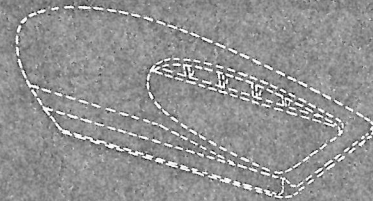


10

OPERATION N° 10
OPERATION - SCOUR CASTING
MACHINE - BENCH
TOOL N°



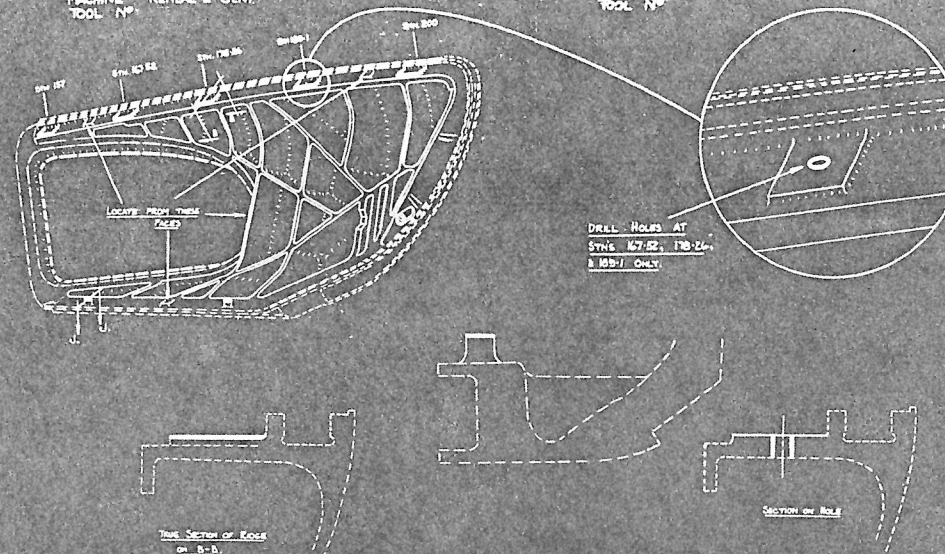
20

OPERATION N° 20
OPERATION - INSPECT
MACHINE
TOOL N°

USE CASTING MANUFACTURED
DATUM POINTS FOR PICK-UP

30

OPERATION N°30
OPERATION - MILL PAD FACES & LOCATING PADS FOR CR# 50
MACHINE KENDAL & GENT.
TOOL N°



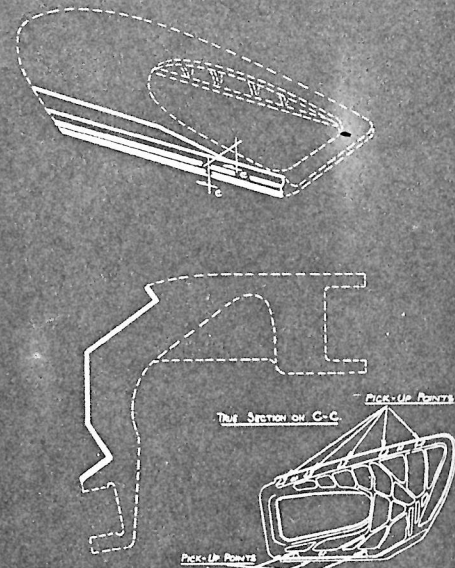
30

OPERATION - DRILL 3 TOOLING HOLES
MACHINE -
TOOL -

[illegible]

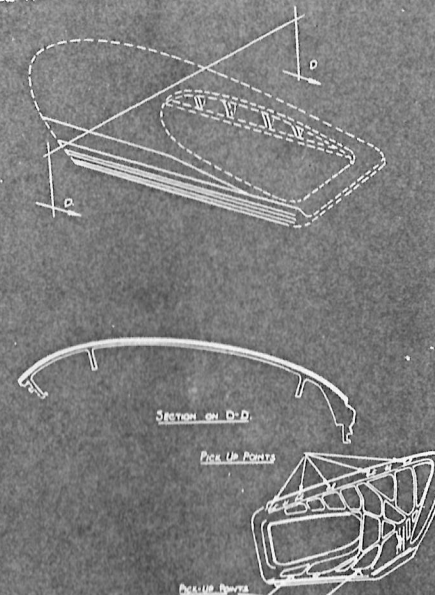
50

OPERATION N° 50
OPERATION- MACHINE HINGE FACES. LOCATE FROM TOOLING HOLES & PAD
MACHINE - HORIZONTAL BORING MILL. FACE MILLED AT OP° 30 & 40.
TOOL N°



