PART NUMBER _____ TEAM _____

Operation:

Part:

Process Step Description	
Fixed Asset	
Workholding	
Tooling	
Speed / Feed	
Estimated Cycle Time	
Actual Cycle Time	
Notes about Operation	

Team:

Revision: _____

Process Step Description	Use this text box.
Fixed Asset(s), Workholding, Tooling	
Speed / Feed	
Cycle Time (Load to Unload)	
Inspection Plan	
Notes about Operation	Use this text box.

Operation:

Part:

Operation	
Description	
Comment	

Operation	
Description	
Comment	

Operation	
Description	
Comment	

Operation	
Description	
Comment	

Operation	
Description	
Comment	

Operation	
Description	
Comment	

PART NUMBER _____ TEAM _____

Part: 4 Operation: 41

Process Step Description	Part 4 - Rough in Slot
Fixed Asset	Milling Machine 1
Workholding	vice @ 90°
Tooling	ø 3/4 roughing endmill
Speed / Feed	700 RPM, 5.5 IPM
Estimated Cycle Time	15m
Actual Cycle Time	12m
Notes about Operation	Centerline Cut - start on right side of part, DRO set on Y 0.000, feed left. Set DRO on Y 0.400 and feed right; set DRO on - 0.400 and feed left Use calipers to measure slot to reference end, target dim is 0.725" Use calipers to measure slot width, target dim is 1.550" Use depth mic to measure slot depth, target is 0.380" ** MARK END OF PART WITH SHARPIE BEFORE BEGINNING OPERATION (ensures you don't lose reference edge between operations) ** Perform inspection with part in the vice ** Deburring is not required before next Op

Team:

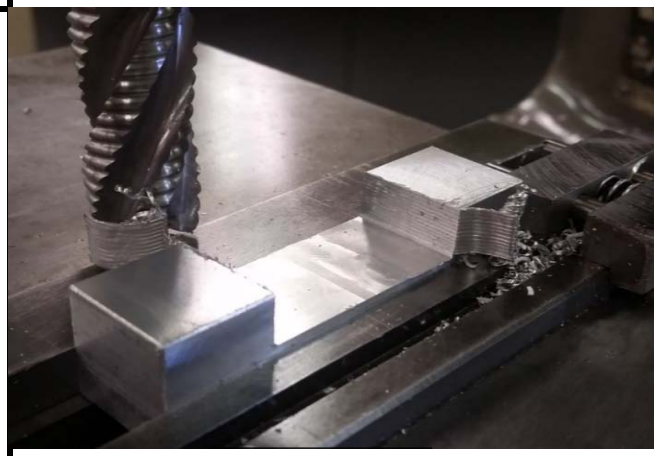
Revision: _____

Operation: 41

Part: 4

Process Step Description
Rough in Slot
Fixed Asset(s), Workholding, Tooling
Bridgeport Mill 1, Vice @ 90°, ø 3/4 Roughing Endmill
Speed / Feed
700 RPM, 5.5 IPM
Cycle Time (Load to Unload)
12m
Inspection Plan
Calipers: Measure slot to end, target dimension is 0.725" Measure slot width, target dimension is 1.550" Depth Micrometer: Measure depth of slot, target dimension is 0.380"
Notes about Operation
1. Mark end of part with a Sharpie before beginning operation *ENSURES REF EDGE IS MAINTAINED 2. Perform inspection while part is in the vice ...MUST DEBURR TOP OF PART 3. Clean vice, parallels before moving onto next operation 4. Check vice to ensure no debris prior to loading part 5. Deburring is not required before next Op 6. Move to starting position before loading next part

Centerline Cut
Start on Right Side of Part, Feed Left
Set DRO: Y 0.000
X 1.000



Side Cuts
Set DRO: Y 0.400
Feed to the Right
Set DRO: Y -0.400
Feed to the Left