

TITLE: Final Assy XP100

Process Header

Process Header

Document ID: Final Assy XP100	Remington Arms Company
Part Name: Final Assy XP100	
Product Line: C/F Rifle	Effective Date: 05-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 01-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
01-Oct-1992	Retype Entire Process from 288782 - Replaces Old Paper Process - Remove 221 F.B. - Add New Matte Ramacs	GLC 293071

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

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Process Material

Part Number	Qty	Description
925471	1	Final Assembly - XP100 7MM BR
1729	1	Bag Assembly Complete
31561	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
28600	1	Firing Pin Assembly
15447	1	Forward Receiver Screw
15485	1	Forward Receiver Screw Washer
91763	1	Front Sight Ramp
28505	1	Front Sight Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
15450	1	Rear Receiver Screw
15484	1	Rear Receiver Screw Washer
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
94749	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925492	1	Final Assembly - XP100 .223
1729	1	Bag Assembly Complete
31562	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
28600	1	Firing Pin Assembly
15447	1	Forward Receiver Screw
15485	1	Forward Receiver Screw Washer
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
15450	1	Rear Receiver Screw
15484	1	Rear Receiver Screw Washer
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin

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Part Number	Qty	Description
94749	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925473	1	Final Assembly - XP100 .35 Rem.
1729	1	Bag Assembly Complete
31563	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
28600	1	Firing Pin Assembly
15447	1	Forward Receiver Screw
15485	1	Forward Receiver Screw Washer
91763	1	Front Sight Ramp
28505	1	Front Sight Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
15450	1	Rear Receiver Screw
15484	1	Rear Receiver Screw Washer
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
94749	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925384	1	Final Assembly - XP100 .223 Rem.
1729	1	Bag Assembly Complete
105855	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw

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Part Number	Qty	Description
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925469	1	Final Assembly - XP100 7MM BR (10.5)
1729	1	Bag Assembly Complete
105856	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
97691	1	Front Sight
28505	1	Front Sight Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
97761	1	Rear Sight Assembly
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105881	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925386	1	Final Assembly - XP100 7MM BR (14.5)
1729	1	Bag Assembly Complete

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Process Material

Part Number	Qty	Description
105857	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925388	1	Final Assembly - XP100 7MM-08
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1729	1	Bag Assembly Complete
105858	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front

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Process Material

Part Number	Qty	Description
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925390	1	Final Assembly - XP100 .35 Rem.
1729	1	Bag Assembly Complete
105859	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw

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Process Routing

Dept	Oper	Operation Description	Part Numbers		
8761	575	Final Assembly	925471	925492	925473
			925384	925469	925386
			925388	925390	
8785	603	Proof, Test, Test and Target	925471	925492	925473
			925384	925469	925386
			925388	925390	
8785	603J	Proof, Test, Test and Target - Rejected Guns	925471	925492	925473
			925384	925469	925386
			925388	925390	
8785	605	Inspect for Live Ammunition	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	610	Print Box End Label	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	615	Match Label to Gun and Place	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	620	Adjust Sear Housing Assembly on Comparator 100%	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	625	Assemble Stock to Action	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	626	Final Inspect - Visual	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	630	Final Inspection	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	634	Pack Authorized Gunsmith Folder	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	635	Inspect for Live Ammunition and Oil Metal Parts	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	640R	Re-Pack	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	645R	Strip Defective Barrel and Receiver Assemblies	925471	925492	925473
			925384	925469	925386
			925388	925390	

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Process Routing
Dept Oper

Operation Description

Part Numbers

8761	650R	Repair Fire Controls	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	655R	Strip Defective Bolts	925471	925492	925473
			925384	925469	925386
			925388	925390	
		To Warehouse	925471	925492	925473
			925384	925469	925386
			925388	925390	

Operation Step Detail

Operation: 575

Step

Operation / Step Description

	Final Assembly
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Operation Tool Detail

Operation: 575

Tool Number

Tooling Description

B-86362	Special Holding Plug
A-35645	Pin Punch
Std	Molly Kote Type 'GN' Paste
Std	.002 Tempered Steel Shim Stock
C-47741	Solid Bolt
Std	1/16" Stamp
B-52089	Protrusion Gage - .075/.045

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Description

NOTE: Unless Otherwise Stated - All Relative Directions, (Up, Down, Clockwise, Etc.) are from the Shooter's Point of View with Gun Held in Normal Firing Position.

