

TITLE: Barrel Bracket XP100

Process Header

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Document ID: Bbl Brkt XP100	Remington Arms Company
Part Name: Barrel Bracket XP100	
Product Line: C/F Rifle	Effective Date: 07-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 05-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
05-Oct-1992	Retype Entire Process from 290120 - Replaces Old Paper Copy	GLC 293087

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15475	1	Barrel Bracket (Steel) - XP100
15487	1	Blank

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Process Routing

Dept	Oper	Operation Description	Part Numbers
8158	2	Drill and Buttmill (2) Holes	15475
8158	3	Flat File to Remove Burr (One Side Only)	15475
8551	5	Neutral Salt Harden, Oil Quench, Wash and Dry	15475
8551	10	Nitre Draw, Water Quench, Wash and Dry	15475
9257	11	Inspect for Rockwell Hardness	15475
8502	14	Wash Brfore Grind	15475
8502	15	Grind Both Sides	15475
8579	20	Supersheen Tumble	15475
8579	25	Wax	15475
		To MRP Crib# 06	15475

Operation Step Detail

Operation: 2

Step

Operation / Step Description

1	Drill and Buttmill (2) Holes
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Operation: 2

Tooling Description

Operation: 2

NOTE: Locate Parts with "X" Stamp Facing Up (To Orient C' Bore with Locating Surface)

Operation: 3

Operation / Step	Description
1	Initial Setup
2	Parameter Configuration
3	Data Collection
4	Analysis
5	Reporting
6	Conclusion

Operation: 3

Tooling Description

Std	File
1	1
2	2
3	3
4	4
5	5
6	6
7	7
8	8
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10	10
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96	96
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98	98
99	99
100	100

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Operation Step Detail

Operation: 5

Step

Operation / Step Description

Neutral Salt Harden, Oil Quench, Wash and Dry

Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

Std

Neutral Salt Furnace

Operation Procedure Notes

Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 8630 - 4130

TEMPERATURE: 1550 Degrees F

MAXIMUM LOAD:

TIME: 20 Min. @ Temp.

QUENCH: Oil

REMARKS: Wash and Dry

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 10

Step

Operation / Step Description

Nitre Draw, Water Quench, Wash and Dry

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Operation Tool Detail

Operation: 10

Tool Number

Tooling Description

Std

Nitre Furnace

Operation Procedure Notes

Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 8630 - 4130

TEMPERATURE: 900 - 950 Degrees F

MAXIMUM LOAD:

TIME: 30 Min. @ Temp

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 202

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 11

Step

Operation / Step Description

Inspect for Rockwell Hardness

Operation Tool Detail

Operation: 11

Tool Number

Tooling Description

Std

Rockwell Hardness Tester

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Operation Procedure Notes

Operation: 11

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 8630 - 8640

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS: RC 33-38

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 14

Step

Operation / Step Description

Wash Brfore Grind

Operation Step Detail

Operation: 15

Step

Operation / Step Description

Grind Both Sides

Operation Tool Detail

Operation: 15

Tool Number

Tooling Description

X-7137

Mics. - .187/.185

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