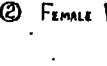
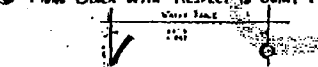
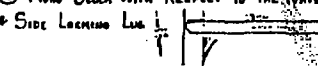
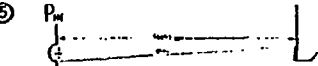


M/3200 Bol. Set INTERCHANGABILITY 12-20-28-410 GA. (ONE FORE END) WITH SPACERS

CRITICAL DIMENSION	PRESENT METHOD	PROPOSED METHOD
① PITCH OF BOL. 	NORMAL QUALITY CONTROL	MATCHED LINE OF SITE
② MALE WIDTH OF MONO BLOCK WITH RESPECT TO FEMALE WIDTH OF FRAME 	4  3  2  1  SELECTIVE ASSEMBLY	MATCHED SET. BOLS. ORDERED WITH S-SFACE GRIND TO WIDTH OF 12 GA. BOL. ASSEMBLY
③ LENGTHWISE POSITION OF SIDE LOCKING LUGS OF MONO BLOCK WITH RESPECT TO JOINT PIN. 	FITTED AT ASSEMBLY - JOINT PIN & FRAME & MONO BLOCK	FIT MATCHED BOLS. TO FRAME USING FINISHED JOINT PIN. HOLE IN FRAME AS BEARING. CUTTER MUST NOT BE ROTATING WHEN ENTERING OR LEAVING FRAME.
④ ANGULAR POSITION OF TOP LOCKING SURFACES ON MONO BLOCK WITH RESPECT TO THE WATER TIGHT & SIDE LOCKING LUG. 	SURFACE GRIND IS DONE ON MONO BLOCK BEFORE ASSEMBLY TO BOL. - FIT TOP LOCK AT ASSEMBLY	USE 12 GA. BOL. TO SET UP GRINDING WHEEL. GRIND 20-28-410 TO SAME SETTING. (WILL BE DONE TO MONO BLOCK AFTER ASSEMBLY TO BOL.)
⑤ LENGTHWISE POSITION OF THE BOL. LOOP FROM JOINT PIN. 	ADJUST ECCENTRIC PIN IN FORE END IRON ASSEMBLY.	a) USE RIGHT & LEFT FORE END SPACERS b) MEASURE FOR LONGEST BOL. ASSY. USE AS SET UP PIECE TO MILL THE OTHER 3 BOL. ASSEMBLIES TO THAT LONGEST LENGTH.
⑥ INVENTORY OF BOL. SUB-ASSEMBLIES	NONE	MAINTAIN AN INVENTORY OF SETS GA. 12 26 28 20 - x x 28 - x x 410 - x x SHEET CHOKER FIG. 2