Procedure:

1. Pick Barreled Action and Inspect:
 - Good Uniform Black Color
 - No Mars or Scratches
 - Proper Roll Marks
 - Legible, Uniform Serial Number
 - Bore Must Be Concentric to Muzzle
2. Clamp in Vise
3. Assemble Three (5) Receiver Plug Screws into Receiver
4. Pick Bolt Stop Spring - Place One End of Spring into Detent in Bottom of Bolt Stop Slot
5. Pick Bolt Stop and Inspect:
 - Black color
 - Free of Burrs
6. Insert Bolt Stop into Receiver Slot, Fitting Bolt Stop Spring into Slot in Rear of Bolt Stop
7. Pick Bolt Stop Pin - Position and Drive into Receiver from Left to Right:
 - End of Pin Must Be Just Above Flush with Bolt Stop
 - Opposite End of Pin Must Not Protrude into Sear Housing Slot
8. Push Upward on Rear End of Bolt Stop and Release Slowly:
 - Bolt Stop Must Rotate Freely and Return Fully - File Receiver Slot if Necessary
9. Repeat Step (8) But Release Quickly Under Spring Tension
 - Bolt Stop Spring Must Remain in Place
10. Pick Trigger Housing and Inspect:
 - Black Color
 - No Burrs or Damage to Inside Surfaces which could Interfere with Proper Trigger Rotation
 - If Trigger Housing is Slightly Closed In, Spread with Special Holding Plug, to Align Holes with Barrel Bracket Holes
11. Assemble Trigger Housing to Barrel Bracket with Two (2) Trigger Housing Screws:
 - Trigger Housing Ears Must Be Flush to Bottom and both Sides of Barrel Bracket
 - Reject for Serious Mismatch
12. Pick Sear Housing Assembly and Inspect:
 - Swaged End of Trigger Link Pin Must Be Flush or Below Right Side Surface of Link on Sear Housing End
 - Ears of Link Must Be Straight
 - Link and Sear Block Assembly Must Move Freely in Housing

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Operation Procedure Notes

Operation: 575

Description

- Trigger Must Rotate Freely
- 13. Insert Sear Housing into Receiver and Align Sear Pin Holes of Receiver and Housing
- 14. Pick Sear Pins and Start, Chamfered End First - Drive Rear Pin First, Left to Right, to Just ABOVE Flush with Inside Surface of Bolt Stop Slot (To Clear Safety Assembly on Opposite Side) - Drive Front Pin, Chamfered End First, Left to Right, to Slightly BELOW Flush with Inside Surface of Bolt Stop Slot (To Clear Bolt Stop)
- 15. Push Upward on Rear End of Bolt Stop and Release Slowly:
 - Bolt Stop Must Rotate Freely and Return Fully Without Bind
- 16. Pick Trigger Pin - Align Trigger Hole with Trigger Housing Holes
- 17. Position and Drive Pin Through, Left to Right:
 - End of Pin Must Be Flush to Slightly Below at Right Side of Trigger Housing
- 18. Pull Trigger Several Times and Release Slowly:
 - Trigger and Link Must Return Freely and Fully
 - Push Forward on Trigger to Verify Trigger has Returned Fully
 - File and/or Adjust to Free Trigger If Necessary
- 19. Stake Both Sides of Trigger Housing to Retain Trigger Pin
- 20. Retighten Trigger Housing Screws
- 21. Stake Barrel Bracket at Trigger Housing Screw Slots to Prevent Screws Loosening
- 22. Lubricate Sear housing at Detent Holes intersection:
 - Only a Small Amount of Lubricant is Required
- *****Sketch Needed*****
- 23. Lubricate Cam Surface of Safety Assembly:
 - Only a Small Amount of Lubricant is Required
- *****Sketch Needed*****
- 24. Assemble:
 - Safety Assembly
 - Safety Detent Ball
 - Safety Detent Spring - Visually Check for Correct Size Dimple
 - Safety Pivot Pin - Seat Pin Head Lightly Against Left Side of Sear Housing
 - Safety Snap Washer - Side with Deep Notch (For Safety Pivot Pin) Must Be On Top
- *****Sketch Needed*****
- Safety Snap Washer MUST Be Completely Contained within Pivot Pin Groove
- The Raised End of dimple on Safety Detent Spring Must Be at the Left of Opening, at the Closed End of the Safety Snap Washer

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Operation Procedure Notes

Operation: 575
Description

*****Sketch Needed*****

25. Function Check Safety Assembly Components

- Push Safety Thumb Piece Fully Forward Beyond Detent Position
- Safety Must Spring Return to Detent Position
- Push Safety Thumb Piece Fully Rearward Beyond Detent Position
- Safety Must Spring Forward to Detent Position
- Move Safety from "On Safe" to "Off Safe" Position and Back - Twice
- Safety Must Spring Forward into "Off Safe" Position When Pushed
- There Must Be No Hang-Up or Hesitation Between Detent Positions
- The Flat Arm of the Safety Assembly Must Work Freely - It Must Not Bind on Housing, Receiver Slot, Link, Trigger Link Pin, or Sear Block Pin
- Adjust If Necessary

26. Pull Trigger Several Times and Release Slowly:

- Trigger Must Return Freely and Fully
- Push Forward on Trigger to Verify Trigger has Returned Fully

