

THE HONG KONG POLYTECHNIC UNIVERSITY
INDUSTRIAL CENTRE
 Metal Cutting Unit
Introduction to Milling

STUDENT NAME: _____

CLASS / GROUP _____

DATE _____

The technical drawing includes the following views and dimensions:

- MOVING JAW**: Front view (30 width, 15 height), side view (9.5 width, 12 height, 6 thickness), top view (17.8 width, 14 height, $\phi 5.5$ hole).
- PLATE**: Side view (3 width, 3 height).
- VICE BODY**: Front view (30 width, 15 height, 16 depth, 11.5 offset, 13 hole diameter, 18 base width, 22 total height), side view (30 width, 10 height, 15 depth, 55 total length).

Fasteners: M5 X 0.8 (for Moving Jaw), M6x1 (for Vice Body).

Specification Table:

SIMPLE VICE	
Part Name:	SIMPLE VICE
Part No:	
Org No:	Body
Des By:	CF Sin
Date:	05/2003
File:	Body.ipt
Rev No:	
Rev By:	iccfsin
Date:	
Proj:	
Material:	MILD STEEL
Scale:	
DO NOT SCALE DRAWING	
PROJECTION:	
GENERAL MACHINING TOLERANCE	
X ± 0.20	
XX ± 0.05	
0 TO 250 ± 0.5	
500 & ABOVE ± 2.0	
TIR ± 0.20	
ANGULAR ± 1/4°	

OPERATION PLANNING SHEET

MATERIAL:-
Mild Steel
(32X32X57mm)

MACHINE TYPE:-
Vertical Milling
Machine

CUTTING TOOLS:-
End Mill $\phi 12$ & $\phi 16$
mm

MACHINE ACCESSORIES:-
Machine Vice
Parallel Bar
Round Bar
Hide Face Hammer

MEASURING EQUIPMENT:-
Steel Rule
Vernier Calipers
Vernier Height Gauge
Digital Readout

Sequence No	Description	Tooling / Equipment	Speed	Remarks
1.	Prepare the material	---	---	Mild Steel (32 X 32 X 57)
2.	Milling the 1 st surface		550 RPM	
3.				