

# OPERATION SHEET



STAR/WETTER DIV.  
HAZELTON, PENNA.

PART NO. A3-1

DATE:  
Retyped 11-30-78

RM 000100 *000 200*

SHEET 1 OF 1 SHEETS

DESCRIPTION: POT MOUTH WIPER

DWG. C6913 DWG.

MATERIAL: ~~5/32 x 5/32~~ C.R.S. *3/16 x 3/16*

10 PIECES PER 12 FT. LG.

OPER.	MACH. NO.	DESCRIPTION OF OPERATION	SPECIAL TOOLS
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- |     |             |   |  |
|-----|-------------|---|--|
| 1 ✓ | Punch Press | Cut off 14 3/8 long <i>stamp</i>  | Std. Cut-off die.<br><br><br><br><br>Bending fixture :ClF4<br>LOC: 1-A-4 |
| 2 ✓ | Grind       | Grind point on end to 5/16  |  |
| 3 ✓ | Heat Treat  | Anneal 1" to 2" back from point   |  |
| 4 ✓ | Bench       | Tumble to clean off scales before bending                                     |  |
| 5 ✓ | Punch Press | Bend at right angle, point end to be 1" long from inside of bend <i>stamp</i> |  |
| 6   | Bench       | Blacken and transfer to stock   |  |