27. Stake Left Side of Receiver, Below Both Sear Pins, and Bolt Stop Pin

28. Pick Firing Pin Assembly and Inspect:

- Firing Pin Must Not Be Marred
- Bolt Plug Must Have Good Color and Appearance
 - No Marks or Scratches
 - No Rusty Parts
 - No Miscut or Incorrect Parts
- Lubricate Bolt Plug Threads and Cocking Cam Surface, Before Assembly into Bolt

29. Assemble Firing Pin Assembly to Bolt and Remove Washer, so that Bolt Final Assembly is in Fired Position

30. Check Firing Pin Protrusion

31. Place Final Bolt Assembly into Rearward (Cocked) Detent Position

32. Move Safety to "Off Safe" Position, Insert Bolt into Receiver - Open and Close Bolt Several Times to Distribute Lubricant and verify Smooth Operation

33. Initially Adjust Sear Safety Cam - Sear Block Engagement (Before Comparator)

- Apply Locknut to the Trigger Housing Engagement Screw
- Turn Trigger Adjusting Screw SLOWLY Until Firing Pin "Just" Falls
- Back Out Trigger Adjusting Screw (2) Turns (This Produces .030 Engagement)
- Tighten Locknut While Holding Screw in Place (This Will Ensure No Movement Will Occur at Proof and Test)

*****Sketch Needed*****

- Visually Check for Correct Engagement

34. Initially Adjust Sear Block Overtravel

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35. Inspect for Correct Sear Safety Cam - Sear Block Clearance with Shim
- Put Safety Lever to "On Safe" Position
 - Insert .002 Shim Fully into View Hole in Left Side of Sear Housing

- Shim Must Be Between Sear Safety Cam and Sear Block

- Move Safety Lever to "Off Safe" Position
- Lightly Pull on Shim with Thumb and Finger
- Shim Must REMAIN TRAPPED Between Sear Safety Cam and Sear Block

- If Shim is Free - Try New Shim
- Move Safety Lever from "Off Safe" Position Toward "On Safe" Position, to LOCATE AND STOP Safety Lever at the FORWARD MOST NULL LOCATION

- If Null Location is Passed (Too Far Forward "On Safe"), Then Return to "Off Safe" Position and Approach Null Location from the "Off Safe" Position Again
- With the Safety Lever in the Forward Most Null Location, Lightly Pull on Shim with Thumb and Finger
 - IF SHIM BINDS OR HANGS UP Between Sear Safety Cam and Sear Block REJECT AND REWORK as per Process

- IF SHIM REMOVES FREELY CLEARANCE IS CORRECT

36. Perform Trick Test

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- There Must Be No Click or Catch in Pull
- Firing Pin Must NOT Fall
- D. RELEASE TRIGGER SLOWLY:
 - Trigger Must Move to Full Forward Position When Released
- E. MOVE SAFETY LEVER TO "OFF SAFE" POSITION:
 - Firing Pin Must NOT Fall
 - Pull Trigger - Firing Pin Must Fall
- F. RE-COCK PISTOL
- G. POSITION SAFETY LEVER IN THE FORWARD MOST NULL POSITION (Previously Defined - Two Fingers May Be Necessary to Position the Safety)
- H. PULL TRIGGER HARD
 - There Must Be No Click or Catch in Pull
- I. RELEASE TRIGGER SLOWLY:
 - Trigger Must Not Bind
 - Trigger Must Move to Full Forward Position when Released
 - Firing Pin Must NOT Fall
- J. PUSH SAFETY LEVER TO "OFF SAFE" POSITION
 - Firing Pin Must Not Fall
 - Safety Lever Must Spring to "Off Safe" Position by Itself when Pushed from the Null Location
 - In the "Off Safe" Position the Safety Must Have an Observable "Spring Back" from the Fullest Forward and Rearward Position
- K. PULL TRIGGER
 - Firing Pin MUST Fall
- L. OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK
 - Firing Pin Must NOT Fall
- M. REPEAT STEPS G - L

FOR THE THIRD AND LAST TRIAL

- N. MOVE SAFETY TO "ON SAFE" POSITION
O. FROM THE "ON SAFE" POSITION MOVE THE SAFETY LEVER TO THE FORWARD MOST NULL LOCATION - (PREVIOUSLY DEFINED)
P. PULL TRIGGER HARD
Q. RELEASE TRIGGER SLOWLY
 - There Must Be No Click or Catch in Pull
 - Trigger Must Not Bind
 - Trigger Must Return to Full Forward Position When Released
 - Firing Pin Must NOT Fall
R. PUSH SAFETY LEVER TO "OFF SAFE" POSITION:
 - Firing Pin Must NOT Fall
 - Safety must Spring to "OFF SAFE" Position When Pushed from the Null Location
S. PULL TRIGGER
 - Firing Pin MUST Fall
T. OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK
 - Firing Pin Must NOT Fall

