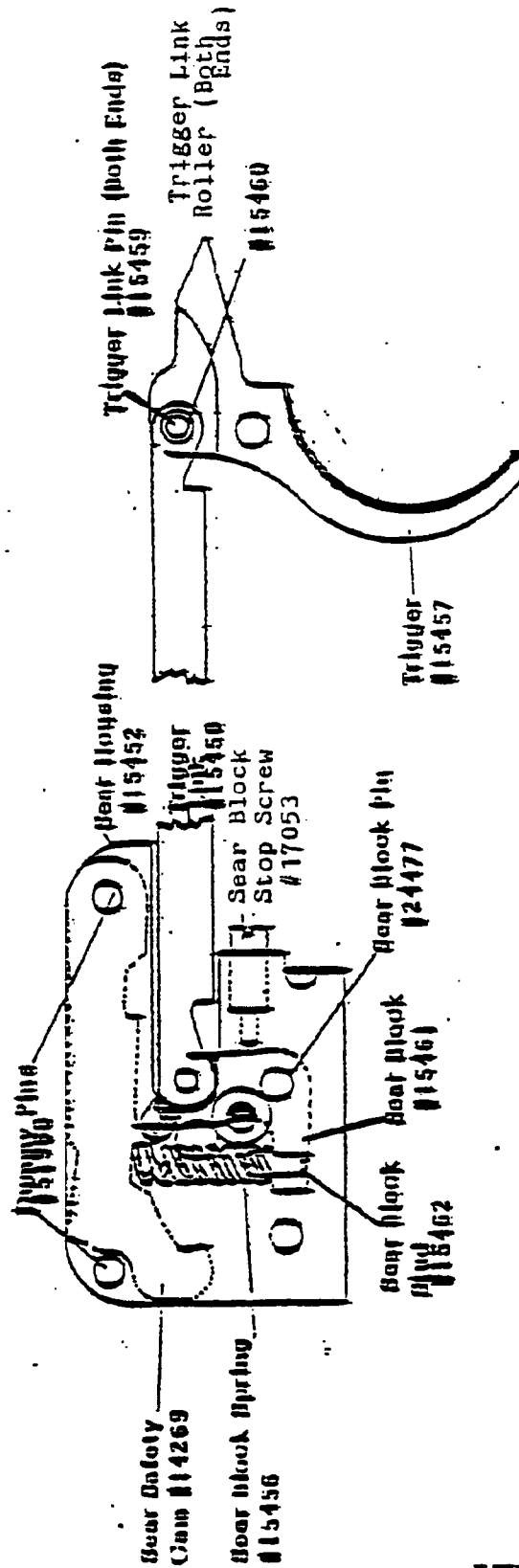


DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

BEAR HOUSING ASSEMBLY



PART NAME SCRP HOUSING ASSEMBLY COOLANT SET UP MODEL No. XP-100 OPER. No. 55
TYPE MACHINE DEPT. No. 15 PAGE 1 OF 12

PROCESS JNDS

DATES AND REASONS FOR REVISIONS		9/28/80-NEW-MRP-JAA-279130	
TOLERANCES AND EQUIPMENT		DA ON CAL	
FIXTURE		DB5455	
CROCUS CLOTH		Std.	
OPERATION DESCRIPTION		PART NO.	
Assemble Sear Housing Assembly		26970	
Housing Assembly			
APPROVAL AND DATES			
1. Pick Sear Block Assembly			
2. Polish Sear Safety Cam contact surface.			
• Use new crocus cloth			
• Keep rear edge sharp			
3. Pick Roller			
• Roller must be burr-free,			
4. Insert Roller into Sear Block Assembly			
link pin hole.			
PART NAME Sear Housing Assembly		COULANT	
TYPE MACHINE		MACHINE	
MODEL No. XP-100		SERIAL No. 55	
DEPT No. 15		PAGE 2 OF 12	

END

DATE AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

Trigger Link
#15450



PART NAME Sear Housing Assembly COOLANT SET UP MODEL No. XP-100 OPER. No. 55
TYPE MACH. HRS. DEPT. No. 15 PAGE 3 OF 12
MACHINE

PROC RECORD

DATE 9/29/80 REASONS FOR REVISIONS 9/29/80-NEW-MHP-JAA-21, 130

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT GA. OR CAL.

