

Operation Step Detail

Operation: 20

Step

Operation / Step Description

Supersheen Tumble

Operation Tool Detail

Operation: 20

Tool Number

Tooling Description

DB 2020

Machine

#42

Compound

#53

Compound

Std

Immunol

Operation Procedure Notes

Operation: 20

Description

NOTES: 1. Chip Size - #4-1/2 Bonded

2. Chip Quantity - Chip and Parts 50% Barrel Capacity

3. Number of Pcs. per Compartment - 200

4. Grind: #42 Compound - 6 Oz. Water - Low

- Time: 3-1/2 Hrs.

- Rinse: 3 Times

5. Clean: Immunol - 6 Oz. Water - 1" Above Mass

- Time: 30 Min.

- Rinse: 2 Times

6. Burnish: #53 Compound - 6 Oz. Water - 1" Above Mass

- Time: 1 Hr.

- Rinse: 3 Times

7. Barrel Speed: 18 RPM

8. SEPARATE FROM CHIPS AND OIL

Operation Step Detail

Operation: 25

Step

Operation / Step Description

Wax

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