37. Put Safe in "OFF SAFE" Position

- Re-Cock Action
 - A. Push with Steady Pressure on the End of Firing Pin Head - (Use Suitable Non-marring Means) - Remove Bolt Assembly
 - B. Insert Solid Bolt - Apply Steady Pressure of 6-8 Lbs. at Rear of Bolt Tool, with Safe in the "OFF SAFE" Position
- Firing Pin Head Must Not Move Forward
- Tool Must Remain Engaged with Sear

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38. Check Notch Escape
 - Put Safe in "Off Safe" Position
 - Hold Trigger Back
 - Close Bolt Slowly
 - Firing Pin MUST Follow Down
39. Use Dummy Cartridges to Check Feeding, Extraction, and Ejection
 - Adjust If Necessary
40. Assemble Front Sight Ramp to Barrel with Front Sight Screw (925471,925473)
 - Assemble Front Sight to Barrel with Front Sight Screw (925469)
41. Mark Assembler's Identification on Gun Ticket and Last Four Digits of Serial Number
42. Pick Correct Ticket and Fill In
43. If Repairs from Test Are Necessary Work MUST Be Done By the Assembler Who Built and Stamped the Action

Operation Step Detail

Operation: 603

Step

Operation / Step Description

Proof, Test, Test and Target

Operation Tool Detail

Operation: 603

Tool Number

Tooling Description

Std Proof, Test, Test Targeting Jack

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Operation Procedure Notes

Operation: 603

Description

Procedure:

Inspect Pistol for Live Ammunition:

1. Make Sure that the Safety is in the "S" Position
2. Pull Bolt Fully to Rear
3. Visually Inspect - Chamber Must Be Empty and there Must Be No Ammo in the Receiver

Operation Step Detail

Operation: 603J

Step

Operation / Step Description

Proof, Test, Test and Target - Rejected Guns

Operation Procedure Notes

Operation: 603J

Description

Procedure:

Inspect Pistol for Live Ammunition:

1. Make Sure that the Safety is in the "S" Position
2. Pull Bolt Fully to Rear
3. Visually Inspect - Chamber Must Be Empty and there Must Be No Ammo in the Receiver

Operation Step Detail

Operation: 605

Step

Operation / Step Description

Inspect for Live Ammunition

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Operation Procedure Notes Operation: 605

Description

Procedure:

Inspect Pistol for Live Ammunition:

1. Make Sure that the Safety is in the "S" Position
2. Pull Bolt Fully to Rear
3. Visually Inspect - Chamber Must Be Empty and there Must Be No Ammo in the Receiver

Operation Step Detail Operation: 610

Step Operation / Step Description

Print Box End Label

Operation Procedure Notes Operation: 610

Description

Procedure:

1. Log onto Printer (Start of Shift)
2. Push Gun Truck to Coder Station
3. Code Guns On Truck
 - a. Lift Gun - Check for Live Ammo
 - b. Type in Serial Number from Receiver
 - c. Type in Index Number from Production Tickets
4. Tear Off Labels
5. Place in Proper Gun Pouches
6. Push Gun Truck to Holding Area

Operation Step Detail Operation: 615

Step Operation / Step Description

Match Label to Gun and Place

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Operation Step Detail

Operation: 620

Step

Operation / Step Description

Adjust Sear Housing Assembly on Comparator 100%

Operation Tool Detail

Operation: 620

Tool Number

Tooling Description

Std	J & L TC-10 Comparator with 20 Power Projection Lens Assembly
Std	Air Line Nozzle
A-XP-100-37	Comparator - Template
	Comparator - Fixture
Std	Inhibisol
Std	Freon Tank
Std	Vibra-tite
Std	"Duco" Cement

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Description

Procedure:

1. Pick Barreled Action
2. Inspect for Live Ammunition:
 - Chamber Must Be Empty
3. Air-Clean Sear Block and Sear Safety Cam thru Sear Housing Opening
 - DO THIS AWAY FROM COMPARATOR

NOTE: Realign Lamphouse Each Time Bulb is Replaced - This Centralizes Bulb Filament On Optical Axis - Light Beam from Condensing Lens to Projection Lens Must Be Parallel - Adjust As Required - Refer to Pg.7 of J & L Operating Manual

4. Put Safety Lever in "OFF SAFE" Position
5. Place Action in Fixture and Secure
 - A. Remove Trigger Engagement Screw & the Locknut
 - a. Degrease the Threaded Hole in the Trigger Housing Using Inhibisol
 - b. Degrease Trigger Housing Screw in the Freon Tank and Let Dry
 - c. Apply Vibra-tite to the Trigger Housing Screw
 - Check Screws for the Absence of Oil, If Oil Exists Repeat Step b
 - Using a Trigger Housing Bracket, Insert Screw One Turn - This Will Hold the Screw While You Apply the Vibra-tite
 - Apply Vibra-tite Evenly Over the Full 360 Degrees and Over the Entire Length of the Screw - Be Careful Not to Apply Vibra-tite to the Screw Slot or On the Point
 - Curing Time is to be a Minimum of 45 Min. Before Assembly with Optimum Assembly Time of 3 to 4 Hours - Only Apply Vibra-tite to the Screws to be Used in the Following (8) Hour Period