SPEED FEED

5. Pick Trigger Link
 - Black Color
 - Ears must be straight (Both Ends)
 - Holes must be counter-bore (Both Ends),
6. Assemble Trigger Link (Housing End) over Sear Block
7. Insert Trigger Link Pin (With head to the left) and swage end,
 - Swage must be on right side,
 - Swage must be flush or below surface,
 - Sear Block must freely rotate about pivot pin.

PART NAME Sear Housing Assembly COOLANT

TYPE

FILE up

MODEL No. XP-100

OPER. No. 55

MACH. HRS.

DEPT. No. 15

PAGE 4 of 12

MACHINE

RD-6402

PROCT RECORD

DATE 9/29/80-NEW-MIP-JAA-275130

REASONS FOR REVISIONS

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT GA. OR CAL.

SPEED FEED

8. Pick Trigger
 - Good black color,
 - Striations on Bow uniform.
 - Improved design at top front - machined slot omitted.
9. Insert one roller into link pivot hole
 - Roller must be burr-free
10. Assemble Trigger Link over Trigger.
 - Ears of Trigger link must be straight - not bowed in.
11. Insert Trigger Link Pin and Swage End.
 - Swage must be flush or below surface.
 - Trigger must fully rotate freely around pin and roller.

PART NAME Sear Housing Assembly

COOLANT

MODEL No. XP-100

OPER. No. 55

TYPE

DEPT. No. 15

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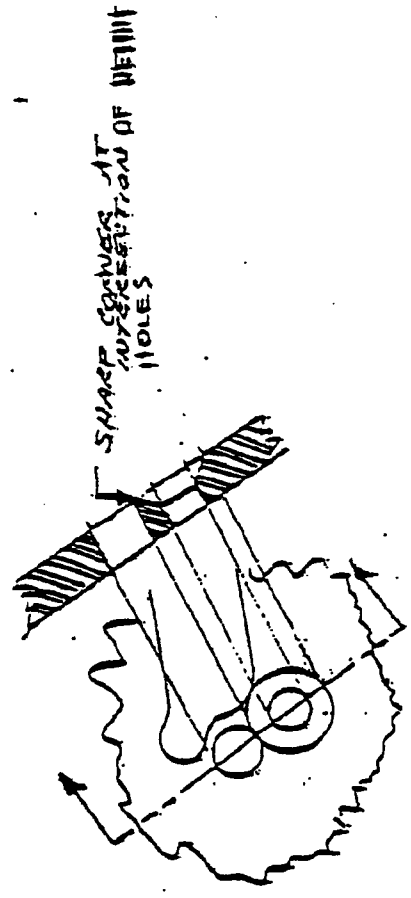
MACHINE

RD-400

DATE AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

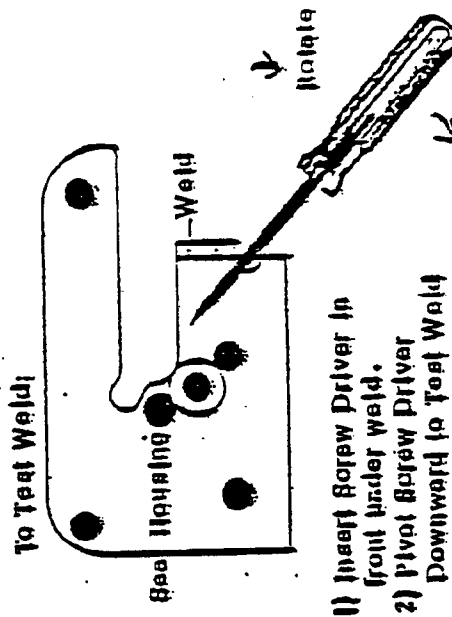
12. Pick Rear Housing
- Black Color
 - Sharp Corner at Intersection of the two safety detent holes - No Flat
 - Uniform opening at top for Rear Safety Cam



PART NAME	Sear Housing Assembly	coolant	SET UP	MODEL No.	XP-100	OPER. No.	55
TYPE			TIME	DEPT. No.	15	PAGE	6 OF 12
				MACHINE			

DATE AND REVISIONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION



PART NAME Sear Housing Assembly coolant SET UP TIME MODEL No. XP-100 OPER. No. 55
TYPE MACHINE MACH. HRS. 15 PAGE 7 OF 12

PROC RECORD

DATE 9/29/80 REVISIONS 9/29/80-NEW-MRP-JAA-2, 130

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT GA. OR CAL.

