

Lathe Certification

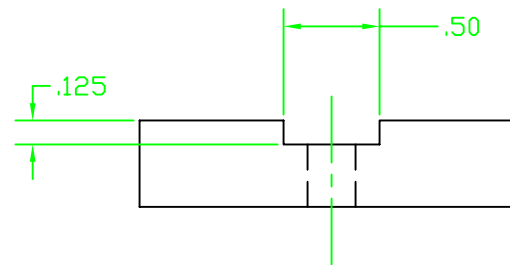
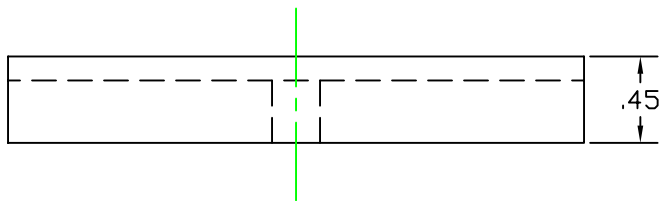
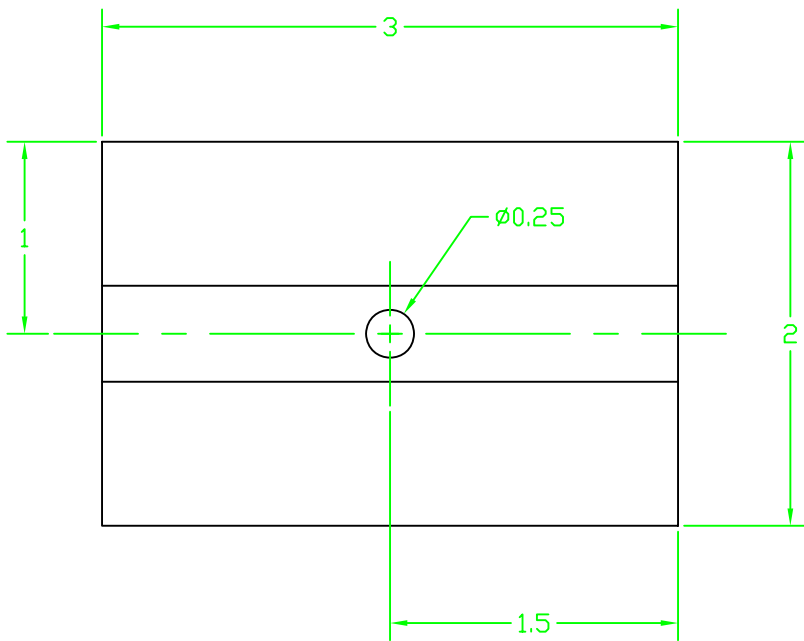
Reference the lathe certification drawing for dimensions and material

1. ~~Rough cut stock with saw for 2" length dimension~~
2. Turn the 2" length dimension (face both ends)
3. Turn the 0.62" diameter x 0.27" boss
4. Drill and tap the $\frac{1}{4}$ -20 hole using lubricant for each operation:
 - a. Center drill #3
 - b. Drill $\frac{13}{64}$ diameter x 0.75 deep (a #7 drill may also be used)
 - c. Chamfer the hole with a countersink
 - d. Tap $\frac{1}{4}$ -20 x .5 deep

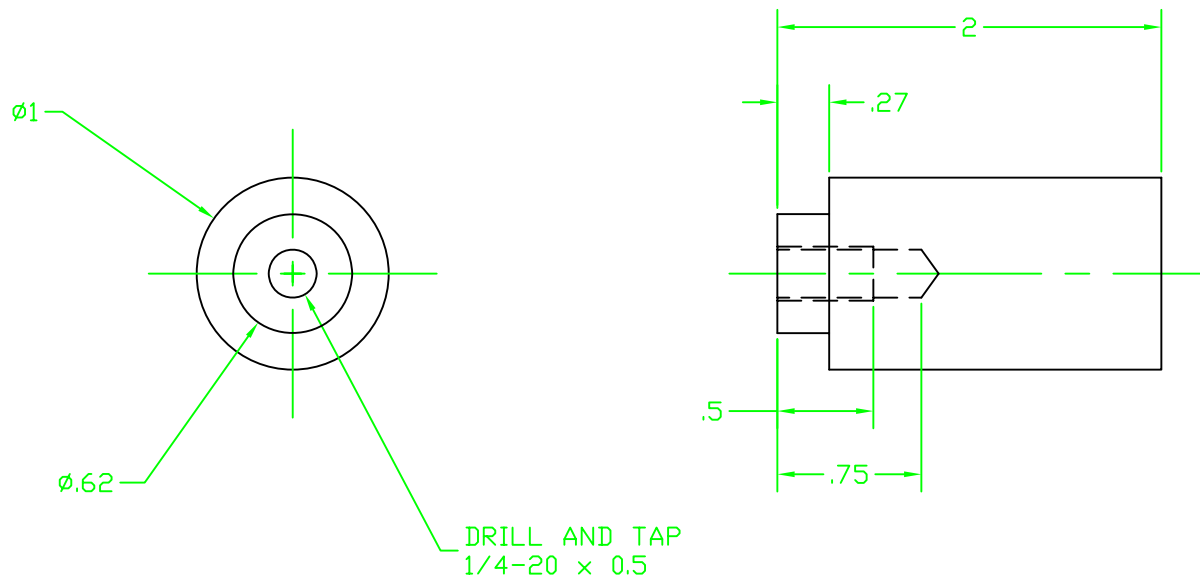
Mill Certification

Reference the mill certification drawing for dimensions and material

1. ~~Rough cut stock with saw for 3" length dimension~~
2. Mill the 3" length dimension using $\frac{1}{2}$ " diameter end mill
3. Mill the .45" thickness dimension using facing tool
4. Mill the $\frac{1}{2}$ " wide x $\frac{1}{8}$ " deep slot on the centerline using $\frac{1}{2}$ " end mill
5. Center drill #3 for $\frac{1}{4}$ diameter hole at center of block – use lubricant
6. Drill $\frac{1}{4}$ " diameter hole through center of block – use lubricant



AME40463 Mill Certification
 Material: 2" x 3" x 1/2" Aluminum
 August 24, 2006



AME40463 Lathe Certification
Material: 1" diameter Aluminum
August 24, 2006