NOTE: When Two-Thirds of the Bottle has been Consumed Dispose of the Existing Vibra-tite Due To the Evaporation of the Thinner

6. Push Bolt Stop to Free Position and Secure with a Non-Marring Means
7. Close Bolt
8. Move Fixture to Position Sear Safety Cam Vertical Surface to Engagement Set Line of Comparator Overlay
9. Check Sear Safety Cam - Sear Block Engagement (.020/.015)
 - Must Be Within Tolerance Lines of Comparator Overlay
 - A. If Engagement is More than Max. Line:
 - Turn Trigger Adjusting Screw Slowly Clockwise (Viewed From Muzzle End) Until Engagement Comes Within Tolerance Lines
 - B. If Engagement is Less than Min. Line:
 - Raise Bolt Handle (Actually Lowering Handle While Action is In the Fixture) and Turn Adjusting Screw Counter-Clockwise
 - Close Bolt Handle (Sear Block Will Not Always Follow as Trigger Adjusting Screw is Turned Counter-Clockwise with Bolt Closed)
 - Return to 9A
 - C. Remove Slave Sear Block Stop Screw
 - Degrease Stop Screw the Same As Step 5 b
 - D. Apply Vibra-tite Using the Same Parameters as Step 5 c, But Holding the

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Operation Procedure Notes Operation: 620
Description

- Screw by the Slotted Head Durring Application
E. Curing Time is to be a Minimum of 45 Min. Before Assembly with Optimum Assembly Time of 3 to 4 Hours - Only Apply Vibra-tite to the Screws to be Used in the Following (8) Hour Period

NOTE: When Two-Thirds of the Bottle has been Consumed Dispose of the Existing Vibra-tite Due To the Evapaoration of the Thinner

10. Pull Trigger to Drop Firing Pin
11. Move Fixture to Position Sear Safety Cam Vertical Surface to Overtravel "Set" Line On Caomparator Overlay
12. Hold Trigger Back Firmly Against Stop Screw
 - Clearance Between Sear Safety Cam and Sear block Must Be Within Overtravel Tolerance Lines On Comparator Overlay (.015/.005)
 - A. If Over Travel is Less than Min. Line:
 - Turn Sear Block Stop Screw Counter-Clockwise Until Clearance is Within Tolerance Lines
 - B. If Overtravel is More than Max. Line:
 - Turn Sear Block Stop Screw Clockwise Until Clearance is Within Tolerance Lines
13. Remove Bolt Stop Means
14. Remove Action from Fixture
15. Seal Both Screws with "Duco" Cement Including Slot Screws
 - Cement Must Not Interfere with Link Freedom

Operation Step Detail

Operation: 625

Step

Operation / Step Description

Assemble Stock to Action

Operation Tool Detail

Operation: 625

Tool Number

Tooling Description

Std Molly Kote Type "GN" Paste

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Description

Procedure:

1. Pick Barreled Action and Inspect:
 - No Marks or Scratches
 - Legible Proof, Test, Target Stamps
2. Tighten Barreled Action in Vise
3. Insert Receiver Screw Washers in C' Bore on Underside of Receiver
4. Assemble Trigger Balance Pin and Spring to Trigger Balance
5. Lubricate Trigger Balance
- *****Sketch Needed*****
6. Select Stock Assembly and Inspect:
 - Reasonably Uniform Matt Finish
 - No Splits, Cracks, or Breaks
 - No Marks or Scratches
 - No Missing Parts
7. Assemble Trigger Balance Sub-Assembly to Stock:
 - Trigger Balance Must Be Installed Correctly
- *****Sketch Needed*****
8. Assemble Stock Assembly to Action with Forward and Rear Screws - Bolt Must Be Removed to Expose Rear Screw
 - Trigger Must Be Central in Trigger Guard - It Must Not Touch At Any Point
 - Receiver Tang Must Be Fully Seated in Stock at Rear
 - Safety Must Snap Freely Forward and Rearward with No Bind on Stock or Receiver
9. Perform Trick Test
 - A. COCK PISTOL
 - B. MOVE SAFETY LEVER TO "ON SAFE" POSITION:
 - There Must Be No Bind
 - There Must Be A Good Sharp Single Detent
 - In the "On Safe" Position, the Safety Must Have an Observable "Spring Back" from the Fullest Rearward and Forward Positions
 - C. PULL TRIGGER:
 - There Must Be No Click or Catch in Pull
 - Firing Pin Must NOT Fall
 - D. RELEASE TRIGGER SLOWLY:
 - Trigger Must Move to Full Forward Position When Released
 - E. MOVE SAFETY LEVER TO "OFF SAFE" POSITION:
 - Firing Pin Must NOT Fall
 - Pull Trigger - Firing Pin Must Fall
 - F. RE-COCK PISTOL
 - G. MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TO THE FORWARD MOST NULL LOCATION (Previously Defined in Operation #575 - Two Fingers May Be Necessary to Position the Safety)
 - H. PULL TRIGGER HARD
 - There Must Be No Click or Catch in Pull
 - I. RELEASE TRIGGER SLOWLY:

