

TITLE: Trigger Link Pin XP100

Process Header

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Document ID: Trig Link Pin XP100	Remington Arms Company
Part Name: Trigger Link Pin XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 31-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
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31-Oct-1992	Retype Entire Process from 283475 - Replaces Old Paper Process - Chg. Description Op.#4	GLC 293288
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Process Approval List

Approved By:	Badge #:	Date:	Designation:
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Jacksora			
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Process General Notes

Notes:

Process Material

Part Number	Qty	Description
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15459	1	Trigger Link Pin
16505	1	Blank

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Process Routing

Dept	Oper	Operation Description	Part Numbers
8551	4	Degrease, Carbo-Nitride (Micro-Carb), Oil Quench, Degrease	15459
8551	8	Lindberg Draw	15459
9257	10	Inspect for Hardness	15459
8551	12	Torch Draw - Small End	15459
		To MRP Crib #29	15459

Operation Step Detail

Operation: 4

Step	Operation / Step Description
	Degrease, Carbo-Nitride (Micro-Carb), Oil Quench, Degrease

Operation Tool Detail

Operation: 4

Tool Number	Tooling Description
Std	Micro-Carb Furnace
Std	Basket - 12"x20"x2" Deep (Fine Mesh)

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TITLE: Trigger Link Pin XP100

Operation Procedure Notes Operation: 4

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: .75 Carbon Pot. @ 1650 Degrees F

MAXIMUM LOAD: 10000 Pcs. - 2 Baskets 5000 Pcs. per Basket

TIME: 1.5 Hrs. @ Temp.

QUENCH: Oil

REMARKS: Degreased

INSPECT FOR: File HARD to Insure Proper Quench

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free from Oil

Operation Step Detail Operation: 8

Step Operation / Step Description

Lindberg Draw

Operation Tool Detail Operation: 8

Tool Number Tooling Description

Std Electric Lindberg Furnace

Std Basket - 12"x20"x2" Deep (Fine Mesh)

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Operation Procedure Notes Operation: 8

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: 350 +/- 10 Degrees F

MAXIMUM LOAD: 10000 Pcs. - 2 Baskets 5000 Pcs. per Basket

TIME: 1 Hr. @ Temp.

QUENCH: Air Cool

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail Operation: 10

Step Operation / Step Description

Inspect for Hardness

Operation Tool Detail Operation: 10

Tool Number Tooling Description

Std Rockwell Hardness Tester

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Operation Procedure Notes Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: File Hard

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail

Operation: 12

Step

Operation / Step Description

Torch Draw - Small End

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Operation Procedure Notes

Operation: 12

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS: Torch Draw Small End - 1/8" Up

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

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