

REV 4/23/80

"Rivetless" Extractor

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• SEQUENCE OF OPERATIONS •

~~SS~~ 5-28660

MODEL 718 COMPONENT Bolt Load PART NO. 34573
DATE 9-6-72 COMPUTER PHS SHEET 1 OF 2

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
5	WASH	A.L. PRESENT OPERATION FOR PT. NOS. 14207 & 14208	10		
10	ROUGH AND FINISH BUTTMILL AND RISEN HEADING, FROM TO DRUM, SMALL HOLE AND BACK TO LENGTH	" "	10		
20	BUTT MILL EXTRACTOR RETAINING PIN HOLE; BUTT MILL EXTRACTOR HOLE; DRILL EXTRACTOR RETAINING PIN HOLE; DRILL EXTRACTOR HOLE; FROM EXTRACTOR HOLE & DRUM EXTRACTOR HOLE AT REAR END	A.L. PRESENT OPER. FOR PT. NOS. 14207 & 14208 EXCEPT: DRILL RISING & DRILL EXTRACTOR RIVET HOLE	10		
25	BUTT MILL CLEARANCE CUT	AUTOMATIC DRILL PRESS CASE PLATE		4	12,000 3,200
		DRILL DIG (BIG GAL)	25		100
		DRILL DIG (SMALL GAL)	25		100
		BUTT DRILL (BIG)			3
		BUTT DRILL (SMALL)			3
		RIVETING GAGE (BIG)	20		90
		RIVETING GAGE (SMALL)	20		90
30	ROUGH & FINISH MILL EXTRACTOR CLEARANCE CUT	SEE ATTACHED SHEET	100		
TOTAL					

NO-6368 1-18-53

REVISED 4/23/80

"Rivets" Extractor

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• SEQUENCE OF OPERATIONS •

~~EX~~-D-28660

MODEL 755 COMPONENT Low Noise

PART NO. 9-52

DATE 9-6-75 COMPUTER SPS

SHEET 2 OF 2

[illegible]

AD-6568 1-18-63

REV. 4/23/80

"RINGLESS" EXTRACTOR
PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• COMPUTATION •

RED-28660

MODEL 785 COMPONENT ROLL HEAD PART NO. 3430
 OPERATION ROUGH FINISH FULL EXTRACTOR CONCENTRIC OUT-ER OPER. NO. 30
 MACHINE PITTSBURGH E-75540 DEPT. NO. 30
 COMPUTER _____ DATE _____ SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
REMINGTON SPECIAL #30187	E-75540	ALUM	50	90
FIXTURE	D-85265	A.U.		
LAGGING UNIT (22, 223 CAL)		NEW	20	30
LOG UNIT (622, 243, 305, 22-350 CAL)		NEW	20	30
"T" CUTTER - ROUGH (22-250, 622, 243, 305)	B-64445-W	A.U.		
"T" CUTTER - ROUGH (222, 223)	B-64445-V	A.U.		
"T" CUTTER - FINISH (22-250, 622, 243, 305)	B-64445-R	A.U.		
"T" CUTTER - FINISH (222, 223)	B-64445-P	A.U.		
SET-UP CUTTER GAGE	B-89277	A.U.		
PLUG GAGE	A-85282	A.U.		
DIAL BASIS GAGE	D-85644	A.U.		
CONCENTRICITY GAGE		NEW	20	30
SETTING MASTER (2250, 622, 243, 305)				
SETTING MASTER (222, 223)				
LOG. UNIT (622, 243, 305, 22-350)				
LOG. UNIT (222, 223)				
DIAL UNIT (622, 243, 305, 22-350)				
DIAL UNIT (222, 223)				
PLUG GAGE (222, 223)	B-80220-R	A.U.		
PLUG GAGE (622, 243, 305, 22-350)	B-80220-C	A.U.		
TOTAL			90	360

SKETCH

RD-6567

1-18-63