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Operation Procedure Notes

Operation: 625

Description

- Trigger Must Not Bind
- Trigger Must Move to Full Forward Position when Released
- Firing Pin Must NOT Fall
- J. PUSH SAFETY LEVER TO "OFF SAFE" POSITION
 - Firing Pin Must Not Fall
 - Safety Lever Must Spring to "Off Safe" Position by Itself when Pushed from this Null Location
 - In the "Off Safe" Position the Safety Must Have an Observable "Spring Back" from the Fullest Forward and Rearward Position
- K. PULL TRIGGER
 - Firing Pin MUST Fall
- L. OPEN ACTION AND CLOSE BOLT FORCIBLY TO RE-COCK
 - Firing Pin Must NOT Fall
- M. REPEAT STEPS G - L

FOR THE THIRD AND LAST TRIAL

- N. MOVE SAFETY TO "ON SAFE" POSITION
- O. FROM THE "ON SAFE" POSITION MOVE THE SAFETY LEVER TO THE FORWARD MOST NULL LOCATION - (PREVIOUSLY DEFINED)
- P. PULL TRIGGER HARD
- Q. RELEASE TRIGGER SLOWLY
 - There Must Be No Click or Catch in Pull
 - Trigger Must Not Bind
 - Trigger Must Return to Full Forward Position When Released
 - Firing Pin Must NOT Fall
- R. PUSH SAFETY LEVER TO "OFF SAFE" POSITION:
 - Firing Pin Must NOT Fall
 - Safety must Spring to "OFF SAFE" Position When Pushed from the Null Location
- S. PULL TRIGGER
 - Firing Pin MUST Fall
- T. OPEN ACTION AND CLOSE BOLT FORCIBLY TO RE-COCK
 - Firing Pin Must NOT Fall

Operation Step Detail

Operation: 626

Step

Operation / Step Description

Final Inspect - Visual

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Description

NOTE: The Final Assembler Who Assembled the Pistol is to Perform the Visual Inspection and to Identify the Passed Pistol with His Assembler's Stamp

Procedure:

1. AMMUNITION INSPECTION

A. Inspect Gun for Live Ammunition

- Chamber Must Be Empty and There Must Be No Live Ammunition Present

2. RECEIVER ROLL MARKINGS

- Must Be Present, Clear, Distinct, and Visible Above Stock

TYPE

LOCATION

- | | |
|---------------------------------------|-----------------------------------|
| - Remington - In Script | Left Side, Center |
| - Model XP-100 | Left Side, Below "Remington" |
| - Serial Number and Alphabetic Prefix | Left Side, Forward of Above Items |

3. BARREL ROLL MARKINGS

- Must Be Present, Clear, Distinct, and Visible Above Side of Stock

TYPE

LOCATION

- | | |
|--|------------------------------|
| - Remington Arms Co., Inc.
Ilion, New York Made in U.S.A. | Left Side |
| - Des. 201,366 | Right Side, Toward Rear |
| - Pat. 3,255,545 | Right Side, Below Above Item |

4. BARREL STAMP MARKINGS

- Must Be Present, Clear, Distinct, and Visible Above Stock

TYPE

LOCATION

- | | |
|-------------------|--|
| - Magnaflux Mark | Right Side, Rear |
| - Proof | Right Side, Near Barrel Bracket,
Above Centerline of Barrel |
| - Test and Target | Just Forward of Proof Stamp |
| - Assembler | Left Side, Forward of Receiver,
Above Centerline of Barrel |

5. BOLT MARKINGS

- Must Be Present, Clear, and Distinct

TYPE

LOCATION

- | | |
|--|--------------------------|
| - Bolt Head Pull Test - Prick Punch | Right Side Lug |
| - Proof Mark - Prick Punch | Bottom of Bolt Handle |
| - Bolt Handle Braze Test - Prick Punch | Rear of Bolt Handle |
| - Magnaflux Bolt Assembly Inspection
- Prick Punch | Left Side Lug |
| - Serial Number, Must Match Receiver
- Last Four Digits | Bottom Rear of Bolt Body |

6. BARREL FINISH

- Must Be Uniform - Black Color, Medium Lustre Finish - Free of Seams and Stress Marks

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Operation Procedure Notes

Operation: 626

Description

- Muzzle Crown Must Be Reasonably Smooth with No Burrs, Jams, or Deformation in Bore
- Bore Must Be Concentric with Muzzle O.D.

