

*Relayed
Checked
8/20/46
OBSOLETE*

PROCESS RECORD

SAFETY

PART No. 17040

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____

DEPARTMENT

Re-type
 Check
 8/20/46

PART: **SAFETY**

PART No. **17040**

SEQUENCE OF OPERATIONS

NO.	OPER. NO.	OPERATION	DEPT.
1	1	Purchase Inspection	
2	2	High Temperature Cyanide Harden, Oil Quench, Wash and Dry	
3	3	Inspect for file hardness	
4	4	Black oxide coloring	
5	5	Process Control Inspection for color and oil	
		<u>To Part Store</u>	

COMPILED BY: _____

APPROVAL & DATE: _____

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

Safety 17040

Register Sheet Obscured 1-27-47

M H Smith

See Barrel Assembly 17000 for Signed Sheet

PART: SAFETY		PART No. 17040
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
OBSOLETE 10/28/46 JAN 27 1947	Changes in Operation #4 - Black Oxide coloring, in timing and temperature only.	
COMPILED BY:		APPROVAL & DATE: <i>WLF 10/29</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART 1 SAFETY

PART No. 17040

Relief
OBsolete
 10/29

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
10/26/46	changes in of 4 - Black oxide coating in timing and temperatures only

COMPILED BY:

APPROVAL & DATE:

REVISED AUG 27 1946

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

Retyped
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8/20/46

PART

SAFETY

PART No.

17040

REGISTER OF ALL PROCESS RECORD REVISIONS

OBSOLETE

DATE

DESCRIPTION OF CHANGE

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART No. 17040

MATERIAL PROCUREMENT

Detailed Description

Material Specification : #101-E

Size : .080" +.002"
 -.002" x 2-9/8" +.008"
 -.008"

Temper : Dead Soft

Finish : #2

Weight Per 100 : Calculated: 9.1 lbs. Measured:

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Identification of Material : Routing ticket to show actual material used.

Remarks: (1) This page is to be used for purchase of material by Remington for vendor.

APPROVAL & DATE: *R.H. Grace 3/15/46*

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Safety (1)	PART No. 17040
MATERIAL PROCUREMENT #855	
Detailed Description	
OBSOLETE Uses Required Per Assembly: 1 Material Specification : #101-E Material : AISI C-1020 or substitute C-1020 Size : .080" $\pm .002$" x 2-3/8" $\pm .008$" $-.002$ $-.008$ Condition : Cold Rolled Strip Temper : Dead Soft Edge : #3 Finish : #2 Weight Per 100 : Calculated: <u>9.1 lbs.</u> Measured: _____ Additional Uses of Material : Uses of Part : M/721 - All Calibers; M/722 - All Calibers Identification of Material : Routing ticket to show actual material used. Remarks: (1) This page is to be used for purchase of material by Remington for vendor.	
COMPILED BY: B. C. Andrews	APPROVAL & DATE: <i>R.H. Grace 3/15/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART: Safety (Purchased ready for assembly)

PART NO. 17040

MATERIAL PROCUREMENT - SEMI-FINISHED COMPONENT

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part

M/721 - All Calibers;
M/722 - All Calibers

Vendor

Material : AISI C-1022 or substitute
C-1020. Material supplied by
Remington. Packing slip to show
material used for each shipment.

Heat Treatment : None

Final Appearance : Parts to be bright, free of rust, oiled with
light rust proofing oil, (SAR-20 or equiv.)

Packaging : Purchase Order Number and quantity of pieces
to be shown on each container, the gross weight
of which must not exceed 200 lbs.

Acceptance Testing :

Inspection will be based on statistical sampling according to
Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments
will be accepted if the quality on each of the following items is
sufficient to keep within the "Average Outgoing Quality Limit" figure.

Inspection :

Spec No.	Type	Use	Allow.
1. Visual	Visual	Defects	5%
2. B-S0024-2	Adj. Snap Gage	Material Thickness	5%
3. B-S0022-2	Width Gage	Width Inside Hole	5%
4. Standard Finish	Surface Gage	Surface Finish	7%
5. A-S0023-2	Width Gage	Width Inside	5%
6. C-50	Dial Gage	Hole Location & Radii	5%
7. Standard Finish	Master Setting Gage	Surface Finish	7%
8. Standard Finish	Block		

Prostate

CONTROLLED BY:

W. J. Anderson

APPROVAL & DATE

W. J. Anderson

REMINGTON ARMS COMPANY, INC., MILWAUKEE, WIS.

PART: Safety (Purchased ready for DRILLING)		PART No. 17040	
5-21-46			
MATERIAL PROCUREMENT - SEMI FINISHED COMPONENT			
Detailed Description		REV. NO.	DATE
Remington Planning		1	9-23-46
Pieces Required Per Assembly: 1		2	2-7-47
Uses of Part : M/721 - All Calibers; M/722 - All Calibers			
Vendor			
Material : AISI C-1022 or substitute C-1020. Material supplied by Remington. Packing slip to show material used for each shipment.			
Heat Treatment : None			
Final Appearance : Parts to be bright, free of rust, oiled with light rust proofing oil, (SAE-20 or equiv.)			
Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.			
Acceptance Testing :			
Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.			
Inspection :			
<u>Gage No.</u>	<u>Type</u>	<u>Use</u>	<u>AOQL</u>
1.	Visual	Defects	5%
2. B-80024-Q	Adj. Snap Gage	Material Thickness	5%
3. B-80002-W	Ring Gage	Drill Hole	5%
4. B-80003-W	Ring Gage	Drill Hole	5%
3. A-50124	Width Gage	Width Inside	5%
4. A-50124	Master Gage	Hole Location & Radius	5%
4. Standard Finish Blocks	Visual	Surface Finish	7%

WPK

COMPILED BY: B.C. Andrews	APPROVAL & DATE: <i>[Signature]</i>
REMINGTON ARMS COMPANY, INC.	

REVISED OCT 2 - 1946

PART: Safety (Purchase ready for Heat Treatment)

PART NO. 17040

MATERIAL PROCUREMENT - SEMI FINISHED COMPONENT

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers;
M/722 - All Calibers

Vendor

Material : AISI C-1022 or substitute C-1020. Material supplied by Remington. Packing slip to show material used for each shipment.

Heat Treatment : None

Final Appearance : Parts to be bright, free of rust, oiled with light rust proofing oil, (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AQQL
1.	Visual	Defects	5%
2. B-80024-Q	Adj. Snap Gage	Material Thickness	5
3. B-80002-N	Plug Gage	Dia. Small Hole	5
4. B-80003-W	Plug Gage	Dia. Large Hole	5
5. A-50124	Width Gage	Width Inside	5
6. A-50511	Hole Locating & Radius Gage	Hole Location & Radii	5
A-50510	Master Setting Gage		
7. Standard Finish Blocks	Visual	Surface Finish	7%

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBsolete
 4-23-46 -
 2 typed
 12-23-46

PART: Safety (Purchase ready for Heat Treatment)

PART No. 17040

5/21/46

MATERIAL PROCUREMENT - SEMI FINISHED COMPONENT

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
 Uses of Part : M/721 - All Calibers;
 M/722 - All Calibers

Vendor

Material : AISI C-1022 or substitute
 C-1020. Material supplied by
 Remington. Packing slip to show material
 used for each shipment.

Heat Treatment : None

Final Appearance : Parts to be bright, free of rust, oiled
 with light rust proofing oil, (SAE-20
 or equiv.).

Packaging : Purchase Order Number and quantity of
 pieces to be shown on each container, the
 gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to
 Dodge and Romig Sampling Tables of Bell Telephone Company. Ship-
 ments will be accepted if the quality on each of the following
 gages is sufficient to keep within the "Average Outgoing Quality
 Limit" listed.

Inspection:

<u>Gage No.</u>	<u>Type</u>	<u>Use</u>	<u>AOQL</u>
1.	Visual	Defects	5%
2. B-80024-Q	Adj. Snap Gage	Material Thickness	5
3. B-80002-N	Plug Gage	Dia. Small Hole	5
4. B-80003-W	Plug Gage	Dia. Large Hole	5
5. A-50124	Width Gage	Width Inside	5
6. D-50511	Hole Locating & Radius Gage	Hole Location & Radii	5
A-50510	Master Setting Gage		
7. Standard Finish) Blocks)	Visual	Surface Finish	7%

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

M. J. Smith 5/27/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Safety (Purchase ready for Heat Treatment)

PART No. 17040

MATERIAL PROCUREMENT #1004 (Replaces #373)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : AISI C-1022 or substitute C-1020. Material supplied by Remington. Packing slip to show material used for each shipment.

Heat Treatment : None

Final Appearance : Parts to be bright, free of rust, oiled with light rust proofing oil, (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AOQL
1.	Visual	Defects	5%
2. B-80024-Q	Adj. Snap Gage	Material Thickness	5
3. B-80002-W	Plug Gage	Dia. Small Hole	5
4. B-80003-W	Plug Gage	Dia. Large Hole	5
5. B-50124	Width Gage	Width Inside	5
6. D-50511	Hole Locating & Radius Gage	Hole Location & Radii	5
A-50510	Master Setting Gage		

COMPILED BY: B. C. Andrews

APPROVAL & DATE

R. H. Grace 4/5/46

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

PART: Safety (Purchase ready for Heat Treatment)

PART No. 17040 \

OBsolete

MATERIAL PROCUREMENT #1004 (Replaces #373)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material* : AISI C-1022 or substitute C-1020. Material supplied by Remington. Packing slip to show material used for each shipment.

Heat Treatment* : None

Final Appearance : Parts to be bright, free of rust, oiled with light rust proofing oil, (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:*

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

<u>Gage No.</u>	<u>Type</u>	<u>Use</u>	<u>AOQL</u>
1.	Visual	Defects	5%
2. B-80024-Q	Adj. Snap Gage	Material Thickness	5
3. B-80002-N	Plug Gage	Dia. Small Hole	5
4. B-80003-W	Plug Gage	Dia. Large Hole	5
5. B-50124	Width Gage	Width Inside	5
6. D-50511	Hole Locating & Radius Gage	Hole Location & Radii	5
A-50510	Master Setting Gage		

*Revised 4/5/46

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

R. H. Grace 4/5/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART Safety (Purchase ready for ~~assembly~~ ^{Heat Treatment})

PART NO. 17040

MATERIAL PROCUREMENT ~~373~~ 1004 (Replaces 373)**OBsolete**

Detailed Description

Remington Planning

Pieces Required Per Assembly : 1

Uses of Part :

M/721 - All Calibers; M/722 - All Calibers

Vendor

Material *

AISI C-1022

or Substitute C-1020

Surface Finish

Flat Surface - Cold Finished Surface (Commercial)

Cross Section All shear marks to be removed

Shipments of parts from area indicated on sketch.

32 microinch finish. Other

areas - as sheared surface satisfactory.

Heat Treatment *

None

Case Depth

None

Final Color

Black Oxide Finish. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil.

Packaging

Ship in containers of 1,000 to 5,000 pieces.

Acceptance Testing

Purchase Order Number and quantity of pieces to be shown on each container. The gross weight of which must not exceed 200 lbs.

Acceptance Testing *

Inspection will be based on statistical sampling according to Dodge and Romney Sampling Tables of Bell Telephone Co. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average City Quality Limit" listed.

Inspection

Gage No.

Type

Use

AQL

1.

Visual

Defects

5%

2.

B-80024-Q

Adj. Snap Gage

Internal thickness

5

3.

B-80002-N

Plug Gage

Dia. Small Hole

5

4.

B-80003-W

Plug Gage

Dia. Large Hole

5

5.

A-50124

Width Gage

Width inside

5

6.

D-50511

Hole Location & Radius Gage

Hole Location & Radius

5

A-50510

Master Setting Gage

PART Safety (Purchase ready for Assembly)

PART NO. 17040

MATERIAL PROCUREMENT #373

Detailed Description

OBsolete

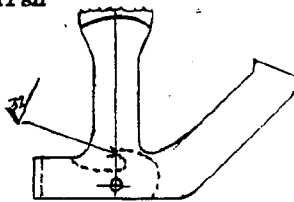
Remington Planning

Pieces Required Per Assembly : 1
Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : AISI C-1020

Surface Finish : Flat Surface - Cold Finished Surface (Commercial)
Cross Section - All shear marks to be removed from area indicated on sketch. 32 microinch finish. Other areas - as sheared surface satisfactory.



Heat Treatment : Case Harden

Case Depth : .005 - .008"

Final Color : Black Oxide Color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil.

Packaging : Ship in containers of 1,000 to 5,000 pieces.

Acceptance Gages:

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each shipment of parts.

Finish - Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.

Gaging -

COMPILED BY B. C. Andrews

APPROVAL & DATE

R.H. Grace 11/16/45

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART:

SAFETY

PART No.

17040

OPERATION

PURCHASE INSPECTION

OPER. No.:

1

PROCESS RECORD — ILLUSTRATION SKETCH

6

GAGE ±005

GAGE ±002

.1574
.1566 DIA.

GAGE ±001

MASTER

SLIDE 25°

.1262
.1254 DIA..282
.278 R.

COMPILED BY:

ES&M

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

E-212 ALT. D.

PART:

SAFETY

PART No.

17040

PURCHASE INSPECTION

OPER. No.:

PROCESS RECORD — ILLUSTRATION SKETCH

6

GAGE ±005

GAGE ±002

1574 DIA.
1566

GAGE ±001

MASTER

SLIDE 25°

1262 DIA.
1254282
278

925

915

235

233

110

108

433

431

130

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130

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COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. ILION, N.Y.

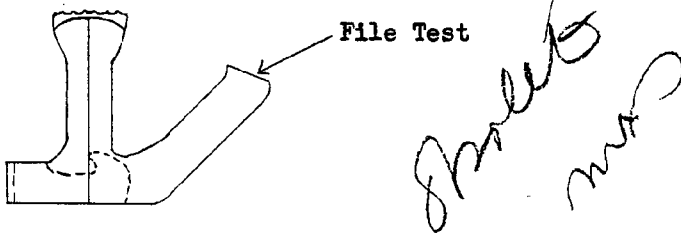
Retyped 10/1

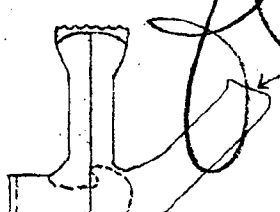
OBSELETE

PART: SAFETY		PART No. 17040		
OPERATION: Purchase Inspection		OPER. No.: 1		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
1.		Visual Inspect for Defects		
2.	Adj. Snap Gage B-80024Q	Check Material Thickness	.082	.078
3.	Plug Gage B-80002N	Check Small Hole	.1262	.1254
4.	Plug Gage B-80003W	Check Large Hole	.1574	.1566
5.	Width Gage A-50124	Check Inside Width	.145	.140
6.	Hole Location & Radius Gage Master Setting Gage A-50511 A-50510	(a) Place master setting gage on pins of hole location & radius gage. Hold master against stop pin & set dial to zero. Release slide to square up master and set indicators to zero. Adjust tolerance hands on indicator with right angle attachment to plus .005 - minus .005. Adjust tolerance hands on indicator with hole attachment to plus .001 - minus .001. Adjust tolerance hands on third indicator to plus .002 - minus .002. <i>Real gage</i> J.A.P. 9/13/46 Per L.T.M. (b) Remove master setting gage. Place part on two pins. Must go. Release slide to square up part. Use indicator to check location of bolt stop arm. ($\pm .005$) Use indicator to check sear restricting radius. ($\pm .002$) Use indicator to check sear cam point.	Plus .005 Minus .005 Plus .001 Minus .001 Plus .002 Minus .002 <i>Hold gage against stop pin</i> .925 .915 .282 .278 .110 .106	
COMPILED BY: ES&M		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

*Revised
1971*
OBsolete

PART: SAFETY			PART No. 17040	
OPERATION: Purchase Inspection			OPER. No.: 1	
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
1.		Visual Inspect for Defects		
2.	Adj. Snap Gage B-80024Q	Check Material Thickness	.082	.078
3.	Plug Gage B-800Q2N	Check Small Hole	.1262	.1254
4.	Plug Gage B-80003W	Check Large Hole	.1574	.1566
5.	Width Gage A-50124	Check Inside Width	.145	.140
6.	Hole Location & Radius Gage D-50511 Master Setting Gage A-50510	(a) Place master setting gage on pins of hole location & radius gage. Release slide to square up master and set indicators to zero. Adjust tolerance hands on indicator with right angle attachment to plus .005 - minus .005 Adjust tolerance hands on indicator with hole attachment to plus .001 - minus .001. Adjust tolerance hands on third indicator to plus .002 - minus .002 (b) Remove master setting gage. Place part on two pins. Must go. Release slide to square up part. Use indicator to check location of bolt stop arm. Use indicator to check sear restricting radius. Use indicator to check sear cam point	Plus .005 Plus .001 Plus .002 .925 .282 .110	Minus .005 Minus .001 Minus .002 .915 .278 .108
COMPILED BY: ES&M		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: Safety		PART No. 17040
OPERATION: High Temperature Cyanide Harden, Oil Quench, Wash and Dry		OPER. No.: 2
OBSOLETE MAR 4 1947 HEAT TREATMENT SPECIFICATION No. 923		
Equipment: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep		
Detailed Description		
Material Specification No.: 101-E		
Material	:	AISI C-1022 or substitute C-1020
Temperature	:	1575 - 1600°F.
Container	:	Basket - 7-1/2" dia. x 6" deep
Maximum Load - H. T.	:	125 pieces = approximately 1-1/4" depth in basket
Time	:	10 minutes at temperature
Quench	:	Oil
Standard Practice	:	#198
Maximum Load - Wash	:	125 pieces
Remarks:		
		
HEAT TREATMENT INSPECTION		
		Oper. No.: 3
Operation: Inspect for File Hardness		
Standard Practice	:	#163
Hardness Limits	:	File Hard
Appearance of Part	:	Steel grey color, clean, free of salt.
		Next Oper. No.: 4
COMPILED BY: B. C. Andrews		APPROVAL & DATE: <i>mks 11/6/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Safety		PART No. 17040
OPERATION: High Temperature Cyanide Harden, Oil Quench, Wash and Dry		OPER. No.: 2
HEAT TREATMENT SPECIFICATION No. 923		
Equipment: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep		
Detailed Description		
Material Specification No.: 101-E		
Material	:	AISI C-1022 or substitute C-1020
Temperature	:	1575 - 1600°F.
Container	:	Basket - 7-1/2" dia. x 6" deep
Maximum Load - H. T.	:	125 pieces = approximately 1-1/4" depth in basket
Time	:	10 minutes at temperature
Quench	:	Oil
Standard Practice	:	#198
Maximum Load - Wash	:	125 pieces
Remarks:		
 File Test		
HEAT TREATMENT INSPECTION		
Operation: Inspect for File Hardness		
Standard Practice	:	#163
Hardness Limits	:	File Hard
Appearance of Part	:	Steel grey color, clean, free of salt.
		Next Oper. No.: 4
COMPILED BY: B. C. Andrews		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Safety		PART NO. 17040	
OPERATION: Bluing Coloring		OPER. No.: 4	
HEAT TREATMENT SPECIFICATION No. 924			
Equipment: Best Standard Practice Operation Description: Clean, Rinse, Pickle, Rinse, Color Rinse, Oil, Dry and Oil. Detailed Description Standard Practice : #223 Container : Mesh basket - 8" dia. x 12" deep Maximum Load Size : 500 pieces (approx.). Electro Clean : Boughto Clean #174; 200-212°F.; 10 min. Cold Rinse : Dip in and out of clean water 2 times. Drain. Pickle : 50:50 Commercial Muratic; 3 to 10 min. Shake at least 3 times. Cold Rinse : Dip in and out of clean cold water 2 times. Drain. Clean : Dip in and out of Electro Cleaner 2 times. No current. Drain. Cold Rinse : Dip in and out of clean boiling water 2 times. Drain. Color : 30 to 40 min @ 300-305°F.; Capacity: 4 racks. Drain. Cold Rinse : Dip in and out of clean water 10 minutes. Drain. Soluble Oil : Code No. A60; Concentration: 5% Oil @ 180-200°F. for 10 to 2 min. Dry : Place on steam table for 5 to 20 min. Final Oil : Dip in and out of A-60 (Concentrated) oil. Drain.			
HEAT TREATMENT INSPECTION		Oper. No.: 5	
Operation: Process Control Inspection for Color and Oil			
Standard Practice : #165			
Appearance of Part : Uniform black color, clean, free of rust, well oiled for storage.			
COMPILED BY: B. C. Andrews		APPROVAL & DATE: <i>M/K 10/29</i>	
REMINGTON ARMS COMPANY, INC. MILWAUKEE, WIS.			

PART: Safety		PART No. 17040
OPERATION: Black Oxide Coloring		OPER. No.: 4
OBSOLETE MAR 3 1945 HEAT TREATMENT SPECIFICATION No. 924		
Equipment: See Standard Practice Operation Description: Clean, Rinse, Pickle, Rinse, Color Rinse; Oil, Dry and Oil.		
Detailed Description		
Standard Practice	: #223	
Container	: Mesh basket - 8" dia. x 12" deep	
Maximum Load Size	: 500 pieces (approx.).	
Electro Clean	: Boughto Clean #174; 200-212°F.; 10 min.	
Cold Rinse	: Dip in and out of clean water 2 times. Drain	
Pickle	: 50:50 Commercial Muratic; 3 to 10 min. Shake at least 3 times.	
Cold Rinse	: Dip in and out of clean cold water 2 times. Drain.	
Clean	: Dip in and out of Electro Cleaner 2 times. No current. Drain.	
Cold Hot Rinse	: Dip in and out of clean water 2 times. Drain.	
Color	: 30 to 60 min. @ 300-305°F.; Capacity: 4 racks. Drain.	
Cold Rinse	: Set in cold running water 5 to 10 minutes. Drain	
Soluble Oil	: Code No. A50; Concentration: 8% Oil @ 180-200°F. for 10 to 2 min.	
Final Oil	: Dip in and out of A-60 (Concentrated) oil. Drain.	
HEAT TREATMENT INSPECTION		Oper. No.: 5
Operation: Process Control Inspection for Color and Oil		
Standard Practice : #165		
Appearance of Part : Uniform black color, clean, free of rust, well oiled for storage.		
COMPILED BY: B. C. Andrews		APPROVAL & DATE: <i>Mike 10/29</i>
		To Part Stores.
REVISED OCT 31 1945		

PART: Safety

PART No. 17040

OPERATION: Black Oxide Coloring

OPER. No.: 4

HEAT TREATMENT SPECIFICATION No. 924

Equipment: See Standard Practice

Operation Description: Clean, Rinse, Pickle, Rinse, Color Rinse, Oil, ~~Rinse~~ and Oil.

Detailed Description

Standard Practice : #223

Container : Mesh basket - 8" dia. x 12" deep

Maximum Load Size : 500 pieces (approx.).

Electro Clean : Houghto Clean #174; 200-212°F.; 1/2 min.

~~Cold~~ Rinse : Dip in and out of clean water @ ~~180-200~~ 180°F. 2 times. Drain.

Pickle : 50:50 Commercial Muriatic; ^{3 TO 10} 1 1/2 to 2 min. SHAKE AT LEAST 3 TIMES

Cold Rinse : Dip in and out of clean cold water 2 times. Drain.

Clean : Dip in and out of Electro Cleaner 2 times. No current. Drain.

~~Cold~~ Rinse : Dip in and out of clean ~~running~~ water 2 times. Drain.

Color : ^{30 TO 60} 20 minutes @ ^{300 TO 305} 225-230°F.; Capacity: 2 racks. Drain.

Cold Rinse : ^{SET IN} ~~Dip in and out of~~ cold running water ^{5 TO 10 MIN.} 4 times. Drain.

Soluble Oil : Code No. A60; Concentration: 8% Oil @ 180-200°F. for ¹⁰⁻²⁰ 20 min.

~~Rinse~~ : ~~Place on steam table for 5 to 20 min.~~

Final Oil : Dip in and out of ^{A-60 (CONCENTRATED) OIL} ~~oil~~ with ~~1% oil~~ added. Drain.

HEAT TREATMENT INSPECTION

Oper. No.: 5

Operation: Process Control Inspection for Color and Oil

Standard Practice : #165

Appearance of Part : Uniform black color, clean, free of rust, well oiled for storage.

To Part Stores.

COMPILED BY: B. C. Andrews

APPROVAL: DATE

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

PART: Safety

PART No. 17040

OPERATION: Black Oxide Coloring

OPER. No.: 4

HEAT TREATMENT SPECIFICATION No. 924

Equipment: See Standard Practice

Operation Description: Clean, Rinse, Pickle, Rinse, Color Rinse, Oil, Dry and Oil.

Detailed Description

Standard Practice : #223

Container : Mesh basket - 8" dia. x 12" deep

Maximum Load Size : 500 pieces (approx.).

Electro Clean : Houghto Clean #174; 200-212°F.; 5 min.

Warm Rinse : Dip in and out of clean water @ 120-150°F. 2 times. Drain.

Pickle : 50:50 Commercial Muriatic; 1/2 to 3 min.

Cold Rinse : Dip in and out of clean cold water 2 times. Drain.

Clean : Dip in and out of Electro Cleaner 2 times. No current. Drain.

Hot Rinse : Dip in and out of clean boiling water 2 times. Drain.

Color : 20 minutes @ 285-300°F.; Capacity: 2 racks. Drain.

Cold Rinse : Dip in and out of cold running water 4 times. Drain.

Soluble Oil : Code No. A60; Concentration: 8% Oil @ 180-200°F. for 10 min.

Dry : Place on steam table for 5 to 20 min.

Final Oil : Dip in and out of A-5 oil with 1% Oleic Acid added. Drain.

HEAT TREATMENT INSPECTION

Oper. No.: 5

Operation: Process Control Inspection for Color and Oil

Standard Practice : #165

Appearance of Part : Uniform black color, clean, free of rust, well oiled for storage.

To Part Stores.

