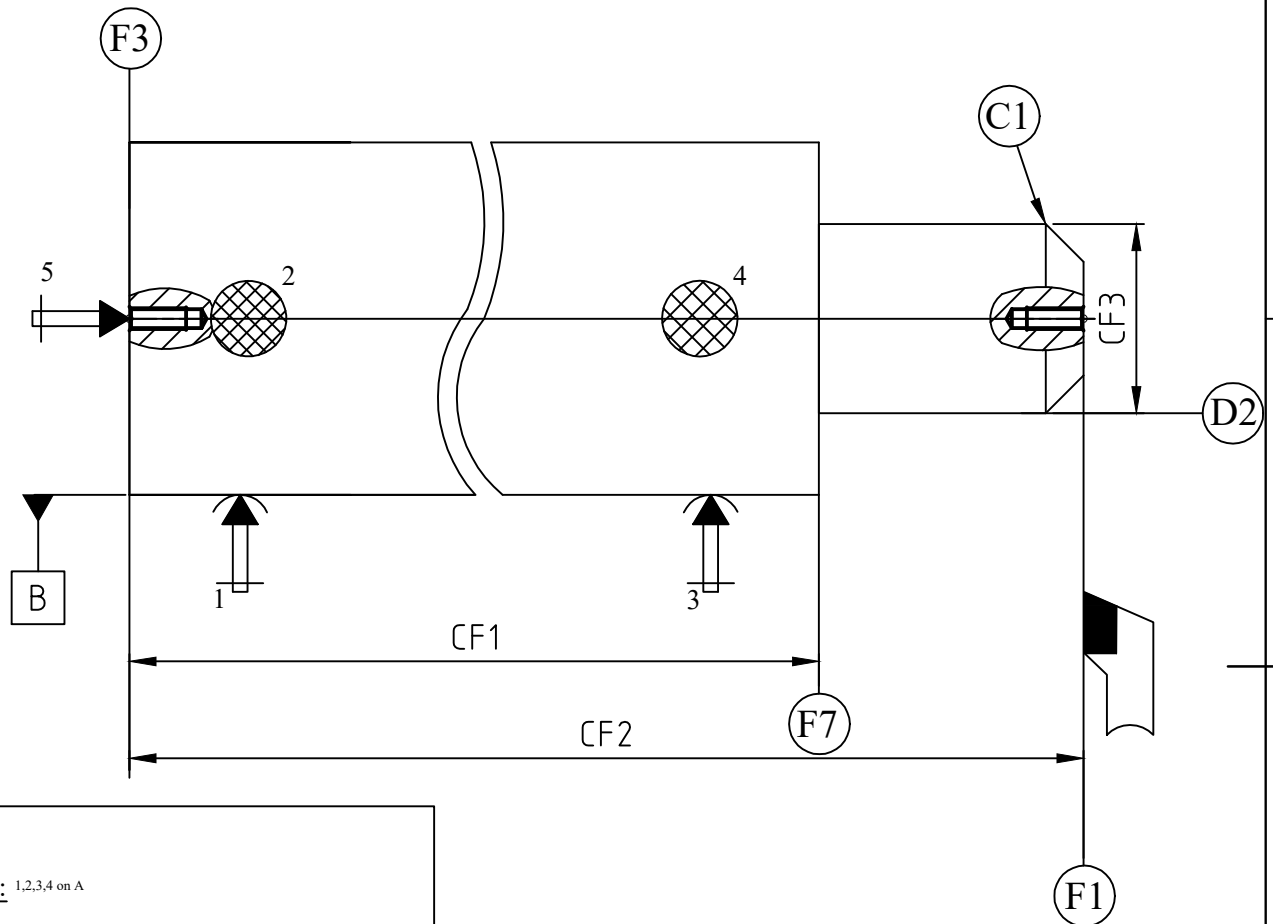


1	2	3	4
E.N.S.E.T	MACHINING PHASE CONTRACT	Page : 2	OCTOBER 2022
Shaft	PHASE 20: Turning 1		MATERIAL : Alloy steel ,C30
DONFACK FORTUNE			CRUDE : Drawn
SUB PHASE :			MACHINE : Parallel lathe



OPERATIONS	ELEMENTS							EQUIPMENTS	
	CHANGING			CUTTING				Cutting tool	Verificator
	E	F/2	F	a	n	A	Vc		
Dress F1E,F1F	X		X	0.2	265.39	53.07	25	Dressing tool	Vernier caliper Depth gauge
Turning and dressing D2E,D2F,F7E,F7F	X		X	0.2	265.39	53.07	25	knife tool	
Centring									
chamfring C1F			X	0.2	265.39	53.07	25	Chamfer mill	