

"Rivstless" EXTRACTOR

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET 28665

• SEQUENCE OF OPERATIONS •

MODEL 700 COMPONENT Car 700 PART NO. _____
DATE 9-14-75 COMPUTER OKS SHEET 1 OF 2

OPER NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
5-	DRAW TURN EARTH SHAPE FINISH FACE AND CUT DIRT	A.U. PORTLAND OPER. FROM 19479, 1976 1957, 2211, 332872	03		
15-	PILING MILL BOLT LUGS	" "	60		
	TOTAL AMOUNT PAID - FOR LTD-3497 (LEFT HAND)				
22-	BUTMILL EXTRACT RETAINING PIN HOLE, DRILL EXTRACT RETAINING PIN HOLE, BUTMILL EXTRACT HOLE, DRILL EXTRACT EXTRACT HOLE & DRILL & SINK GAS ESCAPE HOLE, EXTRACT EXTRACT RETAINING PIN HOLE. LEFT HAND ONLY.	" "	60		
23-	BUTMILL DRILL & OIL EXTRACT HOLE, BUTMILL DRILL EXTRACT RETAINING PIN HOLE AND MILL NORTH END BRIZING. (RIGHT HAND)	" "	60		
30-	DRILL & PILE EXTRACT PIN HOLE DRILL AND SINK GAS ESCAPE HOLE, EXTRACT NOTION-BOTTOM SIDE - ALONG AUTOMAT "DRILL & SINK EXTRACT RIVER HOLE"	SAME AS PRESENT OPER. EXCEPT AMT: "DRILL & SINK EXTRACT RIVER HOLE"	60		
35-	DRILL & PILE EXTRACT PIN HOLE LEFT HAND ONLY	SAME AS PRESENT OPER.	10		
	TOTAL				

REVISED 4/23/80

"RIVETLESS" EXTRACTOR
PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET
*** SEQUENCE OF OPERATIONS ***

(R.N.) ~~28665~~ 28665
 (L.N.) ~~28670~~ 28670

MODEL 700 COMPONENT BOLT HEAD PART NO. 28665
 DATE 9-14-78 COMPUTER LES SHEET 2 OF 2

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
40	BOTTOM CLEARANCE CUT (RHS. & SMALL CANS. ONLY) RH & LH.	AUTOMATED DRILL PRES BASE PLATE		4	16
		DRILL JIG (R.H.) (REG. CAL.)		25	100
		DRILL JIG (R.H.) (SMALL CAL.)		25	100
		DRILL JIG (L.H.) (REG. CAL.)		25	100
		DRILL JIG (L.H.) (SMALL CAL.)		25	100
		CUT DRILL (REG. CAL.)			3
		CUT DRILL (SMALL CAL.)			3
		FINISHING GRIND (REG. CAL.)		20	80
		FINISHING GRIND (SMALL CAL.)		20	80
47	MILL EXTRACTOR CLEARANCE CUT AND SCRAP BURN FROM EXTRACTOR CLEARANCE CUT (SKD-3435 ONLY) RH	SEE ATTACHED SHEET P. 47			
50	MILL EXTRACTOR CLEARANCE CUT AND SCRAP BURN FROM EXTRACTOR CLEARANCE CUT (SKD-3437 ONLY) LH	SEE ATTACHED SHEET P. 50			
55	GRIND MATCH FOR BRADING 1 SURFACE (SKD-3437 ONLY) LH	A.U. PRESENT OPER. P. 55 PT. NO. 32571, 32572			
60	REAM DIRECTOR PIN HOLES AND EXTRACTOR HOLES	A.U. PRESENT OPER. P. 60 PT. NO. 15479, 15706, 15551, 32871, 32872			
- To Bolt Body Area -					
DIP 60					
TOTAL					

12,000

RD-6568 1-18-63