

## "RINGLESS" EXTRACTOR

## PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• SEQUENCE OF OPERATIONS •

MODEL 785 COMPONENT FINAL ASSEMBLY PART NO. \_\_\_\_\_  
DATE 12-13-75 COMPUTER XPS SHEET 1 OF 1

[illegible]

RD-6368 1-18-63

Revised 7/23/80

"RINGSTAY" EXTRACTOR

## PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

Zoo-Xp100

• SEQUENCE OF OPERATIONS •

542-

MODEL 788 COMPONENT EXTRACTOR (SMALL CARS) PART NO. 3395

DATE 12-13-78 COMPUTER SLB SHEET 1 OF 1

| OPER.<br>NO. | OPERATION NAME                                                                                                                                                                                           | MACHINE                  | DEPT.<br>NO. | HOURS<br>DESIGN | HOURS<br>BUILD |
|--------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|--------------|-----------------|----------------|
|              | PURCHASE FROM STAMPING VENDOR                                                                                                                                                                            |                          |              |                 |                |
|              | VENDOR TOOLING                                                                                                                                                                                           | \$19,350.00              |              |                 |                |
|              |                                                                                                                                                                                                          | <del>\$2,200.00</del>    |              |                 |                |
|              |                                                                                                                                                                                                          | 139.75/M                 |              |                 |                |
|              | VENDOR A/P                                                                                                                                                                                               | <del>\$1,200.00</del> /M |              |                 |                |
|              | PURCHASABLE INSPECTION                                                                                                                                                                                   |                          |              |                 |                |
|              | MICS                                                                                                                                                                                                     | STD                      |              |                 |                |
|              | CAMP. FIXTURES                                                                                                                                                                                           | STD                      |              | 30              | 60*            |
|              | CAMP. SCRAMBLES                                                                                                                                                                                          | WGS                      |              | 11.             |                |
|              | DIAL CAMP.                                                                                                                                                                                               | STD                      |              |                 |                |
|              | <hr/>                                                                                                                                                                                                    |                          |              |                 |                |
|              | NAME: TRIC EXTRACTOR PART NO. #15850                                                                                                                                                                     |                          |              |                 |                |
|              |                                                                                                                                                                                                          |                          |              |                 |                |
|              | DRAWING CURRENT PROCESS FOR                                                                                                                                                                              |                          |              |                 |                |
|              | PART NUMBER 15850                                                                                                                                                                                        |                          |              |                 |                |
|              | (U) * DOUBLE THIS FOR VENDOR                                                                                                                                                                             |                          |              |                 |                |
|              | <div style="text-align: center;"> <p>QTY 10</p> <p>DATE 1-10-10</p> <p>BY J.M.P.</p> <p>CHKD BY [Signature]</p> <p>APPROVED BY [Signature]</p> <p>REVIEWED BY [Signature]</p> <p>DATE 1-10-10</p> </div> |                          |              |                 |                |
|              | TOTAL                                                                                                                                                                                                    |                          |              |                 |                |

REVISED 4/23/80 RLB

## "RIVETLESS" EXTRACTOR

## PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

### • SEQUENCE OF OPERATIONS •

~~sub~~ C-91816

700  
788  
7400  
MODEL 7400 COMPONENT GRANDPRAIR - REC. CALS. PART NO. 3000  
DATE 12-13-75 COMPUTER NBS SHEET 1 OF 1

| OPER NO. | OPERATION NAME                                                     | MACHINE                        | DEPT. NO. | HOURS DESIGN | HOURS BUILD |
|----------|--------------------------------------------------------------------|--------------------------------|-----------|--------------|-------------|
|          | PURCHASE FROM STAMPING VENDOR                                      |                                |           |              |             |
|          | * VENDOR TOOLING                                                   | <del>22,475.00</del> 25,475.00 |           |              |             |
|          |                                                                    | 139.75/M                       |           |              |             |
|          | VENDOR P/PR                                                        | <del>22,475.00</del>           |           |              |             |
|          | PURCHASE INJECTION                                                 |                                |           |              |             |
|          | MIGS                                                               | 3M                             |           | -            | -           |
|          | CAMP. EXTRUSION                                                    | 3M                             |           | -            | -           |
|          | CAMP. SECTIONS                                                     | 3M                             |           | 16           | -           |
|          | DIE CAMP                                                           | 3M                             |           | -            | -           |
|          | NOTE: THIS EXTRUSION SPACER \$14,449                               |                                |           |              |             |
|          | ADD-USE PORTLAND CEMENTS FOR<br>PORT NUMBER, 144129                |                                |           |              |             |
|          | * NOTE: VENDOR TOOLING ALREADY PAID FOR<br>UNDER 7400-7600 RI-1185 |                                |           |              |             |
|          | DO NOT INCLUDE IN FACE SHEET                                       |                                |           |              |             |
|          | TOTAL                                                              |                                |           |              |             |

RD-6568 1-18-63

51550 4/23/80 EUB

## "Rivetless" Extractor

## PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

### • SEQUENCE OF OPERATIONS •

~~SECRET~~ - C-91837

MODEL 700 - COMPONENT EXTRACTOR - MAGNUM PART NO. 3  
DATE 12-13-78 COMPUTER 255 SHEET 1 OF 1

[illegible]

RD-6368 1-18-63