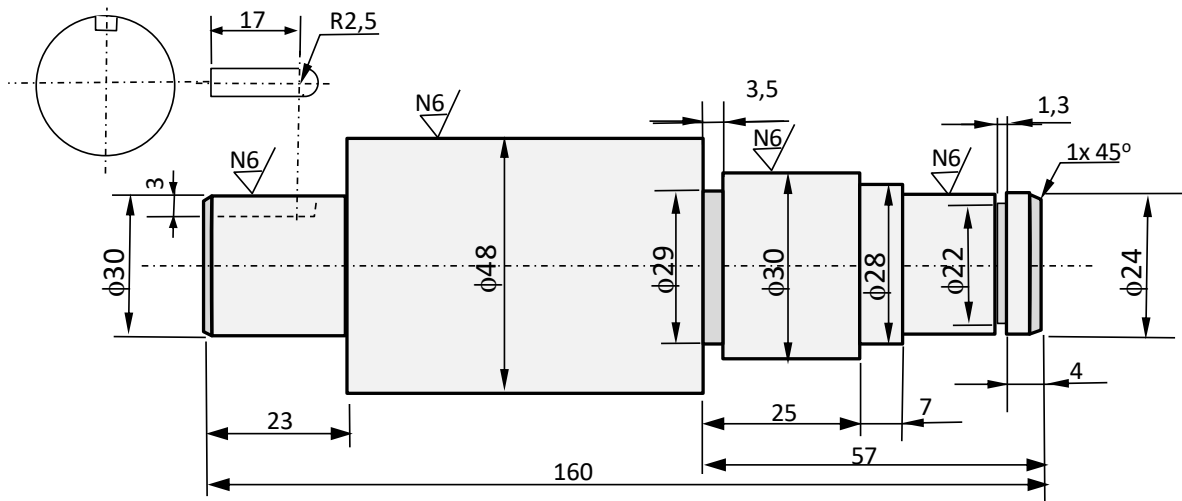
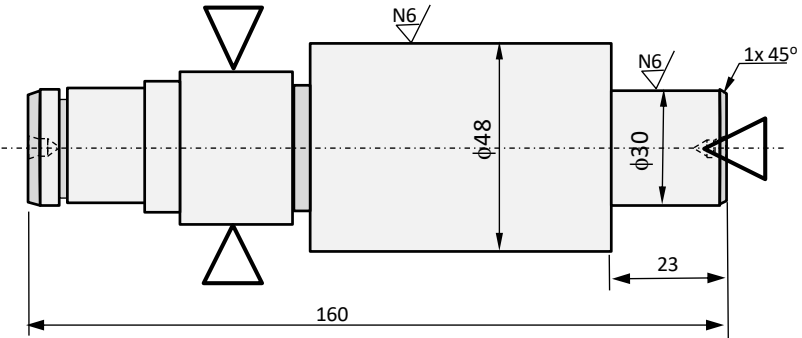
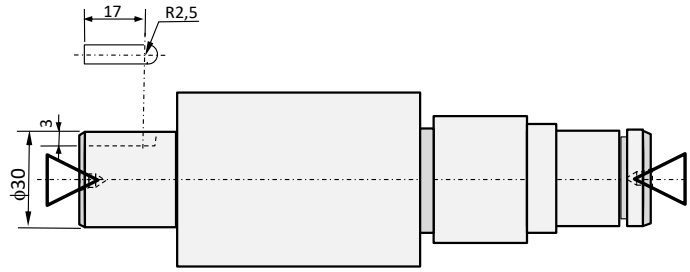
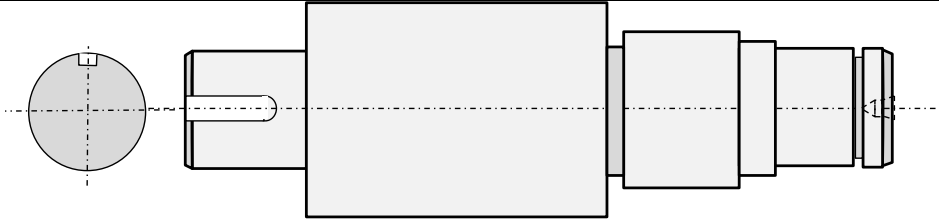


Folha de Processo para fabricação de um eixo em aço ABNT 1050.



Op.	Descrição	Máquina	
10	Alimentar com tarugo de $\phi 50$ mm x 162 mm. Fixar uma face. Facear a extremidade e fazer furo de centro	T.U.	
20	Tornear $\phi 30$ x 57mm.	T.U.	
30	Tornear cilíndrico diâmetro $\phi 28$ x 32.	T.U.	

40	Tornear $\phi 24$ por 25 mm. Chanfrar a extremidade $1 \times 45^\circ$.	T.U.	
50	Fazer canal para saída de rebolo no diâmetro de $\phi 30 \times 3,5 \times 0,5$.	T.U.	
60	Fazer canal para anel elástico no diâmetro $\phi 24 \times 1,3 \times 1$ a 4 mm da face.		
70	Fixar pela face torneada, usinar a face, e fazer furo de centro.	T.U.	
80	Tornear cilíndrico em acabamento diâmetro externo para $\phi 48 \times 103$		

90	Tornear em acabamento diâmetro de 30x23 Chanfrar a extremidade (1x45°).	T.U.	 <p>Technical drawing of a shaft. The drawing shows a shaft with a total length of 160. The main diameter is 48. There is a section with a diameter of 30 and a length of 23. The end of this section is chamfered with a 1x45 degree chamfer. The surface finish is indicated as N6.</p>
100	Fixar em dispositivo especial na mesa da fresadora vertical e fazer rasgo de chave no diâmetro $\phi 30 \times 17 \times 5 \times 3$	Fr. V.	 <p>Technical drawing showing a shaft with a keyway. The drawing includes a detail of the keyway with dimensions 17, R2,5, and 3. The main diameter of the shaft is 30.</p>
110	Peça Pronta		 <p>Technical drawing of a shaft with a keyway. A circular cross-section detail is shown on the left, indicating the keyway's position and dimensions.</p>

