

OPERATION SHEET		STAR PATENTS CO.		PART <i>R-517</i>	
DATE		SOUTH HACKENSACK		NEW JERSEY	
DESCRIPTION		RM		NO. <i>R.H. 30 EMS.</i>	
MATERIAL <i>1" x 1/4 S.S. To MAKE 10 PT.</i>		DWG		SHEET OF SHEETS	
OPER MACH NO		DESCRIPTION OF OPERATION		PIECES PER FT. LG.	
				SPECIAL TOOLS	
<i>1</i>	<i>SAW</i>	CUT OFF To LENGTH $8\frac{1}{16} \pm \frac{1}{32}$ <i>1" x 1/4 S.S.</i>			
<i>2</i>	<i>MILL</i>	MILL <i>1"</i> To <i>.903 - .905</i>			
<i>3</i>	<i>MILL</i>	MILL SLOT To <i>.290</i> wide X <i>.250</i> END WALL X <i>.335</i> FROM BOTTOM			
<i>4</i>	<i>SAW</i>	CUT OFF To <i>.900 ± .010</i>			
<i>5</i>	<i>MILL</i>	MILL KEY <i>.192</i> wide $\frac{9}{16}$ FROM END + POINT SIZE $\pm .010$ LEAVING <i>.005</i> FROM KEY TO SLOT			
<i>6</i>	<i>MILL</i>	MILL TITS (<i>R.H. - 30 cms ONLY</i>) HAND MILL HOLD EM-SIZE To <i>.290</i>			
<i>7</i>	<i>BENCH</i>	BREAK CORNERS ON KEY			
<i>8</i>	<i>GRIND</i>	GRIND BACK OPP KEYSIDE GRIND KEY SIDE TO CLEAN UP			
<i>9</i>	<i>GRIND</i>	GRIND FLAT SIDE TO POINT SIZE			
<i>10</i>	<i>GRIND</i>	<i>.905</i> FIRST SIDE <i>.888</i> GRIND <i>.875</i> $\pm .0002$ $\pm .0003$			
<i>11</i>	<i>GRIND</i>	REMOVE BURRS AND GRIND KEY <i>.1873</i>			
<i>12</i>	<i>GRIND</i>	GRIND <i>.313</i> DIM.			
<i>13</i>	<i>BENCH</i>	BREAK CORNERS ON END OF LINEY AND INSIDE OF $\frac{5}{16}$ SLOT $\frac{1}{4} \times 45^\circ$			

14. GRIND SIZE .063⁵ ✓ 457-585 1/22

✓ 2 AW ✓ 2 AW
 ✓ 3 Mill ✓ 3 Mill
 ✓ 4 Mill ✓ 4 Mill
 ✓ 5 Mill ✓ 5 Mill
 ✓ 6 Mill ✓ 6 Mill
 ✓ 7 Mill ✓ 7 Mill
 ✓ 8 Mill ✓ 8 Mill
 ✓ 9 Mill ✓ 9 Mill
 ✓ 10 Mill ✓ 10 Mill
 ✓ 11 Mill ✓ 11 Mill
 ✓ 12 Mill ✓ 12 Mill
 ✓ 13 Mill ✓ 13 Mill

PRIORITY			MATERIAL MOVE AND SCRAP REPORT	COMPLETION DATE		
A	B	C		/	/	/

PART NUMBER F517 (RM.) F517	JOB NUMBER 1546	QUANTITY 600	FOR
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OTHER MANUFACTURED PARTS ASSOCIATED WITH THIS JOB NUMBER			

MATERIAL TYPE: RM	RH = 10 pt.	MATERIAL USED: RM
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OPR. NO.	MACH.	NO. PCS.	OPR. NO.	MACH.	NO. PCS.	OPR. NO.	MACH.	NO. PCS.	OPR. NO.	MACH.	NO. PCS.	OPR. NO.	MACH.	NO. PCS.
1			11	468										
2	444		12	455	599									
3	444		13	455	591									
4			14	455	585									
5	444	619												
6	402													
7	402													
8	430													
9	430													
10	468													

SHORTAGE REPORT			
OPR.	EMPL. NO.	REASON:	SUPV.

OPERATION SHEET

DATE: Sept. 12, 1962

STAR PARTS, INC.

SOUTH HACKENSACK

NEW JERSEY

PART

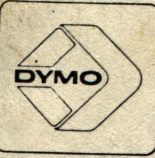
NO.

SHEET 1 OF 1 SHEETS

DESCRIPTION: LINO HL & REC.

MATERIAL:

OPER.	MACH NO.	DESCRIPTION OF OPERATION	SPECIAL TOOLS
<u>FINISHING LINERS FROM ROUGH STOCK</u>			
1 ✓	Bench	Stamp pt. & EM size	NOTE: Oper. for HL & Rec. are the same except no tit
2	Bench	File off bulge from stamp	
3	Mill	Cut to length	
4	Grind	Grind tit & EM size $+.001$ $-.000$	
5	Bench	Remove grinding hurr (Do Not round off corners)	
6	Bench	Straighten & Check for twist	
7	Mill	Mill grooves	
8	Bench	Polish all around (#120 Emery Cloth)	
9	Bench	Inspect	



Star Graphic Systems, Inc.

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Fill out completely and mail to:

Sales and Service Offices:

Star Graphic Systems, Inc.
Order Department
240 South Main St.
South Hackensack, N. J. 07606
Telex 134446 Cable STARPARTS

EASTERN OFFICE: 240 South Main Street, South Hackensack, New Jersey 07606 (201) 489-0200
MID-WESTERN OFFICE: 1127 South Mannheim Road, Westchester, Illinois 60153 (312) 345-1222
SOUTH-EASTERN OFFICE: 1924 Piedmont Circle, N.E., Atlanta, Georgia 30324 (404) 873-3852
WESTERN OFFICE: 1206 South Maple Avenue, Los Angeles, California 90015 (213) 749-2118

FOR OFFICE USE ONLY		
Inv. No.		
Cust. No.		
Picked by:	Pick up FCM PP Spec. Del. Air UPS REA Freight Collect	
Checked by:		
Packed by:		
Shipped by:		
Date		
Sim.	Agt.	St. Cd.
Tax Pct.	Tax Amt.	Loc.

SHIP TO: [Redacted]

ADDRESS: [Redacted]

CITY/STATE: [Redacted] **ZIP:** [Redacted]

ORDER NO.: 21240 **DATE:** 2/22/84

CHARGE TO: [Redacted]

ADDRESS: [Redacted]

CITY/STATE: [Redacted] **ZIP:** [Redacted]

SALESMAN

QUAN.	✓	LIN. OR INT.	PART NO.	LINERS			PLEASE ORDER BY PART NUMBER TO FACILITATE SHIPMENT	UNIT PRICE	EXTENSION
				LEFT-HAND		R.H.			
				PT. SIZE	FOR EMS	PT. SIZE			
1000			F517			10	7 15		
1000			F87L				14 96		
<p>⇒ all 003 undesign</p> <p>Blanket order to be shipped over next (12) month</p> <p>Less 15%</p> <p>Quantity Wincoast</p>									
<input type="checkbox"/> CHECK BOX FOR MORE ORDER BLANKS								TOTAL	

prompt shipment is a STAR tradition. Please note that we cannot accept orders totaling less than \$25. Printed in U.S.A.

Signed by: _____