

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

MODEL BOLT ACTION COMPONENT BOLT LATCH PART NO. SK-C-3550
DATE 5-23-80 COMPUTER KOWALSKI SHEET 1 OF 1

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	PURCHASE INVESTMENT CASTING FROM VENDOR				
	 EST. - P. PRICE - 1.10 EA				
	EST. TOOLING - \$4500.00				
	PURCHASE INSPECTION	BENCH			
		COMPACTOR SURGEON	NEW	10	1
		COMP. FIXTURE	STD	1	1
		GAGES	STD AY	1	1
10	DRILL CROSS PIN HOLE	1 SPOOL DRILL PRESS			
	 52 DRILL	DRILL JIG	NEW	40	90
		DRILL #52 (0635)	STD	1	1
		GAGES	NEW	35	105
20	DEBurr	BENCH			
30	BLANK TOP	POLISHING JACK			
40	CYANIDE HARDEN				
50	LINDBERG DRAW				
60	INSPECT FOR ROCKWELL				
70	BLACK OXIDE				
	TO DISPATCH AREA	TOTAL			

RD-6568 1-18-63