

PROCESS SHEET

Part Name: Motor Coupler Shaft	Material: Mild Steel
Stock Size: 25mm dia. & 150mm length	Checked By:
Prepared By:	Date:

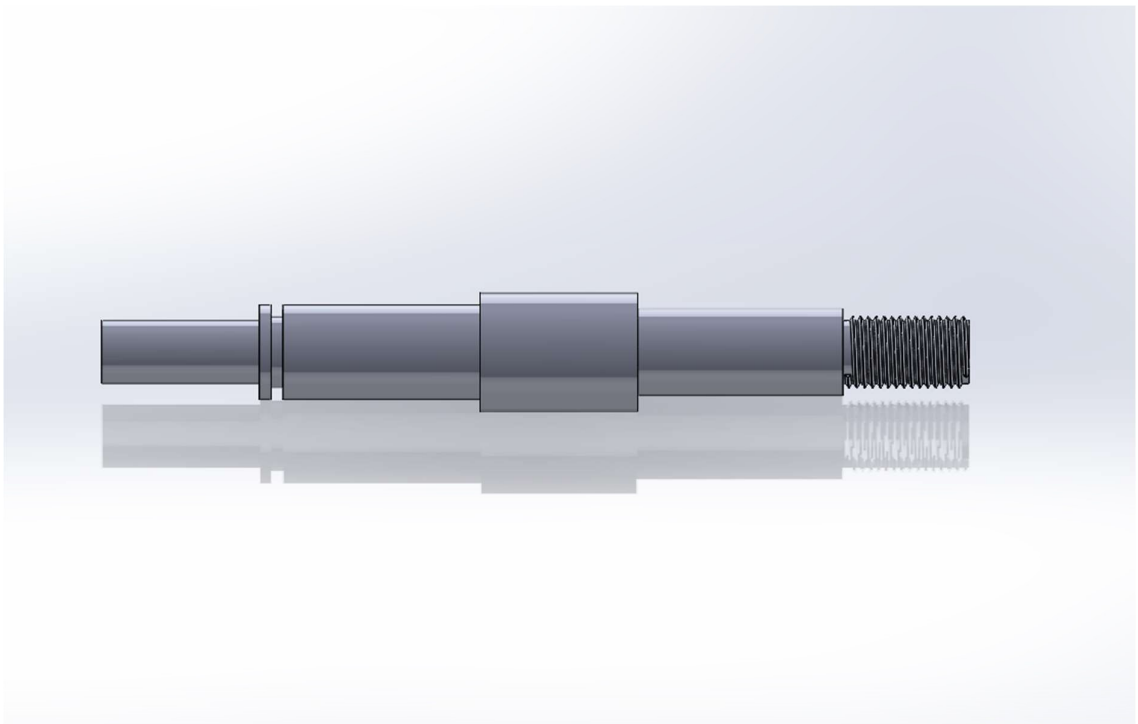
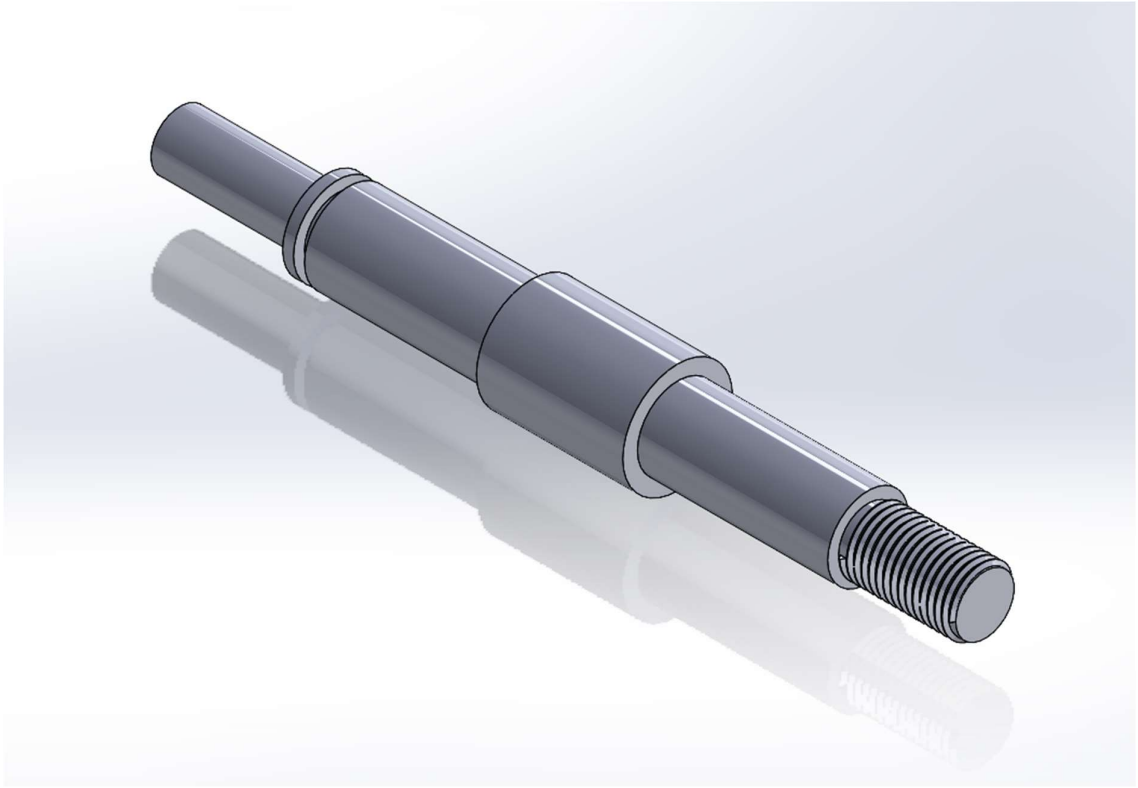
S. No.	Machine	Operation Description	Machine/Tool required	Operation time (Min)	Credit
	Lathe	Machine and workpiece set up	Lathe	15	
1.		Facing the Stock piece.	Lathe / Single point cutting tool	10	
2.		Turning of the piece from 25mm dia. to 15mm dia.	Lathe / Single point cutting tool	30	
3.		Turning of the w/p from 15mm dia. to 8mm dia., 0mm to 20 mm in length.	Lathe / Single point cutting tool	20	
4.		Turning of the w/p from 15mm dia. to 12mm dia., 20mm to 48mm in length.	Lathe / Single point cutting tool	15	
5.		Grooving of the w/p from 12mm dia. to 9mm dia., 21.5mm to 23mm in length.	Lathe / grooving tool	15	
6.		Turning of the w/p from 15mm dia. to 11 mm dia., 68mm to 94 mm in length.	Lathe / Single point cutting tool	15	
7.		Turning of the w/p from 15mm dia. to 8mm dia.(approx.), 94mm to 110 mm in length.	Lathe / Single point cutting tool	30	
8.		Threading M8	Lathe/ M8 threading Mold	20	