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Name SafetyComponent No. 17040Operation Sequence

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 10 1947
Date

M H SMITH
Process Engineer

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Name SafetyComponent No. 17040Operation Line Shut

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 10 1947
Date

M H SMITH
Process Engineer

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Name SafetyComponent No. 17040Operation mat. Proc - semi

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 10 1947

Date

MH Smith
Process Engineer

3-11

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Name SafetyComponent No. 17040Operation mat. Proc - Run

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 10 1947

Date

MH Smith
Process Engineer

3-11

PROCESS RECORDS TURNED OVER TO PLANTModel 121Component Name SafetyComponent No. 17040Operation Nitre Black

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 10 1947
Date

M.H. Smith
Process Engineer
3-11

FORM RT-118

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Name SafetyComponent No. 17040Operation Cyanide Horden - op # 2

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 10 1947
Date

M.H. Smith
Process Engineer
3-11

Retyped
checked 8/20/46
OBSOLETE

PROCESS RECORD

BOLT STOP PIN
TRIGGER PIN
SEAR PIN

PART No. 17037 W, U, V

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____
DEPARTMENT

PART: <i>BOLT STOP PIN</i> <i>TRIGGER PIN</i> <i>SEAR PIN</i>		PART No. <i>17037W</i> <i>17037U</i> <i>17037V</i>	
SEQUENCE OF OPERATIONS			
Seq. No.	OPER. NO.	OPERATION	DEPT.
		<i>MATERIAL PROCUREMENT</i>	
<i>2</i>	<i>1</i>	<i>PURCHASE INSPECTION</i>	
<i>3</i>		<i>TRANSFER TO PART STORES</i>	
COMPILED BY: <i>M. H. J.</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

H. H. SULLIVAN, INC.

PART: Bolt Stop Pin } Trigger Pin } (Purchase ready for Assembly) Sear Pin }		PART No. 17037W 17037U 17037V
MATERIAL PROCUREMENT <i>Finished Component</i>		
Detail Description		
Remington Planning		
Uses of Part and Pieces Required Per Assembly: 17037W - Bolt Stop Pin - (1) 17037U - Trigger Pin - (1) 17037V - Sear Pin - (1)		
Minimum Order Quantity : 25,000 pieces		
Vendor		
Material	: SAE 52100	
Surface Finish	: Smooth surface <i>Packaging Slip</i> 16 microinch ground finish or finer	
Heat Treatment	: Harden and Temper	
Hardness	: Rockwell C50-45	
Final Color	: Black Oxide color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equivalent) oil.	
Packaging	: Ship in containers of 5,000 - 10,000 pieces.	
Acceptance Gages	Length - Adj. Snap Ga. -	17037W B-80012R 17037U B-80024U 17037V B-80024V
	Diameter - Adj. Dial Snap Ga. Master Dwg.	B-80035V B-80039V
Acceptance Testing		
Chemical - Signed statement of compliance to accompany each shipment		
Hardness - This pin is too small to permit accurate hardness testing. Thirty-five pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 50° before fracture. If no more than 4 of the 50 pins fail to meet this requirement, the lot will be accepted.		
Finish - Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.		
Gaging - A random sample of 50 pieces will be selected for gaging. If no more than 4 pieces fail to meet dimensions specified on drawing, lot will be accepted.		
COMPILED BY: B.G. Andrews		APPROVAL & DATE: <i>M/S 4/6/10</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

OBSOLETE

PART: Bolt Stop Pin Trigger Pin) Sear Pin) (Purchase ready for Assembly)	PART No. 17037W 17037U 17037V
MATERIAL PROCUREMENT #1002 (Replaces #794) 4-2-46	
Detail Description	
OBSOLETE Remington Planning Uses of Part and Pieces Required Per Assembly: 17037W - Bolt Stop Pin - (1) 17037U - Trigger Pin - (1) 17037V - Sear Pin - (1) Minimum Order Quantity : 25,000 pieces	
Vendor	
Material	: SAE 52100
Surface Finish	: Smooth surface. 16 microinch ground finish or finer.
Heat Treatment	: Harden and Temper
Hardness	: Rockwell C30-45
Final Color	: Black Oxide color. Parts to be free of rust, oiled for rust protection with light (SAE-20 ot equivalent) oil.
Packaging	: Ship in containers of 5,000 - 10,000 pieces.
Acceptance Gages: Length - Adj. Snap Ga. -	17037W B-80012R 17037U B-80024U 17037V B-80024T
	Diameter - Adj. Dial Snap Ga. B-80035V Master Dwg. B-80039U
Acceptance Testing:	
Chemical	- Signed statement of analysis to accompany each shipment of parts.
Hardness	- This pin is too small to permit accurate hardness testing. Thirty-six pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 30° before fracture. If no more than 4 of the 36 pins fail to meet this requirement, the lot will be accepted.
Finish	- Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.
Gaging	- A random sample of 36 pieces will be selected for gaging. If no more than 4 pieces fail to meet dimensions specified on drawing, lot will be accepted.
COMPILED BY: B.C.Andrews	APPROVAL & DATE: <i>WHS 7/6/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART Bolt Stop Pin
Trigger Pin (Purchase ready for
Sear Pin Assembly)

PART NO. 17037W
17037U
17037V

MATERIAL PROCUREMENT

(Replaces #398) 794

Detailed Description

Remington Planning

Uses of Part and

Pieces Required Per Assembly: 17037W - Bolt Stop Pin - (1)
17037U - Trigger Pin - (1)
17037V - Sear Pin - (1)

Minimum Order Quantity: 25,000 pieces

Vendor

Material: SAE 52100

Surface Finish: Smooth surface. 16 microinch ground finish or finer.

Heat Treatment: Harden and Temper

Hardness: Rockwell C30-45

Final Color: Black Oxide color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equivalent) oil.

Packaging: Ship in containers of 5,000 - 10,000 pieces.

Acceptance Gages: Length - Adj. Snap Ga. - 17037W B-80012R
17037U B-80024U
17037V B-80024T

Diameter - Adj. Dial Snap Ga. B-80035X ✓
Master Dwg. B-80039U

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each shipment of parts.

Hardness - This pin is too small to permit accurate hardness testing. Thirty-six pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 30° before fracture. If no more than 4 of the 36 pins fail to meet this requirement, the lot will be accepted.

Finish - Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.

Gaging - A random sample of 36 pieces will be selected for gaging. If no more than 4 pieces fail to meet dimensions specified on drawing, lot will be accepted.

COMPILED BY B. C. Andrews

APPROVAL & DATE

MKS 2/22/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBSOLETE

PART	Bolt Stop Pin Trigger Pin * Sear Pin *	PART NO.	17037W 17037U * 17037V *
MATERIAL PROCUREMENT #398 *			
Detailed Description			
Pieces Required per Assembly	: 1 of each *		
Material Specification	: 118		
Material	: 1095 Drill Rod		
Size	: .1250 + .0000" rd. - Approx. 12' lengths - .0004"		
Condition	: Ground		
Weight per 100	: Calculated: .316 lbs. W Measured: _____ .133 lbs. U* .262 lbs. V*		
Additional Uses of Material	:		
Uses of Part	: M/721 - All calibers; M/722 - All calibers		
Identification of Material	: Routing card to be marked Mat. Spec. #118		
Remarks:	(1) This material is to be boxed. Maximum weight per box - 200 lbs.		
* Revised 11/21/45			
COMPILED BY B. C. Andrews		APPROVAL & DATE R. H. Grace 10/5/45 M. Williams 11/21/45	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART : Bolt-Stop Pin <i>Trigger Pin</i> <i>Sear Pin</i>		PART NO. 170374 <i>U</i> 174374 <i>U</i> 170374 <i>U</i>	
MATERIAL PROCUREMENT #318 <i>RV8</i>			
Detailed Description <i>398</i>			
Pieces Required Per Assembly	:	1 - <i>just</i>	<i>RV8</i>
Material Specification	:	118	<i>RV8</i>
Material	:	1095 Drill Rod	
Size	:	.1250 $\pm$.0000" rd. - Approx. 12' lengths -.0004"	
Condition	:	Ground	
Weight Per 100	:	Calculated: .316 lbs.	Measured: <i>RV8</i>
Additional Uses of Material	:	M/721 - 170374 170374 <i>RV8</i>	M/722 - 170374 170374 <i>RV8</i>
Uses of Part	:	M/721 - All calibers; M/722 - All calibers	
Identification of Material	:	Routing card to be marked Mat. Spec. #118	
Remarks: (1) This material is to be boxed. Maximum weight per box - 200 lbs.			
COMPILED BY : B. C. Andrews		APPROVAL & DATE: <i>W. H. Lacy 10/15/45</i>	
REMINGTON ARMS COMPANY, INC., MILTON, N. C.			

PART: Sear Pin	PART NO. 17037V
OBSOLETE	
MATERIAL PROCUREMENT #319	
Detailed Description	
Pieces Required Per Assembly	: 1
Material Specification	: 118
Material	: 1095 Drill Rod
Size	: .1250 +.0000" -.0004" rd. Bar Stock - Approx. 12' lengths
Condition	: Ground
Weight Per 100	: Calculated: .262 lbs. Measured: _____
Additional Uses of Material	: M/721 - 17037W M/722 - 17037W 17037U 17037U
Uses of Part	: M/721 - All calibers; M/722 - All calibers
Identification of Material	: Routing ticket to be marked Mat. Spec. #118
Remarks:	(1) This material is to be boxed. Maximum weight per box - 200 lbs.
B.H.A.	
COMPILED BY: B. C. Andrews	APPROVAL & DATE: A.H. Hase 10/5/45
REMINGTON-UMC COMPANY, INC., MILWAUKEE, WIS.	

PART NO. 17037V

MATERIAL PROCUREMENT #319

Detailed Description

Pieces Required Per Assembly : 1

Material Specification : 118

Material : 1095 Drill Rod

Size : .1250 +.0000"
 -.0004" rd. Bar Stock - Approx. 12' lengths

Condition : Ground

Weight Per 100 : Calculated: .262 lbs. Measured: _____

Additional Uses of Material : M/721 - 17037W M/722 - 17037W
 17037U 17037U

Uses of Part : M/721 - All calibers; M/722 - All calibers

Identification of Material : Routing ticket to be marked Mat. Spec. #118

Remarks: (1) This material is to be boxed. Maximum weight per box - 200 lbs.

COMPILED BY : B. C. Andrews

APPROVAL & DATE

REMINGTON ARMS COMPANY, INC., MILTON, N.Y.

PART : Trigger Pin	PART NO. 17037U
OBSOLETE MATERIAL PROCUREMENT #320	
	Detailed Description
Pieces Required Per Assembly :	1
Material Specification :	118
Material :	1095 Drill Rod
Size :	.1250 ^{+ .0000"} _{- .0004"} rd. Approx. 12' lengths
Condition :	Ground
Weight Per 100 :	Calculated: <u>.133 lbs.</u> Measured: _____
Additional Uses of Material :	M/721 - 17037W M/722 - 17037W 17037V 17037V
Uses of Part :	M/721 - All calibers; M/722 - All calibers
Identification of Material :	Routing ticket to be marked Mat. Spec. #118
Remarks:	(1) This material is to be boxed. Maximum weight per box - 200 lbs.
<i>Cancel AHG</i> 	
COMPILED BY : B. C. Andrews	APPROVAL & DATE : <i>R.H. [unclear] 12/5/45</i>
REMINGTON ARMS COMPANY, INC. ILION, N.Y.	

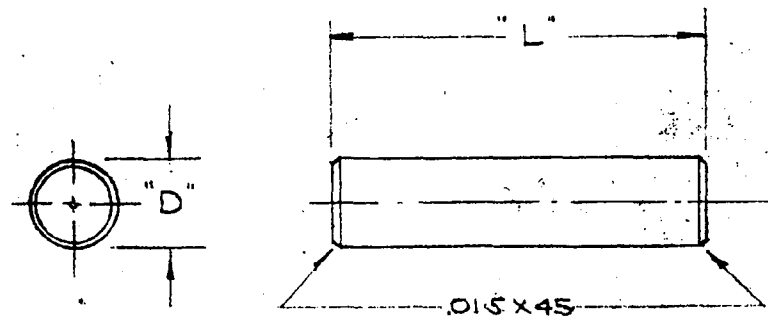
Revised 8/20/46
OBsolete

PART NO. 17037 W 17037 U 17037 V	
PART NO. 17037 W 17037 U 17037 V	OPERATION: FINAL PURCHASE INSPECTION
OPER. No.: ① type	

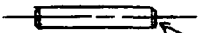
PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Visual		Inspect for Defects and Taper		
Adj. Snap Ga.				
A-17037 U	B-80024 U	"L" length U .340	+ .003	-.001
A-17037 V	B-80024 T	" " V .715	+ .005	-.005
A-17037 W	B-80012 R	" " W .865	+ .005	-.005
Adj. Dial Snap				
A-17037 U)	B-80035 V	"D" diameter U)	+.0001	-.0001
A-17037 V)		" " V) .1249		
A-17037 W)		" " W)		
Master	B80039 U			

SKETCH



COMPILED BY: 1-21-46 E. K. Wheat	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC. ILION, N. Y.	

PART: Bolt Stop Pin Trigger Pin Sear Pin	PART No. 17037W 17037U 17037V
OPERATION: Low Temperature Neutral Salt Harden, Oil Quench, Wash and Dry	OPER. No.:
HEAT TREAT SPECIFICATION #392	
EQUIPMENT: Remington Gas-fired Pot Furnace - 12" dia. x 12" deep DETAILED DESCRIPTION MATERIAL SPECIFICATION No.: 118 MATERIAL: 1095 Drill Rod TEMPERATURE: 1425 - 1450°F. CONTAINER: Basket - 7-1/2" dia. x 6" deep MAXIMUM LOAD: - H. T.: 2500 pieces = approximately 1-1/2" depth in basket TIME: 10 minutes at temperature QUENCH: Oil Max. Load - Wash: 2500 pieces STANDARD PRACTICE: #199 REMARKS:  File Test	
HEAT TREATMENT INSPECTION	
Operation: Inspect for File Hardness Standard Practice: #163 Hardness Limits: File Hard Appearance of Part: Steel grey color, clean, free of salt.	
Next Oper. No.:	
COMPILED BY: B. C. Andrews	APPROVAL & DATE: <i>R.H. Grace</i> 11/23/15
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

OBSOLETE

PART: Bolt Stop Pin Trigger Pin Sear Pin	PART No. 17037W 17037U 17037V
OPERATION: Nitre Black, Water Quench, Wash, Dry and Oil for storage.	OPER. No.:
HEAT TREAT SPECIFICATION #399	
EQUIPMENT: Remington Gas-fired Nitre Pot Furnace #8 - 13-3/4" x 37-1/2" x 11"	
DETAILED DESCRIPTION	
MATERIAL SPECIFICATION No.: 118	
MATERIAL: 1095 Drill Rod	
TEMPERATURE: 900 - 950°F.	
CONTAINER: Wire mesh basket - 19" x 12" x 3"	
MAXIMUM LOAD: 5,000 pieces = approximately 1/4 basket	
TIME: 10 minutes total	
QUENCH: Water	
STANDARD PRACTICE: #200	
REMARKS:	
	
HEAT TREATMENT INSPECTION	
Operation: Inspect for Color and Oil	
Standard Practice: #165	
Appearance of Part: Black color, clean, free of salt, well oiled for storage.	
To Part Stores:	
COMPILED BY: B. C. Andrews	APPROVAL & DATE: <i>R. H. Chase</i> 11/23/45
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PROCESS RECORDS TURNED OVER TO PLANT

Model 721
Component Bolt Stop Pin } 17037 u, v, w
Trigger Pin
Lock Pin
Operation Entire Process

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

10/25/46
Date

R. W. Schward
Process Engineer

PART: FIRING PIN HEAD		PART NO. 17023
SEQUENCE OF OPERATIONS		
OPER. NO.	OPERATION	DEPT.
1	Inspect Extruded Stock (17113)	
1	Screw Machine	
2	Clean	
21	Strip Burrs	
3	Tumble to Remove Burrs	
5	Drill and Ream Small Hole	
7	Grind .095 Radius on END	
11	Clean and Dry	
13	High Temperature, Cyanide Harden, Oil Quench, Wash and Dry.	
17	Inspect for File Hardness	
6	Burr Cut-Off	
19	Ball Burnish	
COMPILED BY: J. Travettino		APPROVAL & DATE: 2/17/77
REVISION: 1		REVISION: 1
REMINGTON-ARMSCOMPANY, INC. MILWAUKEE, WIS.		

PART: FIRING PIN HEAD		PART No. 17023
SEQUENCE OF OPERATIONS		
OPER. NO.	OPERATION	DEPT.
1-1	Inspect Extruded Stock (17113)	
1	Screw Machine	
2	Clean	
21	Strip Burrs	
3	Tumble to Remove Burrs	
5	Drill and Ream Small Hole	
7	Grind .095 Radius	
11	Clean and Dry	
15	High Temperature, Cyanide Harden, Oil Quench, Wash and Dry.	
17	Inspect for File Hardness	
6	Burr Cut-Off	
19	Ball Burnish	
COMPILED BY: A.Travostino 9/26/48		APPROVAL & DATE: 2/11/7
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

H. H. SULLIVAN, INC.

PART: FIRING PIN HEAD		PART No. 17023	
SEQUENCE OF OPERATIONS			
NO.	OPER. NO.	OPERATION	DEPT.
	1-1	Inspect Extruded Stock (17113)	
2	1	Screw Machine	
3	2	Clean	
4	21	Strip Burrs	
5	3	Tumble to Remove Burrs	
6	5	Drill and Ream Small Hole	
7	6	Burr Cut-off	
7	7	Grind .095 Radius	
8	9	Scrape and Buffing Surface	
8	11	Clean and Dry	
9	15	High Temperature, Cyanide Hardening, Oil Quench, Wash and Dry	
10	17	Inspect for File Hardness	
11	19	Ball Burnish	
12			
COMPILED BY: A. Travostino 9/26/46		APPROVAL & DATE: <i>MVS 10/1/46</i>	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.			
REVISED OCT 7 - 1946			

PART: FIRING PIN HEAD		PART No. 17023	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1-1	Inspect Extruded Stock (17113)	
2	1	Screw Machine	
3	2	Clean	
4	21	Strip Burrs	
5	3	Tumble to Remove Burrs	
6	5	Drill and Ream Small Hole	
7	6	Burr Cut-off	
8	7	Grind .095 Radius	
9	9	Serrate Cocking Surface	
10	11	Clean and Dry	
11	15	High Temperature, Cyanide Harden, Oil Quench, Wash and Dry	
12	17	Inspect for File Hardness	
13	19	Ball Burnish	
COMPILED BY: A. Travostino 9/26/46		APPROVAL & DATE: <i>M/K 10/1/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

H. H. SULLIVAN, INC.

PART. SIPPING PIN HEAD

PART No. 17023

SEQUENCE OF OPERATIONS

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1-1	Inspect Extruded Stock (17113)	
2	1	Screw Machine	
3	2	Clean	
4	21	Strip Burrs	
5	3	Tumble to Remove Burrs	
6	5	Drill and Ream Small Hole	
7	6	Burr cut-off	
8	7	Grind .095 Radius	
9	9	Serrate Cocking Surface	
10	11	Clean and Dry	
11	15	High Temperature, Cyanide Harden, Oil Quench, Wash and Dry	
12	17	Inspect for File Hardness	
13	19	Ball Burnish	

COMPILED BY: A. Travostino

APPROVAL & DATE:

8/30/46

REMINGTON ARMS COMPANY, INC.

REVISED AUG 26 1946

PART: FIRING PIN HEAD		PART No. B-17023	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1-1	Inspect Extruded Stock (17113)	
2	1	Screw Machine	
3	2	Clean	
4	3	Tumble to Remove Burrs	
5	5	Drill and Ream Small Hole	
6	7	Grind .095 Radius	
7	9	Serrate Cocking Surface	
8	11	Clean and Dry	
9	15	High Temperature, Cyanide Harden, Oil Quench, Wash and Dry	
10	17	Inspect for File Hardness	
11	19	Ball Burnish	
COMPILED BY: A. Travestino		APPROVAL & DATE: <i>MKS 8/20/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FIRING PIN HEAD		PART No. B-17023	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1-1	<i>Extended</i> Inspect From Stock (17113)	
2	1	Screw Machine	
3	2	Clean	
4	3	<i>Butt Tumble to Remove Burrs</i>	
5	5	Drill and Ream Small Hole	
6	7	Grind .095 Radius	
7	9	Serrate Cocking Surface	
8	11	Clean and Dry	
9	15	Heat Treat <i>High Temperature, Cyanide Harden,</i>	
10	17	<i>Oil Quench, Wash and Dry.</i>	
11	19	Heat Treat Inspection <i>Inspect for File Hardness</i> Ball Burnish	
<i>Retyped 7/31</i> OBsolete			
COMPILED BY: A. Travestino		APPROVAL & DATE: <i>[Signature]</i>	
REMINGTON-ARMS COMPANY, SINGAPORE, SINGAPORE			

PART:		FIRING PIN HEAD		PART No.	B-17023
SEQUENCE OF OPERATIONS					
SEQ. NO.	OPER. NO.	OPERATION			DEPT.
	1-1	Inspect Form Stock			
	1	Screw Machine			
	2	Clean			
	3	Burr			
	5	Drill and Ream Small Hole			
	7	Grind .095 Radius			
	9	Serrate Cocking Surface			
	11	Clean and Dry			
	15	Heat Treat			
	17	Heat Treat Inspection			
	19	Ball Burnish			
COMPILED BY:		APPROVAL & DATE:			
A. Travostino		wfs 7/2/46			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

PART		DATE	
KINZ V. REMINGTON		10/27/23	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
	1	SCREW MACHINE	
	2	CLEAN	
	3	BURR	
	5	DRILL AND REAM SMALL HOLE	
	7	GRIND .095 RADIUS	
	9	SEPARATE COATING SURFACE	
	11	CLEAN AND DRY	
	13	INSPECT	
	15	HEAT TREAT	
	17	HEAT TREAT INSPECT	
	19	DRILL BURNISH	

OBSOLETE

COMPLETED BY	APPROVAL & DATE

REMINGTON ARMS COMPANY, YONKON, N. Y.

PART: FIRING PIN HEAD		PART No. 17023
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
2-25-46	Screw Machine Process Changed	
4-5-46	Added Operation #19 Ball Burnish	
4-5-46	Oper. 7 Changed Locating Pt for Sanding Fixture	
4-5-46	Add dimension .300-.320 on Oper. 1	
4-9-46	Added Oper. 1-1 Inspect Form Stock	
7-12-46	Removed Operation 13	
9/9/46	Operation #1 - Step 5 - Changed Tool Holder No. B-90076-U to B-90076-T	
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: <i>ms 7/18/06</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

FIRING PIN HEAD	
REGISTER OF ALL PROCESS RECORD REVISIONS	
DATE	DESCRIPTION OF CHANGE
3-25-46	Screw Machine Process Changed #83
4-5-46	Added Operation #19 Ball Finish
4-5-46	Oper 7 Changed Location Pt for Sanding Process
4-5-46	Add dimension 3.00 - 3.20 on Oper 1
OBSOLETE	
COMPILED BY:	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC. ILION, N. Y.	

PART: FIRING PIN HEAD

PART No.

