

# OPERATION SHEET



STAR GRAPHIC SYSTEMS, INC.  
SOUTH HACKENSACK NEW JERSEY

PART NO. A3-1

DATE:  
RETPED 9/17/74

RM 000100

SHEET 1 OF 1 SHEETS

DESCRIPTION: POT MOUTH WIPER

DWG. C-6913 DWG.

MATERIAL: 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. <i>OK</i>	Std. Cut-off die.
2	Grind	<del>Grind one side to 5/32 dia sq. .156</del>	
3 ✓	Bench	<del>Grind point on end to 5/16.</del> <i>GRIND POINT ON END TO 5/16</i>	
4 ✓	Heat Treat	Anneal 1" to 2" back from point.	
5 ✓	Bench	Tumble to clean off scales before bending. <i>461-6-3078-80pc</i>	
6 ✓	Punch Press	Bend at right angle, point end to be 1" long from inside of bend.	Bending Fix: Clf4 Loc: 1-A-4
7	<i>6A MILL</i> Bench	Blacken and transfer to stock.	