

SEQUENCE OF OPERATIONS

OP. No.	OPERATION	DEPT. No.	OP. No.	OPERATION	DEPT. No.
1	Dry Tenite Powder	62			
2	Injection Mold	62			
3	Inspect	62			
DATES AND REASONS FOR REVISIONS New suggested process					
DATES AND REASONS FOR REVISIONS					
MODEL 700 PART NAME Fore End Tip PAGE 1 OF 5 GA. OR CAL. C-15299 PART NO.					

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

New Suggested Process

DESCRIPTIVE INFORMATION

Tenite Butyrate Black TRSL

Oven dry 2 Hours @ 170°F.

Material should not be put more than one inch deep in trays while drying.

EQUIPMENT - TOOLS & GAGES

Drying Oven - Lydon

Trays - 34" x 17" x 1 1/2" Deep

OPERATION DESCRIPTION	OCC. No.	STD. HRS/C	STD. No.	EFF. DATE					
Dry Tenite Powder									
PART No.	C-15299								
GA.									

PART NAME Fore End Tip COOLANT _____ SET UP TIME _____ MODEL No. 700 To be Assigned
 TYPE Tenite Butyrate Black TRSL MACH. HRS. _____ DEPT. No. 62 PAGE 2 OF 5
 MACHINE HPM - 200 - P-28

Form R. D. 6463

PROCESS RECORDS

[illegible]

DATES AND REASONS FOR REVISIONS

New Suggested Process

DESCRIPTIVE INFORMATION

CYLINDER TEMP

Zone #1 - 360 °F
 Zone #2 - 360 °F
 Zone #3 - 360 °F
 Zone #4 - 360 °F
 Zone #5 - 350 °F
 Zone #5A - 360 °F
 Nozzle - 350 °F

CLAMP

High Pressure - 2700 lb.
 Low Pressure - 1500 lb.

CYCLE

Clamp Close Time - 60 seconds
 Total Injection Time - 15 seconds
 Injection Full Pressure Time - 10 seconds
 Feed-Automatic - Yes
 Full-Automatic -
 Clamp Open Time - Gate seconds

INJECTION

High Pressure - 1900 lb.
 Low Pressure - 1000 lb.
 Weight of Shot - 86.5 grams
 Booster - No

MOLD

Temperature Stationary Side - 90 °F
 Temperature Movable Side - 100 °F
 Temperature Additional Area -
 Max. Daylight Opening - 8 inches
 Max. Knockout - 1 inches

STARTER

High Pressure - 1900 lb.
 Low Pressure - 200 lb.
 Reverse Step Adjust for Minimum Inventory -
 Booster - No

REMARKS: Set flow control at 0

Cavity side of mold should be kept cold during the start-up to minimize sticking.

PART NAME: Fore End Tip SET UP TIME: MODEL No. 700 TO BE
 TYPE: Tenite Butyrate Black TRSL MACH. HRS. DEPT. NO. 62 LABEL NO. 5
 MACHINE HPM - 200 P-5B

Form R 12-66

PROCES. RECORDS

NO. 5-451

R2503650
BARBER - PRESALE R 0102662

R2503650
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