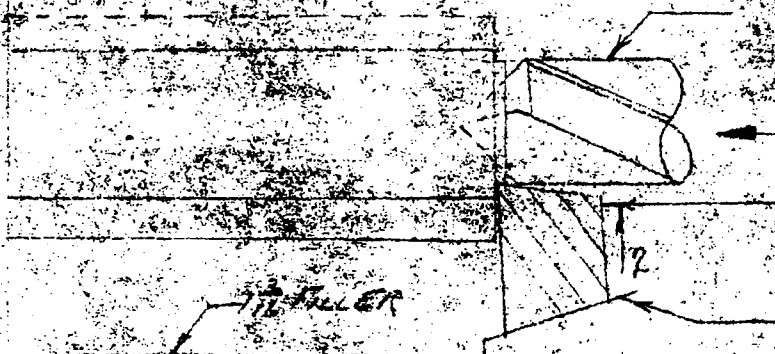
17023

OPERATION: SCREW MACHINING

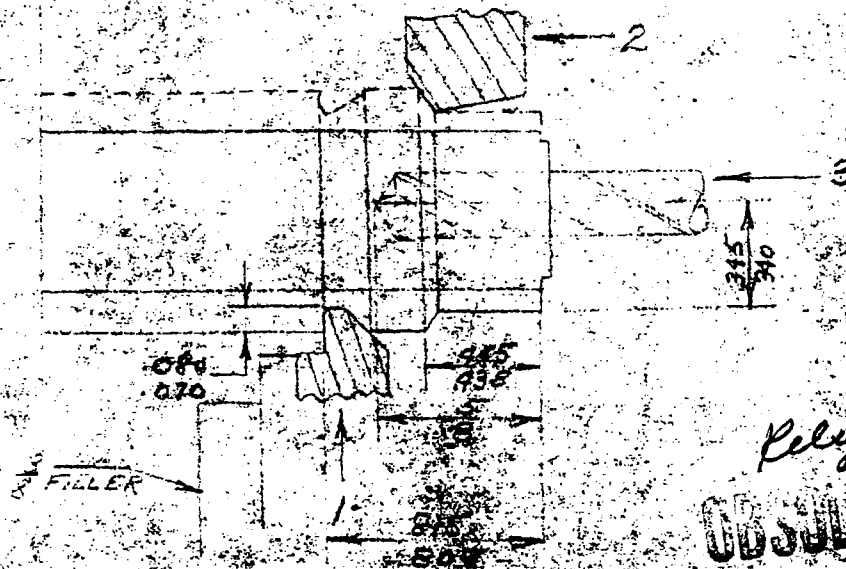
OPER. No. 1

PROCESS RECORD - ILLUSTRATION SKETCH

SPINDLE 1



SPINDLE 2



Relayed 7/31
OBSOLETE

COMPILED BY

BOYLE

REVIEWED BY

BOYLE

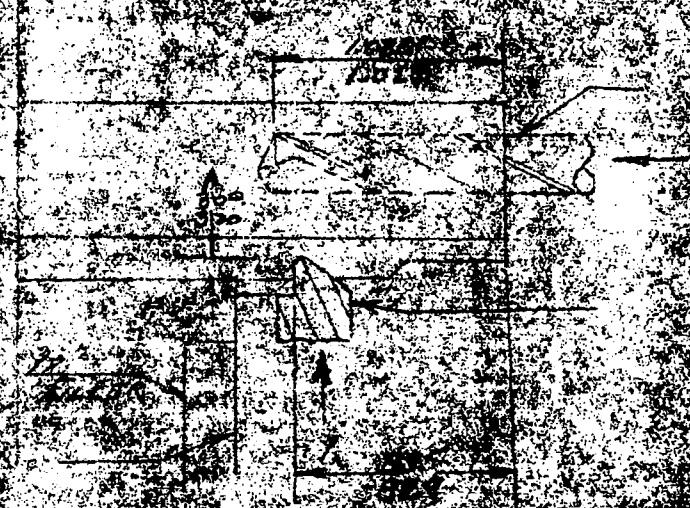
REMINGTON ARMS COMPANY, BRIDGE PLAZA, NEW YORK

Franklin D. Roosevelt

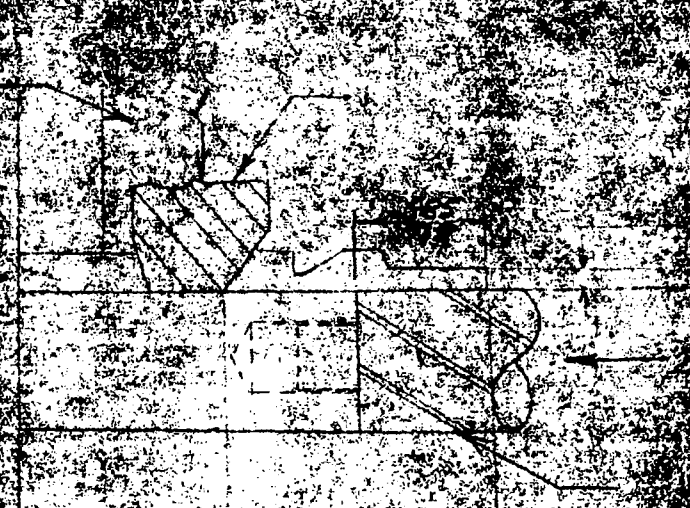
OPERATION: 15-0-0 Machine

PROCESS RECORD - ILLUSTRATION SKETCH

SAMPLE 3



SAMPLE 3



OBSOLETE

1:100
1:100

PART: FIRING PIN HEAD

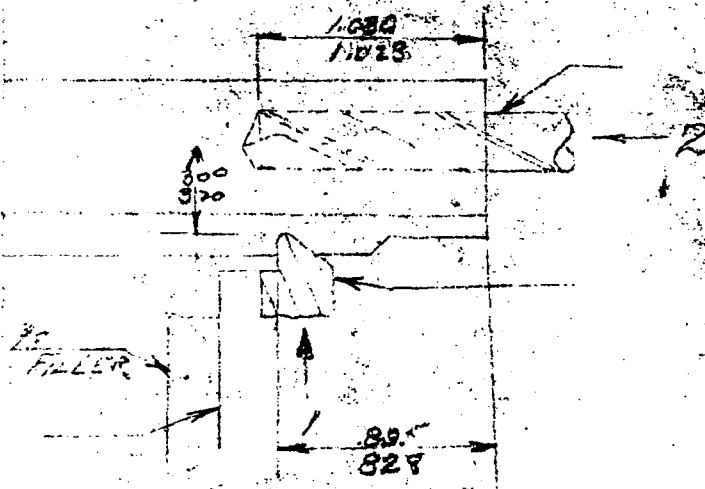
PART No: 117023

OPERATION: SCREW MACHINE

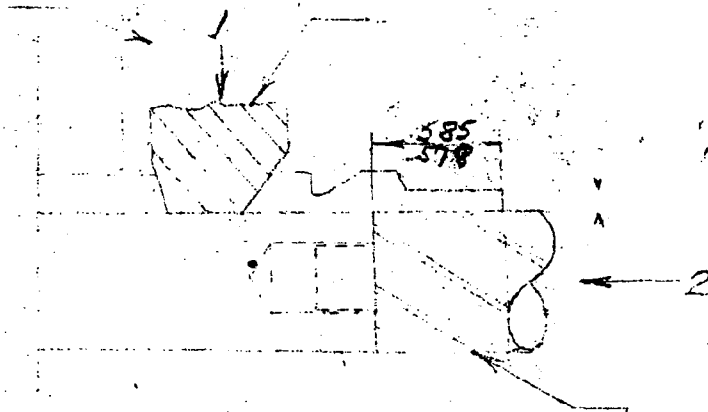
OPER. NO: 1

PROCESS RECORD — ILLUSTRATION SKETCH

SPINDLE 3



SPINDLE 4



Retyped 7/31
OBSOLETE

DESIGNED BY: J. F. HOWLING

APPROVAL & DATE:

REMINGTON-UMC COMPANY, INC. MILTON, N. Y.

7R-7

PART: FIRING PIN HEAD

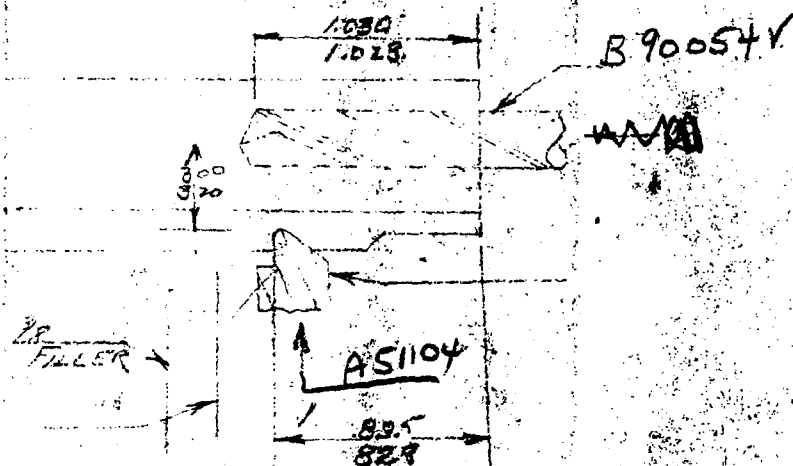
PART No. 17023

OPERATION: SCREW MACHINE

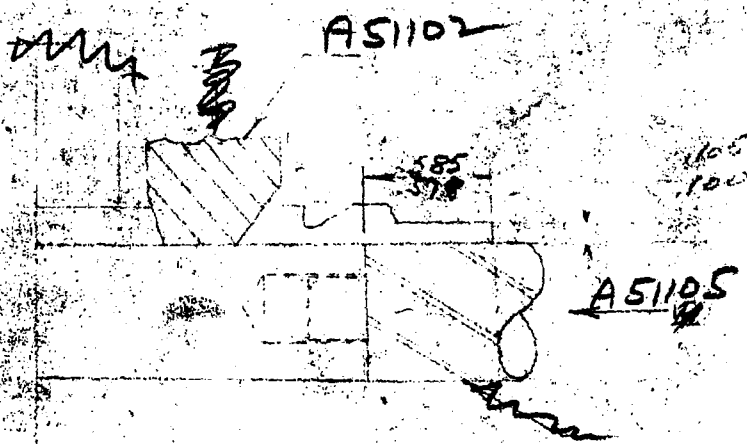
OPER. No.: 1

PROCESS RECORD — ILLUSTRATION SKETCH

SPINDLE 3



SPINDLE 4



1.180
1.173

APPROVED BY: J. J. BOWLING

APPROVAL & DATE

10/11/54

REMINGTON ARMS COMPANY, INC. ALBANY, N. Y.

PART: PIN HEAD

PART No. 17023

SCREW MACHINE

OPER. No. 1

PROCESS RECORD — ILLUSTRATION SKETCH

Spindle #5

A-51161

B-90078W

Spindle #6

B-90078W

BY: J. F. ROWLING

APPROVAL & DATE

REMINGTON ARMS COMPANY, MILITARY DIVISION

REVISED

OCT 11 1940

PART: LIBREX PEN HEAD		PART NO. 13023
OPERATION: SCREW MACHINE		OPER. NO. 1
PROCESS RECORD — ILLUSTRATION SKETCH		
<i>SPINDLE 5</i> <i>45101</i> <i>B90078W</i> <i>SPINDLE 6</i> <i>B90078W</i> <i>1190</i> <i>1183</i>		
COMPILED BY: J. H. BOYLLING	APPROVAL & DATE: <i>[Signature]</i>	
REMINGTON ARMS COMPANY, INC. HARTFORD, CT.		

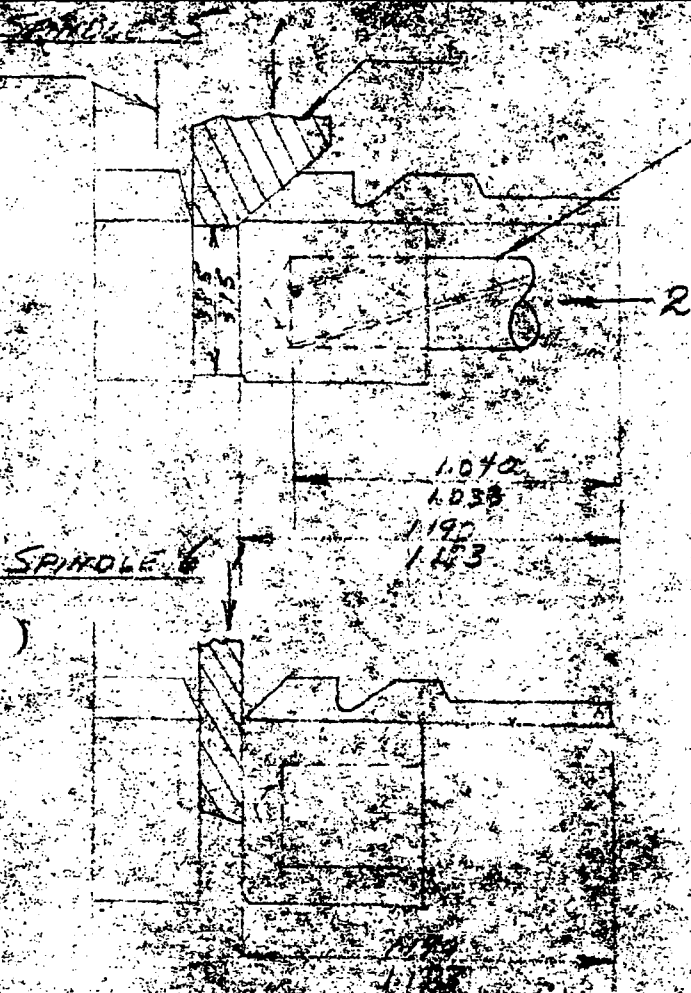
PART: SETTING PEN HEAD

PART NO. 1-17823

OPERATION: SCREW MACHINING

OPERATION: 1

PROCESS RECORD - ILLUSTRATION SKETCH



Relayed 7/30
OBsolete

COMPILED BY: J. J. BOWLING

APPROVAL: [Signature] 7/15/40

KINZEL & COMPANY, INC., CHICAGO, ILL.

NAME: <i>Remington Arms Co.</i>		PART NO.: <i>8711-2</i>
OPERATION: <i>Spindle Alignment</i>		OPER. NO.: <i>1</i>
PROCESS RECORD — ILLUSTRATION SKETCH		
<i>SPINDLE</i> <i>SPINDLE</i> <i>1.180</i> <i>1.181</i> <i>2</i>		
DESIGNED BY: <i>[Signature]</i> APPROVAL: <i>[Signature]</i>		
REMINGTON ARMS COMPANY, INC. MILWAUKEE, WIS.		

OBSOLETE

PART: FIRING PIN HEAD

PART No. B-17023

OPERATION: SCREW MACHINE

OPER. No.: 1

PROCESS RECORD

EQUIPMENT: 1-5/8" 6 Spindle Greenlee's Automatic

Spindle Gears (58) B-90073N

(50) B-90073P

Feed Gears (27) B-90073U

(47) B-90073T

MAX. PROD. PER HOUR: 150/38

COOLANT Cut

Max.

Tool Slide Stroke ~~1 1/4"~~ 3/4"

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
1. Spot Drill	609	.0043	Drill 5/8" Spec. 90° Pt.	A-51076	6-Spec. Stock Reel Bushings 6-Collets for Form Stock 6-Pushers	B90071-U B52006 B52007
Face End	609	.0029	Facing Tool	A-51165	Drill Bushing Plug 2 Universal Chuck 2 Universal Collet Facing Tool Filler 1-3/16" Cam 1:1	B90075-W B90076-U B90067-W B90066-W B90076-W B90076-Y B90072-L
2. Rough Form	609	.0011	Bit Type Form Tool	A51101	Filler 1-5/8" Universal Bit Form Tool Holder 1"	B90075-L B90075-L
Turn .355" Rad.	609	.0043	Bit Type Form Tool	A52008	Knee Turner High Speed Drilling Attachment	B90075-H B90075-T
Drill .283 Dia.	1218	.0021	Drill H.S.S. (B90054-V)	?	Y Universal Chuck (#2 MT) Y Universal Collet Cam 3:1	B90068-V B90066-V B90072-T

COMPILED

PART: FIRING PIN HEAD				PART No. B-17023		
OPERATION: SCREW MACHINE				OPER. No.: 1		
PROCESS RECORD						
EQUIPMENT: 1-5/8" 6 Spindle Greenlees Automatic				Spindle Gears (58) B-90073N (50) B-90073P		
MAX. PROD. PER HOUR: 150				Feed Gears (27) B-90073U (47) B-90073T		
Tool Slide Stroke 11/16"				COOLANT Cut Max.		
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
1. Spot Drill	609	.0043	Drill 5/8" Spec. 90° Pt.	A-51076	6-Spec. Stock Reel Bushings	B90071-U
Face End	609	.0029	Facing Tool	A-51465	6-Collets for Form Stock 6-Pushers	B52006 B52007
2. Rough Form.	609	.0014	Bit Type Form Tool	A51104	Drill Bushing Plug 2 Universal Chuck 2 Universal Collet Facing Tool Holder Filler 1-3/16" Cam 1 1/2:1	B90075-W B90076-U B90067-W B90066-W B90076-W B90076-V B90072-L
Turn .345" Rad.	609	.0043	Bit Type Form Tool	A52008	Filler - 3/8" Vertical Bit Form Tool Holder	B90075-K B90075-J
Drill .283 Dia.	1218	.0021	"I" Drill	B90054-V	Knee Turner High Speed Drilling Attach- ment Y Universal Chuck (#2 MT) Y Universal Collet Cam 3:1	B90075-H B90075-T B90066-V B90072-T
COMPILED BY: J. F. Bowling			APPROVAL & DATE: <i>mkd 8/30/46</i>			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

PART: FIRING PIN HEAD				PART No. B-17023		
OPERATION: SCREW MACHINE				OPER. No.: 1		
PROCESS RECORD						
EQUIPMENT: 1-5/8" 6 Spindle Greenlee Automatic						
MAX. PROD. PER HOUR: 150 COOLANT: Cut Max.						
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
Spindle Gears (Driving 38 Teeth) (Driven 50 ")			B90073N B90073P			
Feed Gears (27 Teeth) (47 ")			B90073V B90073T			
1. Spot Drill	609	.0043	Drill 5/8" Spec. 90° Pt.	A-51076	6-Spec. Stock Reel Bushings	B90071-U
					6- Collets	B52006
					6- Pushers	B52007
2. Face End	609	.0029	Facing Tool	A-51465	Drill Bushing	B90075-W
					Plug	B90076-U
					Z Universal	B90067-W
					A " Collet	B90066-W
					Facing Tool	B90076-W
					Holder	
					Filler 1-13/16	B90076-V
					Cam 1½:1	B90072-L
2. Rough Form	609	.0014	Bit Type Form Tool	A51104	Filler - 3/8	B90075-K
					Vertical Bit	B90075-J
					Form Tool Holder	
Turn .345" Rad.	609	.0043	Bit Type Form Tool	A52008	Knee Turner	B90075-H
					High Speed	B90075-T
					Drilling Attachment	
Drill .283 Dia.	1218	.0021	"I" Drill	B90054-V	Y Universal Chuck (#2MT)	B90067-V
					Y Universal Collet	B90066-V
					Cam 3:1	B90072-T
COMPILED BY J. F. Bowling				APPROVAL & DATE: <i>MVA 7/18/46</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

OBSOLETE

PART: FIRING PIN HEAD

PART No. 17023

OPERATION: SCREW MACHINE

OPER. No.: 1

PROCESS RECORD

EQUIPMENT: 1-5/8" 6 Spindle Greenlee Automatic

MAX. PROD. PER HOUR: 150

COOLANT: Cut Max.

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
3 - Finish Form Groove	609	.0011	Bit Type Form Tool	A51104	Vertical Bit Form Tool Holder (1/8")	B90075J
					Filler-3/8" High Speed Drilling Attachment	B90075K B90075T
4 - Drill .283 Dia. Remainder	1218	.0021	Drill H.S.S. (890054V)	I	Y Universal Chuck Y Universal Collet Cam: 3:1	B90067T B90066T B90072T
4 - Rough Form Back End	609	.0021	Bit Type Tool Form	A51102	Vertical Bit Form Tool Holder (5/8") Bushing Plug Tool Slide Tool Holder Cam: 2:1	B90075T B90075K B90076Q B90072D
4 - Counterbore	609	.0042	Counterbore Spec. with Pilot	A51105		

COMPILED BY: J. F. Bowling

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. MILTON, N. Y.

PART: FIRING PIN HEAD

PART-NO. 17023

OPERATION: SCREW MACHINE

OPER. No.: 1

PROCESS RECORD

EQUIPMENT: 1-5/8" 6 Spindle Greenlee Automatic

MAX. PROD. PER HOUR: 150

COOLANT: Cut Max.

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
3	609	.0011	Bit Type Form Tool	A51103	Vertical Bit Form Tool Holder ($\frac{1}{2}$ ")	B90075J
					Filler- $\frac{3}{8}$ " High Speed Drilling Attachment	B90075K B90075T
2-Drill .283 Dia. Remainder	1218	.0021	"I" Drill	B90054W	Y Universal Chuck Y Universal Collet Cam: 3:1	B90067V B90066V B90072T
4	609	.0021	Bit Type Tool Form	A51102	Vertical Bit Form Tool Holder ($\frac{5}{8}$) Bushing Plug Tool Slide Tool Holder Cam: 2:1	B90076T B90076S B90076R B90076Q B90072U
2-Counterbore	609	.0043	Counterbore Spec. with Pilot	A51105		
COMPILED BY: J. F. Bowling			APPROVAL & DATE: <i>MKS 8/20/46</i>			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

PART: FIRING PIN HEAD				PART No. 917023	
OPERATION: SCREW MACHINE				OPER. No. 1	
PROCESS RECORD					
EQUIPMENT: 1 5/8" 6 Spindle Greenlee Automatic					
MAX. PROD. PER HOUR: 150 COOLANT: Cut Max					
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No.	TYPE No.
3	609	.0014	Bit Type Form Tool	A51102	Vertical Bit Form Tool Holder (1/2") B90075J
					Filler-3/8" High Speed Drilling Attachment B90075K B90075T
2-Drill .283 Dia. Remainder	1218	.0021	"IN" Drill	B90054	Y Universal Chuck B90067V Y Universal Collet B90066V Cam: 3:1 B90072T
4	609	.0021	Bit Type Form Tool	A51102	Vertical Bit form Tool Holder (5/8") B90076T
					Bushing B90076S
					Plug B90076R
1-Rough Form Back End					Tool Slide Tool Holder B90076Q Cam: 2:1 B-90072U
2-Counterbore	609	.0043	Counterbore Spec. with Pilot	A51105	
COMPILED BY: J.F. BOWLING			APPROVAL & DATE: 7/18/46		
REMINGTON ARMS COMPANY, INC. ILION, N.Y.					

PART: FIRING PIN HEAD					PART No. B17023	
OPERATION: SCREW MACHINE					OPER. No.: 1	
PROCESS RECORD						
EQUIPMENT:						
MAX. PROD. PER HOUR:			COOLANT:			
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
3 1-Finish Form Groove	609	.0014	Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder	B90075J
					Filler-3/8 High Speed Drilling Attachment	B90075K B90075T
2-Drill .283 Dia. Remainder	1218	.0021	"I" Drill	B90054V	Y Universal Chuck Y Universal Collet Cam: 3:1	B90067V B90066V B90072T
OBsolete						
4 1-Rough Form Back End	609	.0021	Bit Type Form Tool	A51102	Vertical Bit form Tool Holder	(5/8) B90076T
					Bushing Plug Tool Slide Tool Holder Cam: 2:1	B90076S B90076R B90076Q
2-Counterbore	609	.0043	Counterbore Spec. with Pilot	A51105		
COMPILED BY: J.F. BOWLING			APPROVAL & DATE: WMS 7/18/46			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

PART NO. <i>795-10</i>				PART NAME			
OPERATION							
PROCESS RECORD							
EQUIPMENT				COOLANT			
MAX. PROD. PER HOUR				COOLANT			
STATION		SPEED		FEED		TOOL HOLDERS & FIXTURES	
STEPS				TYPE	NO.	TYPE	NO.
3	<i>FINISH FORM</i> <i>GROOVE</i>	<i>600</i>	<i>001</i>	<i>BIT TYPE FORM</i> <i>TOOL</i>	<i>A-5102</i>	<i>VERTICAL BIT FORM</i> <i>TOOL HOLDER</i> <i>FILLER - 1/8"</i> <i>HIGH SPEED DRILLING</i> <i>ATTACHMENT</i> <i>Y UNIVERSAL CHUCK</i> <i>Y UNIVERSAL CHUCK</i> <i>CAM 3"</i>	<i>B-90015</i> <i>B-90015K</i> <i>B-90015K</i> <i>B-90015K</i> <i>B-90015K</i> <i>B-90015K</i> <i>B-90015K</i>
	<i>DRILL 2-83 DIA</i> <i>REMAINDER</i>		<i>001</i>	<i>BIT TYPE FORM</i> <i>TOOL</i>	<i>B-90054</i>		
4	<i>ROUGH FORM</i> <i>BASIC END</i>	<i>600</i>	<i>001</i>	<i>BIT TYPE FORM</i> <i>TOOL</i>	<i>A-51102</i>	<i>VERTICAL BIT FORM</i> <i>TOOL HOLDER</i> <i>Y UNIVERSAL CHUCK</i> <i>Y UNIVERSAL CHUCK</i> <i>CAM 3"</i>	<i>B-90015</i> <i>B-90015K</i> <i>B-90015K</i> <i>B-90015K</i> <i>B-90015K</i>
	<i>COUNTER BORE</i>	<i>600</i>	<i>001</i>	<i>COUNTER BORE</i> <i>SPEC WITH</i> <i>PILOT</i>	<i>A-51105</i>		
COMPLETED BY				APPROVAL DATE			
REVISIONS							

OBsolete

*complete
for 7/2*

PART: FIRING PIN HEAD				PART No. BL7023	
OPERATION: SCREW MACHINE				OPER. No. 1	
PROCESS RECORD					
EQUIPMENT: 1 5/8" 6 Spindle Greenlee Automatic					
MAX. PROD. PER HOUR: 150			COOLANT: Cut. Max.		
STATION			TOOLS & GAUGES		TOOL HOLDER FIXTURES
STEPS	SPEED	FEED	TYPE	No.	No.
5 Finish Form Rear End	609	.0009	Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder
Ream .283 Dia.	609	.0043	Stub Reamer - H.S.S. 2825/.2823 (B 90068 V)	B90068V 2825/.2823	Floating Holder Reamer Bushing Cam 5:1 Tool Slide Holder Reaming Attach
6 Cut Off	609	.0021	Cut Off Blade	B90078W	Cut Off Holder 1-Cut Off Cam 2:1
Feed To Stop			20 x Comparator		
Between 6.1			Comp. Fixture B51235		
Add			Length .445-.438		
Comp. Stage			Length 1.100-1.183		
B-50156			" .835-.828		
			" .300-.320		
			" .578-.585		
Add			Dial Indicator		
Master A-51199			Depth of Hole 1.140-1.133		
Add			Dial Indicator		
Master A-51113			Snap Gage .100-.105		
Add			Plug Gage		
			Dia. Of Hole .2833-.2818		
COMPILED BY:			APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC. ILION, N.Y.					

PART: FIRING PIN HEAD				PART No. 117023		
OPERATION: SCREW MACHINE				OPER. No.		
PROCESS RECORD						
EQUIPMENT: 1 5/8" 6 Spindle Greenlee Automatic						
MAX. PROD. PER HOUR: 150			COOLANT: Cut. Max.			
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE No.	
5 Finish Form Rear End	609	.0009	Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder (1/2) Floating Holder Reamer Bushing Plug Cam 5:1 Slide Holder	B90076T B90074W B90076N B90076U B90072R B90076Q
Ream .283 Dia.	609	.0043	Stub Reamer .2825/.2823	B90068V		
6 Cut Off	609	.0021	Cut Off Blade	B90078W	Cut Off Holder 1-Cut Off Cam 2:1	B90075P B90072J
Feed To Stop			20 x Comparator Layout Length .445-.438 Length 1.190-1.183 " .835-.826 " .300-.320 " .578-.585 Dial Indicator Spec. Post Depth of Hole 1.140-1.133 Dial Indicator Spec. Post .340-.345 Master Dial Snap Gage .100-.105 Plug Gage Dia. Of Hole .2833-.2818	Fixture B51235 Screen B51238 B51297 C-51106 B51106 A-51113 B51098 B80005M		
COMPILED BY:			APPROVAL & DATE: M/K 8/20/46			
REMINGTON ARMS COMPANY, INC. SEP 9 - 1946						

PART: FIRING PIN HEAD				PART No. 517023	
OPERATION: SCREW MACHINE				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: 1 5/8" 6 Spindle Greenlee Automatic					
MAX. PROD. PER HOUR: 150			COOLANT: Cut. Max.		
STATION		TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE
5			Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder (1/2)
Finish Form Rear End	609	.0009			B90076W
			Stub Reamer	B90068V	B90074W
Ream .283 Dia.	609	.0043	.2825/.2823		B90076N
					B90076J
					B90072R
					B90076Q
6			Cut Off Blade	B90078W	Cut Off Holder
Cut Off	609	.0021			1-Cut Off Cam 2:1
					B90075P
					B90072J
			20 x Comparator Layout		
			Length .445-.438	Fixture	
			Length 1.190-1.185	B51235	
			" .835-.828	Screen	
			" .300-.320	B51238	
			" .578-.585		
			Dial Indicator Spec. Post		
			Depth of Hole 1.140-1.133	B51198	
			Dial Indicator Spec. Post		
			.340-.345	B51106	
			Dial Snap Gage .100-.105	B51098	
			Plug Gage Dia. Of Hole .2833-.2818	B80005M	
COMPILED BY:			APPROVAL & DATE: <i>mks 8/20/46</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

)
Between
631

PART: FIRING PIN HEAD

PART No. 17023

OPERATION: SCREW MACHINE

OPER. No.: 1

PROCESS RECORD

OBSOLETE

EQUIPMENT: 1 5/8" 6 Spindle Greenlee Automatic

MAX. PROD. PER HOUR: 150

COOLANT: Cut. Max.

