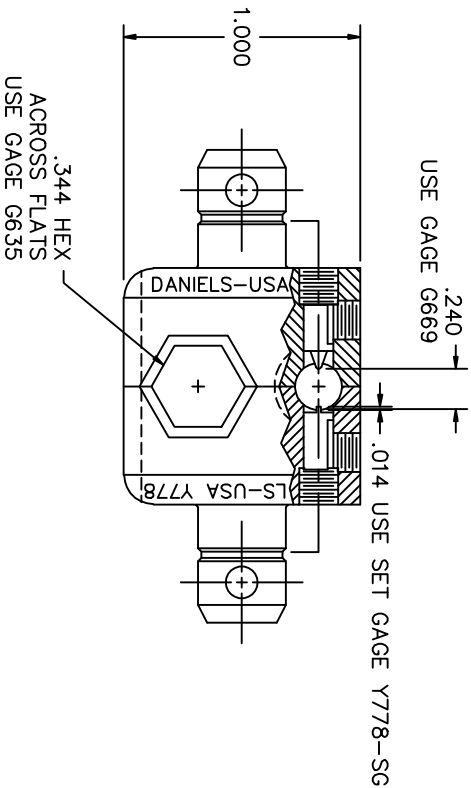
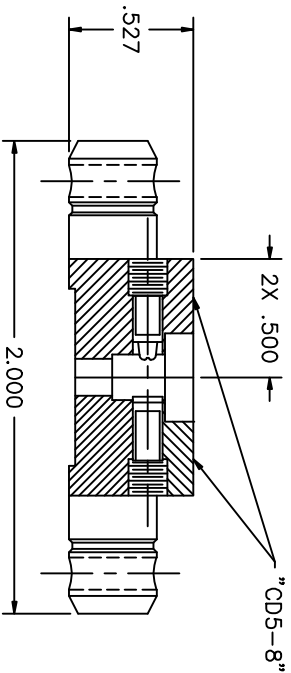



REVISIONS				
REV	ECN	DESCRIPTION	BY	APP'D
SYL	NUMBER		DATE	DATE
5		ADDED SETTING	ENF	RRR
			1-18-10	1-18-10



- TO SET DIE:
1. UNLOCK & BACK INDENTERS SLIGHTLY OUT OF THE CAVITY
 2. INSERT Y778-SG INTO HOLE FROM BACK SIDE OF DIE AS FAR AS IT WILL GO WITH THE SLOT ALIGNED WITH THE FLAT RECTANGULAR INDENTER
 3. ADJUST THE FLAT RECTANGULAR INDENTER UNTIL IT TOUCHES THE SET GAGE (PAY CLOSE ATTENTION TO LINE IT UP IN THE SLOT & DO NOT OVER TIGHTEN)
 4. ADJUST POINTED INDENTER UNTIL IT TOUCHES THE SET GAGE (DO NO OVER TIGHTEN)
 5. REMOVE Y778-SG
 6. VERIFY INDENTER GAGE WITH G669 AND ADJUST POINTED INDENTER IF NEEDED

UNCONTROLLED DOCUMENT
WILL NOT BE UPDATED

RESTRICTED & CONFIDENTIAL CONFIDENTIAL PROPERTY OF DANIELS MANUFACTURING CORP. NOT TO BE DISCLOSED TO OTHERS, REPRODUCED OR IN ANY MANNER, WITHOUT THE WRITTEN PERMISSION OF DANIELS MANUFACTURING CORP. ON COMPLETION OF ORDER OR FOR PURPOSE FOR WHICH LENT.	MATERIAL	ITEM	PART NO.	QTY.	DESCRIPTION/REMARKS					
	HEAT TREAT	DRN. I. STANFILL	DATE 8-2-98		DANIELS MANUFACTURING CORP. ORLANDO, FLORIDA GAGE 11851					
		CHKD. DH	DATE 8-17-98							
		APP'D. AAM	DATE 9-4-98							
		NOTE: THIS DRAWING IS AN OUTLINE DRAWING OF THE RESPECTIVE INDICATED ACTUAL DMC PART NUMBER. IT IS NOT TO BE USED FOR MANUFACTURING PURPOSES WITHOUT THE "-ENV" SUFFIX.	WHERE USED:							
FINISH			SCALE B 2X	CAD P/N Y778-ENV	SHEET 1 OF 1					
DO NOT SCALE DRAWING			POSTING	DMC. NO. Y778-ENV	REV. 5					

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