

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS				6/25/69 - Retyped from 3/16/67 - 267770			
7/15/82 - Renumbered oper 5 was 2 - RBW - 281657							
12/10/84-CHG. PROCESS PARAMETERS-CFC-284979							
TOOLS, GAGES AND EQUIPMENT				APPROVAL AND DATES			
SPEED	FEED	Fixture	GA. OR CAL.				
		Pressure - lbs.	264	Taylor-Winfield "T" Clamping fixture U-12446			
		Tap	P-7				
		Squeeze - cycles	50				
		Hold "	40				
		Off "	30				
		Weld Time "	2 + 10				
	*	Weld Heat %	65%				
		Temper	No				
NOTE: 1		Upper Electrode	Mallory 3 Part No. 3415 Offset Nose Electrode,				
		Lower Electrode	RHMA No. C-228				
NOTE: *		Due to voltage changes - This percentage must be varied to obtain satisfactory welds.					
NOTE: 1		Not a Stores Item					
OPERATION DESCRIPTION			PART NO.				
Weld tab and deburr			15452				
PART NAME			COOLANT	SET UP TIME	MODEL No	OPER. No	
Sear Housing					XP100	5	
TYPE			MACHINE	DEPT. No	PAGE	OF	
E-B3-8-10			TW Welder	79	1	1	