

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/23/63 - Made regular -
7/19/82 - renumbered oper 3 was 1 - RBW - 281657

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

SPEED	FEED	Chem. & Mat. Stand. Pract. No.	206
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1. Alkaline clean

2. Hot Water Rinse

3. Pickle Dip

4. Cold Water Rinse

5. Alkaline clean (To prevent rusting)

OPERATION DESCRIPTION

PART NO.

15452

Clean Bear Housing

PART NAME Bear Housing

COOLANT.

**SET UP
TIME**

MODEL No. XP-100

OPER. No. 3

TYPE _____ **MACHINE** _____

DEPT. No.

—PAGE

LOF

ND-0458

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

R2518461

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/23/63 - Made regular -
 4/21/65 - Chg. dept. # - FR - 261459
 1/19/79 - B-80154 was B-80214-B and B-80219 was B-80214-B - B-80154 was B-80219-Q - PRQ - 277528
 7/19/82 - renumbered oper 7 was 4 - RBW - 281657

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.				
SPEED	FEED					
		Holding Jig	G-85373			
		Step Reamer (.1244)	A-85452V			
		Step Reamer (.1257)	A-85452V			
		Step Reamer (.1261)	A-85452V			
		Plug Gage	H-80214-B	B-80154-K		
		.126 - .125 Dia.				
		Plug Gage	H-80214-B	B-80154-D		
		.1264 - .1254 Dia.				
		Plug Gage	H-80214-B	B-80219-R		
		.1247 - .1237 Dia.		*	For Ga. c-50264 use	
		Piloted C'sink	A-54497		Master A-82354 - Tol - Set dial to	
		Aircraft Stop			"0" to ".0043"	
	*	C'sink Gage	G-50264		Use side of master marked for M/600 & 40X	

OPERATION DESCRIPTION	PART NO.					
Ream 4 holes and c'sink Safety Detent hole	15452					

PART NAME Sear Housing COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 7
 TYPE _____ MACHINE _____ DEPT. No. 75 PAGE 1 OF 1

RD-6481

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
 KINZER V. REMINGTON

R2518462

44

12/21/62 - Was operation 12 - AJW -

5/23/63 - Made regular -

4/21/65 - Chg. dept. # - FB - 261459

5/8/81 - Chg. Dept. # - JRH - 280469

7/19/82 - renumbered oper 9 was 6 - RBW - 281657

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

SPEED	FEED
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FEED

OPERATION DESCRIPTION

PART NO.

15452

Deburr inside and outside

PART NAME Bear Housing

-COOLANT-

SET UP TIME

MODEL No. XP100

OPER. No. 9

TYPE _____ MACHINE _____

DEPT. No. 02 PAGE 1 OF 1

BB-141

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

R2518463

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

5/23/63 - Made regular

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

APPROVAL AND DATES

SPEED

FEED

OPERATION DESCRIPTION

PART NO.

15452

Black Oxide color

PART NAME **Sear Housing**

COOLANT

SET UP
TIME

MODEL No. **XP100**

OPER. No. **16**

TYPE **MACHINE**

DEPT. No. **79**

PAGE **1** of **1**

RD-8461

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R2518465