

Manufacturing Process Instruction

Part #: AN00009 Part Name: GEARBOX SUBASSEMBLY Prepared By: JEREMY RURUP

Team: ME 270 EXAMPLE Sheet: 1 of 1 Date: 2/8/2018

Operation #	Operation/Process Instructions in detail step by step	Machine to be used	Estimated Labor Hours		Remarks
			Set-up	Machine	
1	Align (1) such that all edge faces are flush with (6). Match drill with holes	Drill	0.1	0.1	
2	Secure both (1) onto (6) with (15) in pre-drilled locations	Drill	0	0.1	
3	Align (2) such that all edge faces are flush with (6). Match drill with holes	Drill	0.1	0.1	
4	Secure (2) onto (6) with (15) in pre-drilled locations	Drill	0	0.1	
5	Bolt (5) onto (6) with (10) and (11) hardware	Wrench	0	0.1	
6	Loop chain and belt around sprocket and pulley	Hands	0	0.1	
7	Push (7) through (6), thread (8), slide (4), and thread (9) onto (7)	Wrench	0	0.2	
8	Repeat step 7 for chain side	Hands	0	0.1	
9	Align (3) and use a transfer punch to mark pre-drill locations for (12)	Punch, Hammer	0.1	0.1	
10	Predrill holes	Drill	0	0.1	
11	Hammer in all (12)	Hammer	0	0.1	
12	Bolt on (3) with hardware (14) and (13)	Hex Key Wre	0	0.1	