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
5	Finish Form Rear End	609 .0009	Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder ($\frac{1}{2}$)	B90076B B90076T
	Ream .283 Dia.	609 .0043	Stub Reamer .2825/.2823	B90068V	Floating Holder Reamer Bushing Plug Cam 5:1 Tool Slide Holder	B90074W B90076N B90076U B90072R B90076Q
6	Cut Off	609 .0021	Cut Off Blade	B90078W	Cut Off Holder 1-Cut Off Cam 2:1	B90075P B90072J
	Feed To Stop		20 x Comparator Layout Length .445-.438 Length 1.190-1.183 " .835-.828 " .300-.320 " .578-.585 Dial Indicator Spec. Post Depth of Hole 1.140-1.133 Dial Indicator Spec. Post .340-.345 Dial Snap Gage .100-.105 Plug Gage Dia. Of Hole .2833-.2818	Fixture B51235 Screen B51238 B51198 B51106 B51098 B80005M		

COMPILED BY:

APPROVAL & DATE:

MKS 8/20/46

REMINGTON ARMS COMPANY INC. ILION, N.Y.

REVISED AUG 20 1946

PART: <i>Flare Gun Head</i>		PART NO: <i>102</i>	
OPERATION: <i>Score Machine</i>		OPER: <i>102</i>	
PROCESS RECORD			
EQUIPMENT: <i>Copy</i>			
MAX PROD PER HOUR		COOLANTS	
STATION			
STEPS	FEED	FEED	TOOL HOLDERS & FIXTURES
5. <i>FLARE FORM</i>	<i>1.5</i>	<i>0009</i>	<i>BIT TYPE DINA SHOE</i>
<i>REAR END</i>	<i>609</i>	<i>0001</i>	<i>TOOL HOLDER</i>
<i>REAR 1/2 DIA</i>	<i>609</i>	<i>0003</i>	<i>REARER DILL CUSHING</i>
<i>6. CUT OFF</i>	<i>609</i>	<i>0001</i>	<i>CUT OFF BLADE</i>
<i>7. REAR 1/2 DIA</i>	<i>609</i>	<i>0001</i>	<i>REAR 1/2 DIA</i>
<i>8. REAR 1/2 DIA</i>	<i>609</i>	<i>0001</i>	<i>REAR 1/2 DIA</i>
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*Complete
to this*

PART: FIRING PIN HEAD				PART No. 17023	
OPERATION: SCREW MACHINE				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: <i>1 5/8" 6 spindle breech automatic</i>					
MAX. PROD. PER HOUR: <i>150</i> COOLANT: <i>Cut Work</i>					
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No.	TYPE
5	609	0009	Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder
			<i>Per Design</i> OBSOLETE <i>per spec</i>	<i>Per Design</i> OBSOLETE <i>per spec</i>	Floating Holder B90074W Reamer Bushing B90076N Plug B90076U Cam 5:1 B90072R Tool Slide Tool B90076Q Holder
6	609	0021	Cut Off Blade	B90078W	Cut Off Holder B90075P 1 Cam 1 CO. B90072J 1 2:1
Between 631	Feed to Stop		20x Comparator Fixture Screen	B51235 B51238	
			Lgth. 445-438 Lgth. 1.190-1.183 " .835-.828 " .300-.320 " .578-.585		
			Dial Indicator Spec. Post Depth of Hole 1.140-1.133	B51192	
			Dial Indicator Spec. Post .340-.345	B51106	
			Sample Gage DIAL SAMPLE GAGE .100-.105 Plug Gage .2833-.2818	B51098 B8005M B-8005M	
COMPILED BY: J. F. BOWLING			APPROVAL & DATE: <i>1/16/46</i>		
REMINGTON-ARM COMPANY, INC. UNION, N. Y.					

PART: FIRING PIN HEAD				PART No. B17023		
OPERATION: SCREW MACHINE				OPER. No.: 1		
PROCESS RECORD						
EQUIPMENT:						
MAX. PROD. PER HOUR:			COOLANT:			
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	No.	
5	1-Finish Form Rear End	609	0009	Bit Type Form Tool	A51101	Vertical Bit Form Tool Holder
						Floating Holder B90074W Reamer Bushing B90076N Plug B90076U Cam 5:1 B90072R Tool Slide Tool B90076Q
6	1-Cut Off	609	0021	Cut Off Blade	B90078W	Cut Off Holder B90075P 1 Cam 21 Co. B90072J
Between 631	Feed to Stop			20x Comparator Fixture Screen	B51235 B51238	
				Lgth. 445-438 Lgth. 1.190-1.183 " .835-.828 " .300-.320 " .578-.585		
				Dial Indicator Spec. Post Depth of Hole 1.140-1.133	B51192	
				Dial Indicator Spec. Post .340-.345	B51106	
				Sample Gage Hill .100-.105	B51098	
				Plug Gage .2833-.2818	B51098	
COMPILED BY: J.F. BOWLING			APPROVAL & DATE: <i>mjs 7/15/46</i>			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

PART: EXTRUDED STOCK FIRING PIN HEAD		PART No. <u>17023</u> 17113	
OPERATION: Inspect EXTRUDED STOCK (17113)		OPER. No. <u>1-1</u>	
PROCESS RECORD — INSPECTION			
GAUGES		LIMITS	
Type	No.	USE	Max Min.
J & L Comparator with 30" Screen 10" Screen			
Base	B50156	Diameter of Round Section	.445 .440
Screen	B50097	Center Line to Tongue	.172 .168
Fixture	B50098	Width of Tongue Radius	.015
		OBSOLETE	
SKETCH			
- LOCATING POINTS			
COMPILED BY: <u>BOWLING</u>		APPROVAL & DATE: <u>[Signature] 7/18/46</u>	
REMINGTON ARMS COMPANY, MILWAUKEE, WIS.			

PART: FIRING PIN HEAD		PART No. 17023
OPERATION: CLEAN		OPER. No.: 2
PROCESS RECORD #837		
Equipment: Washer Basket - 10" x 23" x 5".		
Detailed Description		
Load Size	:	_____ maximum
Method:	:	
Cycles	:	1
Position of Components	:	Not critical
Standard Practice	:	#206
Remarks: All oil must be removed as tumbling operation follows.		
COMPILED BY: P. H. Eccleston		APPROVAL & DATE: <i>MKS 8/20/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: ~~Screw Machine Parts~~

PART No.

17023

Firing Pin Head
OPERATION: Clean (~~Remington-made Ranschoff~~)

OPER. No.:

JAN 6

1947

PROCESS RECORD NO. _____

Equipment: Remington constructed Ranschoff
 Baskets - 20" x 23" x 5" deep - 1/4" mesh
 20" x 23" x 6" deep - 1/2" mesh
 ~~12" x 6" x 4 1/2" deep - 1/16" mesh~~
 Drier - 43" x 27" - gas heated.

Detailed Description

Standard Practice : 206

Temperature : 212°F.

Time in cleaning chamber : 3 min

Spray pressure : Full

Load Size : 500

Drying Time : not critical. 15 to 15 minutes

Remarks: *Hole for Firing Pin must be clean,*
 a. free from chips, oil, etc.
~~b. correct operation~~
~~c. handling care~~

Varnish must be

MHL
1/5/46

COMPILED BY: P. H. Eccleston

APPROVAL & DATE:

AK Grace *11/4/46*

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin Head		PART No. 17023
OPERATION: Clean		OPER. No.: 2
PROCESS RECORD #837		
Equipment: Remington Washer Basket - 10" x 23" x 5" Detailed Description Load Size : _____ maximum. Method : Power Wash Cycles : 1 Position of Components: Not critical. Standard Practice : #206 Remarks: All oil must be removed as tumbling operation follows.		
<i>Relieved</i> <i>7/31</i> OBSOLETE		
COMPILED BY: P. H. Eccleston		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Firing Pin Head

PART No. 17023

OPERATION: Clean

OPER. No.: 2

PROCESS RECORD #837

Equipment: Ranschoff Washer
Basket - 10" x 23" x 5" .

Detailed Description

Load Size : _____ maximum.

Method : Conveyor belt.

Cycles : 1

Position of Components: Not critical.

Standard Practice : #206

Remarks: All oil must be removed as tumbling operation follows.

Relayed 7/31

COMPILED BY: P. H. Eccleston

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FLYING PIN HANG		PART NO.
OPERATION: CLEAN		
PROCESS RECORD #32		
Equipment: Remington Machine Basket: 10" x 23" x 5"		
Detailed Description		
Load Size	Maximum	
Method	Conveyor Belt	
Cycles	1	
Position of Components	Not Critical	
Standard Practice	#206	
Remarks: All oil must be removed as tumbling operation follows.		
COMPILED BY: P. H. Eccleston	APPROVAL & DATE	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

OBSOLETE

PART: Firing Pin Head

PART No. 17023

DISOLETE

OPERATION: Tumble to Remove Burrs and Copper (Wet)

OPER. No.: 3

FEB 24 1947

PROCESS RECORD #825

Equipment: 1. Oblique Type drum - 22" and 28" (24 RPM)
 and 2. #150 Grit Alundum (Emery)
 Materials 3. Clepo 16-J. Mixed alkaline abrasive.
 4. 58% Sodium Carbonate (Soda Ash).
 5. 1% Sodium Cyanide Emulsion
 6. Rinse basket 12" x 11"
 7. Hot soda ash and water rinse tank - 20" x 19" x 21"
 8. Hot water rinse tank - 20" x 19" x 21"
 9. Steam heated drier

Detailed Description

Load Size : 500 components maximum per drum

Angle of Drum : 10° when tumbling.

Time Cycle : 4 Hours.

Rinse with Cold water in and out

Empty into basket.

Soda ash and water rinse : Temperature, 212°F. Time, 2 minutes.

Hot water rinse : Temperature, 212°F. Time, 2 minutes.

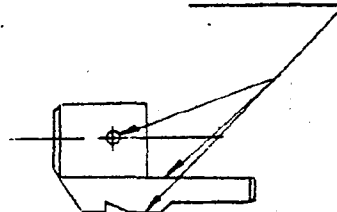
Dry : Place components on steam drier and leave until thoroughly dry.

Standard Practice : #175

Remarks:

All traces of copper must be removed, and parts must be thoroughly dry
 as per test results.

BURRS TO BE REMOVED



COMPILED BY: P. H. Eccleston

APPROVAL & DATE:

MAR 4/1947

REVISED FEB 17 1947

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin Head		PART No. 17023
OPERATION: Tumble to Remove Burrs		OPER. No.: 3
OBSOLETE SEP 12 1947		
PROCESS RECORD #825		
Equipment: 1. Oblique Type drum - 22" and 28" (24 RPM) 2. #150 Grit Alundum (Emery) 3. Clepo 16-J. Mixed alkaline abrasive. 4. 58% Sodium Carbonate (Soda Ash). 5. Rinse Basket 12" x 12". 6. Hot soda ash and water rinse tank - 20" x 19" x 21". 7. Hot water rinse tank - 20" x 19" x 21". 8. Steam heated drier.		
Detailed Description		
Concentration of Solution:		
Load Size	:	Maximum components per drum.
Angle of Drum	:	___° when tumbling.
Time Cycle	:	___ Hours.
Rinse with Cold water	___	minutes.
Empty into basket.		
Soda ash and water rinse	:	Temperature, 212°F. Time, ___ minutes.
Hot water rinse	:	Temperature, 212°F. Time, ___ minutes.
Dry	:	Place components on steam drier and leave until thoroughly dry.
Standard Practice	:	#175
Remarks:		
COMPILED BY: P. H. Eccleston		APPROVAL & DATE: <i>mld 11/6/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Firing Pin Head

PART No. 17023

OPERATION: Tumble to Remove Burrs and Coffee (wet)

OPER. No. 3

PROCESS RECORD #825

- Equipment: 1. Oblique Type drum - 22" and 28" (24 RPM)
 and 2. #150 Grit Alundum (Emery)
 Materials: 3. Clepo 16-J. Mixed alkaline abrasive.
 4. 58% Sodium Carbonate (Soda Ash).
 5. Rinse Basket 12" x 12".
 6. Hot soda ash and water rinse tank - 20" x 19" x 21".
 7. Hot water rinse tank - 20" x 19" x 21".
 8. Steam heated drier.
 9. Two Sodium Cyanide Eggs

Detailed Description

Concentration of Solution:

Load Size ~~Two~~ : ⁵⁰⁰ Maximum components per drum.

Angle of Drum : 10° when tumbling.

Time Cycle : 4 Hours.

Rinse with Cold water ~~2~~ minutes. IN & OUT

Empty into basket.

Soda ash and water rinse : Temperature, 212°F. Time, 2 minutes.

Hot water rinse : Temperature, 212°F. Time, 2 minutes.

Dry : Place components on steam drier and leave until thoroughly dry.

Standard Practice : #175

Remarks: All traces of coffee must be removed and parts must be thoroughly dry as heat treating operation follows. BURRS to be removed.



checked by: P. H. Eccles

APPROVAL DATE

REMINGTON-UMC COMPANY, INC.

PART: Pin Head		PART NO: 17022	
OPERATION: Tumble to Remove Burrs		DATE: 1/20/22	
PROCESS RECORD #825			
Equipment: 1. Gishurst type drum - 22" and 28" (24 RPM) 2. #150 Grit Aluminum (Emery) 3. Glass Bead - Mixed alkaline abrasive. 4. 50% Soda Ash Carbonate (Soda Ash) 5. Rinse Basket 12" x 12" 6. Hot soda ash and water rinse tank - 20" x 19" x 21" 7. Hot water rinse tank - 20" x 19" x 21" 8. Steam heated drier.			
Detailed Description			
Concentration of Solution:			
Load Size	Maximum components per drum.		
Angle of Drum	° when tumbling.		
Rinse Cycle	Hours		
Rinse with Cold water	minutes.		
Empty into basket.			
Soda ash and water rinse	Temperature, 212° F.	Time	minutes
Hot water rinse	Temperature, 212° F.	Time	minutes
Dry	Place components on steam drier and leave until thoroughly dry.		
Standard Practice	#175		
Remarks:			
OBSOLETE			
COMPLETED BY: P. H. [Signature]		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. [Signature]			

PART: FIRING PIN HEAD

PART No. 17023

OPERATION: DRILL & REAM SMALL HOLE

OPER. No.: 5

PROCESS RECORD

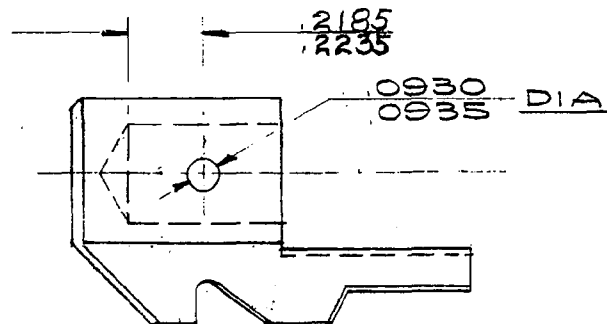
EQUIPMENT: Leland Gifford Drill Press 2 Spindle#1
 SPEED: 3600 Drill Speed FEED: .003 Drill
 2400 Reamer Speed .009 Ream
 MAX. PROD. PER HOUR: 180 COOLANT: Soluble oil

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
Drill #44 (.086 Dia.)	B90054U	Jig 2 pcs. Drill Bushings	B51071 B90092R
Ream .0935 Dia.	B90079U	Reamer Bushings	B90092Q
Gages: Plug .0935-.0930	B80001V		
Indicator Gage .2185-.2235	B51541		
Master for Indicator Gage	A51546		

SKETCH



F.C. 7-9-46

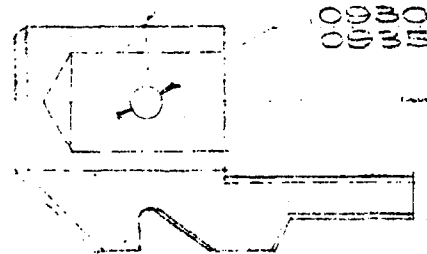
COMPILED BY: A. TRAVOSTINO

APPROVAL & DATE:

m/ll 7/18/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

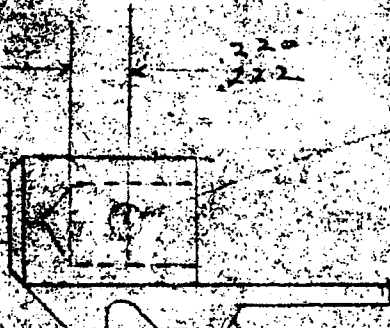
Revised
OBSELETE
DEC 27 1946

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: DRILL & REAM SMALL HOLE		OPER. No.: 5	
PROCESS RECORD			
EQUIPMENT: Leland Gifford Drill Press 2 Spindle #1			
SPEED: 3600 Drill Speed 2400 Reamer Speed		FEED: .003 Drill .009 Ream	
MAX. PROD. PER HOUR: 180		COOLANT: Solutia oil	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Drill #44 (.086 Dia.)	B90054U	Jig 2 pcs. Drill Bushings	B51071 B90092R
Ream .0935 Dia.	B90079U	Reamer Bushings	B90092Q
Gages: Plug .0935-.0930	B80001V		
Indicator Gage	B51541		
2185-2235-220-222 Master for Indicator Gage	A51546		
SKETCH			
12/18/46 JP 222 220 0930 - DIA. 0935  MKS 12/19/46			
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: 2/12/46	
REMINGTON ARMS COMPANY, INC. REVISED AUG 26 1946			

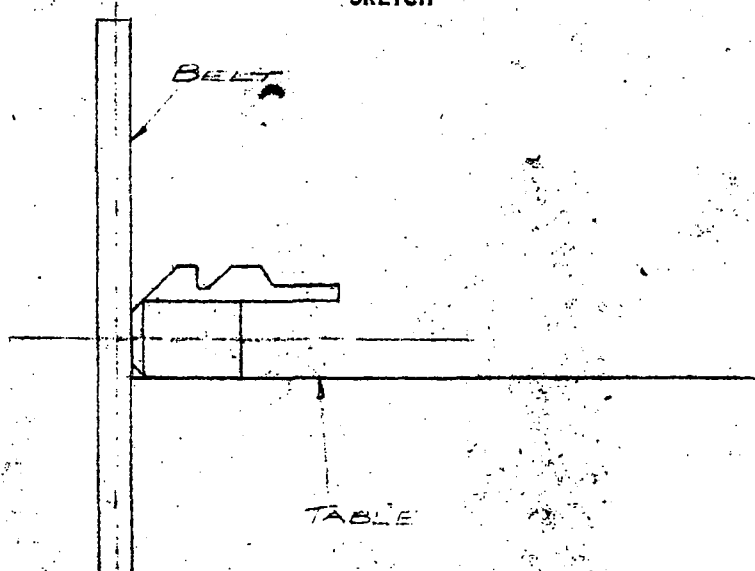
COPIED
11/20/76

PART: <i>FIRING PIN HEAD</i>		PART No. <i>17023</i>	
OPERATION: <i>DRILL & REAM SMALL HOLE</i>		OPER. No.:	
PROCESS RECORD			
EQUIPMENT: <i>LELAND GIFFORD DRILL PRESS 2 SPINDLE #1</i>			
SPEED: <i>3600 DRILL SPEED</i> <i>2400 REAMER SPEED</i>		FEED: <i>1003 DRILL</i> <i>1009 REAM</i>	
MAX. PROD. PER HOUR:		COOLANT: <i>SOLUBLE OIL</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>SPOT DRILL .0935" DIA.</i>		<i>JIG 2 Pcs.</i>	<i>B-51071</i>
<i>DRILL #44 (.086 DIA)</i>	<i>B-90054W</i>	<i>DRILL BUSHINGS</i>	<i>B-90092R</i>
<i>REAM .0932 DIA.</i>	<i>B-90094W</i>	<i>REAMER BUSHINGS</i>	<i>B-90092Q</i>
<i>GAGES: PLUG .0935</i>	<i>B-80001V</i>		
<i>.0930</i>			
<i>INDICATOR GAGE</i>	<i>B-51541</i>		
<i>1.220 -.222</i>			
<i>MATER FOR INDICATOR GAGE</i>	<i>A-51546</i>		
SKETCH			
<i>Sketch</i>			
COMPILED BY: <i>[Signature]</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

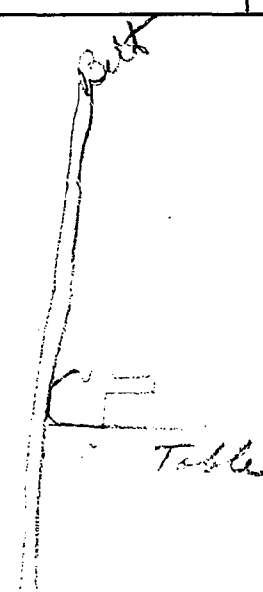
PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: DRILL & REAM SMALL HOLE		OPER. No.: 5	
PROCESS RECORD			
EQUIPMENT: Leland Gifford Drill Press 2 Spindle #1 SPEED: 3600 Drill Speed FEED: .003 Drill 2400 Reamer Speed .009 Ream MAX. PROD. PER HOUR: 180 COOLANT: APC Soluble Oil			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Drill #44 (.086 Dia.)	B90054U	Jig 2 pcs. Drill Bushings	B51071 B90092R
Ream .0935 Dia.	B90079U	Reamer <i>Bushing</i>	B90092Q
Gages: Plug .0935-.0930	B80001V	<i>Revised 7/31</i> 	
Indicator Gage .220-.222	B51541		
Master for Indicator Gage	A51546		
SKETCH 			
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: <i>W/L 7/18/46</i>	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.			

PART: <i>Hand</i>		PART NO: <i>17023</i>	
OPERATION: <i>Drill Press</i>		OPER. NO: <i>1</i>	
PROCESS RECORD			
EQUIPMENT: <i>Hand Drill Press 2 Spindle</i>			
SPEED: <i>1000 RPM</i>		FEED: <i>0.002</i>	
MAX. PROD. PER HOUR: <i>100</i>		COOLANT: <i>A9C</i>	
TOOLS & GAGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE: <i>Drill</i> NO.: <i>B-90054-V</i> <i>Lucrase</i> <i>B-90079-V</i>		TYPE: <i>Drill Press</i> NO.: <i>B-51971</i> <i>Design</i> <i>B-90092-R</i> <i>Reamer Bushing</i> <i>B-90092-Q</i>	
GAGE: <i>B-80001-V</i>			
PANG: <i>2935</i> <i>Hand Drill Press</i> <i>Location in this in Holes</i> <i>with Two Flutes</i>		SKETCH <i>B-5154</i> 	
COMPILED BY: <i>K. R. S. M. D.</i>		APPROVAL & DATE: <i>Complete 7/2</i>	
REMINGTON ARMS COMPANY, INC. PHILLY, N. Y.			

OBsolete

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: BURR CUT-OFF		OPER. No.: 6	
PROCESS RECORD			
EQUIPMENT: Porter Cable Belt Sander			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT: Soluble Oil	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
None 180 GRIT BELT B96093W	STD	None	
SKETCH			
			
COMPILED BY: Bowling 9/26/46		APPROVAL & DATE:	
REVISED OCT 7 - 1946 REMINGTON ARMS COMPANY, INC.			

new of
set
10/1
OBsolete

PART: <i>Finishing Pin Head</i>		PART No. <i>17123</i>	
OPERATION: <i>Burr Cut off</i>		OPER. No.: <i>6</i>	
PROCESS RECORD			
EQUIPMENT: <i>Porta Cable Belt Sander</i>			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>None</i>		<i>None</i>	
SKETCH			
			
COMPILED BY: <i>Bowling</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FIRING PIN HEAD

PART No. 17823

OPERATION: MILL ON 95 RADIUS ON END

OPER. No.

FEB

PROCESS RECORD

EQUIPMENT: 0-8 Cincinatti Rise & Fall Mill

SPEED:

FEED:

MAX. PROD. PER HOUR:

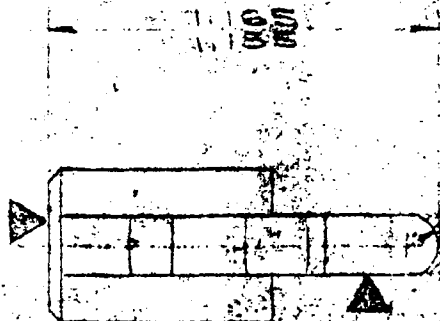
COOLANT: Cim Cool

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
1 Cutter (3/32" R.)		Fixture	C-52904
2" x 3/8 x 7/8 - 14 teeth (B 90139W)	STD.	1 #40 - 7/8 A-10 Arbor	B-90057T
Gage Comparator		Cycle Selector Cam	D-51799
Fixture Screen Stage	A51536 B51540 B50156	<i>BEARING COLLAR</i>	<i>A53124</i>

SKETCH



REVISED

PART: **WIRING PIN HEAD**PART No. **17023**

ON END .095 RADIUS

OPER. No. **7**

PROCESS RECORD

EQUIPMENT: **0-8 Cincinnati Rise & Fall Mill**

SPEED:

FEED: **Manual**

MAX. PROD. PER HOUR:

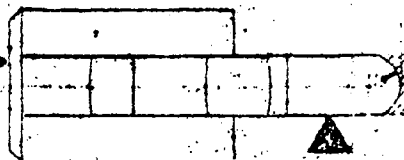
COOLANT: **Cim Cool**

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
1 Cutter (3/32" R.)	B-90139W	Fixture	
2" x 3/8 x 7/8 - 14 teeth		1 #40 - 7/8 A-10 Arbor	B-90057T
Gage Comparator		<i>Cycle Selector Cam</i>	<i>D-51777</i>
Fixture	A51536		<i>1/30/47</i>
Screen	B51540		
Stage	B50156		

SKETCH



REVISION POINTS

REVISED DEC 27 1947

PART:

FIRING PIN HEAD

PART No.