7. SIGHTS

- Rear Sight Ramp Screwed Tightly - Reasonably Central to Barrel
- Rear Sight Leaf Reasonably Central Crosswise on Ramp - Set Screw Tight in Position
- Rear Sight Eyepiece - Top Approximately Flush with Top Surface of Leaf - Set Screw Tight
- Rear Sight Assembly Must be Level, Crosswise, with Front Sight and with Line of Sight as Viewed from Rear - Not Tipped, Twisted or Bent

8. RECEIVER FINISH

- All Outside Exposed Surfaces Must Have a Smooth, Polished Finish, Uniform Black in Color, Free of Burrs, Jams, or Dents
- Ejection Port Edges Must Not Be Sharp, Chipped, or Marred
- Receiver Plug Screws Must be Present in Front (2) and Top Rear (1) - Slots Not Mutilated
- Gas Escape Hole Must Be Present at Front Right Side of Receiver and Show a Minimum of 1/2 of Hole Above Stock

9. BARREL AND RECEIVER FIT

- Barrel, Barrel Bracket, and Receiver Must Be Tight at Joint
- Must Be in Alignment Lengthwise

10. STOCK ASSEMBLY

A. Stock and Trigger Guard

- Stock Must Present a Reasonably Uniform Matt Finish, Clean and Free of Breaks, Splits, and Cracks
- Slight Acid Marks (At Sides of Striations) Permissible, But No Blisters or Bubbles
- No Bad Scratches or Abrasions
- Trigger Guard Must Present Good Uniform Black Finish - Not Chipped or Marred
- Trigger Guard Must Fit Well In Stock, At Sides and Around Ends
- Molding Mark Inside Guard Must Not Be Sharp - No Protruding Flash
- Trigger Opening Clean, Not Broken Through or Chipped at Edges

B. Striations

- Must Be Distinct, Uniform and Complete Full Length - Spacer and Grip Diamond Not Striated

C. Checkering

- Must Be Distinct and Good Form - Not Abraded or Flattened - Complete On Both Sides of Grip

D. Fore End Spacer and Tip

- Must Be Tight to Stock
- Spacer Must Not Be Broken and Must Conform to Contour of Stock and tip

E. Diamond Inserts

- Must Be Clean White in Color and Tight in Stock
- Must Be a Good Fit in Cavities - No Appreciable Openings

11. STOCK FIT

A. To Receiver

- Receiver Must Fit Tightly in Stock
- Receiver Tang Must Seat Fully in Stock at Rear - It Must Not Protrude

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Operation Procedure Notes Operation: 626
Description

Beyond Stock at Rear

- Must Be a Good Fit at Both Sides Full Length
- B. To Barrel
 - Must Show a Reasonably Uniform Opening On Both Sides for Full Length Forward of Barrel Bracket

12. BOLT ASSEMBLY

- Bolt Plug and Firing Pin Head - Good Smooth Finish with Uniform Black Color
- Bolt Handle, Bolt Body, Bolt Head Have Good Smooth Bright Finish - No Rust, Excess Braze, Bad Nicks, or Burrs - Rub Marks On Body Are Acceptable
- Bottom "Half Ball" of "S" Bolt Handle - Serrated with No Burrs or Sharp Edges
- Sear Notch at Front of Firing Pin Head - Good Smooth Finish - No Deep Lines
- Rear Surfaces of Locking Lugs Must Be Smooth - No Deep Lines
- Gas Escape Hole Must be Present in Bottom Front
- Bolt face Must Be Smooth - No Deep Rings
- Extreme Front Face of Bolt (Shroud) Must Be Smooth and Flat
- Extractor and Rivet Present - Good Claw - Not Broken or Damaged
- Depress Ejector with Hand Punch and Release
 - Must Depress At Least Flush with Bolt Face and Return to Forward Position Freely Under Spring Tension
 - Must Be Retained by Ejector Pin

13. STAMP BARREL

- If Pistol Meets All Visual Requirements - Identify with Assembler's Stamp

Operation Step Detail Operation: 630

Step Operation / Step Description

Final Inspection

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Operation Tool Detail

Operation: 630

Tool Number	Tooling Description
B-45160	Min. Heading Plug - 7MM BR
B-86881	Min. Heading Plug - .223 Rem.
B-TS-4333	Min. Heading Plug - .35 Rem.
B-45161	Max. Heading Plug - 7MM BR
B-86883	Max. Heading Plug - .223 Rem.
B-84290	Max. Heading Plug - .35 Rem.
Std	Spring Scale

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Description

Procedure:

