

Methods Listing

User DKW
Company Jims Machining

Part 35029-85 Description 5th Gear Mainshaft U/M EA Customer
Rev K
Prod Notes Updated 02/17/04

MATERIAL

Seq	Part	Description	Quantity	U/M	Est Unit Cost	Lead	Vendor	Opr
1	35029F	5th Gear, Mainshaft rough turn These parts come from Job#	1.00000	EA	1.44202	0		0

OPERATIONS

Seq	Wrkc	Oper	Description	Pieces	Set Std	Prod Std	Est Unit Cost	Vendor
5	S/R	TAKE	Take from stock	1.00	0.00	20.0000	TM	0.00
10	SL3	TURN	Turning Hold on Ø1.772; prebore Ø1.241 and 1.26. Face and turn Ø3.444 +/- .001 Counter bore 1.440 X .275 +/- .001 on depth and 2.760 X .065 Program #J:\Turning\6T\PO2016	1.00	4.00	3.7500	MP	0.00
20	SL3	TURN	Turning Hold on Ø3.444 Turn O.D., Leave Ø.010+/- .001 for grind per note 3 hold .812 +/- .001 don't thread part. or turn thread relief. Program #J:\Turning\6T\PO02166	1.00	4.00	3.7500	MP	0.00
30	M042	MILL	Milling Mill dogs complete. Program: #\Milling1\FDL4020\MD1307 #I:\MILLING1\HITACHI\MD630300 0	1.00	2.50	4.3750	MP	0.00
40	HONE	HONE	Honing Hone to note #5 (MUST match gear cutting arbor).	1.00	1.00	1.5000	MP	0.00
50	INSP	BEFOR	Inspection Make sure parts are complete before gear cutting.	1.00	0.00	20.0000	TM	0.00
60	S OP	GRHOB	Gear Hob Cut gear per 35029-85 Rev:____ AGMA Quality 9. **Watch pr heat treat sizes** MUST have good finish and TIR. **MUST HAVE FULL ROOT RADIUS** Keep free from dings-dents-scratches. Return prints with parts.	1.00	120.00	0.0000	MP	9.50 CLA80
70	INSP	INSP	Inspection *** HAVE 10 TO 15 PCS DEBURRED BY DEBURRING FOR YOUR SAMPLE LOT *** Inspect gear cutting. Use Illitron gear rolling instrument. Follow gear inspect setup chart. Make sure parts are complete before heat treat.	1.00	0.00	1.0000	TH	0.00
80	BURR	BURR	Deburring Run in spindle burr machine.	1.00	0.00	4.0000	MP	0.00