

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/10/69 - Retyped from 5/13/63-Revised process - chg. read. & equip. CP- 267968
 9/17/76 - Chg. dept. no. 61 to 15 - Joy - 275236
 1/20/77 - Added item five - Joy - 275554

DESCRIPTIVE INFORMATION

1. Assemble Extractor To Bolt Assembly with Extractor Rivet.
 a. Blend Extractor with Extractor shroud.

2. Assemble Ejector Spring and Ejector to Bolt with Ejector Pin.
 a. Pin must be a drive fit.
 b. Ejector must be free with tension.

3. Check for Extractor movement.
 Max. Plug must depress Extractor to bottom on face of sq. plug.

4. Number Bolt to match Receiver Serial number with Ideal etcher.
 a. Use last four numbers only.

5. If necessary, file Extractor to insure good working fit under shroud of Bolt Head.

EQUIPMENT - TOOLS & GAGES

Only correct components of good color
 Not broken or deformed should be used.

Fixture D-84993

Punch C-71477W

Hydraulic Press - Pressure approx.

2200 lbs., .027 on deflection Ga. TS-1764

Shell Head Dia. Max. Plug (222 Mag.) B-84831A

Ideal Etcher Std.
 NOTE: - Numbers must be uniform and legible.

Vise Jaws C-51730

OPERATION DESCRIPTION

Assemble Extractor, to Bolt Assembly and rivet. Assemble Ejector Spring, and Ejector to Bolt with Ejector Pin. Number Bolt.

OCC. NO.

STD. HRS/C

UID. NO.

EFF. DATE

PART NO.

GA.

Final Assembly

COOLANT

SET UP

MODEL NO.

XP-100

OPER. NO.

90

TYPE

CH. HRS.

DEPT. NO.

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