1. MATCH LABEL TO SERIAL NUMBER
2. HEADING
 - Cock Pistol Place Heading Plug Into Chamber - Move Bolt To Forward Position and Rotate Clockwise - DO NOT USE EXCESSIVE FORCE
 - A. On Min Plug - Bolt MUST FULLY Close
 - B. On Max Plug - Bolt MUST NOT Fully Close
3. FUNCTION
 - With Dummy Cartridges, Check for Proper Feeding, Extraction, and Ejection
4. TRIGGER PULL
 - MEASURE Pull with Spring Scale:
 - Gun Must Fire with 1-1/2 to 2-3/4 Lbs. Force
 - Trigger Must Be Central in Trigger Guard - It Must Not Touch At Any Point - Adjust If Necessary
5. PERFORM TRICK TEST
 - A. Cock Pistol
 - B. Move Safety Lever to "ON SAFE" Position:
 - There Must Be No Bind
 - There Must Be A Good Sharp Single Detent
 - In the "On Safe" Position, the Safety Must Have an Observable "Spring Back" from the Fullest Rearward and Forward Positions
 - C. Pull Trigger:
 - There Must Be No Click or Catch in Pull
 - Firing Pin Must NOT Fall
 - D. Release Trigger Slowly:
 - Trigger Must Move to Full Forward Position When Released
 - E. Move Safety Lever to "OFF SAFE" Position:
 - Firing Pin Must NOT Fall
 - Pull Trigger - Firing Pin Must Fall
 - F. Re-Cock Pistol
 - G. Moving Safety Lever from "OFF SAFE" Position to the Forward Most Null Position (Previously Defined Op.#575 - Two Fingers May Be Necessary to Position the Safety)
 - H. Pull Trigger Hard
 - There Must Be No Click or Catch in Pull
 - I. Release Trigger Slowly:
 - Trigger Must Not Bind
 - Trigger Must Move to Full Forward Position when Released
 - Firing Pin Must NOT Fall
 - J. Push Safety Lever to "OFF SAFE" Position
 - Firing Pin Must Not Fall
 - Safety Lever Must Spring to "Off Safe" Position by Itself when Pushed from the Null Location
 - In the "Off Safe" Position the Safety Must Have an Observable "Spring Back" from the Fullest Forward and Rearward Position
 - K. Pull Trigger
 - Firing Pin MUST Fall
 - L. Open Action and Close Bolt Forcibly to Re-Cock
 - Firing Pin Must NOT Fall
 - M. Repeat Steps G - L

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Operation Procedure Notes Operation: 630
Description

FOR THE THIRD AND LAST TRIAL

- N. Move Safety to "ON SAFE" Position
 - O. From the "ON SAFE" Position Move the Safety Lever to the Forward Most Null Location
 - P. Pull Trigger Hard
 - Q. Release Trigger Slowly
 - There Must Be No Click or Catch in Pull
 - Trigger Must Not Bind
 - Trigger Must Return to Full Forward Position When Released
 - Firing Pin Must NOT Fall
 - R. Push Safety Lever to "OFF SAFE" Position:
 - Firing Pin Must NOT Fall
 - Safety must Spring to "OFF SAFE" Position When Pushed from the Null Location
 - S. Pull Trigger
 - Firing Pin MUST Fall
 - T. Open Action and Close Bolt Forcibly to Re-Cock
 - Firing Pin Must NOT Fall
6. STAMP BARREL
- If Pistol Meets ALL Inspection Requirements, Stamp Final Inspection Mark and Date Code Stamp on Left Rear Side of Barrel

Operation Step Detail Operation: 634

Step Operation / Step Description

1. Pack Authorized Gunsmith Folder

Operation Step Detail Operation: 635

Step Operation / Step Description

1. Inspect for Live Ammunition and Oil Metal Parts

Operation Tool Detail Operation: 635

Tool Number Tooling Description

Std Oil

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Operation Procedure Notes Operation: 635

Description

Procedure:

1. Inspect for Live Ammunition
2. Oil Metal Parts
3. Match Label to Serial Number
4. Match Bolt to Receiver Number - Close Bolt and Fire Pistol Down
5. Pack Pistol in Case
 - Place Instruction Folder in Case
6. Pack Case in Carton and Seal

Operation Step Detail Operation: 640R

Step Operation / Step Description

Re-Pack

Operation Procedure Notes Operation: 640R

Description

Re-Pack Pistol

Operation Step Detail Operation: 645R

Step Operation / Step Description

Strip Defective Barrel and Receiver Assemblies

Operation Step Detail Operation: 650R

Step Operation / Step Description

Repair Fire Controls

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Operation Procedure Notes Operation: 650R

Description

NOTE: Repair Defective Fire Controls - Make Sure All Moving Parts Move Freely
and Engagement Surfaces are Clean and Burr-Free

Operation Step Detail

Operation: 655R

Step

Operation / Step Description

Strip Defective Bolts

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