

REMINGTON ARMS CO., INC. - PROGRAM MANUSCRIPT FOR L.S.S. AVS 20-13 LATHE-Sht. 1/2
 Part Name 100 Wrennot Drawing No. D-754796 Tape No. Tuev Date 2-24-68 Programmer NEZELAN Mat'l 9/40
 C-141
 2

N	G	X	Z	K	F	S	T	M	SPEED	FEED	ACCUMULATED	OPERATIONS - REMARKS
SEQ. NO.	PREP. FUNC.	DEPARTURE (DWEIL)	DEPARTURE (DWEIL)	ARC OFFZ (SIN/LEAD)	ARC OFFZ (COS/LEAD)	FEED RATE	SPIN (RPM)	TOOL (MISC)	RPM	SFM	IPM	ED X ED Z FROM ZERO (FROM ZERO)
N001	604	X02	STOP CODE	127	THIS POINT	FO95			INITIALIZE			96998 23747 FROM SPINDLE NOSE
N002	604	X02	Z0293		K99999	FO95		M07				96998 -23243 FROM PROGRAM ZERO
N003	604	X02						M06				" -0313 POSITION TO "HOME"
N004	604	X02						M02				" " " "
N005	604	X02	12 INCHES OF LEADER									GEAR RANGE - HIGH
N006	604	X02	STOP CODE	AT THIS POINT				M07				" " " "
N007	604	X02										96998 -0313 "HOME" POSITION
N008	604	X02						M06				" " " "
N009	604	X02										06575 " "
N010	604	X02										" " 09337 TURN TO 1.252 DIA
N011	604	X02										09565 " " PULL OUT
N012	604	X02										09813 RE POSITION
N013	604	X02										" " FEED IN
N014	604	X02										09337 TURN TO 1.130 ±005
N015	604	X02										" " RETRACT
N016	604	X02										" " " "
N017	604	X02										09698 " " "
N018	604	X02										101685 -4170
N019	604	X02										" 213650
N020	604	X02										09000 " "
N021	604	X02										" " " "
N022	604	X02										94000 " "
N023	604	X02										99373 206783
N024	604	X02										09000 213963
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N163	604	X02										" " " "
N164	604	X0										

REMINGTON ARMS CO., INC. - PROGRAM MANUSCRIPT FOR L.S. AVS 20-13 LATHE-Sht. 3/2

Part Name _____ Drawing No. _____ Tape No. _____ Date _____ Programmer _____ Mat'l _____

SEQ. NO.	G	PREP	X	Z	I	K	F	S	T	M	SPEED			FEED			ACCUMULATED		REMARKS
											RPM	SFM	IPM	IPR	ED	ED	FROM ZERO	TO ZERO	
N023	601	X	0277		179999		F005										08000	215963	
N024	601	X	0083	Z-00083	170711	K70711	F002										05230	"	
N025	605	X	0075	Z-155			F0125	523			1291	385	19.4	.005	.005	0	2063	57880	CHAMFER
N026	601	X	0065	Z-36			F0233	522			1244	440	12	.008	.008	0	7713	21880	
N027				Z-1538			F012			M07						"	"	08500	
N028	604	X	002														"	"	
N029	601	X	00285	Z-18187	179999	K99999	F005										98998	19687	READY FOR T11
N030	604	X	002							M06							"	"	
N031										M06									