


| OPERATION SHEET                     |             |  <b>STAR GRAPHIC SYSTEMS, INC.</b><br>SOUTH HACKENSACK NEW JERSEY |  | <b>PART NO.</b> A3-1            |  |
|-------------------------------------|-------------|---|--|---------------------------------|--|
| <b>DATE:</b><br>RETYPED 9/17/74     |             | <b>RM</b> 000100  |  | SHEET 1 OF 1 SHEETS             |  |
| <b>DESCRIPTION:</b> POT MOUTH WIPER |             |   |  | <b>DWG.</b> C-6913              |  |
| <b>MATERIAL:</b> 5/32 x 5/32 C.R.S. |             |   |  | 10 PIECES PER 12 FT. LG.        |  |
| OPER.                               | MACH. NO.   | DESCRIPTION OF OPERATION  |  | SPECIAL TOOLS                   |  |
| 1                                   | Punch Press | Cut-off 14-3/8 long.  |  | Std. Cut-off die.               |  |
| 2                                   | Grind       | Grind one side to 5/32 dia sq. .156   |  |                                 |  |
| 3                                   | Bench       | Grind point on end to 5/16.   |  |                                 |  |
| 4                                   | Heat Treat  | Anneal 1" to 2" back from point.  |  |                                 |  |
| 5                                   | Bench       | Tumble to clean off scales before bending.  |  |                                 |  |
| 6                                   | Punch Press | Bend at right angle, point end to be 1" long from inside of bend.   |  | Bending Fix: Clf4<br>Loc: 1-A-4 |  |
| 7                                   | Bench       | Blacken and transfer to stock.  |  |                                 |  |