

cc: H. J. Hackman
Methods & Standards
P.H. Eccleston - File

Ilion, New York
November 11, 1964

TO: E. R. CARR

FROM: W. E. LEEK

SUGGESTED PROCESS RECORDS
Model 600 - Tang Support

Attached are suggested Process Records covering the Model 600 - Tang Support.

Should you have any questions, please do not hesitate to contact us.


W. E. Leek
Firearms Research & Design

PHEccleston:WEL:T

SEQUENCE OF OPERATIONS	
Op. No.	Description
1	Injection Mold
2	Degate and Inspect
DATE AND REASONS FOR REVISIONS New Suggested Process	
MODEL 600 PART NAME Tang Support GA. OR CAL. B-15883 PART NO.	

R2503739

DATES AND REASONS FOR REVISIONS

New Suggested Process

DESCRIPTIVE INFORMATION

MOLD

IGT Serial No. _____
 Type Standard
 No. of Cavities 2
 Knockout Setting 1/4"
 Temp. Stationary Side 180 °F.
 Temp. Movable Side 180 °F.

CLAMP

Adjust clamp toggle for maximum clamping pressure.

TEMPERATURES

Plastifying Cylinder 440 °F.
 Nozzle Variac Setting 100

CYCLE

Inject 10" second
 Cure 10" second
 Preheat 10" second
 Clamp Open Time 10" second

INJECTION PRESSURE 1200 psiFEED ADJUSTMENT

Adjust for Minimum Injection

SHOT WEIGHT 6.3 gramsSemi-Automatic YesFull Automatic YesAir Blast YesREMARKS Periodical spraying of mold will eliminate sticking.PART NAME Tang SupportTYPE Dalton 500 BK 602

COOLANT

SET UP

TIME

MACH

HRS

MACHINE

MATERIAL

R2503741