

REVISED 4/23/80

"RIVETLESS" EXTRACTOR

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET 28665

• SEQUENCE OF OPERATIONS •

MODEL 700 COMPONENT Left Hand PART NO. (REV) 28665-38670
 DATE 9-14-75 COMPUTER LLB SHEET 1 OF 2

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
5-	DRILL, TURN FIRM, SHAVE, FINISH FACE AND END ARE.	A.U. PORTABLE DRILL FD# 15479 15706 15857, 32271, 33257	03		
15-	GRIND MILL BOLT LINES	" "	60		
	GRIND MILL BOLT LINES END-3487 (LEFT HAND)				
22-	BUTMILL EXTRACTOR RETAINING PIN HOLE, DRILL EXTRACTOR RETAINING PIN HOLE, BUTMILL EXTRACTOR HOLE DRILL & BORE EXTRACTOR HOLE & DRILL & BORE GAS ESCAPE HOLE. EXTRACTOR EXTRACTOR RETAINING PIN HOLE. <u>LEFT HAND ONLY</u>	" "	100		
23-	BUTMILL DRILL & BORE EXTRACTOR HOLE, BUTMILL DRILL EXTRACTOR RETAINING PIN HOLE AND MILL NOTCH AND GRINDING. (RIGHT HAND)	" "	100		
30-	DRILL & BORE FIRMING PIN HOLE DRILL AND BORE GAS ESCAPE HOLE. DURING NOTCH-BORE SIDE-ALONG EXTRACTOR RIVET HOLE	SAME AS PORTABLE DRILL OPER. EXCEPT AMING "DRILL & BORE EXTRACTOR RIVET HOLE"	100		
35-	DRILL & BORE FIRMING PIN HOLE <u>LEFT HAND ONLY</u>	SAME AS PORTABLE DRILL OPER. 100	100		
	TOTAL				

RD-5568

1-18-83

REVISED 4/23/80

"RIVETLESS" EXTRACTOR
PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET
*** SEQUENCE OF OPERATIONS ***

MODEL 700 COMPONENT ROCK HEAD PART NO. 28665
 DATE 9-14-78 COMPUTER YES SHEET 2 OF 2

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
40	BOTTOM CLEARANCE CUT (RHS. & SMALL CARS ONLY) RH & LH.	AUTOMATED DRILL PRES BASE PLATE		4	16
		DRILL JIG (R.H.) (REG. CAL.)		25	100
		DRILL JIG (R.H.) (SMALL CAL.)		25	100
		DRILL JIG (L.H.) (REG. CAL.)		25	100
		DRILL JIG (L.H.) (SMALL CAL.)		25	100
		CUT DRILL (REG. CAL.)			3
		CUT DRILL (SMALL CAL.)			3
		FINISHING GRIND (REG. CAL.)		20	80
		FINISHING GRIND (SMALL CAL.)		20	80
47	MILL EXTRACTOR CLEARANCE CUT AND SCRAP BURN FROM EXTRACTOR CLEARANCE CUT (SKD-3435 ONLY) RH	SEE ATTACHED SHEET P. 47			
50	MILL EXTRACTOR CLEARANCE CUT AND SCRAP BURN FROM EXTRACTOR CLEARANCE CUT (SKD-3437 ONLY) LH	SEE ATTACHED SHEET P. 50			
55	GRIND MATCH FOR BRADING 1 SURFACE (SKD-3437 ONLY) LH	A.U. PRESENT OPER. P. 50 PT. NO. 32571, 32572			
60	REAM DIRECTOR PIN HOLES AND EXTRACTOR HOLES	A.U. PRESENT OPER. P. 140 PT. NO. 15479, 15706, 15551, 32871, 32872			
- To Body Body Area -					
DIP 60					
TOTAL					

RD-6568 1-18-63