

But Action

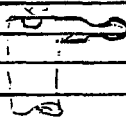
• SEQUENCE OF OPERATIONS •

MODEL RAABINE COMPONENT DOUGLAS M. B. V.

PART NO. 25 D. 222

DATE 5-22-70 COMPUTER KOWALSKI

SHEET 1 OF 1

OPER NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	NOTE: SAVE AS PRESENT M600 BOLT ASSEMBLY # 29870 PROCESS EXIST FOR THE ADDITIONAL OPERATION				
36	MILL BOLT LATCH SLOT ON END & DEBUR	1-18 C.I.N.J MILLER OR EQUIV.			
		FIXTURE	NEW	40	120
		FIRM CUTTER	"	10	20
		AIRBOR	AM	-	-
		CAGES	NEW	70	180
	TOTAL				

RD-6563

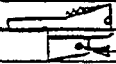
1-18-63

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

M-1700 Bolt Action

• SEQUENCE OF OPERATIONS •

MODEL 422015 COMPONENT BOLT LATCHSK- C-3550
PART NO.DATE 5-23-80 COMPUTER KOWALSKISHEET 1 OF 1

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	PURCHASE INVESTMENT CASTING FROM VENDOR				
	 EST. PRICE - 1.10 / EA				
	EST. TOOLING - \$4500.00				
	PURCHASE INSPECTION	BENCH			
		COMPACTOR SURGEON	NEW	10	1
		COMP. FIXTURE	STD	1	1
		GAGES	STD AY	1	1
10	Drill Cross Pin Hole	1 Spindle Drill Press			
	 52 DRILL	Drill Jig	NEW	40	90
		Drill #52 (0635)	STD	1	1
		GAGES	NEW	35	105
20	DEBUR	BENCH			
30	Buff Top	POLISHING JACK			
40	CYANIDE HARDEN				
50	LINDBERG DRAW				
60	INSPECT FOR ROCKWELL				
70	BLACK OXIDE				
	TO DISPATCH AREA	TOTAL			

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