
9	½ in End Mill	½ in Collet	>.625 in	

Op-Sequence:	Description:
1-1	Face top surface to finished surface
1-2	Center drill all holes
1-3	Drill and Tap four 8-32 holes
1-4	Drill and Ream four ¼ in holes
1-5	Drill and Ream .498 in center hole
1-6	Rough mill profile
1-7	Finish mill profile