17023

OPERATION: MILL ON END .095 RADIUS

OPER. No.

7

PROCESS RECORD

EQUIPMENT: 0-8 Cincinnati Rise & Fall Mill

SPEED:

FEED:

MAX. PROD. PER HOUR:

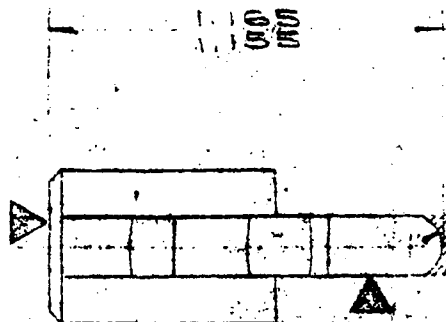
COOLANT: Cim Cool

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
1 Cutter (3/32" R.)	B-90139W	Fixture	C52904
2" x 3/8 x 7/8 - 14 teeth	57D	1 #40 - 7/8 A-10 Arbor	B-90057T
(B 70139 W)		Cycle Selector Cam	D51799
Gage Comparator			
Fixture	A51536		
Screen	B51540		
Stage	B50156		

SKETCH



COMPLETION

TRAY

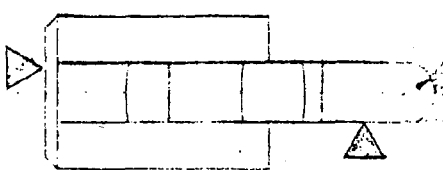
APPROVAL

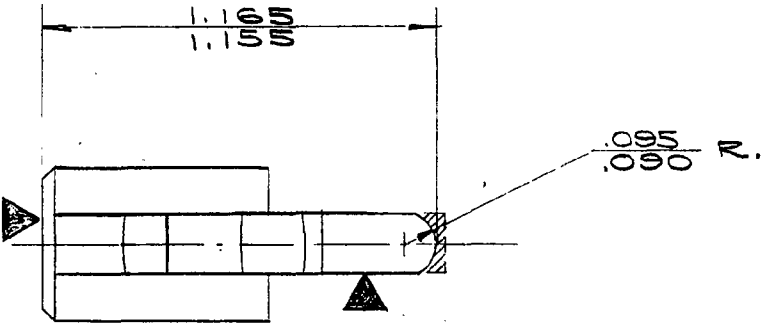
DATE

REVISIONS OR AMENDMENTS AND DATES

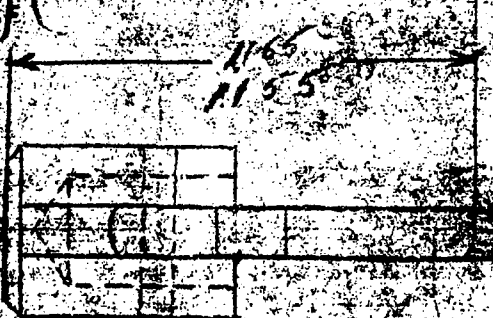
REVISED

OBSELETE
DEC 23 1945

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: GRIND .095 RADIUS <i>MILL ON END</i>		OPER. No.: 7	
PROCESS RECORD			
EQUIPMENT: Porter Cable Belt Sander <i>O-8 Cincinnati</i>		<i>Rise & Fall Mill</i>	
SPEED:		FEED: Manual	
MAX. PROD. PER HOUR: 150		COOLANT: Soluble Oil <i>Cin Cool</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1 Cutter (1/32" R.)</i>	<i>B90139 W</i>	<i>Swivel Type Fixture</i>	<i>O-1111</i>
<i>150-Grain Belt</i>	<i>B90139 W</i>	<i>1-440-2 A-10 Arbor</i>	<i>B90057 T</i>
<i>2" x 1/2" x 1/8" - 14 TPI</i>			
Gage Comparator			
Fixture	A51536		
Screen	B51540		
Stage	B50156		
SKETCH			
			
<i>.095 R.</i> <i>.090 R.</i>			
<i>A - LOCATING POINTS</i>			
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: <i>2/14/46</i>	
REVISIED AUG 26 1946			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: GRIND .095 RADIUS		OPER. No.: 7	
PROCESS RECORD			
OBsolete DEC 23 1946			
EQUIPMENT: Porter Cable Belt Sander			
SPEED:		FEED: Manual	
MAX. PROD. PER HOUR: 150		COOLANT: Soluble Oil	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
180 Grit Belt	B90093W	Swivel Type Fixture	C51141
Gage Comparator			
Fixture Screen Stage	A51536 B51540 B50156		
SKETCH			
			
- LOCATING POINTS			
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: <i>mfd 7/18/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: GRIND .095 RADIUS		OPER. No.: 7	
PROCESS RECORD			
EQUIPMENT: Porter Cable Belt Sander			
SPEED:		FEED: Manual	
MAX. PROD. PER HOUR: 150		COOLANT: <i>submerged</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
180 Grit Belt	B90093W	Swivel Type Fixture	C51141
Gage Comparator			
Fixture	A51536		
Screen	B51540		
Stage	B50156		
SKETCH			
Recypt 7/31 COMPLETE			
- LOCATING POINTS			
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: <i>W. P. 7/11/46</i>	
REMINGTON ARMS COMPANY, INC. MILTON, N. Y.			

PART: <i>Frame Pump Motor 14 721 722</i>		PART NO. <i>17023</i>	
OPERATION: <i>Frame 1000 X 1000</i>		OPER. NO. <i>1000</i>	
PROCESS RECORD			
EQUIPMENT: <i>Frame 1000 X 1000</i>			
SPEED:		FEED: <i>MANUAL</i>	
MAX. PROD. PER HOUR: <i>150</i>		COOLANT: <i>Cool</i>	
TOOLS & GAUGES		TOOL HOLDERS, NGS & FIXTURES	
TYPE	NO.	TYPE	NO.
<i>10 GRIT BELT</i>	<i>Pump Motor 14 721 722</i>	<i>Frame 1000 X 1000</i>	<i>DESIGN C-51141</i>
<i>COMPARATOR FIXTURE</i>	<i>A-51536</i>	<i>SKETCH FOR PICTURE</i>	
<i>STAGE</i>	<i>B-50156</i>		
<i>SCREEN</i>	<i>B-51540</i>		
<i>Case Use Comparator</i> <i>ABOUT 20X</i> <i>ON OPER. 2.6 but with</i> <i>FINISH DIMENSION LINE</i>			
<i>Complete for 7/2</i>		OBsolete	
COMPLETED BY: <i>TRACOS</i>		APPROVAL: <i>[Signature]</i>	
REMINGTON ARMS COMPANY, INC. SIMON, N. Y.			

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: SERRATE COCKING SURFACE		OPER. No.: 9	
PROCESS RECORD			
EQUIPMENT: Waterbury Farrel Press SPEED: FEED: Manual MAX. PRODUCTION HOUR: 101 COOLANT: Soluble Oil			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Shaving Punch	B51303	Shaving Die	C51301
Check Serrations by Visual Inspection	<i>Handwritten signature</i>		
SKETCH			
▲ - LOCATING POINT FIG. 7-8-46			
COMPILED BY: A. TRAVOSTINO		APPROVAL & DATE: <i>W. J. 7/1/50</i>	
REMINGTON ARMS COMPANY, INC. REVISED AUG 26 1946			

PART: FIRING PIN HEAD

PART No. 17023

OPERATION: SERRATE COCKING SURFACE

OPER. No.: 9

PROCESS RECORD

EQUIPMENT: Waterbury Farrel Press Press

SPEED: 2.4

FEED: Manual

MAX. PROD. PER HOUR: 101

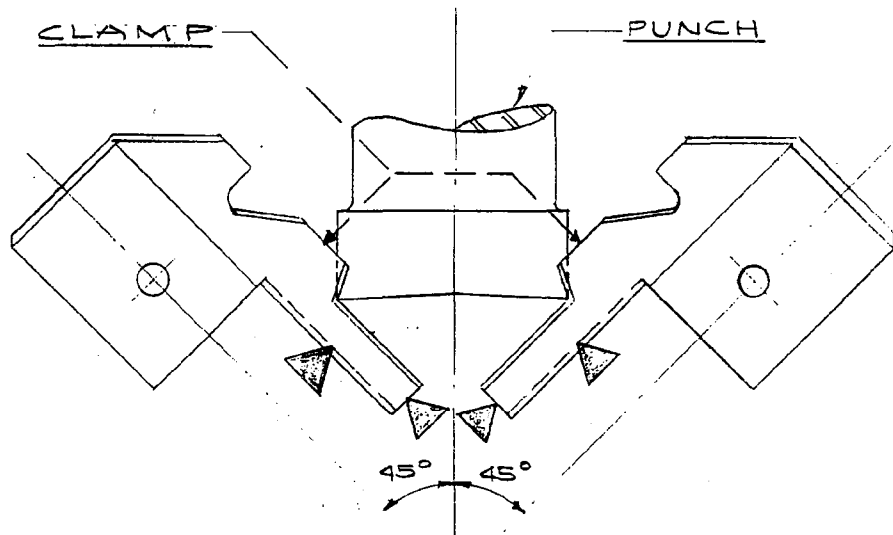
COOLANT: Soluble Oil

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
Shaving Punch	B51303	Shaving Die	C51301
Check Serrations by Visual Inspection			

SKETCH



▲ -LOCATING POINT

F.C. 7-8-46

COMPILED BY:

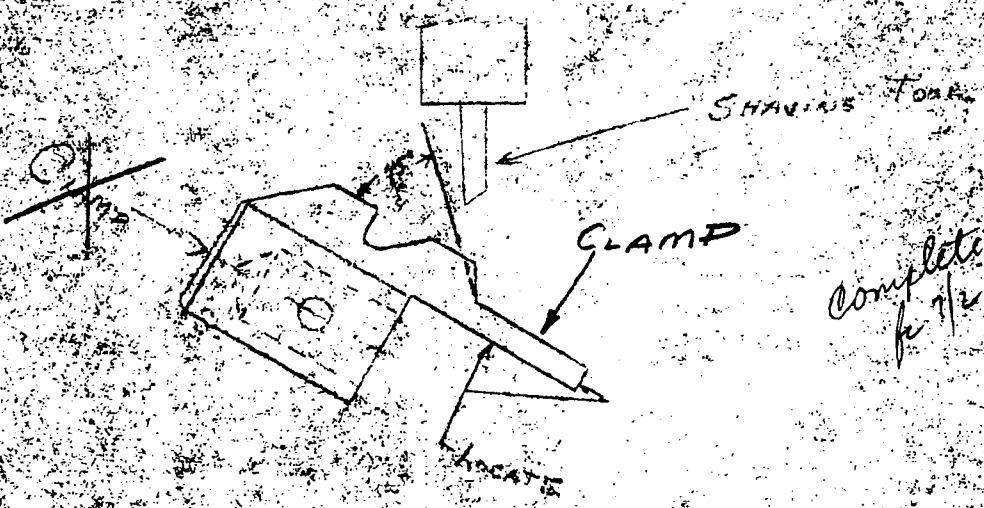
A. TRAVOSTINO

APPROVAL & DATE:

2/18/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FIRING PIN HEAD		PART No. 17023	
OPERATION: SERRATE COCKING SURFACE		OPER. No.: 9	
PROCESS RECORD			
EQUIPMENT: <i>Waterbury Farrel Press</i> #16 Bliss Shaving Press SPEED: _____ MAX. PROD. PER HOUR: 101 FEED: Manual COOLANT: AWC <i>soluble oil</i>			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Shaving Punch	B51303	Shaving Die	C51301
Check Serrations by Visual Inspection		<i>received 7/31</i> OBSOLETE	
SKETCH			
-LOCATING POINT COMPILED BY: A. TRAVOSTINO APPROVAL & DATE: <i>W.H. 7/18/46</i>			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: <i>FRONT PIN HEAD M 721 722</i>		PART NO. <i>127023</i>	
OPERATION: <i>SEPARATE COATING SURFACE</i>		OPER. NO. <i>100</i>	
PROCESS RECORD			
EQUIPMENT: <i># 16 BUSS SHAVING PRESS</i>			
SPEED: <i>150 STROKES/MIN</i>		FEED: <i>MANUAL</i>	
MAX. PROD. PER HOUR: <i>101</i>		COOLANT: <i>AIR</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE <i>SHAVING TOOL</i> <i>SEE DWG B17038</i> <i>FOR DETAIL OF SERRATIONS</i>	No. <i>DESIGN B-51303</i>	TYPE <i>SHAVING TOOL HOLDER</i> <i>DIE</i> <i>FIXTURE</i>	No. <i>DESIGN C-51301</i> <i>DESIGN</i>
<i>CHECK SERRATIONS</i> <i>BY VISUAL INSPECTION</i>		SKETCH 	
COMPLETED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FIRING PIN HEAD		PART No. 17023
OPERATION: CLEAN		OPER. No. 2 11
PROCESS RECORD NO.		
Obsolete FEB 23 1946 Equipment: Remington Constructed Ranschoff Baskets 20" x 23" x 5" deep 1/4" mesh 20" x 23" x 6" deep 1/2" mesh Drier 43" x 27" gas heated Detailed Description Standard Practice : 206 Temperature : 212° F. Time in Cleaning Chamber : 3 min. Spray Pressure : Full Load Size : 500 Drying Time : Not critical. 5 to 15 minutes. Remarks: Hole for Firing Pin must be clean, free from chips, oil, etc. <i>Parts must be thoroughly dry.</i>		
Operation: Inspect		Oper. No. 23
<i>Parts must be clean, free of oil and thoroughly dry. Heat treat operation follows.</i> <i>OK M. H. Moore</i>		
COMPILED BY: P. H. Eccleston 1/6/46		APPROVAL & DATE: <i>M. H. Moore</i>
REMINGTON ARMS COMPANY, INC. MILTON, N. Y.		

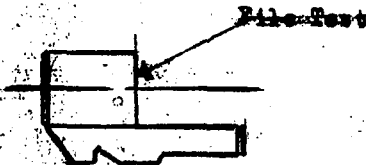
PART: FIRING PIN HEAD		PART No. 17023
OPERATION: CLEAN AND DRY		OPER. No.: 11
PROCESS RECORD #838		
<i>Refused</i> OBSOLETE FEB 85 1946 Equipment: Basket - 10" x 23" x 5". Detailed Description Load Size : _____ maximum. Method : Cycles : 1 Position of Components : Not critical. Standard Practice : #206 Remarks: Parts must be thoroughly dry as heat treat operations follow.		
COMPILED BY: P. H. Eccleston	APPROVAL & DATE: <i>MKS 8/20/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

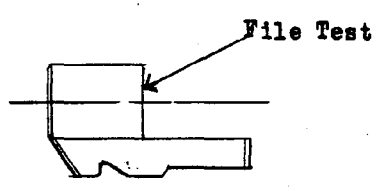
PART: Firing Pin Head		PART No. 17023
OPERATION: Clean and Dry		OPER. No.: 11
PROCESS RECORD #838		
Equipment: Ranschoff Washer Basket - 10" x 23" x 5"		
Detailed Description		
Load Size	:	_____ maximum.
Method	:	Quenching
Cycles	:	1
Position of Components:	Not critical.	
Standard Practice	:	#206
Remarks: Parts must be thoroughly dry as heat treat operations follow.		
<i>Retyped 7/31</i> OBSOLETE		
COMPILED BY: P. H. Eccleston		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Firing Pin Head		PART No. 17023
OPERATION: Clean and Dry		OPER. No.: 11
PROCESS RECORD #838		
Equipment: Ranschoff Washer Basket - 10" x 23" x 5" '		
Detailed Description		
Load Size	:	_____ maximum.
Method	:	Conveyor belt.
Cycles	:	1
Position of Components:	Not critical.	
Standard Practice	:	#206
Remarks: Parts must be thoroughly dry as heat treat operations follow.		
<i>Retyped 7/31</i>		
COMPILED BY: P. H. Eccleston		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Firing Pin Head		PART NO: 37029
OPERATION: Clean and Ins		OPER. NO: 11
PROCESS RECORD #328		
Equipment: Bauschhoff Washer Basket: 10" x 23" x 5"		
Detailed Description		
Load Size	maximum	
Method	Conveyor belt	
Cycles	1	
Position of Components	Not critical	
Standard Practice	#206	
Remarks: Parts must be thoroughly dry as heat treat operations follow.		
OBSOLETE		
COMPILED BY: P. H. Eccleston	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

PART: <i>Finishing Pin Gun</i>		PART No. <i>17123</i>			
OPERATION: <i>Inspect</i>		OPER. No.: <i>13</i>			
PROCESS RECORD — INSPECTION					
GAUGES		USE			
TYPE	No.		LIMITS		
			MAX. MIN.		
OBSOLETE					
GAUGING TABLE					
LOT SIZE	FIRST SAMPLE	ALLOWABLE No REJECTS	RETEST	TOTAL SAMPLE	TOTAL REJECTS ALLOWABLE
COMPILED BY:		APPROVAL & DATE:			
REMINGTON ARMS COMPANY, INC. MILION, N.Y.					

PART: Firing Pin Head		PART No. 17023
OPERATION: High Temperature Cyanide Harden, ^{Water} Quench, Wash and Dry		OPER. No.: 15
HEAT TREAT SPECIFICATION #397		
EQUIPMENT: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep		
DETAILED DESCRIPTION		
MATERIAL SPECIFICATION No.	116K	
MATERIAL:	C-1116	
TEMPERATURE:	1575 - 1600°F.	
CONTAINER:	Basket - 7-1/2" dia. x 6" deep	
MAXIMUM LOAD: - H. T.:	250 pieces - approximately 2" depth in basket	
TIME:	15 minutes at temperature	
QUENCH:	Oil W/Air	
Max. Load - Wash:	750 pieces	
STANDARD PRACTICE:	#198	
REMARKS:		
HEAT TREATMENT INSPECTION		
		Oper. No.: 17
Operation:	Inspect for File Hardness	
Standard Practice:	#163	
Hardness Limits:	File-Hard	
Appearance of Parts:	Steel grey color, clean, free of salt.	
		Next Oper. No.:
COMPILED BY: B. O. Andrews	APPROVAL & DATE: R.H. Shaw 11/23/55	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

PART: Firing Pin Head		PART No. 17023
OPERATION: High Temperature Cyanide Harden, Oil Quench, Wash and Dry		OPER. No.: 15
HEAT TREAT SPECIFICATION #397		
EQUIPMENT: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep		
DETAILED DESCRIPTION		
MATERIAL SPECIFICATION No.:	116K	
MATERIAL:	C-1118	
TEMPERATURE:	1575 - 1600°F.	
CONTAINER:	Basket - 7-1/2" dia. x 6" deep	
MAXIMUM LOAD: - H. T.:	250 pieces - approximately 2" depth in basket	
TIME:	10 minutes at temperature	
QUENCH:	Oil	
Max. Load - Wash:	750 pieces	
STANDARD PRACTICE:	#198	
REMARKS:		
HEAT TREATMENT INSPECTION		
		Oper. No.: 17
Operation:	Inspect for File Hardness	
Standard Practice:	#163	
Hardness Limits:	File Hard	
Appearance of Part:	Steel grey color, clean, free of salt.	
COMPILED BY: B. C. Andrews		Next Oper. No.:
APPROVAL & DATE:		
		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Filing Pin Head		PART NO. 17083	
OPERATION: High Temperature Cyanide Harden, Oil Quench, Wash and Dry		TEMP. NO. 17	
HEAT TREAT SPECIFICATION #171			
EQUIPMENT: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep			
DETAILED DESCRIPTION			
MATERIAL SPECIFICATION No. 116X			
MATERIAL: C81115			
TEMPERATURE: 1575 - 1600°F			
CONTAINER: Basket - 7-1/2" dia. x 6" deep			
MAXIMUM LOAD: - H. T. 1 - 150 pieces - approximately 2" depth in basket			
TIME: 45 minutes at temperature			
QUENCH: Oil			
Max. Load - Wash: 150 pieces			
STANDARD PRACTICE: 171			
REMARKS:			
			
HEAT TREATMENT INSTRUCTION			
Operation: Inspect for File Hardness			
Standard Practice: 171			
Hardness Limit: 171			
Appearance: 171			
Compiled by: 171			
Approval: 171			
REMINGTON ARMS COMPANY KINC. 171			

OBsolete

Part *FIRING P. HEAD*

Part No. *17023*

Operation: *Nitro Draw, Water Quench, Air Cool, Wash & Dry*
~~and oil for storage.~~

Oper. No. *17*

HEAT TREATMENT SPECIFICATION NO. _____

Equipment: Remington Gas-fired Nitro Pot Furnace - 13-3/4" x 37-1/2" x 11"

Detailed Description

Material Specification No.: *1164*

Material : *1115*

Temperature : *600° F*

Container : Wire mesh basket - 19" x 12" x 3"
~~Fine wire mesh basket 19" x 12" x 3"~~

Maximum Load : *1000* = approximately *1/2* basket.

Time : *30* minutes total

Quench : Air Cool, ~~Water~~

Standard Practice : #201, 202

Remarks:



Rockwell Test

HEAT TREATMENT INSPECTION

Oper. No.:

Operation: Inspect for Rockwell Hardness, Color and Oil

Standard Practice : ~~#165~~ - *1115* Anvil, #165

Hardness Limits : ~~Re~~ - *15N - 83-88*

Appearance of Part : *Gray* color, clean, free of salt, ~~well oiled for storage.~~

~~To Part Storage~~

Next Oper. No.: *19*

Oiled By:

Approval & Date:

0118
1/15

APP. NO. 200-1000	PAGE NO. 1
OPERATION: Ball Burnish	OPER. NO. 1
PROCESS RECORD #343	
Equipment: Burnishing Barrel - 15 1/2 dia. x 7-1/2" wide Burnishing Medium - 5/16" case hardened steel balls and rings	
Detailed Description	
Electro-Clean and Pickle: Standard Practice #85. Temperature _____ °F. Time: _____ minutes	
Ball Burnish: Add approximately 6 balls of granule to burnishing barrel for that particular component.	
Load Size: _____ Places.	
Time Cycle: _____ Set timer for _____	
Separation of Medium and Components: Transfer load to screen. Shake screen.	
Rinse: Clean, boiling water. Dry with compressed air.	
Standard Practice: #212	
OBSOLETE	
COMPILED BY: P. H. EGGLESTON	APPROVAL & DATE
REMINGTON ARMS COMPANY, INC., ILION, N.Y.	

PART: <i>Firing Pin Head</i>		PART No. <i>17023</i>	
OPERATION: <i>STRIP BUIERS</i>		OPER. No.: <i>21</i>	
PROCESS RECORD			
EQUIPMENT: <i>BENCH</i> SPEED: _____ FEED: _____ MAX. PROD. PER HOUR: _____ COOLANT: _____			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
		<i>FIXTURE</i>	<i>D52806</i>
SKETCH			
COMPILED BY: _____		APPROVAL & DATE: _____	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

ON-SITE
FEB 13 1947

Form 33-118

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Name Firing Pin Head

Component No. 17023

Operation Spot drill, drill & Ream Small Hole

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

3/3/47
Date

R. W. Selwood
Process Engineer

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Name Firing Pin Head

Component No. 17023

Operation 1

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

12/5/46
Date

R. Angell
Process Engineer

Form RT-118

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Name Firing Pin Head

Component No. 17023

Operation Inable To Remove Bullet

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

MAR 20 1947
Date

R. W. Selwood
Process Engineer

OBSOLETE

Revised

PROCESS RECORD

FIRING PIN CROSS YIN
PART No. 17022

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____

DEPARTMENT

PART: <i>FIRING PIN CROSS PIN</i>		PART No. <i>17022</i>	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
<i>1</i>		<i>MATERIAL PROCUREMENT</i>	
<i>2</i>	<i>1</i>	<i>PURCHASE INSPECTION</i>	
<i>3</i>		<i>TRANSFER TO PART STORES</i>	
COMPILED BY: <i>H. H. S.</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

H. H. SULLIVAN, INC.

OBsolete

FIRING PIN CROSS PIN

PART No.

