

SEQUENCE OF OPERATIONS

OP. No.	OPERATION	DEPT.	OP. No.	OPERATION	DEPT.
1	Dry Tenite Powder	62			
2	Injection Mold	62			
3	Inspect	62			
DATES AND REASONS FOR REVISIONS New suggested process					
DATES AND REASONS FOR REVISIONS					
MODEL 700 PART NAME Fore End Tip PAGE 1 OF 5 GA. OR CAL. C-15299 PART NO.					

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

New Suggested Process

DESCRIPTIVE INFORMATION

Tenite Butyrate Black TRSL

Oven dry 2 Hours @ 170°F.

Material should not be put more than one inch deep in trays while drying.

EQUIPMENT - TOOLS & GAGES

Drying Oven - Lydon

Trays - 34" x 17" x 1 1/2" Deep

OPERATION DESCRIPTION

Dry Tenite Powder

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

C-15299

COOLANT

SET UP TIME

MODEL No.

700

DEPT. No.

62

PAGE

2 OF 5

OPER. No. Assigned

To be

5

MACHINE

HPM - 200 - P-28

PROCESS RECORDS

[illegible]

177-011

DATES AND REASONS FOR REVISIONS

New Suggested Process

DESCRIPTIVE INFORMATION

CYLINDER TEMP

Zone #1 - 360 °
 Zone #2 - 360 °
 Zone #3 - 360 °
 Zone #4 - 360 °
 Zone #5 - 350 °
 Zone #5A - 360 °
 Nozzle - 350 °

CLAMP

High Pressure - 2700
 Low Pressure - 1500

CYCLE

Clamp Close Time - 60 seconds
 Total Injection Time - 15 seconds
 Injection Full Pressure Time - 10 seconds
 Feed-Automatic - Yes
 Full-Automatic -
 Clamp Open Time - Gate seconds

INJECTION

High Pressure - 1900 lb.
 Low Pressure - 1000 lb.
 Weight of Shot - 86.5 grams
 Booster - NO

MOLD

Temperature Stationary Side - 90 °
 Temperature Movable Side - 100 °
 Temperature Additional Area -
 Max. Davlight Opening - 8 inches
 Max. Knockout - 1 inches

STUFFER

High Pressure - 1900 lb.
 Low Pressure - 200 lb.
 Reverse Stop Adjust for Minimum Inventory -
 Booster - No

REMARKS: Set flow control at 0

Cavity side of mold should be kept cold during the start-up to minimize sticking.

PART NAME: Fore End Tip SET UP TIME: MODEL No 700 TO BE
 TYPE: Tenite Butyrate Black TRSL MACH. HRS. DEPT. No 66 LABEL No 5
 MACHINE HPM - 200 - P-2B

Form K. 12-54

[illegible]