

REV 4/23/80

"RIVETLESS" EXTRACTOR

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

* SEQUENCE OF OPERATIONS *

5-28660

MODEL 718 COMPONENT BOLT LEAD PART NO. 2452
 DATE 9-6-78 COMPUTER PRB SHEET 1 OF 2

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
5	WASH	A.L. PRESENT	10		
		OPERATION FOR			
		PT. NOS. 14207 & 14208			
10	ROUGH AND FINISH BUTTMILL AND RIVET HEADINGS, FLAM TO DEBURR SMALL HAIR AND BRUSH TO LENGTH	" "	10		
20	BUTTMILL FINISH RETAINING PIN HAIR; BUTTMILL EXTRACTOR HAIR; DRILL EXTRACTOR RETAINING PIN HAIR; DRILL EXTRACTOR HAIR; DRILL EXTRACTOR HAIR; DRILL EXTRACTOR HAIR & DEBURR EXTRACTOR HOLE AT REAR END	A.L. PRESENT EXTR. FOR PT. NOS. 14207 & 14208 EXCEPT: OMIT "RIVET & DRILL EXTRACTOR RIVET HAIR"	10		
25	BUTTMILL GLASSPANE CUT	AUTOMATIC DRILL PRESS			12,000
		CAGE PLATS	4	112	3,300
		DRILL CUG (BIG GAL)	25	100	
		DRILL SIG (SMALL GAL)	25	100	
		BUTT DRILL (BIG)			3
		BUTT DRILL (SMALL)			3
		RIVETING CAGE (BIG)	20	90	
		RIVETING CAGE (SMALL)	20	90	
30	ROUGH & FINISH HILL EXTRACTOR GLASSPANE CUT	SEE ATTACHED SHEET	10		
TOTAL					

RD-0368 1-18-83

REV. 4/23/80

**"RINGLESS" EXTRACTOR
PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET**

• COMPUTATION •

RD-28660

MODEL 785 COMPONENT ROLL HEAD PART NO. 3430
 OPERATION ROUGH & FINISH MILL WORK FOR CHUCKING OUT-ER OPER. NO. 30
 MACHINE RPM SPECIAL E-75540 DEPT. NO. 30
 COMPUTER _____ DATE _____ SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
REWORKING SPECIAL #30157	E-75540	ALTER	See H-200 ESTIMATE	
FIXTURE	D-85265	A.U.		
LOADING UNIT (222, 223 CAL)		NEW	20	30
LOC. UNIT (622, 243, 305, 22-250 CAL)		NEW	20	30
"T" CUTTER - ROUGH (22-250, 622, 243, 305)	B-64645-W	A.U.		
"T" CUTTER - ROUGH (222, 223)	B-64645-V	A.U.		
"T" CUTTER - FINISH (22-250, 622, 243, 305)	B-64645-R	A.U.		
"T" CUTTER - FINISH (222, 223)	B-64645-P	A.U.		
SET-UP CUTTER GAGE	A-89277	A.U.		
PLUG GAGE	A-85282	A.U.		
DIAL BASIS GAGE	D-85644	A.U.		
CONCENTRICITY GAGE		NEW	20	200
SETTING MASTER (2250, 622, 243, 305)				
SETTING MASTER (222, 223)				
LOC. UNIT (622, 243, 305, 22-250)				
LOC. UNIT (222, 223)				
DIAL UNIT (622, 243, 305, 22-250)				
DIAL UNIT (222, 223)				
PLUG GAGE (222, 223)	B-80220-R	A.U.		
PLUG GAGE (622, 243, 305, 22-250)	B-80220-C	A.U.		
TOTAL			90	360

SKETCH

RD-6567

1-18-63