

# SEQUENCE OPERATIONS

| OP. No.                                                                         | OPERATION                                                                                                                                                                                              | DEPT.       | OP. No. | OPERATION | DEPT. |
|---------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|---------|-----------|-------|
| 55                                                                              | <p>Draw the following Parts to make a Sear Block Assembly</p> <p>Sear Block Assembly Pt.# 26845</p> <p>Sear Block Pt.# 15461</p> <p>Sear Block Stud Pt.# 15462</p> <p>Assembly Sear Block Assembly</p> | 15          |         |           |       |
| <p>DATE AND REASONS FOR REVISIONS</p> <p>9/29/80 - New - MRP - JAA - 279156</p> |                                                                                                                                                                                                        |             |         |           |       |
| <p>DATE AND REASONS FOR REVISIONS</p>                                           |                                                                                                                                                                                                        |             |         |           |       |
| <p>MODEL XP-100 PART NAME Sear Block Assembly PAGE 1 OF 1</p>                   |                                                                                                                                                                                                        |             |         |           |       |
|                                                                                 |                                                                                                                                                                                                        | GA. OR CAL. |         |           |       |
|                                                                                 |                                                                                                                                                                                                        | PART No.    | 26845   |           |       |
|                                                                                 |                                                                                                                                                                                                        |             |         |           |       |
|                                                                                 |                                                                                                                                                                                                        |             |         |           |       |
|                                                                                 |                                                                                                                                                                                                        |             |         |           |       |
|                                                                                 |                                                                                                                                                                                                        |             |         |           |       |
|                                                                                 |                                                                                                                                                                                                        |             |         |           |       |

RD-4480

DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - JAN - 279156

DESCRIPTIVE INFORMATION

11 2 Greenhard Press  
C-06199 Fixture  
C-06199-A Ram

Bear Block  
Assembly

Smooth and uniform  
surface  
Safety cam contact

Edge sharp.  
No visible radii

All Edges  
Dirt-Free

Bear Block

Bear  
Block  
#15461

Bear Block  
Stud  
#15462

Holes Free of Residue

PART NAME Sear Block Assembly coolant oil SET UP MODEL No. XP-100 OPER. No. 55  
TYPE 15 MACH. HRS. 15 DEPT. No. 15 PAGE 1 OF 1

Form M. D. 6456

PROCESS CORDS

DATES AND REASONS FOR REVISIONS 9729780 - NEW - MRP - JMA - 279156

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

SPEED FEED

Sear Block Pt. #15461

Sear Block Stud Pt. #15462

1. Visually inspect Sear Block
  - o All holes must be free of residue.
  - o Clean With paper clip wire if necessary.
  - o Sear Safety Cam contact surface must be:
    - o Smooth
    - o Burr-free
    - o Rear edge must be sharp

Check for burrs and smoothness with fingertip.

2. Start Sear Block stud into Sear Block hole and position into fixture.
3. Pull handle on press to firmly seat Sear Block stud shoulder,
  - o Sear Block Stud must be tight to Sear Block.

OPERATION DESCRIPTION

PART NO. 26B45

Assemble Sear Block Assembly

SET UP

MODEL No. XP-100

OPER. No. 55

PART NAME Sear Block Assembly

COOLANT

TYPE MACHINE

DEPT No. 15

PAGE 1 of 1