

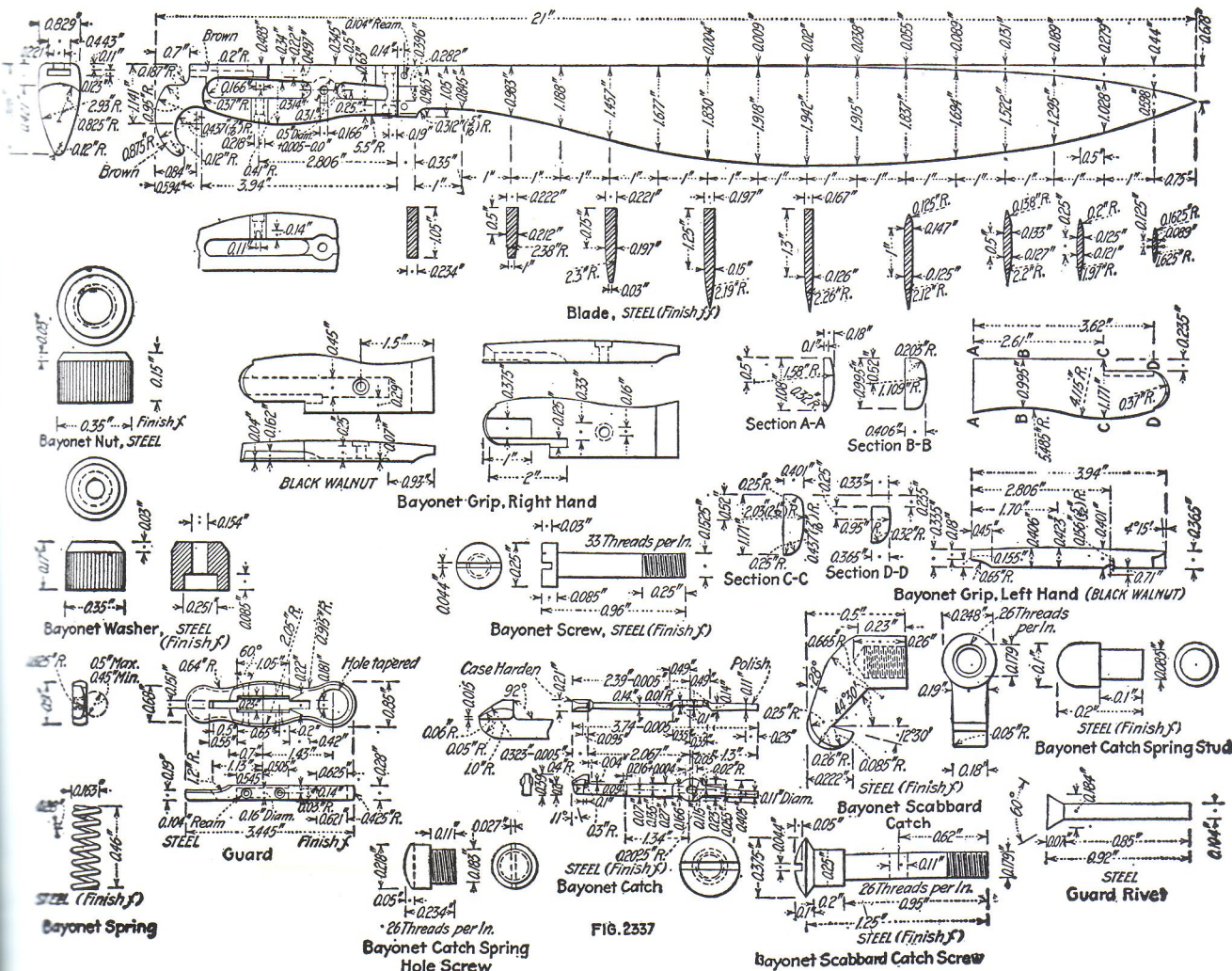
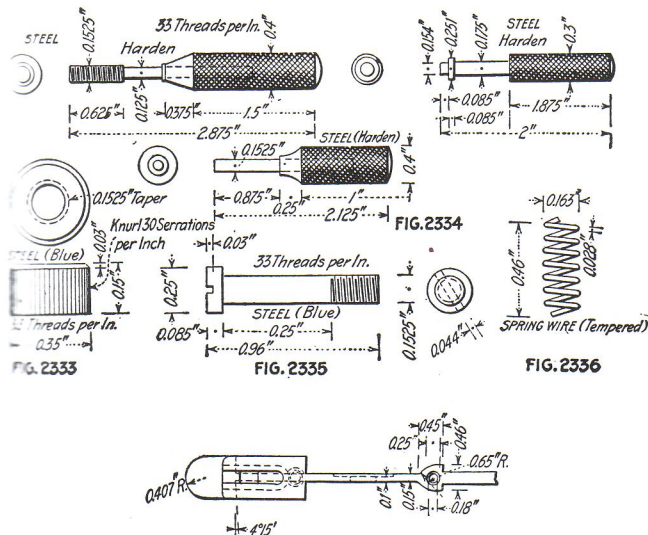
OPERATION CC. REMOVING BURRS LEFT BY
OPERATION 5

OPERATION BB. REMOVING BURRS LEFT BY
OPERATION 4

Number of Operators—One. Description of Operation—Removing burrs from operation b. Apparatus and Equipment Used—File. Production—Grouped with operation 5.

OPERATION 5. MILLING TOP AND CIRCLE OF HOOK

Transformation—Fig. 2330. Machine Used—Pratt & Whitney rebuilt No. 2. Number of Operators per Machine—One. Work-Holding Devices—Work located against stop, clamped by vise jaws as usual. Tool-Holding Devices—Standard arbor. Cutting Tools—Formed milling cutters. Number of Cuts—One. Cut Data—70 r.p.m.; $\frac{1}{8}$ -in. feed. Coolant—Cutting oil, put on with brush. Average Life of Tool Between Grindings—5000 pieces. Gages—Form. Production—350 pieces per hr.



THE BAYONET NUT

OPERATIONS ON THE BAYONETT NUT

Operation

1. Automatic
2. Polishing
3. Bluing

OPERATION 1. AUTOMATIC

Machine Used—Hartford No. 2 automatic. Number of Machines per Operator—Four. Work-Holding Devices Held in draw-in chuck. Tool-Holding Device—Turret on machine. Cutting Tools—Standard number of Cuts—Five; fourth cut is a tap. Cut Data—700 r.p.m., 5-in. feed. Coolant—Cutting oil. Sp. stream. Average Life of Tool Between Grindings—700 pieces. Gages—Fig. 2334. Production—90 pieces per hr.