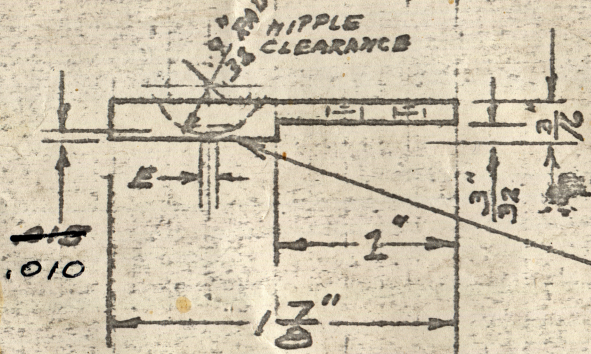
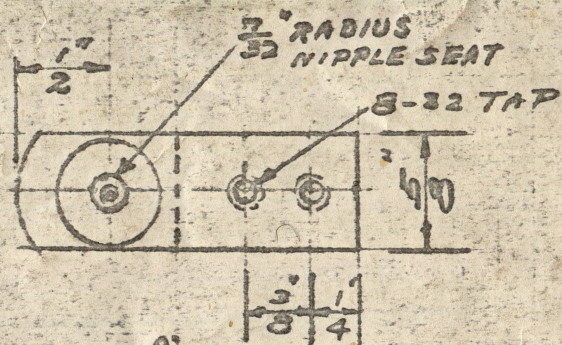


OPERATIONS

- 1-USE STOCK $\frac{3}{16}$ " X $\frac{5}{8}$ "
- 2-CUT STOCK $1\frac{1}{8}$ " LONG
- 3-MILL $\frac{1}{2}$ " RADIUS ON END
- 4-MILL $\frac{3}{32}$ " STEP
- 5-DRILL AND TAP 2 HOLES
- 6-DRILL HOLE -E
- 7-DRILL $\frac{7}{32}$ " AND $\frac{3}{32}$ " RADIUS HOLE, USE BALL REAMER WITH PILOT TO SUIT HOLE -E
- 8-HARDEN AND DRAW
- 9-POLISH FLAT SURFACE AND HOLE RADIUS WITH EMERY CLOTH GRADE 180
- 10-GRIND SMALL BOTTOM SURFACE ONLY.



BODY	DRILL SIZE IN INCH E	DRILL SIZE IN INCH E
6PT.	53	.059
8PT.	53	.059
10PT.	50	.070
12PT.	50	.070
16PT.	45	.082
20PT.	45	.082
24PT.	40	.092

HARDEN AND DRAW

- PREHEAT 1600° F
 SUPER HEAT 2350° F
 1-2 MINUTES
 QUENCH IN OIL
 DRAW - 1 HOUR AT 900° F
 COOL IN AIR. ROCKWELL 59-61

STEEL

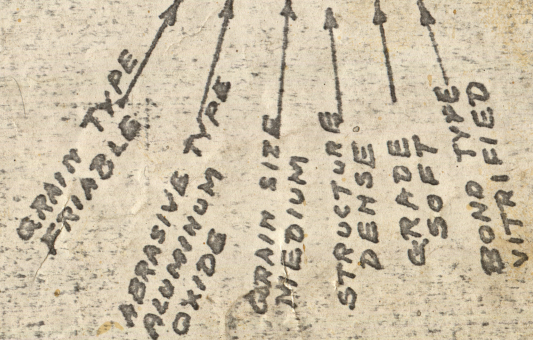
L-XX

CHEMICAL PROPERTIES

CARBON TUNGSTEN CHROMIUM VANADIUM

.70	18.00	4.00	1.00
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GRIND THIS SURFACE
 ROBERTSON MFG. CO. GRINDING WHEEL
 TRENTON 5 N.J.
 7" X 1/2" X 1 1/4"
 WA 464 HV



F. PETERS
 MAY 2 1930