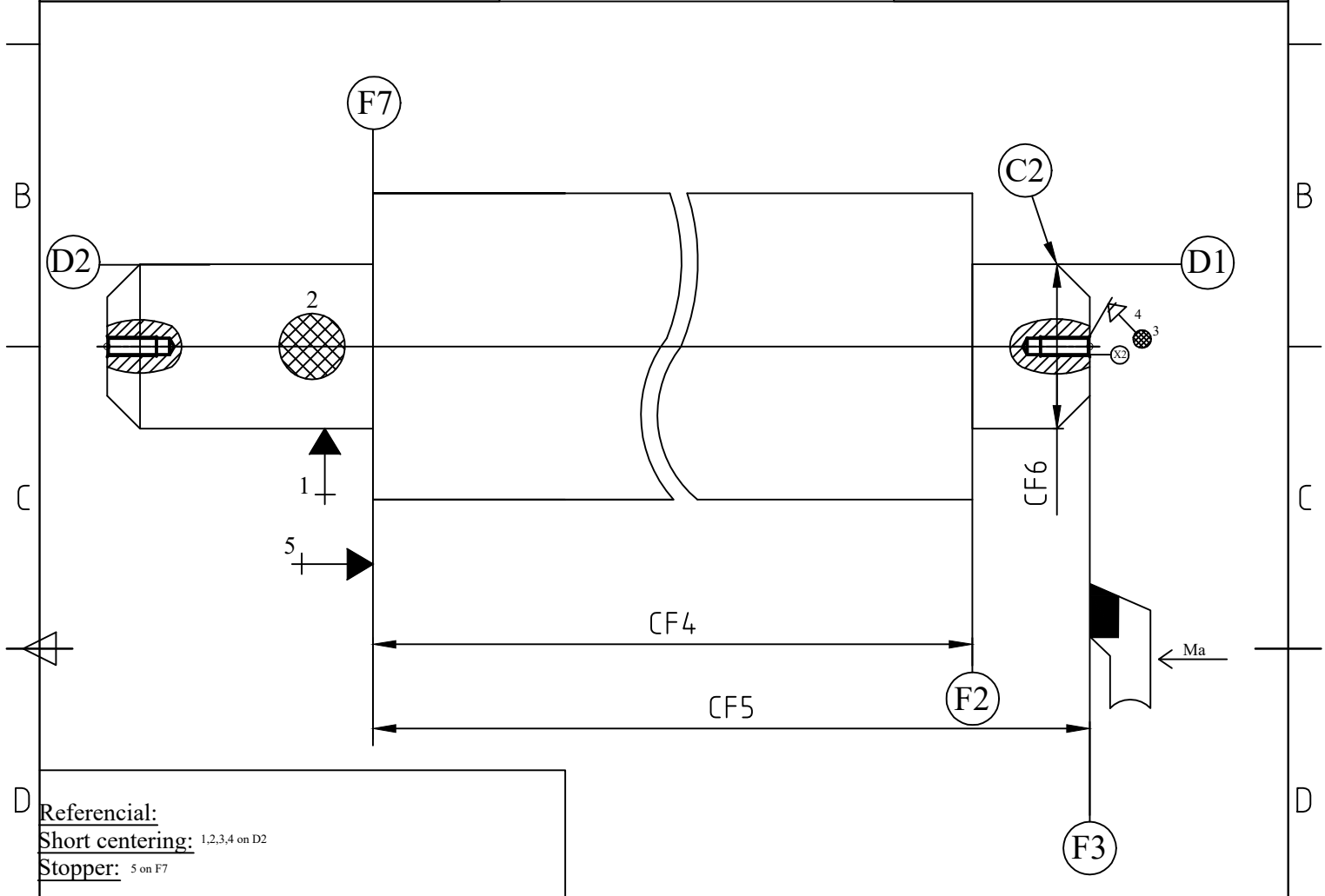


1	2	3	4
E.N.S.E.T	MACHINING PHASE CONTRACT	Page : 3	OCTOBER 2022
Shaft	PHASE 30: Turning 2	MATERIAL : Alloy steel ,C30	
DONFACK FORTUNE		CRUDE : Drawn	
SUB PHASE :		MACHINE : Parallel lathe	



Referencial:
Short centering: 1,2,3,4 on D2
Stopper: 5 on F7

OPERATIONS	ELEMENTS							EQUIPMENTS	
	CHANGING			CUTTING				Cutting tool	Verificator
	E	F/2	F	a	n	A	V _c		
Dresse F3F			X	0.2	318.47	63.69	25	Dressing tool	Vernier caliper Depth gauge
Turning and dressing D1F,F2F, CF4= 992±0.1 CF6=Ø25m6			X	0.2	318.47	63.69	25	knife tool	
Centring									
chamfring C1F			X	0.2	318.47	63.69	25	Chamfer mill	