

**TITLE: Bolt Stop XP100**

**Process Header**

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Document ID: Bolt Stop XP100	Remington Arms Company
Part Name: Bolt Stop XP100	
Product Line: C/F Rifle	Effective Date: 08-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 07-Oct-1992

**Process Revision Reasons**

Date:	Reason For Revision:	Eng Log #:
07-Oct-1992	Retype ENTire Process from 284125 - Replaces Old Paper Process - Removed 221 FB	GLC 293099

**Process Approval List**

Approved By:	Badge #:	Date:	Designation:
JacksonRA			

**Process General Notes**

**Notes:**

**Process Material**

Part Number	Qty	Description
91761	1	Bolt Stop - XP100
C-16812	1	Blank

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**Process Routing**

Dept	Oper	Operation Description	Part Numbers
8551	4	Neutral Salt Harden, Oil Quench, Wash and Dry	91761
8551	8	Nitre Black, Water Quench, Wash and Dry, Oil for Storage	91761
9257	12	Inspect for Rockwell Hardness	91761
		To MRP Crib #29	91761

**Operation Step Detail**

Operation: 4

**Step**

**Operation / Step Description**

Neutral Salt Harden, Oil Quench, Wash and Dry

**Operation Tool Detail**

Operation: 4

**Tool Number**

**Tooling Description**

Std Ajax Electric Neutral Salt Bath

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**Operation Procedure Notes      Operation: 4**

**Description**

**PROCESS RECORD - HEAT TREAT SPECIFICATION**

**MATERIAL & SPECIFICATION: C-1095 or C-1070**

**TEMPERATURE: 1550 Degrees F**

**MAXIMUM LOAD:**

**TIME: 15 Min. @ Temp.**

**QUENCH: Oil**

**REMARKS: Wash and Dry**

**INSPECT FOR: Product Check for File Hardness**

**HEAT TREAT INSPECTION:**

**STANDARD PRACTICE NO:**

**HARDNESS LIMITS:**

**APPEARANCE OF PARTS: Clean, Dry, Free from Salt**

**Operation Step Detail**

**Operation: 8**

**Step**

**Operation / Step Description**

**Nitre Black, Water Quench, Wash and Dry, Oil for Storage**

**Operation Tool Detail**

**Operation: 8**

**Tool Number**

**Tooling Description**

**Std      Rem. Gas Nitre Pot Furnace**

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**Operation Procedure Notes      Operation: 8**

**Description**

**PROCESS RECORD - HEAT TREAT SPECIFICATION**

**MATERIAL & SPECIFICATION: C-1095 or C-1070**

**TEMPERATURE: 900 Degrees F**

**MAXIMUM LOAD: 1000 Pcs. - Approximately 1/3 Basket**

**TIME: 20 Min. Total**

**QUENCH: Water**

**REMARKS:**

**INSPECT FOR:**

**HEAT TREAT INSPECTION:**

**STANDARD PRACTICE NO:**

**HARDNESS LIMITS:**

**APPEARANCE OF PARTS: Black Color, Clean, Free from Salt, Well Oiled for Storage**

**Operation Step Detail**

**Operation: 12**

**Step**

**Operation / Step Description**

**Inspect for Rockwell Hardness**

**Operation Tool Detail**

**Operation: 12**

**Tool Number**

**Tooling Description**

**Std**

**Rockwell Hardness Tester**

**165**

**Spot Anvil**

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Operation Procedure Notes      Operation: 12

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness, Color, and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 164 - Spot Anvil #165

HARDNESS LIMITS: RC 37-42

APPEARANCE OF PARTS: Black Color, Clean, Free from Salt, Well Oiled for  
Storage

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