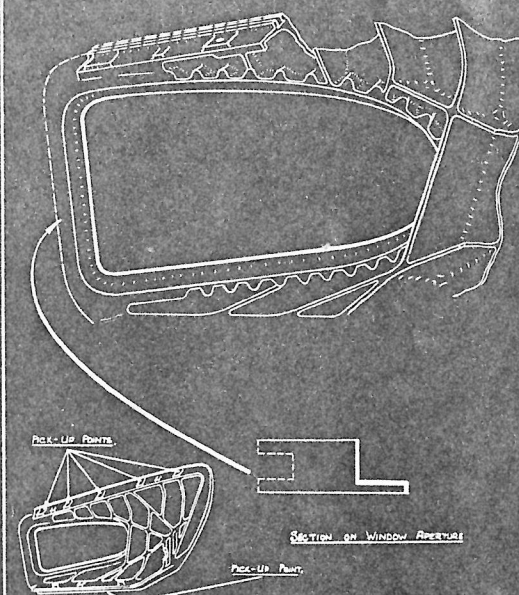
60

OPERATION - NO 60
OPERATION - PROFILE OUTLINE SURFACE & LOCATE FROM HANGS & PAD FACIL.
MACHINE - KENDALL & GENT WITH TEACHING HEAD. AS OFF 50.
TOOL NO



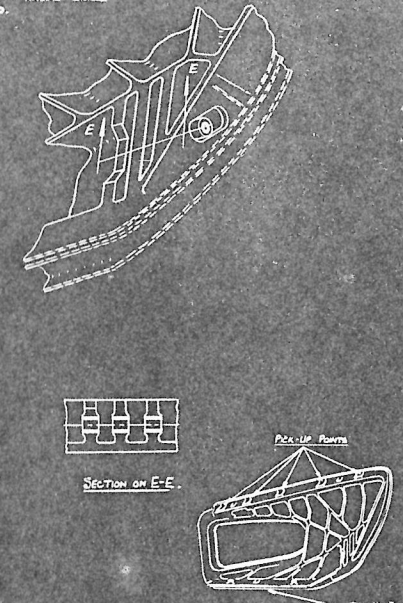
70

OPERATION No: 70
OPERATION: - MILL OUT WINDOW APERTURE. LOCATE AS DR# 60.
MACHINE: - MOREY PROPLER.
TOOL No: -

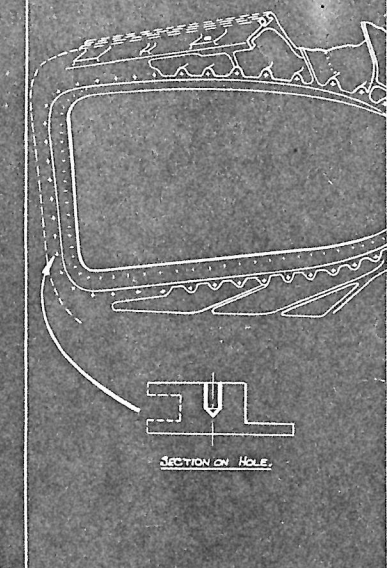


80

OPERATION N° 80
✓ OPERATION - DRILL & REAM HOLES FOR OPERATING MECH. PICK-UP. LOCATE AS OP. 79
✓ MACHINE - RADIAL DRILL
✓ TOOL N° -

