

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/25/69 - Retyped from 3/16/67 - 267770

7/15/82 - Renumbered oper 5 was 2 - RBW - 281657

12/10/84-CHG. PROCESS PARAMETERS-CFC-284979

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.				
SPEED	FEED	Fixture	Taylor-Winfield "T" Clamping fixture U-12446			
		Pressure - lbs.	264			
		Tap	P-7			
		Squeeze - cycles	50			
		Hold "	40			
		Off "	30			
		Weld Time "	2 + 10			
	*	Weld Heat %	65%			
		Temper	No			
NOTE: 1		Upper Electrode	Mallory 3 Part No. 3415 Offset Nose Electrode,			
		Lower Electrode	RHMA No. C-228			
NOTE: *		Due to voltage changes - This percentage must be varied to obtain satisfactory welds.				
NOTE: 1		Not a Stores Item				
OPERATION DESCRIPTION			PART NO.	15452		
Weld tab and deburr						

PART NAME Sear Housing COOLANT SET UP TIME MODEL No XP100 OPER. No 5
 TYPE E-B3-8-10 MACHINE TW Welder DEPT. No 79 PAGE 1 OF 1