

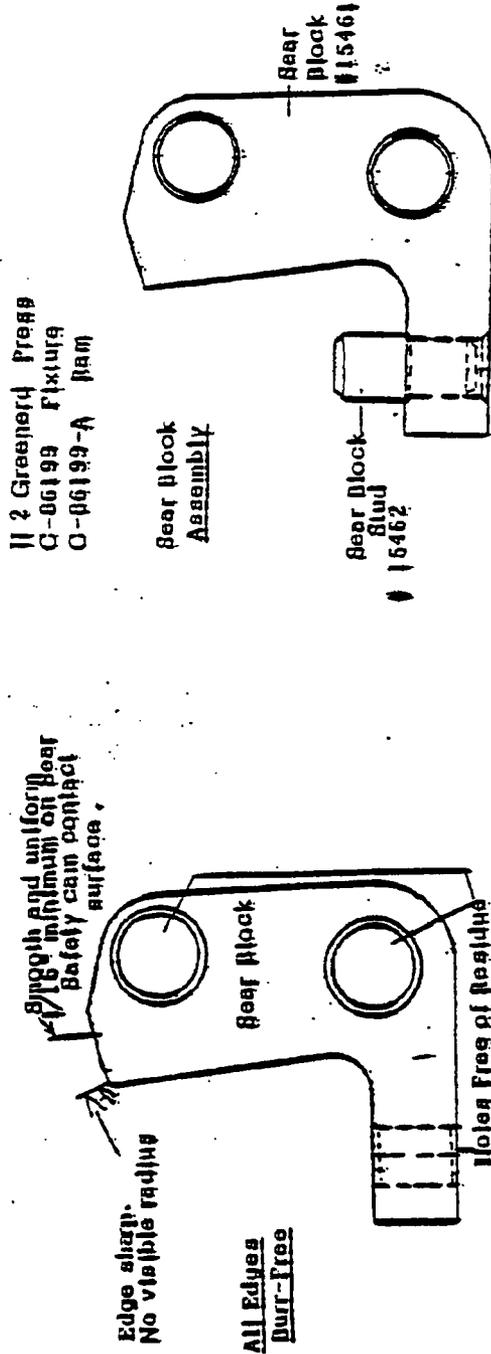
SEQUENCE OPERATIONS

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

RD-1480

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

DESCRIPTIVE INFORMATION



PART NAME Bear Block Assembly COOLANT _____ SET UP _____ MODEL No. XP-100 PAPER No. 55
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 1 OF 1
 MACHINE _____

Form No. 31. 6456

PROCESS CORDS

DATE AND REASON FOR REVISIONS 9729780 - NEW - MRP - JAA - 279156

APPROVAL AND DATES

TOOLS, GAUGES AND EQUIPMENT GA. OR CAL.

SPEED FEED

Sear Block Pt. #15461

Sear Block Stud Pt. #15462

OPERATION DESCRIPTION

PART NO. 26B45

Assemble Sear Block Assembly

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.

PART NAME Sear Block Assembly coolant
 TYPE MACHINE
 SET UP TIME
 MODEL No. XP-100
 DEPT No. 15
 OPER. No. 55
 PAGE 1 of 1

RD 1401