

RIVETLESS "EXTRACTOR"

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• COMPUTATION •

~~SD~~-28665

MODEL 700 COMPONENT Left Hand PART NO. 3455
 OPERATION MIL. EXTRACTOR CLEARANCE CUT ETC. OPER. NO. 97
 MACHINE REM. ENGINE #29186 DEPT. NO.
 COMPUTER FAB DATE 9-21-78 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
ROTINGTON SPECIAL #29186	B-75540	ALTER	30	120
FIXTURES				
--LOC. UNIT (REG. CALS.)			100	400
--LOC. UNIT (MAG. CALS.)				
--LOC. UNIT (SMALL CALS.)				
"T" CUTTER				
ROUGH (REG. & MAG.)	B-64645-W	A.V.		
ROUGH (SMALL CALS.)		NEW	2	5
FINISH (REG. & MAG.)	B-64645-R	A.V.		
FINISH (SMALL CALS.)	B-64645-P	A.V.		
PING GAGE - WIDTH (HISAND)	A-85282	A.V.		
DIAL BASE GAGE	C-94996	A.V.		
PING GAGE - (REG. CALS.)	A-80220-V	A.V.		
(MAG. CALS.)	A-80270-D	A.V.		
(SMALL CALS.)	A-80270-R	A.V.		
COOPER - WIDTH GAGE (REG. CALS.)		NEW	25	100
(MAG. CALS.)		NEW	25	100
(SMALL CALS.)		NEW	25	100
SEALING FOR BARR (REG. CALS.)	B-85016-A	A.V.		
(MAG. CALS.)	B-85016-B	A.V.		
(SMALL CALS.)	B-85016-D	A.V.		
TOTAL			207	825

NOTE.
X 722
8805

SKETCH

RD-6367

1-18-63

"RIGTLESS" EXTRACTOR

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• COMPUTATION •

~~ME~~ - 28670

MODEL 700LH COMPONENT Car Load PART NO. 357
 OPERATION Mill Extractor 2 Cylindrical Cyl. Hts. OPER. NO. 50
 MACHINE Rev. 5-27-66 #2915C DEPT. NO. _____
 COMPUTER TLA DATE 9-21-78 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
KETTINGTON SPECIAL #27186	E-75540	A.J. FROM MR. HANCOCK	—	—
LOG UNIT (RIG. CALS)		NONE	20	90
LOG UNIT (MAG. CALS)		NONE	20	90
"T" CUTTER (ROUGH)	B-64445-W	A.U.	—	—
"T" CUTTER (FINISH)	B-64445-R	A.U.	—	—
PENG GAGE (RIG. CALS)	B-50220-J	A.U.	—	—
PENG GAGE (MAG. CALS)	B-50270-D	A.U.	—	—
PENG GAGE - WIDTH (.15/.18)	B-55282	A.U.	—	—
CIRCULARITY GAGE (RIG. CALS)		NONE	25	100
CIRCULARITY GAGE (MAG. CALS)		NONE	25	100
DIAL CASE GAGE - POSITION	B-54996	A.U.	—	—
SCRAPER END BURR (RIG. CALS)	B-55016-A	A.U.	—	—
SCRAPER END BURR (MAG. CALS.)	B-55016-B	A.U.	—	—
TOTAL			90	360

SKETCH

RD-6547

1-18-63