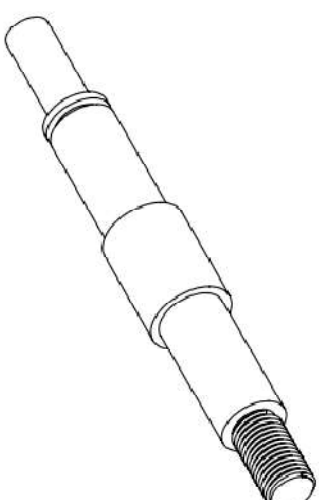
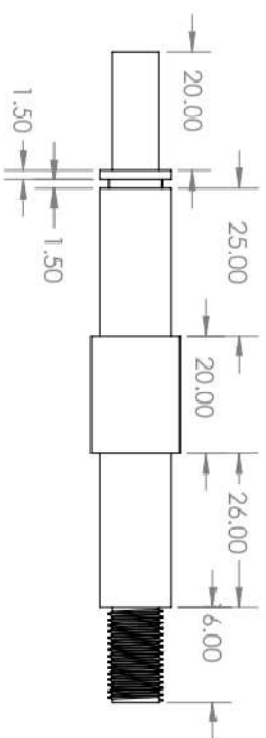
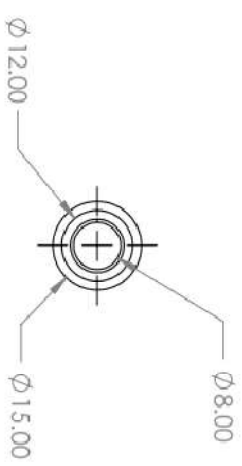
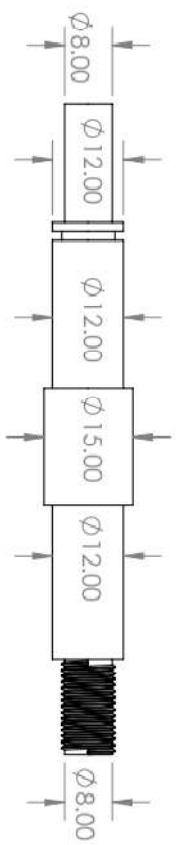
***For measurement, Vernier Calipers are used.**

Learning Outcomes

- Proper use of marking and hand tools
- Workpiece alignment
- How the feed and depth of cut are provided
- Facing
- Turning
- Step turning
- Grooving
- Threading

Student Signature: _____





1 unit = 1mm