

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/23/63 - Made regular -
 4/21/65 - Chg. dept. # - FR - 261459
 1/19/79 - B-80154 was B-80214-B and B-80219 was B-80214-B - B-80154 was B-80219-Q - PRQ - 277528
 7/19/82 - renumbered oper 7 was 4 - RBW - 281657

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.				
SPEED	FEED					
		Holding Jig	G-85373			
		Step Reamer (.1244)	A-85452V			
		Step Reamer (.1257)	A-85452V			
		Step Reamer (.1261)	A-85452V			
		Plug Gage	H-80214-B	B-80154-K		
		.126 - .125 Dia.				
		Plug Gage	H-80214-B	B-80154-D		
		.1264 - .1254 Dia.				
		Plug Gage	H-80214-B	B-80219-R		
		.1247 - .1237 Dia.		*	For Ga. c-50264 use	
		Piloted C'sink	A-54497		Master A-82354 - Tol - Set dial to	
		Aircraft Stop			"0" to ".0043"	
	*	C'sink Gage	C-50264		Use side of master marked for M/600 & 40X	

OPERATION DESCRIPTION	PART NO.					
Ream 4 holes and c'sink Safety Detent hole	15452					

PART NAME Sear Housing COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 7
 TYPE MACHINE DEPT. No. 75 PAGE 1 OF 1

RD-6483

BARBER - PRESALE R 0117474

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

R2518462

~~BARBER - PRESALER~~ 01174475

00-140

BARBER - PRESALE R 0117475

70

BARBER - PRESALE R0117476

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/23/63 - Made regular -
4/21/65 - Chg. dept. # - FR - 261459
7/19/82 - renumbered oper 10 was 8 - RBW - 281657

APPROVAL AND DATE

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

SPEED	FEED
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FEED

Holding Fixture

0-85317

H.S.H. Tap #6-40 NF-2

~~1-901879~~

Thread Plug

1-80223W

OPERATION DESCRIPTION

PART NO.

15452

Tap Bear Block Stop Screw hole

PART NAME Bear Housing COOLANT _____ SET UP TIME _____ MODEL No. XP100 OPER. No. 10
TYPE _____ MACHINE _____ DEPT. No. 75 PAGE 1 OF 1

RD-6401

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

R2518464
BARBER - PRESALE R 0117476

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

5/23/63 - Made regular

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

APPROVAL AND DATES

SPEED

FEED

OPERATION DESCRIPTION

PART NO.

15452

Black Oxide color

PART NAME Bear Housing

COOLANT

SET UP TIME

MODEL No. XP100

OPER. No. 16

TYPE MACHINE

DEPT. No. 79

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