

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• $\frac{1}{100} \text{ } \frac{1}{\text{Bolt Action}}$

• SEQUENCE OF OPERATIONS •

SK-D-2551

MODEL CARBINE

COMPONENT Bolt Plug

PART NO.

DATE 5-27-80

COMPUTER KOWALSKI

SHEET 1 OF 3

OPER NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	PURCHASE SCREW MACHINE BLANK FROM VENDOR.				
	EST PRICE - .58¢ EACH				
	EST. TOLLING - 150¢				
					
	PURCHASE INSPECTION	GAGES	STANDARD	-	-
		COMP SCREEN	NEW	8	-
12	MILL FIRING PIN HEAD SLOT & FLATS ON BOTTOM	SAME AS PRESENT M/700 PT # 17012			
15	MILL FLAT ON SIDE	0.8 CIND MILLER OR EQUIV.			
	FIXTURE	NEW	45	135	
	CUTTER	"	5	100%	
	ARBOR	STD	-	-	
	GAGE	NEW	40	120	
24	HAND REAM FIRING PIN HEAD HOLES TO REMOVE BURR IN SLOT & BURR BOTH SIDES OF FIRING PIN HEAD SLOT	SAME AS PRESENT M/700 PT # 17012			
	TOTAL				

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

M/700 & Bolt Action Machine
 MODEL COMPONENT Bolt Plug PART NO. 3551
 DATE 5-27-80 COMPUTER KOWALAK SHEET 2 OF 3

SEQUENCE OF OPERATIONS

JK-D

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
(NEW) 25	LOAD & UNLOAD	7 STA. SPEC MACHINE	INDEX TYPE		
	MILL FRONT END OF BOLT LATCH SLOT				
	PERFORM REAR END " " "	MACHINE COST	NEW		100,000
	DRILL 1/2" STARTING HOLE	FIXTURE (TREAD)	"	70	57,000
	" 2ND " "	PERISHABLE TOOLS	"	6	550
	MILL SMALL SLOT	TOOL HOLDERS	"	20	3750
	MILL FROM IN CENTER SECTION	GAGES	"	180	550
	CIRCLE TIME - 45 SEC (APPROX)				
(NEW) 26	BUTT & DRILL TO DEPTH	2 SPINDLE DRILL PRESS			
	DETENT PLUNGER HOLE				
		DRILL JIG	NEW	60	120
		TOOLS	STD	1	1500
		GAGES	"	40	110
(NEW) 27	BUTT SPOT DRILL - REM	4 SPINDLE DRILL PRESS			
	RETAINING PIN HOLE				
		DRILL JIG	NEW	60	120
		TOOLS	STD	6	1500
		GAGES	"	35	95
(NEW) 27.5	DEBURR	BENCH			
29	SUPERFINISH	(SAME AS M/700)			
TOTAL					

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• SEQUENCE OF OPERATIONS •

MODEL Carbine COMPONENT Bar Plug PART NO. 3551
DATE 5-27-80 COMPUTER KOWALSKI SHEET 3 OF 3

SHEET 3 OF 3

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KINZER V. REMINGTON**

BARBER - PRESALE R 0108086 R2509074