SPEED FEED

13. Sear Housing Cont.
 • Weld at front of housing must not interfere with Sear Block Screw Hole,

14. Test Weld

- Pry Sear Housing with medium force on screw driver to test for good weld.
- Weld must remain good, (Note illustration)

55

MODEL No. XP-100

TIME UP

SEAR HOUSING ASSEMBLY COOLANT

PART NAME

TYPE

MACH. NRS.

MACHINE

DEPT. No. 15

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OF 12

MB-5400

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MWP-JAA-279130

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

QA OR CAL

OPER

PROD

Pin Punch

A-35645

15. Assemble Trigger Link Assembly into Sear Housing, and insert Sear Block Pin, Drive Pin Left to Right.

This is easiest done by pivoting Sear Block Assembly fully forward - hold vertically - and place Sear Housing over it.

- Pin must be flush on right side and tight in housing.
- Sear Block Assembly and Trigger Link must be free in housing.

Hold Sear Housing, Move Link forward and backward.

- Link and Sear Block Assembly must move freely.

Press left end of Sear Block Pin firmly against bench block.

- Pin must not move. Stake Housing at right side if required.

PART NAME: Sear Housing Assembly

COOLANT

FINISH

MODEL No. XP-100

OPER. No. 55

TYPE

MACH. HRS.

DEPT. No. 15

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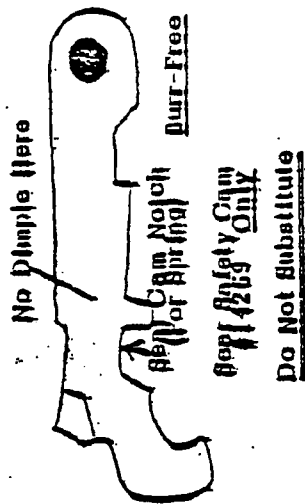
OF 12

MACHINE

NO. 5445

DATES AND REASONS FOR REVISIONS 9/29/80-NEH-MRP-IAA-279130

DESCRIPTIVE INFORMATION



PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No XP-100 OPER. No 55
TYPE MACHINE MACH. HRS. DEPT. No 15 PAGE 10 OF 12

PROCESS RECORD

DATE 9/20/80 NEW-MRP-JAA-219130

REASONS FOR REVISIONS

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

BY OLD

FIELD

QA OR CAL

16. Pick Sear Safety Cam
 ♦ There must be No Burrs on any surface
17. Assemble Sear Safety Cam into Sear Housing
 with Front Dummy Pin,
18. Drop Sear Block Spring into position on
 Sear Block Stud.
19. Rotate Sear Safety Cam into position,
 ♦ Sear Block Spring must be in position
 in Sear Cam Notch.

PART NAME Sear Housing Assembly

FILE UP

MODEL No. XP-100

OPFR No. 55

TYPE

MACH. WRS.
MACHINE

DEPT. No. 15

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RD 6000

DATE 9/29/80 NEW-MRP-JAA-2

DATE 9/29/80 NEW-MRP-JAA-2

DATE		REVISIONS		9/29/80-NEW-MRP-JAA-2, /30	
APPROVAL AND DATES					
TOOLS, GAGES AND EQUIPMENT		QA OR CAL.			
SPEED	FEED				
				20. Install Rear Dummy Pin over Sear Safety Cam.	
				21. Check for correct Sear Safety Cam freedom and Spring Force. • Sear Safety Cam must not bind in Housing. Pull Link forward and hold, Then, Depress Sear Safety Cam at top rear and release, • Sear Safety Cam must fully depress and return to full upward position against dummy pin. • Sear Block must fully rotate under Sear Safety Cam. Hold Sear Housing Pull Trigger Link and Release • Sear Block must return under Sear Housing with Spring Force,	

PART NAME Sear Housing Assembly coolant

TYPE TIME up

MACH. HRS. MACH. MACHINE

DEPT. No. 15 OPER. No. 55 PAGE 12 OF 12