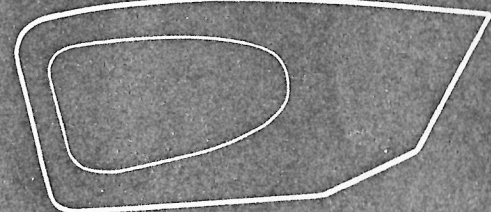


OPERATION # 85
OPERATION - DRILL HOLES FOR ROSAN INSERTS
MACHINE LOCATE AS OF 80
TOOL N°

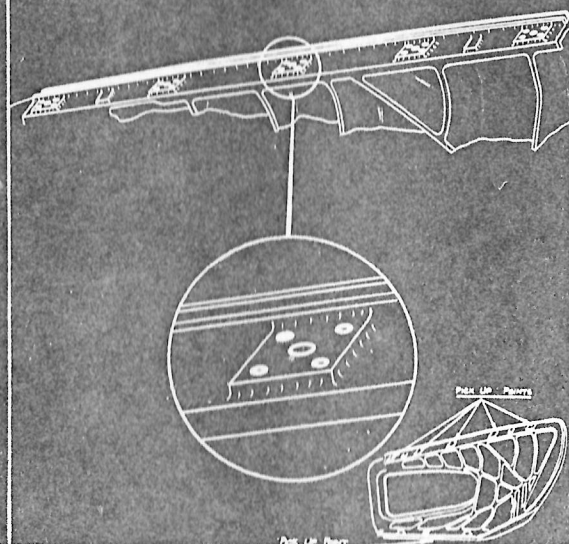


90

OPERATION N° 90
OPERATION - FILE & DRESS PERIPHERY OF CASTING.
MACHINE BENCH
TOOL N°

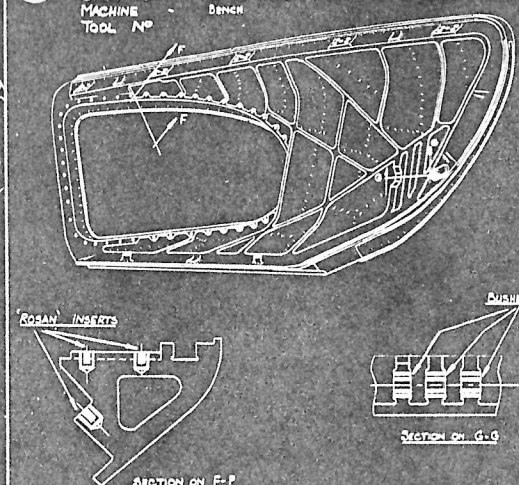


OPERATION - NO 100
OPERATION - DRILL HOLES FOR LATCH PADS TO SIZE. LOCATE AS OF 80
MACHINE - RADIAL DRILL.
TOOL - NO



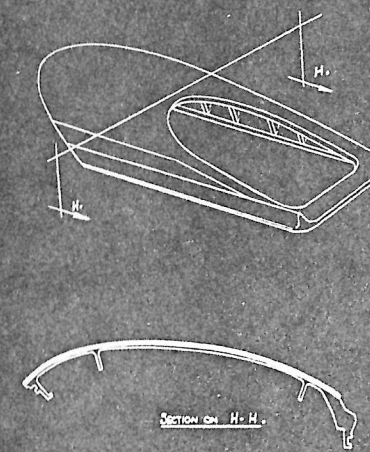
110

OPERATION*110
OPERATION - TAP ALL HOLES & INSERT ROSSIN INSERTS & BUSHES
MACHINE - BENCH
TOOL N°



120

OPERATION N° 120
OPERATION - FINAL POLISH OUTSIDE CONTOUR & CUT OFF CLEAN LOC. PDS.
MACHINE - BENCH.
TOOL N°.



DATE	EMPLOYEE		DATE	BY	OTHER
10/1/55					
 AVCO AIRCRAFT LIMITED					
PRODUCTION ENGINEERING DEPARTMENT TOOL DESIGN					
TOOL NUMBER DRAWING NO. TOOLING NO. TOOLING NO.			TITLE <u>MACHINING OPERATIONS</u> <u>PILOTS CANOPY</u>		DRAWN BY CHECKED BY
NAME POSITION INITIALS APPROVED APPROVED			DATE TIME		DATE TIME
DRG. NO. 7-0152-PE23					