

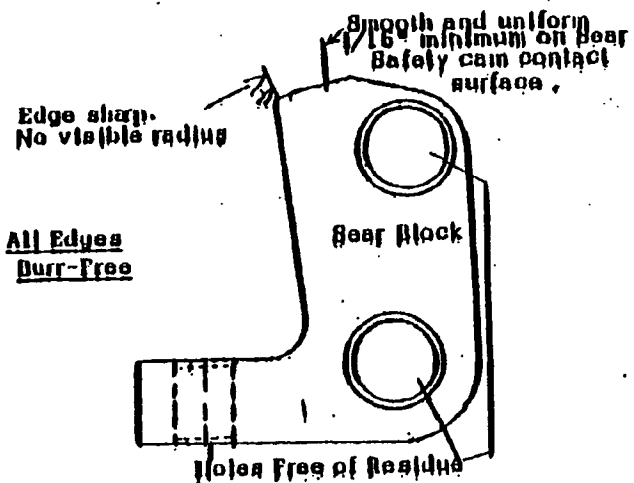
SEQUENCE OPERATIONS

OP. No.	OPERATION	DEPT.	OP. No.	OPERATION	DEPT.
	Draw the following Parts to make a Sear Block Assembly				
	Sear Block Assembly Pt.# 26845				
	Sear Block Pt.# 15461				
	Sear Block Stud Pt.# 15462				
55	Assembly Sear Block Assembly	15			
DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - JAA - 279156			DATES AND REASONS FOR REVISIONS		
MODEL XP-100			PART NAME Sear Block Assembly		
QA. OR CAL.			PAGE 1		
PART No. 26845			OF 1		

AD-8480

DATE AND REASON FOR REVISIONS 9/29/80 - New - MRP - JAA - 279156

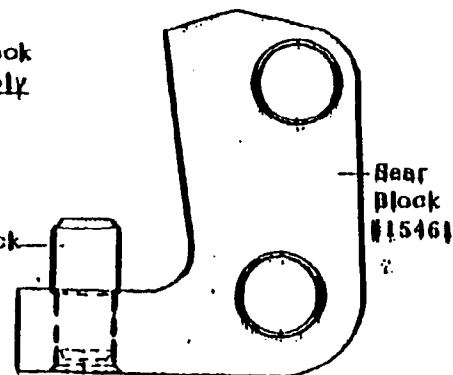
DESCRIPTIVE INFORMATION



11 2 Greenard Press
C-06199 Fixture
C-06199-A Ram

Sear Block
Assembly

Sear Block
Stud
15462



PART NAME Sear Block Assembly COOLANT TIME SET UP MODEL No. XP-100 OPER. No. 55
TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 1
MACHINE

PROCES. CORDS

DATES AND REASONS FOR REVISIONS 9729780 - NEW - MRP - JAA - 279156

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

SPEED		FEED	
1	2	3	4
5	6	7	8
9	10	11	12
13	14	15	16
17	18	19	20
21	22	23	24
25	26	27	28
29	30	31	32
33	34	35	36
37	38	39	40
41	42	43	44
45	46	47	48
49	50	51	52
53	54	55	56
57	58	59	60
61	62	63	64
65	66	67	68
69	70	71	72
73	74	75	76
77	78	79	80
81	82	83	84
85	86	87	88
89	90	91	92
93	94	95	96
97	98	99	100

FILED

~~Sear Block Pt. #15461~~

Sear Block Stud Pt. #15462

1. Visually Inspect Sear Block
- o All holes must be free of residue.
Clean with paper clip wire if necessary.
 - o Sear Safety Cam contact surface must be:
 - o Smooth
 - o Burr-free
 - o Rear edge must be sharp

Check for burrs and smoothness with fingertip.

2. Start Sear Block stud into Sear Block hole and position into fixture.
3. Pull handle on press to firmly seat Sear Block stud shoulder,
 - o Sear Block Stud must be tight to Sear Block.

OPERATION DESCRIPTION

PART NO.

26845

Assemble Sear Block Assembly

PART NAME Sear Block Assembly

COOLANT.

SET UP

MODEL No. XP-100

OPER. No. 55

TYPE _____ MACHINE _____

MACHINE

DEPT No. 15

PAGE 1 OF 1