17022

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE

DESCRIPTION OF CHANGE

Retyped

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

Received
10/23

PART: Firing Pin Cross Pin (Purchase ready for Assembly)		PART No. 17022	
Date: 5-25-46			
MATERIAL PROCUREMENT - FINISHED COMPONENT			
Detailed Description		REV. NO.	DATE
Remington Planning		1	6-21-46
		2	10-23-46
Pieces Required Per Assembly: 1			
Uses of Part : M/721 - All Calibers			
: M/722 - All Calibers			
Minimum Order Quantity : 25,000 pieces			
Vendor			
Material	: SAE 52100 Packing slip to show material used for each shipment of parts.		
Heat Treatment	: Harden and Temper		
Hardness	: This pin is too small to permit accurate hardness testing. Sample pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 60° before fracture.		
Final Appearance	: Black Oxide Color. Parts to be free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)		
Packaging	: Purchase Order No. and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.		
Acceptance Testing:			
Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.			
Inspections:			
Gage No.	Type	Use	AQCL
1.	Fracture	Hardness	7%
2. Std. Finish Blocks	Visual	Surface Finish	7%
3. B-80024W	Adj. Snap Ga.	Length	7%
4. B-80055U → <i>V</i>	Dial Snap Ga.	Diameter	7%
B-80058W	Master		
COMPILED BY: B.C. Andrews		APPROVAL & DATE: <i>W.H.S. 10/23/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

W.H.S.
10/23/46

PART: Firing Pin Cross Pin (Purchase ready for Assembly)	PART No. 17 ABSOLUTE																																												
Date: 5-28-46																																													
MATERIAL PROCUREMENT - FINISHED COMPONENT																																													
Detailed Description Remington Planning Pieces Required Per Assembly: 1 Uses of Part : M/721 - All Calibers M/722 - All Calibers Minimum Order Quantity : 25,000 pieces Vendor Material : SAE 52100 Packing slip to show material used for each shipment of parts. Heat Treatment : Harden and Temper Hardness : This pin is too small to permit accurate hardness testing. Sample pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 60° before fracture. Final Appearance : Black Oxide Color. Parts to be free of rust, oiled with light rust proofing oil (SAE-20 or equiv.) Packaging : Purchase Order No. and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs. Acceptance Testing: Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed. Inspection: <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left; border-bottom: 1px solid black;">Gage No.</th> <th style="text-align: left; border-bottom: 1px solid black;">Type</th> <th style="text-align: left; border-bottom: 1px solid black;">Use</th> <th style="text-align: left; border-bottom: 1px solid black;">AQL</th> </tr> </thead> <tbody> <tr> <td>1.</td> <td>Fracture</td> <td>Hardness</td> <td>7%</td> </tr> <tr> <td>2. Std. Finish Blocks</td> <td>Visual</td> <td>Surface Finish</td> <td>7%</td> </tr> <tr> <td>3. B-80024W</td> <td>Adj. Snap Ga.</td> <td>Length</td> <td>7%</td> </tr> <tr> <td>4. B-80035U</td> <td>Dial Snap Ga.</td> <td>Diameter</td> <td>7%</td> </tr> <tr> <td> B-80038W</td> <td>Master</td> <td></td> <td></td> </tr> </tbody> </table>	Gage No.	Type	Use	AQL	1.	Fracture	Hardness	7%	2. Std. Finish Blocks	Visual	Surface Finish	7%	3. B-80024W	Adj. Snap Ga.	Length	7%	4. B-80035U	Dial Snap Ga.	Diameter	7%	B-80038W	Master			<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="text-align: center; padding: 2px;">REV No.</th> <th style="text-align: center; padding: 2px;">DATE</th> </tr> <tr> <td style="text-align: center; padding: 2px;">1</td> <td style="text-align: center; padding: 2px;">6-20-46</td> </tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> <tr><td style="height: 15px;"></td><td></td></tr> </table>	REV No.	DATE	1	6-20-46																
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4. B-80035U	Dial Snap Ga.	Diameter	7%																																										
B-80038W	Master																																												
REV No.	DATE																																												
1	6-20-46																																												
COMPILED BY: B.C.Andrews																																													
APPROVAL & DATE: <i>J.W. Smith 5/27/46</i>																																													
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																																													

PART Firing Pin Cross Pin (Purchase ready for Assembly)

PART NO. 17022

MATERIAL PROCUREMENT

Finished Component
~~#795 (Replaces #321)~~

Detailed Description

OBSOLETE

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721- All Calibers; M/722 - All Calibers
Minimum Order Quantity : 25,000 pieces

Vendor

Material : SAE 52100
Parking slip etc.
~~Surface Finish : Smooth surface. 16-microinch ground finish or finer~~
Heat Treatment : Harden and Temper
Hardness : ~~Rockwell C 50-55~~
Final Color : Black Oxide Color. Parts to be free of rust, oiled for rust protection with light. (SAE-20 or equiv.) oil

Packaging : Ship in containers of 5,000 to 10,000 pieces
Each container 8. 2

Acceptance Gages: Length - Adj. Snap Ga. B-80024W
Diameter - Dial Snap Gage, B-80035U
Master - Dwg. #B80038W

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each shipment of parts.

Hardness - This pin is too small to permit accurate hardness testing. ~~Thirty~~ 36 pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 30° before fracture. ~~If no more than 1 of the 36 pins fail to meet this requirement, the lot will be accepted.~~

Finish - Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.

Gaging - A random sample of 36 pieces will be selected for gaging. If no more than 1 piece fails to meet dimensions specified on drawing, lot will be accepted.

Gage No. 1444 Use AOQ1

*Fracture Hardness 77°
Visual inspection 77°
80024W*

COMPILED BY B. C. Andrews

APPROVAL & DATE

MYD 2/22/46

REMINGTON ARMS COMPANY, INC., ILION, N.Y.

OBSOLETE

PART Firing Pin Cross Pin (Purchase ready for Assembly)		PART NO. 17022
MATERIAL PROCUREMENT #795 (Replaces #321)		
Detailed Description		
Remington Planning		
Pieces Required Per Assembly: 1		
Uses of Part : M/721- All Calibers; M/722 - All Calibers		
Minimum Order Quantity : 25,000 pieces		
Vendor		
Material	:	SAE 52100
Surface Finish	:	Smooth surface. 16 microinch ground finish or finer
Heat Treatment	:	Harden and Temper
Hardness	:	Rockwell C30-45
Final Color	:	Black Oxide Color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil
Packaging	:	Ship in containers of 5,000 to 10,000 pieces.
Acceptance Gages: Length - Adj. Snap Ga. B-80024W		
Diameter - Dial Snap Gage, B-80035U		
Master - Dwg. #B80038W		
Acceptance Testing:		
Chemical	-	Signed statement of analysis to accompany each shipment of parts.
Hardness	-	This pin is too small to permit accurate hardness testing. Thirty-six pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 30° before fracture. If no more than 4 of the 36 pins fail to meet this requirement, the lot will be accepted.
Finish	-	Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.
Gaging	-	A random sample of 36 pieces will be selected for gaging. If no more than 4 pieces fail to meet dimensions specified on drawing, lot will be accepted.
COMPILED BY B. C. Andrews		APPROVAL & DATE <i>MVA 2/22/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART Firing Pin, Cross-Pin (Purchase ready for Assembly)		PART NO. 17022
MATERIAL PROCUREMENT #795 (Replaces #321)		
Detailed Description		
Remington Planning		
Pieces Required Per Assembly:	1	
Uses of Part	: M/721- All Calibers; M/722 - All Calibers	
Minimum Order Quantity	: 25,000 pieces	
Vendor		
Material	: SAE 52100	
Surface Finish	: Smooth surface. 16 microinch ground finish or finer	
Heat Treatment	: Harden and Temper	
Hardness	: Rockwell C30-45	
Final Color	: Black Oxide Color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil	
Packaging	: Ship in containers of 5,000 to 10,000 pieces.	
Acceptance Gages:	Length - Adj. Snap Ga. B-80024W	
	Diameter - Dial Snap Gage, B-80035U	
	Master - Dwg. #B80038W	
Acceptance Testing:		
Chemical	- Signed statement of analysis to accompany each shipment of parts.	
Hardness	- This pin is too small to permit accurate hardness testing. Thirty-six pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 5° and not more than 30° before fracture. If no more than 4 of the 36 pins fail to meet this requirement, the lot will be accepted.	
Finish	- Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used.	
Gaging	- A random sample of 36 pieces will be selected for gaging. If no more than 4 pieces fail to meet dimensions specified on drawing, lot will be accepted.	
COMPILED BY R. C. Andrews		APPROVAL & DATE <i>MYH 2/22/46</i>
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

PART Firing Pin Cross Pin (Purchase ready for Assembly)	PART NO. 17022
MATERIAL PROCUREMENT #596 (Replaces #321)	
Detailed Description	
Remington Planning Pieces Required Per Assembly: 1 Uses of Part : M/721 - All Calibers; M/722 - All Calibers Minimum Order Quantity : 25,000 pieces	
Vendor Material : SAE 52100 Surface Finish : Smooth surface. 16 microinch ground finish or finer. Heat Treatment : Harden and Temper Hardness : Rockwell C30-45 Final Color : Black Oxide Color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil Packaging : Ship in containers of 5,000 to 10,000 pieces. Acceptance Gages: Length - Dial Comparator Gage, Federal #35B-8 Dial - C-6-0 <i>Adj. snap ga B-80024W</i> Point - Taper Feature - Dwg. # Diameter - Dial Snap Gage, Federal #194D <i>B-80038W</i> Master - Dwg. # <i>B 80038 W</i>	
Acceptance Testing: Chemical - Signed statement of analysis to accompany each shipment of parts. Hardness - This pin is too small to permit accurate hardness testing. Thirty-six pieces will be selected at random from each container and fractured. Grain must be fine. Pins are expected to take a permanent set of at least 50° and not more than 30° before fracture. If no more than 4 of the 36 pins fail to meet this requirement, the lot will be accepted. Finish - Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent will be used. Gaging - A random sample of 36 pieces will be selected for gaging. If no more than 4 pieces fail to meet dimensions specified on drawing, lot will be accepted	
COMPILED BY B. C. Andrews	APPROVAL & DATE
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART: FIRING PIN CROSS PIN

PART No. 17022

OPERATION: PURCHASE & INSPECTION

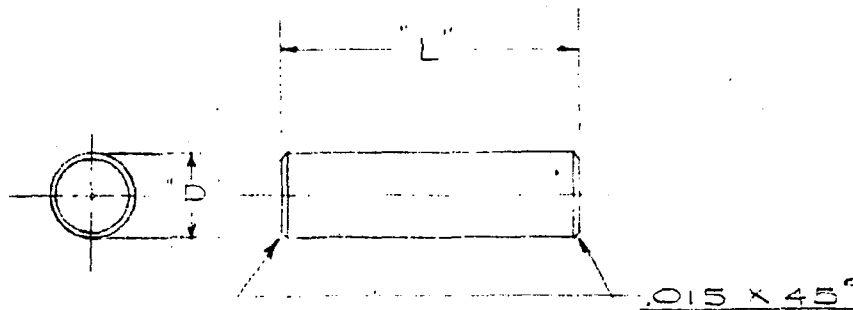
OPER. No.: ...

Revised
10/23
OBsolete

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Visual		Inspect for Defects and Taper		
Adj. Snap Gage	B-80024-W	"L" length .437	.437	.437
Adj. Dial Snap	L-80035-U	"D" diameter .0936	.0936	.0936
Master	B-80032-W			

SKETCH



MPS
10/22/06

COMPILED BY:

L-21 46 E. R. Wheat

APPROVAL & DATE:

REVISED AUG 26 1946

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBsolete

PART: FIRING PIN CROSS PIN

PART No. 17022

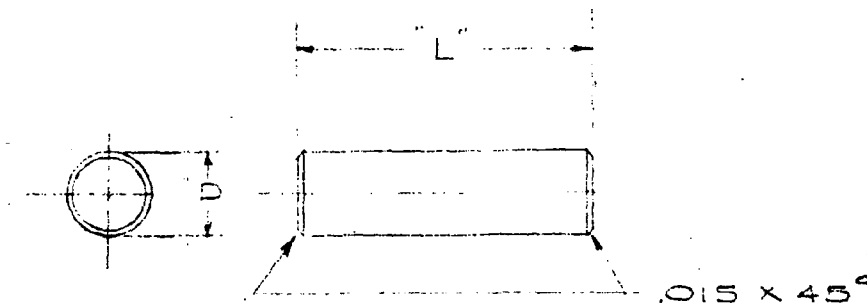
OPERATION: ~~FINAL~~*Purchase Inspection*

OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Visual		Inspect for defects and Taper		
Ang. Comp. Gauge	E-S0024-W	"L" length .0017		
Ang. Diam. Gauge	E-S0035-W	"D" diameter .0016		
Master	E-S0038-W			

SKETCH



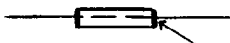
COMPILED BY:

1-21-40 E. K. Wheat

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin Cross Pin	PART No. 17022
OPERATION: Nitre Black, Water Quench, Wash, Dry and Oil for storage	OPER. No.:
HEAT TREAT SPECIFICATION #396	
EQUIPMENT: Remington Gas-fired Nitre Pot Furnace #8 - 13-3/4" x 37-1/2" x 11"	
DETAILED DESCRIPTION	
MATERIAL SPECIFICATION No.: 118	OBSOLETE
MATERIAL: 1095 Drill Rod	
TEMPERATURE: 900 - 950°F.	
CONTAINER: Fine wire mesh basket - 19" x 12" x 3"	
MAXIMUM LOAD: 10,000 pieces = approximately 1/4 basket	
TIME: 10 minutes total	
QUENCH: Water	
STANDARD PRACTICE: #200	
REMARKS: The ends of this pin show on the outside of the gun; hence, should have uniform color. Nitre Black is applied for rust resistance.	
	
HEAT TREATMENT INSPECTION	
Oper. No.:	
Operation: Inspect for Color and Oil	
Standard Practice: #165	
Appearance of Part: Black Color, clean, free of salt, well oiled for storage.	
To Part Stores:	
COMPILED BY: B. C. Andrews	APPROVAL & DATE: <i>R.H. Grace 11/23/45</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART: Firing Pin Cross Pin		PART No. 17022
OPERATION: Low Temperature Neutral Salt Harden, Oil Quench, Wash and Dry		OPER. No.:
HEAT TREAT SPECIFICATION #395		
EQUIPMENT: Remington Gas-fired Pot Furnace - 12" dia. x 12" deep		
DETAILED DESCRIPTION		
MATERIAL SPECIFICATION No.:	118	
MATERIAL:	1095 Drill Rod	
TEMPERATURE:	1425 - 1450°F.	
CONTAINER:	Fine mesh basket - 7-1/2" dia. x 6" deep	
MAXIMUM LOAD: - H.T.:	7500 pieces = approximately 3/4" depth in basket	
TIME:	10 minutes at temperature	
QUENCH:	Oil	
Max. Load - Wash	7500 pieces	
STANDARD PRACTICE:	#199	
REMARKS:	OBSOLETE  File Test	
HEAT TREATMENT INSPECTION		
		Oper. No.:
Operation:	Inspect for File Hardness	
Standard Practice:	#163	
Hardness Limits:	File Hard	
Appearance of Part:	Steel grey color, clean, free of salt.	
		Next Oper. No.:
COMPILED BY: B. C. Andrews	APPROVAL & DATE: <i>P. H. Grace</i> 11/23/45	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

Form RT-118 .

OK

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Firing Pin Cross Pin 17022

Operation Entire Process

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

10/25/46
Date

R. H. Schwood
Process Engineer

PROCESS RECORDS TURNED OVER TO PLANT

Model 721
Component Firing Pin 17021
Operation Sequence

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

8/26/46
Date

H. W. Lupton
Process Engineer

ok.

Form RT-118

PROCESS RECORDS TURNED OVER TO PLANT

Model 721
Component Firing Pin 17021
Operation op# 7, 11

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

11/27/46
Date

R. W. Selman
Process Engineer

10/2
OBsolete
Relayed

*omit Dwg
prefixes*

PROCESS RECORD

FIRING PIN

Ⓟ B17021 W,V

MODEL 721-722

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____

DEPARTMENT

Retyped
OBsolete
10/2

PROCESS RECORD

FIRING PIN

B-17021 W,V

MODEL 721-722

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____

DEPARTMENT

PROCESS RECORD

Firing Pin

B 17021 W V

OBSOLETE

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO:

DEPARTMENT

PART: FIRING PIN		PART NO. 17021 W.V.	
SEQUENCE OF OPERATIONS			
<i>Retired</i> DESOLETE			
SE. NO.	OPER. NO.	OPERATION	DEPT.
10/2	1	Finish Turn	
2	3	Clean	
3	5	Inspect	
4	7	High Temperature Neutral Salt Harden, Oil Quench, Wash and Dry.	
5	9	Inspection for Rockwell Hardness	
6	11	Nitre Draw, Water Quench, Wash and Oil for Storage.	
7	13	Inspect for Rockwell Hardness, Color and Oil.	
COMPILED BY: A. Travostina		APPROVAL & DATE: <i>mds 8/20/46</i>	

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FIRING PIN

PART No. 17021 W,V

SEQUENCE OF OPERATIONS

OBSCLETE

10/2

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1	Finish Turn	
2	3	Clean	
3	5	Inspect	
4	7	High Temperature Neutral Salt Harden, Oil Quench, Wash and Dry.	
5	9	Inspection for Rockwell Hardness	
6	11	Nitre Draw, Water Quench, Wash and Oil for Storage.	
	13	Inspect for Rockwell Hardness, Color and Oil.	
COMPILED BY: A. Travostino		APPROVAL & DATE: <i>mks 8/20/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: Firing Pin		PART NO. 17021 W,V	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1	Finish Turn	
2	3	Clean	
3	5	Inspect	
4	7	High Temperature Neutral Salt Harden, Harden Front End Oil Quench, Wash and Dry	
5	9	Inspect Inspection for Rockwell Hardness	
6	11	Temper Front End Nitro Draw, Water Quench, Wash and Oil for Storage	
	13	Inspect for Rockwell Hardness, Color and Oil.	
COMPILED BY: A. Travostino		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

12-17-71
OBSOLETE

PART: Firing Pin		PART NO. 17021 W,V	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
	1	Finish Turn	
	3	Clean	
	5	Inspect	
	7	Harden Front End	
	9	Inspect	
	11	Temper Front End	
	13	Inspect	
COMPILED BY: A. Travostino		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

FIRING PIN		PART No. 17021 W V	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
	1	FINISH TURN	
	3	CLEAN	
	5	• INSPECT	
	7	HARDEN FRONT END	
	9	INSPECT	
	11	TEMPER FRONT END	
	13	INSPECT	
OBsolete			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: Firing Pin		PART No. 17021-N, V
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
5/24/46	Process Record Sheets retyped and tool and gage numbers added.	
<i>Transmit as clean sheet</i>		
COMPILED BY: A. Travostino		APPROVAL & DATE:

PART: Firing Pin

PART No. 17021-W,V

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
5/24/46	Process Record Sheets retyped and tool and gage numbers added.
COMPILED BY: A. Travostino	
APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART: Firing Pin	PART No. 17021W 17021V																				
Date: 5/27/46																					
MATERIAL PROCUREMENT - RAW MATERIAL																					
Detailed Description Pieces Required Per Assembly: 1 Material Specification : 117K Material : C-1137 Size : .4062 ± .0005" dia. Bars to be 11'7" long. 10% random shorts acceptable down to 5'2" in multiples of 7", plus 6" per bar. Condition : Centerless Ground Weight Per 100 : Calculated: 17021W - 21.16 lbs. 17021V - 21.24 lbs. Measured : <u>21.16</u> Additional Uses of Material : Uses of Part5 : 17021W - M/721, All Calibers 17021V - M/722, All Calibers Identification of Material : Routing ticket to be marked Mat. Spec. #117K. Remarks: 1. This material is to be boxed. Maximum weight per box- 200 lbs. Bars are to be oiled with a light rust proofing oil (SAE-20 or equiv.) and must be free of dirt and grit. 2. This material is to be stored in boxes until fed into machine for manufacture of parts.	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="width: 50%;">REV. No.</th> <th style="width: 50%;">DATE</th> </tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </table>	REV. No.	DATE																		
REV. No.	DATE																				
COMPILED BY: B.C. Andrews	APPROVAL & DATE: MPL 5/27/46																				
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																					

OK - as is
 GH Tech
 with R.H.
 10/12

OBSOLETE

PART: Firing Pin

PART NO. 17021W
17021VMATERIAL PROCUREMENT *New Material*
~~#636 (Replaces #507)~~

Detailed Description

Pieces Required Per Assembly: 1

Material Specification : 117K

Material : 0-1137

Size : .4062 $\pm$.0005" dia. Bar Stock. Bars to be 11.7" long.
10% random shorts acceptable down to
5.2" in multiples of 7", plus 6" per
bar.

Condition : Centerless Ground

Weight Per 100 : Calculated: 17021W - 24.16 lbs. Measured:
17021V - 21.24 lbs.

Additional Uses of Material :

Uses of Part : 17021W - M/721, All Calibers
17021V - M/722, All Calibers

Identification of Material : Routing ticket to be marked Mat. Spec. #117K.

Remarks: #1. This material is to be boxed. Maximum weight per box - 200 lbs. Bars
are to be oiled with a light rust proofing oil (SAB-20 or equiv.) and
must be free of dirt and grit.#2. This material is to be stored in boxes until fed into machine for manu-
facture of parts.~~#Check~~

COMPILED BY B. C. Andrews

APPROVED & DATE

AWP
2/6/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART. Firing Pin

PART NO. 17021W
17021V**OBsolete**

MATERIAL PROCUREMENT #630*(Replaces #507)

Detailed Description

Pieces Required Per Assembly: 1

Material Specification : 117K

Material : C-1137

Size : .4062 $\pm$.0005" dia. Bar Stock. Bars to be 11'7" long.
10% random shorts acceptable down to
5'2" in multiples of 7", plus 6" per
bar.

Condition : Centerless Ground

Weight Per 100 : Calculated: 17021W - 24.16 lbs. Measured: _____
17021V - 21.24 lbs.

Additional Uses of Material :

Uses of Part : 17021W - M/721, All Calibers
17021V - M/722, All Calibers

Identification of Material : Routing ticket to be marked Mat. Spec. #117K.

Remarks: *1. This material is to be boxed. Maximum weight per box - 200 lbs. Bars
are to be oiled with a light rust proofing oil (SAE-20 or equiv.) and
must be free of dirt and grit.*2. This material is to be stored in boxes until fed into machine for manu-
facture of parts.

*Changed 2/6/46

COMPILED BY B. C. Andrews

APPROVAL & DATE *P. H. L. 2/6/46*

REMINGTON ARMS COMPANY, INC., ILION, N. Y..

PART Firing Pin		PART NO. 17021W 17021V
MATERIAL PROCUREMENT #630*(Replaces #507)		
Detailed Description		
Obsolete Pieces Required Per Assembly: 1 Material Specification : 117K Material : C-1137 Size : .4062 ±.0005" dia. Bar Stock. Bars to be 11'7" long. 10% random shorts acceptable down to 5'2" in multiples of 7", plus 6" per bar. Condition : Centerless Ground Weight Per 100 : Calculated: 17021W - 24.16 lbs. Measured: _____ 17021V - 21.24 lbs. Additional Uses of Material : Uses of Part : 17021W - M/721, All Calibers 17021V - M/722, All Calibers Identification of Material : Routing ticket to be marked Mat. Spec. #117K. Remarks: *1. This material is to be boxed. Maximum weight per box - 200 lbs. Bars are to be oiled with a light rust proofing oil (SAE-20 or equiv.) and must be free of dirt and grit. *2. This material is to be stored in boxes until fed into machine for manufacture of parts. *Changed 2/6/46		
COMPILED BY B. C. Andrews	APPROVAL & DATE <i>R. H. Grace 2/6/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y..		

Part: **Firing Pin**

Part No.: **17021W**
17021V

Operation: **Induction Harden Front End, Wash and Temper**

Oper. No.:

HEAT TREATMENT SPECIFICATION NO. 423

Equipment: **Induction Heating Machine - Tosco**
Lindberg Tempering Furnace - #2 and 3 - Laboratory Area
Detailed Description

Material Specification No.: **117K**

Material : **C-1137**

Temperature : **1525 - 1550°F.**

Power Setting : Volts:

Fixture No. : Heating Coil No.:

Pcs. Heated Per Cycle :

Heating Time :

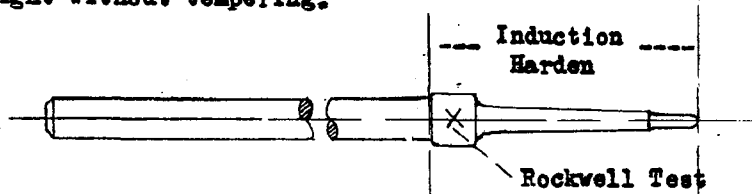
Quench Time : Quench Medium:

Total Cycle Time :

Clean : **Agitate in alkaline cleaning bath. Drain.**

Temper : **350 - 375°F; 20 - 40 minutes; Air Cool.**

Standard Practice :

Remarks: **Temper as soon as possible after hardening. Do not allow pieces to stand over night without tempering.**


HEAT TREATMENT INSPECTION

Oper. No.:

Operation: : **Inspect for Rockwell Hardness and Color**

Standard Practice : **#164**

Hardness Limits : **Rc 50 min.**

Appearance of Part :

Next Oper. No.:

Compiled By: **B. C. Andrews**

Approval & Date:

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

PART: Firing Pin

17021V

17321V

MATERIAL PROCUREMENT #330 507 (Ref. 17021V)

Detailed Description

Pieces Required Per Assembly : 1

Material Specification : ~~117K~~ 117K.

Material : C-1137 *

Size : ~~1.000~~ .0005" dia. Bar Stock - Approx. 12' lengths
~~1.000~~ .0005" long. 11% random shorts
acceptable down to 5' 2"

Condition : Cold ~~drawn~~ in multiples of 7" plus 6" for bar

Weight Per 100 : Calculated: 24.16-lbs. Measured: ~~21.24 lbs~~ *

Additional Uses of Material : ~~17021V~~ 17021V

Uses of Part : M/72 - All calibers 17021V *
M-722 - all Calibers

Identification of Material : Routing ticket to be marked Mat. Spec. #117K

Remarks:

* changed (2/21/45)

COMPILED BY B. C. Andrews

APPROVAL & DATE

DATE: 07-10-45

NO. 17027

MATERIAL PROCEDURE SHEET

Designation: 100

Plates Required Per Assembly: 1

Material Specification: 1018

Material: 1018

Size: 1018

Condition: 1018

Weight Per 100: 1018

Amount Used: 1018

Unit: 1018

Quantity: 1018

1018

1018

1018

1018

Calculated: 1018

1018

1018

1018

COMPILED BY: E. C. Andrews

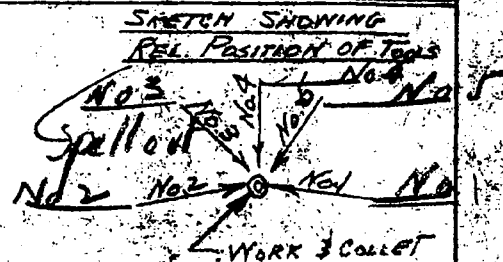
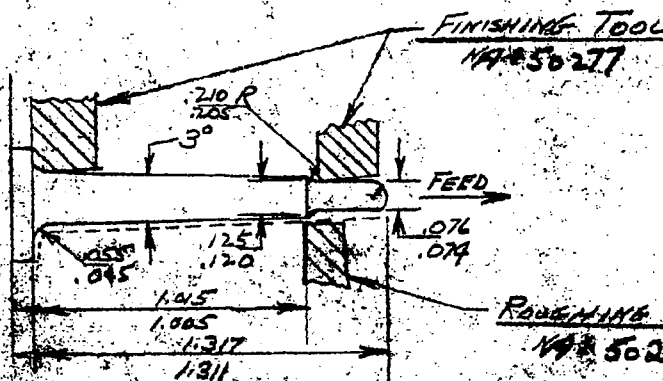
APPROVAL & DATE

10/10/45

REMINGTON ARMS COMPANY, INC., ILION, N.Y.

