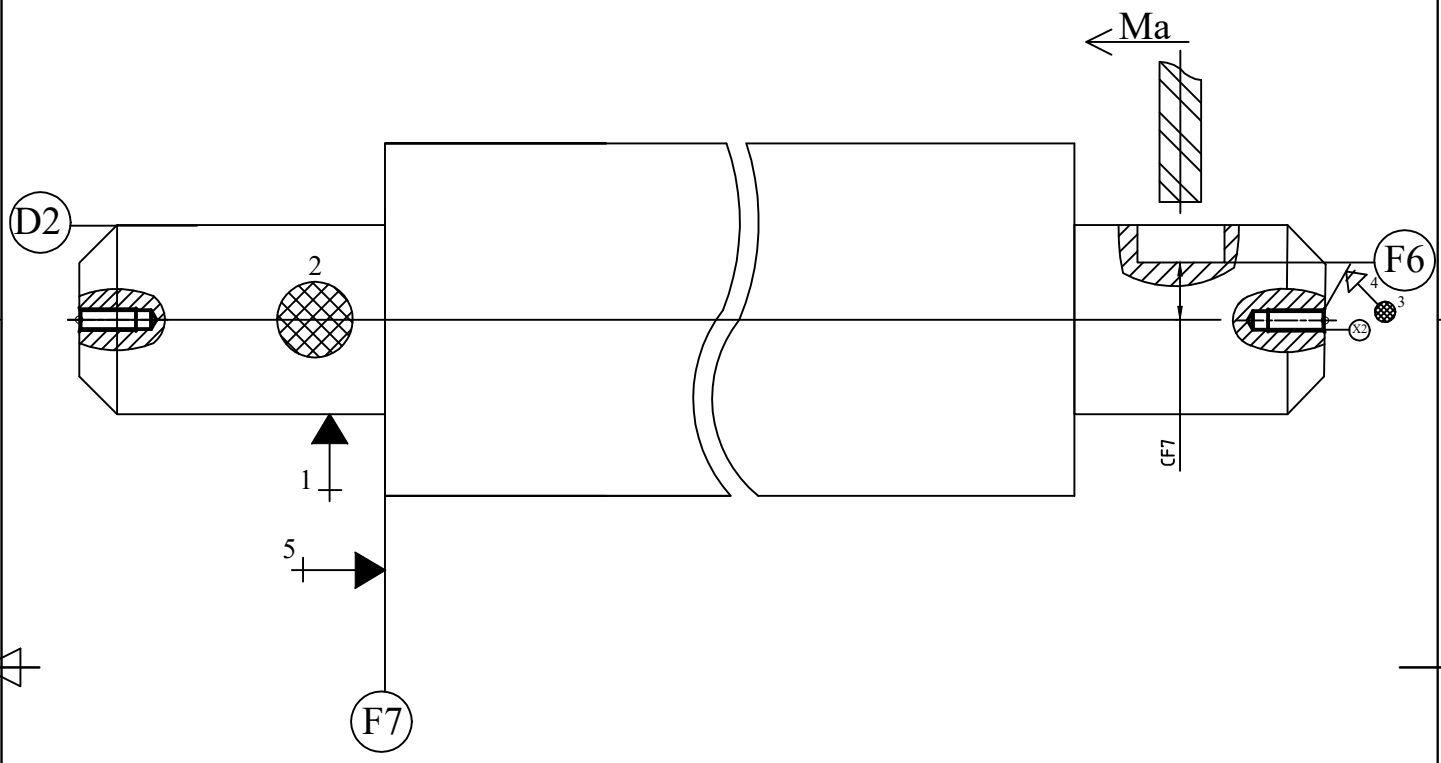
E.N.S.E.T	MACHINING PHASE CONTRACT	Page : 4	OCTOBER 2022
Shaft	PHASE 40: Milling	MATERIAL : Alloy steel ,C30	
DONFACK FORTUNE		CRUDE : Drawn	
SUB PHASE :		MACHINE :Milling machine	



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	Vc		
Milling machine F4F,F5F,F6F, CF7= 4±0.1			X	0.2	1990.4	398.08	25	Cylindrical cutter 2T Ø=3	Vernier caliper,Ruler,Depth gauge