REVISED 4/23/60 - "RIVETLESS" EXTRACTOR

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• COMPUTATION •

SKD-28665

MODEL 700 COMPONENT BOLT HEAD PART NO. [illegible]
OPERATION MILL EXTRACTOR CLIMBANGLE CUT ETC. OPER. NO. 47
MACHINE REM. SPECIAL #291XC DEPT. NO.
COMPUTER HRB DATE 9-21-78 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
REMINGTON-SPECIAL #291XC	E-75540	ALTER	30	120
FIXTURE				
LOC. UNIT (REG. CALS.)			100	400
LOC. UNIT (MAG. CALS.)				
LOC. UNIT (SMALL CALS.)				
"T" CUTTER				
ROUGH (REG. & MAG.)	B-64645-W	A.U.		
ROUGH (SMALL CALS.)		NEW	2	5
FINISH (REG. & MAG.)	B-64645-R	A.U.		
FINISH (SMALL CALS.)	B-64645-P	A.U.		
PLUG GAGE - WIDTH (LISTING)	B-85282	A.U.		
DIAL BASE GAGE	C-94996	A.U.		
PLUG GAGE - (REG. CALS.)	B-80220-J	A.U.		
(MAG. CALS.)	B-80220-D	A.U.		
(SMALL CALS.)	B-80220-R	A.U.		
CONCENTRICITY GAGE (REG. CALS.)		NEW	25	100
(MAG. CALS.)		NEW	25	100
(SMALL CALS.)		NEW	25	100
SCRAPER FOR BURR (REG. CALS.)	B-85016-A	A.U.		
(MAG. CALS.)	B-85016-B	A.U.		
(SMALL CALS.)	B-85016-D	A.U.		
TOTAL			207	825

NOTE: x $22 = $880

SKETCH

RD-6567 1-16-63

REV. 4/23/80

"RIVETLESS" EXTRACTOR

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• COMPUTATION •

ERD-28670

MODEL 700LH COMPONENT Bolt Hand PART NO. [illegible]

OPERATION Mill Extractor Clearance Cut Off. OPER. NO. 50

MACHINE Rem. Spartan #29156 DEPT. NO.

COMPUTER [illegible] DATE 9-21-78 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
Remington Spartan #29186	E-78540	A.U. From Ar. Hand	—	—
Log. Unit (Reg. Calc)		New	80	80
Log. Unit (Mag. Calc)		New	80	80
"T" Cutter (Rough)	B-64645-W	A.U.	—	—
"T" Cutter (Finish)	B-64645-R	A.U.	—	—
Plug Gage (Reg. Calc)	B-80220-J	A.U.	—	—
Plug Gage (Mag. Calc)	B-80270-D	A.U.	—	—
Plug Gage - Width (Hs/Hr)	B-85287	A.U.	—	—
Concentricity Gage (Reg. Calc)		New	25	100
Concentricity Gage (Mag. Calc)		New	25	100
Dial Base Gage - Position	C-84996	A.U.	—	—
Scraper for Burr (Reg. Calc)	B-85016-A	A.U.	—	—
Scraper for Burr (Mag. Calc.)	B-85016-B	A.U.	—	—
TOTAL			90	360

SKETCH

RD-6567 1-18-63