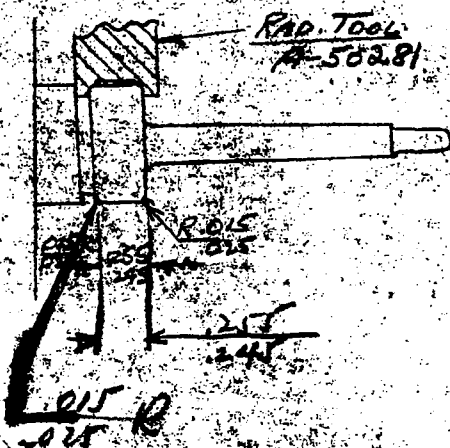
PART:	FIRING PIN	PART NO.	17021-W
OPER. NO.	FINISH TURN - Sheet #1	OPER. No.	

PROCESS RECORD — ILLUSTRATION SKETCH



ROUGHING TOOL
No. 50280

2)

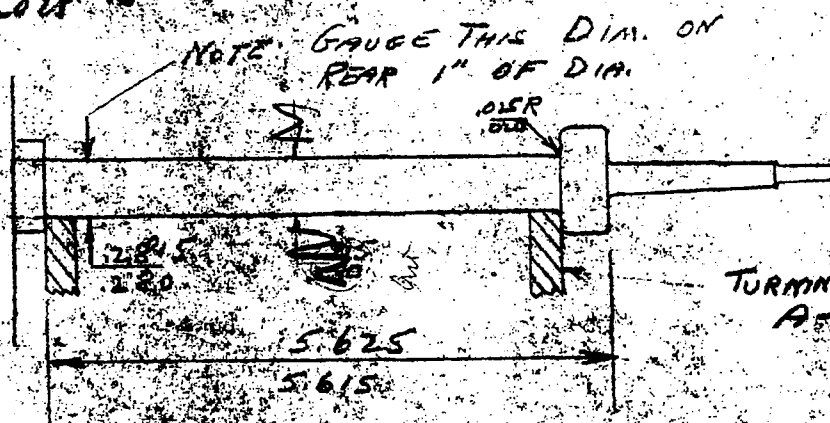


O2alid sheet
\$ type numbers
\$ legends

~~Omit dog prefixes~~

3)

3.



COMPILED BY:

BAILEY

APPROVAL & DATE

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

PART:

FIRING PIN

PART No.

17021-W

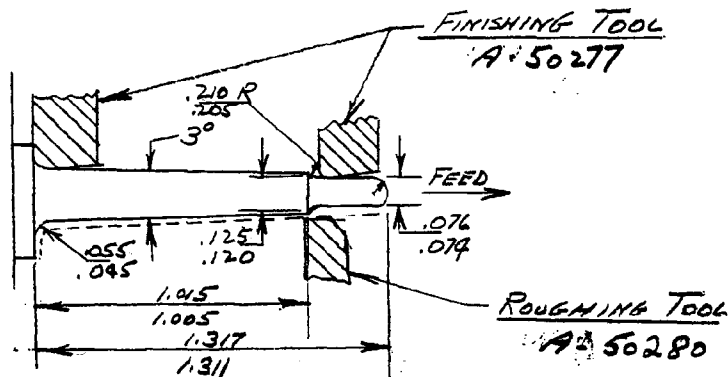
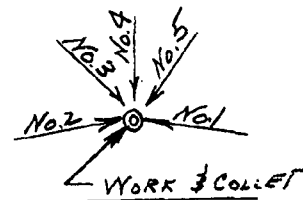
OPER. No.:

FINISH TURN

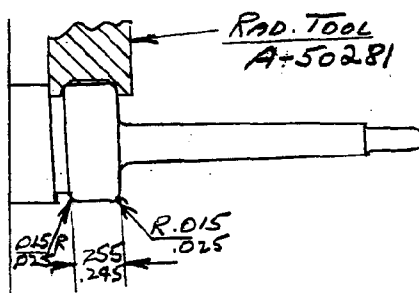
OPER. No.: 1

PROCESS RECORD — ILLUSTRATION SKETCH

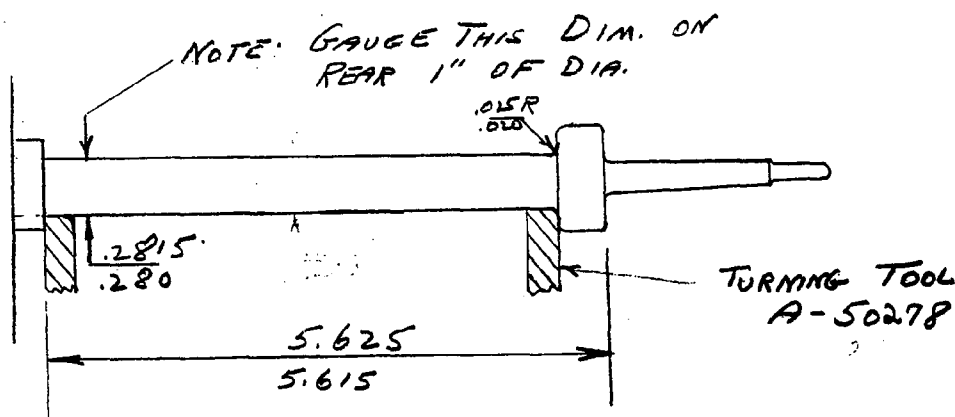
1/

SKETCH SHOWING
REL. POSITION OF TOOLS

2/



3/



COMPILED BY:

BOWLING

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FIRING PIN	PART No. 17021-W
OPERATION: FINISH TURN	OPER. No. 1
PROCESS RECORD — ILLUSTRATION SKETCH	

1/

FINISHING TOOL
No. 4 A-50277

ROUGHING TOOL
No. 4
A-50280

SKETCH SHOWING
REL. POSITION OF TOOLS

2/

RAD. TOOL
No. 5 A-50281

3/

NOTE: GAUGE THIS DIM. ON
REAR 1" OF DIA.

TURNING TOOL
#2
A-50278

OBSOLETE

COMPILED BY: BOWLING	APPROVAL & DATE:
-----------------------------	------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART:

PRIME PIN

PART No.

17021-W

OP:

FINISH TURN

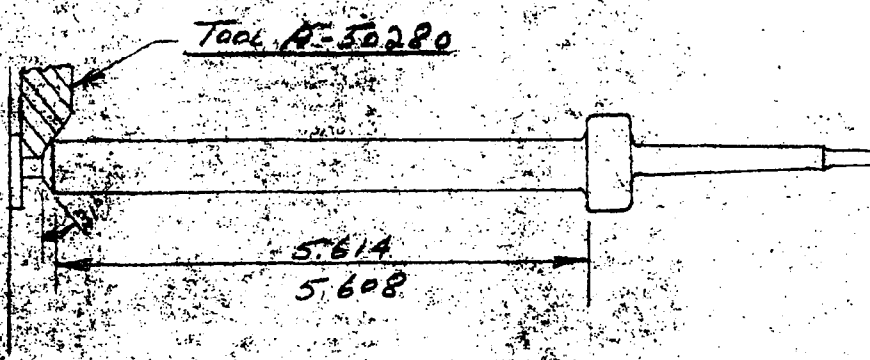
Sheet # 2

OPER. No.

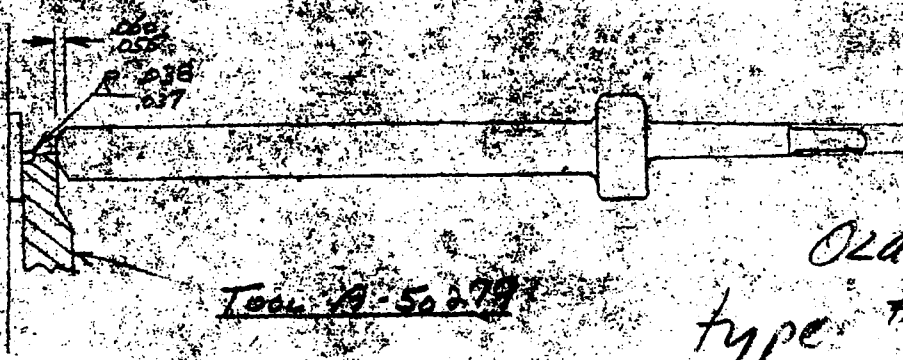
1

PROCESS RECORD — ILLUSTRATION SKETCH

4)



5)



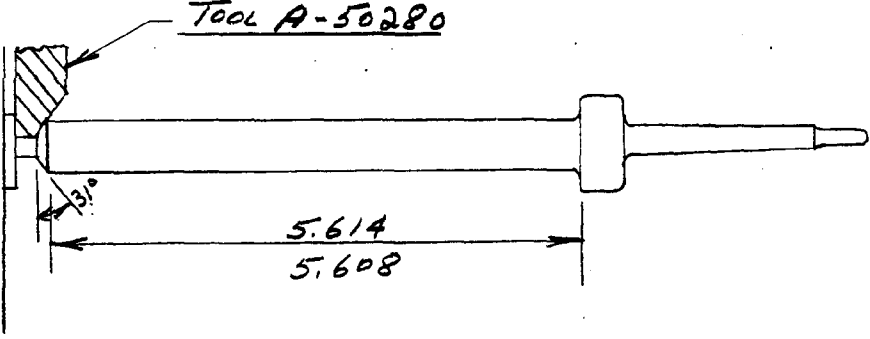
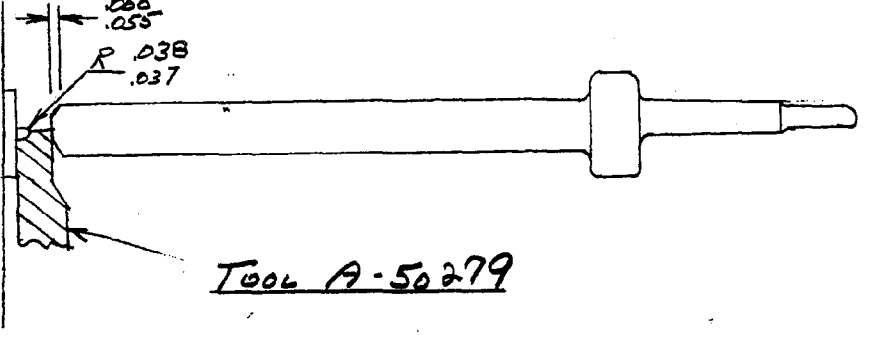
*Oxalid sketches
type #5 &
Legend
~~omit profiles~~*

COMPILED BY

Remington

APPROVAL & DATE

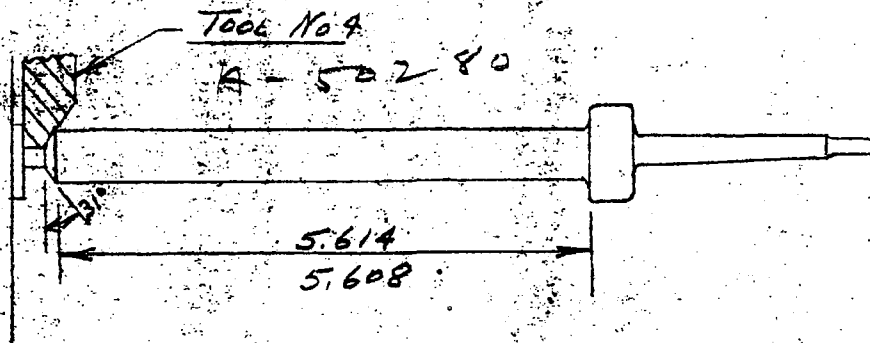
REMINGTON ARMS COMPANY INC JILON N V

PART: FIRING PIN		PART No. 17021-W
OPERATION: FINISH TURN (CONT.)		OPER. No.: 1
PROCESS RECORD — ILLUSTRATION SKETCH		
4) 		
5) 		
COMPILED BY: BOWLING	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

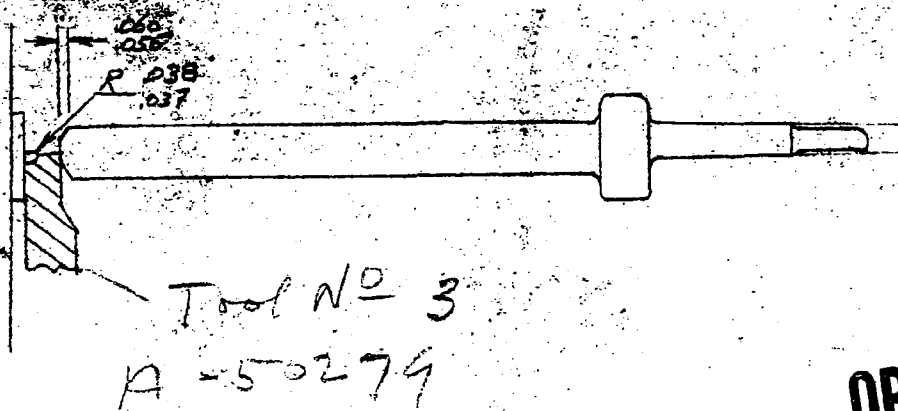
PART: FIRING PIN	PART NO: 17021-W
OPERATION: FINISH TURN (cont.)	OPER. NO.: 1

PROCESS RECORD — ILLUSTRATION SKETCH

4)



5)



OBSOLETE

COMPILED BY: **BOWLING**

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: <i>FINISHING PN</i>	PART No: <i>17021-V</i>
OPERATION: <i>FINISH TURNING - Sheet 4</i>	OPER. No.: <i>1</i>

PROCESS RECORD — ILLUSTRATION SKETCH

10/1

1)

Sketch showing Relative Position of Tools

2)

3)

NOTE: GAGE THIS DIM. ON REAR 1" OF DIA.

*Double check
the #5 & 4
and gages*

COMPILED BY: <i>REYNOLDS</i>	APPROVAL & DATE:
------------------------------	------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FIRING PIN	PART NO. 17021-V
OPERATION: FINISH TURN	OPER. No.: 1

PROCESS RECORD — ILLUSTRATION SKETCH

1)

FINISHING TOOL
No. 4
A-50277

ROUGHING TOOL
No. 4
A-50280

SKETCH SHOWING
REL. POSITION OF TOOLS

WORK & COLLET

2)

RAD. TOOL
No. 5
A-50281

OBSOLETE

3)

TURNING TOOL
#2
A-50278

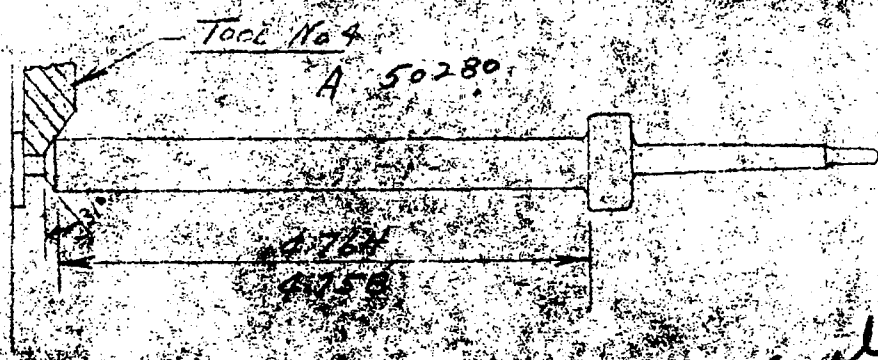
NOTE: GAGE THIS DIM.
ON REAR 1" OF DIA.

COMPILED BY: BOWLING	APPROVAL & DATE:
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

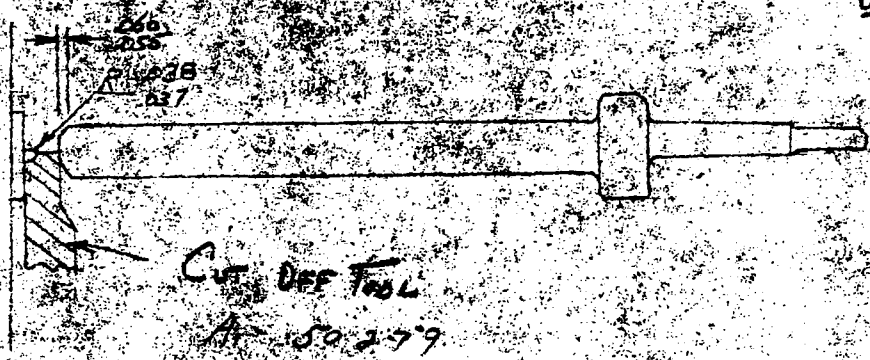
PART: <i>Handwritten: Firing Pin</i>	PART NO: <i>17021-V</i>
OPERATION: <i>FINISH TURN</i>	OPER. No: <i>1</i>
PROCESS RECORD — ILLUSTRATION SKETCH	

4)



*ground
2 type
~~over~~*

5)



COMPILED BY: <i>BOWLING</i>	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC. ILION, N. Y.	

PART: <i>FIRING PIN</i>	PART NO. <i>17021-V</i>
OPERATION: <i>FINISH TURN (CONT.)</i>	OPER. No.: <i>1</i>
PROCESS RECORD — ILLUSTRATION SKETCH	
4/ 5/	
COMPILED BY: <i>Bowling</i>	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

77 10

Relief
023

PART: Firing Pin			PART No. 17021 W		
OPERATION: Finish Turn <i>Shank</i>			OPER. No.: 1		
PROCESS RECORD					
EQUIPMENT: #2 Wickman Swiss Type Screw Machine <i>Code #?</i>					
MAX. PROD. PER HOUR:			COOLANT: Cut Max		
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No.	No.
1. Rough & Finish Front End	2258	Feed is Variable - Produced by Cam	Roughing Tool (No. 4 pos.)	A-50280	Cam <i>tool</i> (Roughing) G-50282Z
			Finish Tool (No. 1 pos.)	A-50277	Cam <i>tool</i> (Finishing) C-50282W Steel Collet B-90084W T. C. Guide B-90083W Bushing Cam and Feed C-50282R Bracket C-50451 Guide A-50449
2. Radius Shoulder	2258		Radius Tool (No. 5 pos.)	A-50281	Cam <i>tool</i> C-50282S
3. Turn Shank	2258		Turning Tool (No. 2 pos.)	A-50278	Cam <i>tool</i> C-50282V
<i>omit deep profiles</i>					
COMPILED BY: Bowling			APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

10/✓

PART: Firing Pin **PART No.** 17021 W

OPERATION: Finish Turn **OPER. No.:** 1

PROCESS RECORD

EQUIPMENT: #2 Wickman Swiss Type Screw Machine

MAX. PROD. PER HOUR: **COOLANT:** Cut Max

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
1. Rough & Finish Front End	2258	Feed is Variable - Produced by Cam	Roughing Tool (No. 4 pos.)	A-50280	Cam (Roughing)	C-50282T
			Finish Tool (No. 1 pos.)	A-50277	Cam (Finishing) Steel Collet T. C. Guide Bushing Cam End Feed Bracket Guide	C-50282W B-90084W B-90083W C-50282R C-50451 A-50449
2. Radius Shoulder	2258		Radius Tool (No. 5 pos.)	A-50281	Cam	C-50282S
3. Turn Shank	2258		Turning Tool (No. 2 pos.)	A-50278	Cam	C-50282V

COMPILED BY: Bowling **APPROVAL & DATE:**

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin		PART No. 17021 W	
OPERATION: Finish Turn <i>(Start #2)</i>		OPER. No.: 1	
PROCESS RECORD			
EQUIPMENT: #2 Wickman Swiss Type Screw Machine			
MAX. PROD. PER HOUR:		COOLANT: Cut Max	
STATION		TOOLS & GAUGES	
STEPS	SPEED	TYPE	No.
4. Form Angle & Break Down		2258	Break Down Tool (No. 4 pos.)
5. Cut Off & Form Head on Next Piece		2258	Cut Off & Form Tool (No. 3 pos.)
		Comparator lay-out Profile of Pt. to shoulder & length 5.614-5.608	E-50439
		Dial Snap for O.D. .2815-.280	B-80021W
		Master Plug	B-80042W
		Dial Snap for Point Dia. .076-.074	B-80021V
		Master Plug	B-80038U
COMPILED BY: Bowling		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: Firing Pin				PART No. 17021 W	
OPERATION: Finish Turn (Cont.)				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: #2 Wickman Swiss Type Screw Machine					
MAX. PROD. PER HOUR:				COOLANT: Cut Max	
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No.	No.
4. Form Angle & Break Down	2258		Break Down Tool (No. 4 pos.)	A-50280	Cam C-50282T
5. Cut Off & Form Head on Next Piece	2258		Cut Off & Form Tool (No. 3 pos.)	A-50279	Cam C-50282U
			Comparator lay-out Profile of Pt. to shoulder & length 5.614-5.608	E-50439	Comparator Fixt. C-50440
			Dial Snap for O.D. .2815-.280 master Plug	B-80021W B-80042W	
			Dial Snap for Point Dia. .076-.074 Master Plug	B-80021V B-80038U	
COMPILED BY: Bowling			APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

PART: Firing Pin				PART NO.: 17021 W		
OPERATION: Finish Turn				OPER. NO.: 1		
PROCESS RECORD						
EQUIPMENT: #2 Wickman Swiss Type Screw Machine						
MAX. PROD. PER HOUR: 12			COOLANT: Cut Max			
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	No.	
1. Rough & Finish Front End	2258		Roughing Tool (No.4)	A-50280 Purchase	C-50282T Purchase	
			Finish Tool	A-50277 Purchase	Cam (Roughing)	
					Cam (Finishing)	C-50282W
					Steel Collet	B-90084W
					T.C. Guide	
					Bushing	WB-90083W
					Closing Cam	"
					Opening Cam	"
					4-No.10 Washers	"
					4- Tee Bolts	"
4- " " Nuts	"					
2. Radius Shoulder	2256		Radius Tool (No.5)	A-50281 Purchase	C-50282K	
			Cam	C-50451		
3. Turn Shank	2258		Turning Tool (No.2)	A-50278 Purchase	C-50282V Purchase	
			Cam			

BRACKET GUIDE

OBSOLETE

COMPILED BY: Bowling	APPROVAL & DATE:
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin				PART No. 17021 W		
OPERATION: Finish Turn (Cont.)				OPER. No.: 1		
PROCESS RECORD						
EQUIPMENT: #2 Wickman Swiss Type Screw Machine						
MAX. PROD. PER HOUR: 12			COOLANT: Cut Max			
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
4. Form Angle & Break Down	2258		Break Down Tool (No.4)	A-50280 <i>Purchase</i>	Cam Steady Rest Attachment	C-50282-T <i>Purchase</i>
5. Cut Off & Form Head on Next Piece	2258		Cut Off & Form Tool (No.3)	A-50279	Cam	C-50282-U <i>Purchase</i>
			Comparator Profile of Pt to Shoulder 20-1 Mag. Dial Snap For O.D. .2815-.280 Dial Snap For Point Diameter .076-.074 DIAL SNAP for B-80021-W ✓ O.D. .2815-.280 ✓ MASTER PLUG B-80042-W ✓ DIAL SNAP for B-80021-V ✓ Point Dia. .076-.074 ✓ MASTER PLUG B-80038-U ✓			
COMPILED BY: Bowling			APPROVAL & DATE:			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

OBSOLETE

7-10

revised

PART: Firing Pin			PART NO. 17021V		
OPERATIONS: Finish Turn <i>shut</i>			OPER. NO.: 1		
PROCESS RECORD					
EQUIPMENT: #2 Wickman Swiss Type Screw Machine					
MAX. PROD. PER HOUR:			COOLANT: <i>Cut Max</i>		
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	NO.	TYPE NO.
1. Rough & Finish Front End	2258	Feed is Variable - Produced by Cam	Roughing Tool (No. 4 pos.)	A-50280	Cam (<i>tool</i> Roughing) C-50282T
			Finish Tool (No. 1 pos.)	A-50277	Cam (<i>tool</i> Finishing) C-50282W
					Steel Collet B-90084W
					T. C. Guide B-90083W
					Bushing C-50283
					Cam End Feed C-50451
					Bracket A-50449
					Guide
2. Radius Shoulder	2258		Radius Tool (No. 5 pos.)	A-50281	Cam - <i>tool</i> C-50282S
3. Turn Shank	2258		Turning Tool (No. 2 pos.)	A-50278	Cam - <i>tool</i> C-50282V
COMPILED BY: <i>Bowling</i>			APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

PART: Firing Pin			PART No 17021V			
OPERATION: Finish Turn			OPER. No.: 1			
PROCESS RECORD						
EQUIPMENT: #2 Wickman Swiss Type Screw machine						
MAX. PROD. PER HOUR:			COOLANT: Cut max			
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No	TYPE	No
1. Rough & Finish Front End	2258	Feed is Variable - Produced by Cam	Roughing Tool (No. 4 pos.)	A-50280	Cam (Roughing)	C-50282T
			Finish Tool (No. 1 pos.)	A-50277	Cam (Finishing)	C-50282W
					Steel Collet	B-90084W
2. Radius Shoulder	2258		Radius Tool (No. 5 pos.)	A-50281	Cam	C-50282S
3. Turn Shank	2258		Turning Tool (No. 2 pos.)	A-50278	Cam	C-50282V
COMPILED BY: Bowling			APPROVAL & DATE:			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

PART: Firing Pin			PART No. 17021 V		
OPERATION Finish Turn			OPER. No.: 1		
PROCESS RECORD					
EQUIPMENT 12 Wickman Swiss Type Screw Machine			OBSOLETE		
MAX PROD PER HOUR 12			COOLANT Cut Max		

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES		
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.	
1. Rough & Finish Front End	2255		Roughing Tool (No. 4)	A-50280 Purchase	Cam (Roughing)	C-50282-T Purchase	
				A-50277 Purchase		C-50282-W	
			Finish Tool		Cam (Finishing)	Steel Collet	B 90084 W
						T.C. Guide	"
						Pushing	B 90083 W
						Closing Cam	"
						Opening Cam	"
						4 No. 10 Washers	"
						4 Tee Bolts	"
						4 " " Nuts	"
2. Radius Shoulder	2258		Radius Tool (No. 5)	A-50281 Purchase	Cam	C-50283 C-50451 A-50449 C-50281-S	
				BRACKET		GUIDE	
3. Turn Shank	2258		Turning Tool (No. 2)	A-50278 Purchase	Cam	C-50282-V Purchase	

