

cc: H. J. Hackman
Methods & Standards
P.H. Eccleston - File

Ilion, New York
November 11, 1964

TO: E. R. CARR

FROM: W. E. LEEK

SUGGESTED PROCESS RECORDS
Model 600 - Tang Support

Attached are suggested Process Records covering the Model 600 - Tang Support.

Should you have any questions, please do not hesitate to contact us.


W. E. Leek
Firearms Research & Design

PHEccleston:WEL:T

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS		New Suggested Process		APPROVAL AND DATE									
TOOL	GAGES AND EQUIPMENT	GA OR CAL											
	Mini Jector Molding Press	65 HA 100											
	2 Cavity Mold												
	Mold Temperature Controller												
	Container for Parts												
	Material - Delrin 500 BK 502												
<table border="1"> <thead> <tr> <th>OPERATION DESCRIPTION</th> <th>PART NO.</th> </tr> </thead> <tbody> <tr> <td rowspan="5">Injection Mold</td> <td>B-15883</td> </tr> <tr> <td></td> </tr> <tr> <td></td> </tr> <tr> <td></td> </tr> <tr> <td></td> </tr> </tbody> </table>						OPERATION DESCRIPTION	PART NO.	Injection Mold	B-15883				
OPERATION DESCRIPTION	PART NO.												
Injection Mold	B-15883												

PART NAME: Tang Support COOLANT: Water
 Type: Delrin 500 - BK 502 MACHINE: Mini Jector

DATES AND REASONS FOR REVISIONS

New Suggested Process

DESCRIPTIVE INFORMATION

MOED

CYCLE

IGT Serial No.

Type

Standard

No. of Cavities

1/4

Knockout Setting

180 OF

Temp. Stationary Side

180 OF

Temp. Movable Side

180 OF

CLAMP

Adjust clamp toggle for maximum clamping pressure.

FEED ADJUSTMENT

Adjust for minimum vibration

TEMPERATURES

Plastifying Cylinder

440 OF

Nozzle Variac Setting

100

SHOT WEIGHT

1.3 grams

Semi-Automatic

Full Automatic

Air Bleed

Yes

Yes

REMARKS Periodical spraying of mold will eliminate sticking.

Part Name Tang Support

Part No. 500 BK 662

Part Desc. 500 BK 662

Part Date 500 BK 662

Part Qty 500 BK 662

Part Unit 500 BK 662

Part Loc 500 BK 662

Part Mat 500 BK 662

Part Fin 500 BK 662

Part Pack 500 BK 662

Part Mfg 500 BK 662

Part Date 500 BK 662

TOOL, GAGES, AND EQUIPMENT		DATE	BY	REVISIONS
1	Break Parts from Gate			
2	Inspect for Extensive Sinks			
3	Regrind Container			
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DATE: 10/10/50

TIME: 10:00

BY: [Signature]

REVISIONS:

1. Break Parts from Gate

2. Inspect for Extensive Sinks

3. Regrind Container

PART NO. B-15883

OPERATION DESCRIPTION: Degate and Inspect

PART NAME: Tank Support

COOLANT: MILK-JECTOR

DATE: 10/10/50

TIME: 10:00

BY: [Signature]