COMPILED BY Bowling	APPROVAL & DATE.
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin				PART No. 17021 V	
OPERATION: Finish Turn (Cont) sheet # 2				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: #2 Wickman Swiss Type Screw Machine					
MAX. PROD PER HOUR:			COOLANT: cut Max		

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	NO	TYPE	NO.
4. Form Angle & Break Down	2258	<i>Feed is variable - produced by cam</i>	Break Down Tool (No. 4 pos.)	A-50280	Cam - Tool	C-50282T
5. Cut Off & Form Head on next piece	2258	<i>Feed is variable - produced by cam</i>	Cut Off & Form Tool (No. 3 pos.)	A-50279	Cam - Tool	C-50282U
			Comparator lay-out Profile of Pt to shoulder & Length 4.764-4.758	E-50439	Comparator Fix.	C-50440
			Dial Snap for O.D. .2815-.280	B-80021W		
			Master Plug	B-80042W		
			Dial Snap for Pt. Dia. .076-.074	B-80021V		
			Master Plug	B-80038U		

COMPILED BY: Bowling	APPROVAL & DATE:
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Firing Pin				PART No 17021 V	
OPERATION: Finish Turn (Cont.)				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: #2 Wickman Swiss Type Screw machine					
MAX. PROD. PER HOUR: COOLANT: Cut Max.					
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No	No.
4. Form Angle & Break Down	2258		Break Down Tool (No. 4 pos.)	A-50280	Cam C-50282T
5. Cut Off & Form Head on next piece	2258		Cut Off & Form Tool (No. 3 pos.)	A-50279	Cam C-50282U
			Comparator lay-out Profile of Pt. to shoulder & Length 4.764-4.758	E-50439	Comparator Fix. C-50440
			Dial Snap for U.D. .2815-.280	B-80021W	
			Master Plug	B-80042W	
			Dial Snap for Pt. Dia. .076-.074	B-80021V	
			Master Plug	B-80038U	
COMPILED BY: Bowling			APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

PART: Firing Pin			PART NO 17021 V			
OPERATION Finish Turn (Cont.)			OPER. No.: 1			
PROCESS RECORD						
EQUIPMENT 2 Wickman Swiss Type Screw Machine						
MAX PROD PER HOUR 12 COOLANT Cut Max						
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	NO	TYPE	NO
4. Form Angle & Break Down	2500		Break Down Tool (No. 4)	A-50280 Purchase	Car Steady Rest Attachment	C-50282-T Purchase
5. Cut Off & Form Head on Next Piece	2250		Cut Off & Form Tool (No. 2)	A-50279	Can	C-50282-U Purchase
			Comarator Profile or Pt to Shoulder Length 4.704-4.758 + 20-1 Mag. Dial Snap for 1.5-2.80 1.5-2.80 1.5-2.80 1.5-2.80 1.5-2.80		ABSOLETE Computer Fixt. C-50440 4.704-4.758	
			Dial Snap B-80021-W for O.D. - 2.815-2.80 4.704-4.758 Master Plug B-80042-W Dial Snap for B-80021-V H. Dia - .076-.074 Master Plug B-80038-U			
COMPILED BY: Bowling			APPROVAL & DATE			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

PART: Firing Pin		PART No 17021W 17021V
OPERATION: Clean		OPER. No.: 3
PROCESS RECORD #826		
Equipment: Machine Washer Basket - 10" x 23" x 5"		
Detailed Description		
Load Size	:	_____ pieces max.
Method	:	Conveyor Belt
Cycles	:	1
Position of Component	:	Horizontal
Standard Practice	:	#206
Remarks: <u>Caution</u> : Handle with care. Points damage easily.		
12-11-71		
COMPILED BY: P. H. Eccleston		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Firing Pin	PART No. 17021W 17021V
OPERATION: Clean	OPER. No.: 3
PROCESS RECORD #826	
Equipment: Ransohoff Washer Basket - 10" x 23" x 5"	
Detailed Description	
Load Size	: _____ pieces max.
Method	: Conveyor Belt
Cycles	: 1
Position of Component	: Horizontal
Standard Practice	: #206
Remarks: <u>Caution</u> : Handle with care. Points damage easily.	
APR 11 1964	
COMPILED BY: P. H. Eccleston	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART: Firing Pin		PART No. 17021W 17021V
OPERATION: Clean		OPER. No.: 3
PROCESS RECORD #826		
Equipment: Ranschoff Washer Basket - 10" x 23" x 5"		
Detailed Description		
Load Size	:	_____ pieces max.
Method	:	Conveyor Belt
Cycles	:	1
Position of Component	:	Horizontal
Standard Practice	:	#206
Remarks: <u>Caution</u> : Handle with care. Points damage easily.		
OBSOLETE		
COMPILED BY: P. H. Ecleston		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Firing Pin		PART No. 17021 WV	
OPERATION: Inspect		OPER. No.: 5	
PROCESS RECORD — INSPECTION			
GAUGES		USE	LIMITS
TYPE	No		MAX MIN.
Dial Snap	B-80021V	Point Diameter	.076 .074
" "	B-80021W	Body Diameter	.2815 .2800
OBSOLETE			
SKETCH			
COMPILED BY: A. MAGOSTINO		APPROVAL & DATE.	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART:	FIRING PIN	PART No.	17071 W/V		
OPERATION:	INSPECT	OPR. NO.	5		
PROCESS RECORD — INSPECTION					
GAUGES		USE	LIMITS		
TYPE	No.		MAX.	MIN.	
DIAL SNAP "	B-800LIV ✓ SEE OPR #1 B-800LIW SEE OPR #1	POINT DIAMETER BODY DIAMETER	.076 .2815	.074 .2800	
USE FORM TIP R 12		OBSOLETE			
GAUAGING TABLE					
LOT SIZE	FIRST SAMPLE	ALLOWABLE NO REJECTS	* RETEST	TOTAL SAMPLE	TOTAL REJECTS ALLOWABLE
COMPILED BY:		APPROVAL & DATE:			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

PART: Firing Pin

PART No. 17021N, V-

OPERATION: High Temperature Neutral Salt Harden, Oil Quench,

OPER. No.: 7

Wash and deplate and dry

HEAT TREATMENT SPECIFICATION No. 823 (Replaces #428)

Equipment: Remington Gas-Fired Pot Furnace, - 12" dia. x 12" deep.
Rack - Dwg. #TS-279

Detailed Description

Material Specification No.: 117K

Material : C-1137

Temperature : 1525 - 1550° F.

Fixture : D-51077 ✓

Maximum Load - H. T. : 100 pieces

Time : 3-5 minutes at temperature

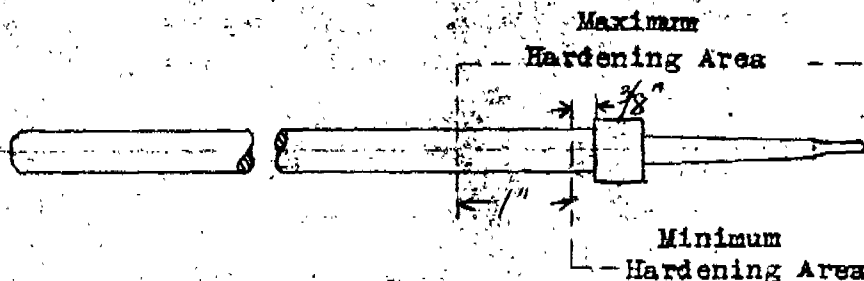
Quench : Oil

Standard Practice : #199

Maximum Load - Wash : 500 pieces

Cyanide deplate
Standard Practice : #188 2 to 3 hrs

Remarks: Care should be taken to avoid dropping parts as point damages easily.



HEAT TREATMENT INSPECTION

Oper. No.: 9

Operation: Inspection for Rockwell Hardness

Standard Practice : #164 - Shallow V Anvil

Hardness Limits : Rc 54.0 min.

Appearance of Part : Steel gray color, clean, free of salt.

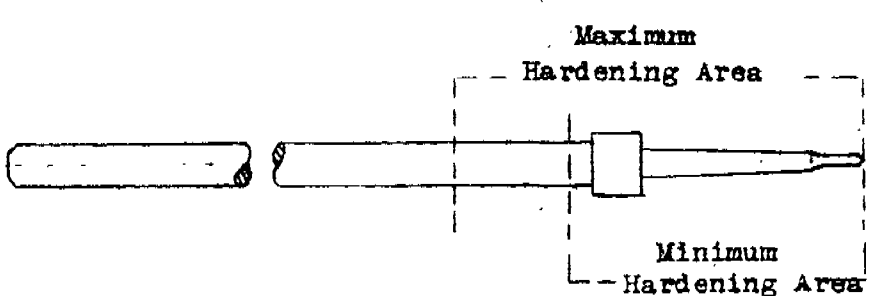
Next Oper. No.: 11

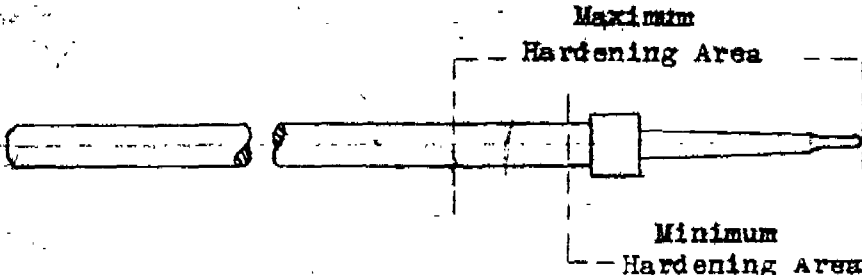
COMPILED BY: B. C. Andrews

APPROVAL & DATE: *WKA 8/20/14*

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

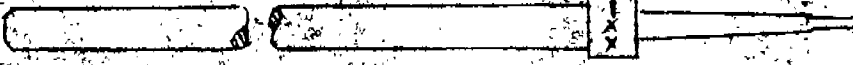
PART: Firing Pin		PART No. 17021W,V
OPERATION: High Temperature Neutral Salt Harden, Oil Quench, Wash and Dry		OPER. No.: 7
RESOLETE 10/28 HEAT TREATMENT SPECIFICATION No. 823 (Replaces #428)		
Equipment: Remington Gas-Fired Pot Furnace - 12" dia. x 12" deep. Rack - Dwg. #TS-279		
Detailed Description		
Material Specification No.: 117K		
Material	:	C-1137
Temperature	:	1525 - 1550°F.
Fixture	:	D-51077
Rack	:	C-51081
Maximum Load - H. T.	:	96 pieces
Time	:	10 minutes at temperature
Quench	:	Oil
Standard Practice	:	#199
Maximum Load - Wash	:	500 pieces
Remarks: Care should be taken to avoid dropping parts as point damages easily.		
HEAT TREATMENT INSPECTION		Oper. No.: 9
Operation: Inspection for Rockwell Hardness		
Standard Practice	:	#164 - Shallow V Anvil
Hardness Limits	:	Rc 40 min.
Appearance of Part	:	Steel grey color, clean, free of salt.
COMPILED BY: B. C. Andrews		Next Oper. No. 11
APPROVAL & DATE:		<i>m/k 8/30/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

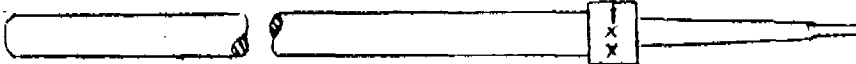
PART: Firing Pin		PART No. 170218, V 190218
OPERATION: High Temperature Neutral Salt Harden, Oil Quench, Wash and Dry		OPER. No.: 7
HEAT TREATMENT SPECIFICATION NO. 823 (Replaces #428)		
Equipment: Remington Gas-Fired Pot Furnace - 12" dia. x 12" deep. Rack - Dwg. #TS-279		
Detailed Description		
Material Specification No.: 117K		
Material	: C-1137	
Temperature	: 1525 - 1550° F.	
Fixture	: D-51077	
Rack	: C-51081	
Maximum Load - H. T.	: 96 pieces	
Time	: 10 minutes at temperature	
Quench	: Oil	
Standard Practice	: #199	
Maximum Load - Wash	: 500 pieces	
Remarks: Care should be taken to avoid dropping parts as point damages easily.		
 Maximum Hardening Area Minimum Hardening Area		
HEAT TREATMENT INSPECTION		Oper. No.: 9
Operation: Inspection for Rockwell Hardness		
Standard Practice	: #164 - Shallow V Anvil	
Hardness Limits	: Rc 40 min.	
Appearance of Part	: Steel grey color, clean, free of salt.	
COMPILED BY: B. C. Andrews		Next Oper. No.: 11
APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

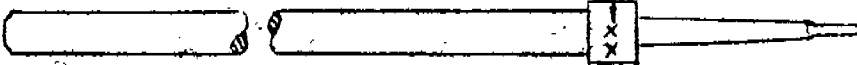
Part: Drilling Pin	PART No. 17021W 17021Y
OPERATION: High Temperature Neutral Salt Harden, Oil Quench, Wash and Dry	OPER. No.: 7
HEAT TREATMENT SPECIFICATION No. 823 (Replaces #428)	
Equipment: Remington Gas-Fired Pot. Furnace - 12" dia. x 12" deep. Rack - Dwg. #TS-279	
Detailed Description	
Material Specification No.: 117K	
Material:	: C-1137
Temperature:	: 1525 - 1550° F.
Fixture <i>Rack</i>	: TS-279 <i>D-51077</i> <i>C-51081</i>
Maximum Load - H. T.	: 96 pieces
Time:	: 10 minutes at temperature
Quench:	: Oil
Standard Practice	: #199
Maximum Load - Wash	: 500 pieces
Remarks: Care should be taken to avoid dropping parts as point damages easily.	
	
HEAT TREATMENT INSPECTION	
Operation: Inspection for Rockwell Hardness	
Standard Practice	: #164 - Shallow V Anvil
Hardness Limits	: Rc 40 min.
Appearance of Part	: Steel gray color, clean, free of salt.
Next Oper. No. 8-11	
COMPILED BY: B. C. Andrews	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

OBSOLETE

Revised
OBSELETE
10/14

PART: Firing Pin		PART No: 170218	
OPERATION: Nitrate Iron, Water Quench, Wash and Oil for Storage		OPER. No: 13	
HEAT TREATMENT SPECIFICATION No: 824 (Replaces 829)			
Equipment: Remington Gas-Fired Nitro Pot Furnace - 13-3/4" x 37-1/2" x 11"			
Detailed Description:			
Material Specification No.: 117A			
Material: C-1137			
Temperature: 725-750 725 - 750 °F			
Container: Wire mesh basket - 19" x 12" x 3"			
Maximum Load: 500 pieces			
Time: 30 minutes total			
Quench: Water			
Standard Practice: #201			
Remarks: Handle with care, points damage easily.			
Rockwell Test			
			
HEAT TREATMENT INSPECTION			
Operations: Inspect for Rockwell Hardness, Color and Oil			
Standard Practice: #164 Shallow V Anvil, and #165			
Hardness Limits: Rc 32-38			
Appearance of Part: Mottled blue and straw color. Red spots or band at salt line.			
COMPILED BY: B. G. Andrews		APPROVAL DATE: 7/10/46	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: Firing Pin	PART NO. 17021W, V K00234
OPERATION: Nitro Draw, Water Quench, Wash and Oil for Storage	OPER. No. 11
HEAT TREATMENT SPECIFICATION No. 824 (Replaces #429)	
Equipment: Remington Gas-Fired Nitro Pot Furnace - 13-3/4" x 37-1/2" x 11"	
Detailed Description:	
Material Specification No.: 117K	
Material	: C-1137
Temperature	: 750 - 775°F.
Container	: Wire mesh basket - 19" x 12" x 3"
Maximum Load	: 500 pieces
Time	: 30 minutes total
Quench	: Water
Standard Practice	: #201
Remarks: Handle with care, points damage easily.	
Rockwell Test 	
HEAT TREATMENT INSPECTION	
Oper. No.: 13	
Operation: Inspect for Rockwell Hardness, Color and Oil	
Standard Practice	: #164 Shallow V Anvil, and #165
Hardness Limits	: Rc 32-38
Appearance of Part	: Mottled blue and straw color.
COMPILED BY: B. C. Andrews	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART: Firing Pin		PART No. 17021W 17021W
OPERATION: Nitre Draw, Water Quench, Wash and Oil for Storage		OPER. No. 11
HEAT TREATMENT SPECIFICATION NO. 824 (Replaces #439)		
Equipment: Remington Gas-Fired Nitre Pot Furnace - 13-3/4" x 37-1/2" x 11"		
Detailed Description		
Material Specification No.: 117E		
Material	: C-1137	
Temperature	: 750 - 775°F	
Container	: Wire mesh basket - 19" x 12" x 3"	
Maximum Load	: 500 pieces	
Time	: 30 minutes total	
Quench	: Water	
Standard Practice	: #201	
Remarks: Handle with care, points damage easily.		
Rockwell Test 		
HEAT TREATMENT INSPECTION		Oper. No.: 13
Operation: Inspect for Rockwell Hardness, Color and Oil		
Standard Practice	: #164 Shallow V. Anvil, and #165	
Hardness Limits	: Rc 32-38	
Appearance of Part	: Mottled blue and straw color.	
COMPILED BY: B. O. Andrews	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

OBSOLETE

Retyped
OBSOLETE

PROCESS RECORD

*GEAR SPRING
TRIGGER SPRING
PART NO. 17047*

ISSUED BY:

TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

ISSUED TO: _____

DEPARTMENT

PART: SEAR SPRING
TRIGGER SPRING

PART No.
17047

SEQUENCE OF OPERATIONS

1 Rejected
10/50
OBsolete

30 SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1		MATERIAL PROCUREMENT	
2	1	PURCHASE INSPECTION	
3		TRANSFER TO PART STORES	
COMPILED BY: M. H. 5 7/1/46		APPROVAL & DATE:	
REMINGTON ARMS COMPANY. INC., ILION, N. Y.			

H. H. SULLIVAN, INC.

OBSCLETE
JAN 15 1947

PART: SEAR SPRING TRIGGER SPRING		PART No. 17047
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
7/1/46	Purchase Inspection Operation #1 rewritten for clarity, no change in gages	
COMPILED BY: M.H.S. 7/1/46		APPROVAL & DATE: <i>mt 8/22/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: <i>Seal Spring</i> <i>Trigger Spring</i>		PART No. <i>17047</i>
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
<i>7/1/46</i>	<i>Punchon Inspection operation /</i> <i>rewritten for clarity and change in</i> <i>name</i>	
	<i>type</i>	
COMPILED BY: <i>W. J. J. J.</i>	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. RIFLE DIV. N. Y.		

Retyped
OBSOLETE

PART: <i>Sear Spring</i> <i>Trigger Spring</i>		PART No. <i>17047</i>
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
<i>7/1/46</i>	<i>Purchase Inspection operations 1</i> <i>rewritten for clarity, no change in</i> <i>pages</i>	
COMPILED BY: <i>WV 7/1/46</i>		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

Retyped
OBSOLETE

PART: <i>See Spring Trigger Spring</i>		PART NO. <i>17047</i>
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
<i>7/1/46</i>	<i>Standard Inspection of operation re-written for clarity</i> OBSOLETE	
COMPILED BY <i>M. F. 7/1/46</i>	APPROVAL & DATE:	
REMINGTON-ARMS COMPANY, INC., ILION, N. Y.		

PART: Sear Spring (Purchase ready for Setting)
Trigger Spring

PART No. 17047

Date 5-8-46

MATERIAL PROCUREMENT #1007 Rev. 3

Detailed Description

Remington Planning

Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring)
Uses of Parts : M/721-All Calibers; M/722- All Calibers

Vendor

Material : Music Wire. Packing Slip to show material used for each shipment of parts.

Heat Treatment : Stress Relieve (See Footnote)

Set : Vendor need not remove set but parts must comply with drawing. When set has been removed by holding fully compressed for 24 hours.

Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Set Sample for inspection by holding fully compressed for 24 hours Rod Dwg. B51364W, Collar B51365W. Balance of lot must also be set before parts are ready for assembly.

Inspection: **

Gage No.	Type	AOQL
1. Coats	"Elasticometer" with)	(Free Length 7%
B-51001T - Pin	)	(Solid Height 7%
B-51000T - Ring	)	(I.D. of Spring 7%
B-50127T - Bushing	)	(O.D. of Spring 7%
		(Load at 80% Deflection 7%
2. Visual	Wind R.H.	7%
	Ends Squared and Ground	7%
	Seams, etc.	7%

**See Process Record - Inspection for procedure.

Note: As a matter of information only this part has been heat treated satisfactorily at Remington as follows:
Stress Relief; DuPont Salt #1; 380 - 400°F; 10 minutes; water quench.

COMPILED BY:
C.B. Buonassisi

APPROVAL & DATE:

M/K Smith 5/6/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Sear Spring (Purchase ready for ^{Setting} ~~Assembly~~)
Trigger Spring

PART NO. 17047

Date: 4-17-46

MATERIAL PROCUREMENT #1007 Rev. 2

Detailed Description

Remington Planning

Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring)
Uses of Parts : M/721- All Calibers; M/722- All Calibers

Vendor

Material : Music Wire. packing Slip to show material used for each shipment of parts.

Heat Treatment : Stress Relieve (See Footnote)

Set : ~~Remove by holding fully compressed for 24 hrs.~~ ^{Do not remove. Vendor need not remove set but parts must comply with drawing.}
when set has been removed by holding fully compressed for 24 hours.

Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection: **

Gage No.	Type	Use	AQCL
1X. Coats	"Elasticometer" with)	(Free Length	7%
B-51001T - Pin	)	(Solid Height	7%
B-51000T - Ring	)	(I.D. of Spring	7%
B-50127T - Bushing	)	(O.D. of Spring	7%
		(Load at 80% Deflection	7%
32% Visual		Wind R.H.	7%
		Ends Squared and Ground	7%
		Seams, etc.	7%

3. Set Sample by holding/compressed for 24 hours Rod Dwg. B51364W, Collar B51365W.

4. Repeat step 1. ^{Balance of lot must fully be set before parts are ready for assembly.}
Parts must meet drawing requirements at steps 1 and 4.

**See Process Record - Inspection for procedure.

Notes: As a matter of information only this part has been heat treated satisfactorily at Remington as follows:

Stress Relief; DuPont Salt #1; 380 - 400°F; 10 minutes; water quench.

COMPILED BY:
C.B. Buonassisi

APPROVAL & DATE: R.H. Grace 4/19/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Sear Spring (Purchase ready for Assembly)
Trigger Spring

PART No.
17047

Date 4-11-46

MATERIAL PROCUREMENT #1007 Rev.1

Detailed Description

OBsolete

Remington Planning

Pieces Required Per Assembly: 2(1 Sear Spring - 1 Trigger Spring)
Uses of Part : M/721-All Calibers; M/722-All Calibers

Vendor

Material : Music Wire. Packing Slip to show materials used for each shipment of parts.
Heat Treatment : Stress Relieve
Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil(SAE-20 or equiv.)
Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the " Average Outgoing Quality Limit" listed

Inspection: **

<u>Gage No.</u>	<u>Type</u>	<u>Use</u>	<u>AOQL</u>
Coates	"Elasticometer" with	Free Length	7%
B-51001T	- Pin	Solid Height	7%
B-51000T	- Ring	I.D. of Spring	7%
B-50127T	- Bushing	O.D. of Spring	7%
		Load at 80% Deflection	7%
Visual		Wind R.H.	7%
		Ends Squared and Ground	7%
		Seams, etc.	7%

** See Process Record - Inspection for procedure.

COMPILED BY:
C.B.Buonassisi

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Sear Spring (Purchase ready for Assembly)	PART No. 17047																																					
Date- 4-8-46																																						
MATERIAL PROCUREMENT #1007 (Replaces #1007)																																						
Rev. 1 867																																						
Detailed Description																																						
Remington Planning OBSOLETE Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring) Uses of Part : M/721-All Calibers; M/722-A 11 Calibers Vendor Material : Music Wire. Packing Slip to show material used for each shipment of parts. Heat Treatment : Stress Relieve Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.) Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs. Acceptance Testing: Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed. <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;"><u>Inspection: **</u></th> <th style="text-align: left;"><u>Gage No.</u></th> <th style="text-align: left;"><u>Type</u></th> <th style="text-align: left;"><u>Use</u></th> <th style="text-align: left;"><u>AOQL</u></th> </tr> </thead> <tbody> <tr> <td>Coates</td> <td>"Elasticometer" with</td> <td>Free Length</td> <td>7%</td> </tr> <tr> <td>B-51001T</td> <td>- Pin</td> <td>Solid Height</td> <td>7%</td> </tr> <tr> <td>B-51000T</td> <td>- Ring</td> <td>I.D. of Spring</td> <td>7%</td> </tr> <tr> <td>B-50127T</td> <td>- Bushing</td> <td>O.D. of Spring</td> <td>7%</td> </tr> <tr> <td></td> <td></td> <td>Load at 80% Deflection</td> <td>7%</td> </tr> <tr> <td>Visual</td> <td></td> <td>Wind R.H.</td> <td>7%</td> </tr> <tr> <td></td> <td></td> <td>Ends Squared and Ground</td> <td>7%</td> </tr> <tr> <td></td> <td></td> <td>Seams, etc.</td> <td>7%</td> </tr> </tbody> </table> * P.E.C.N. #1007 Rev. 1 **See Process Record - Inspection for procedure.		<u>Inspection: **</u>	<u>Gage No.</u>	<u>Type</u>	<u>Use</u>	<u>AOQL</u>	Coates	"Elasticometer" with	Free Length	7%	B-51001T	- Pin	Solid Height	7%	B-51000T	- Ring	I.D. of Spring	7%	B-50127T	- Bushing	O.D. of Spring	7%			Load at 80% Deflection	7%	Visual		Wind R.H.	7%			Ends Squared and Ground	7%			Seams, etc.	7%
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COMPILED BY: C.B. Enonassisi	APPROVAL & DATE: <i>M. Smith 4/8/46</i>																																					
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																																						

PART: Sear Spring (Purchase ready for Assembly)

PART No. 17047

TRIGGER SPRING

Date- 4-8-46

MATERIAL PROCUREMENT #1007 (Replaces #867)

Detailed Description

Remington Planning

OBSOLETE

Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring)
 Uses of Part : M/721-All Calibers; M/722-A 11 Calibers

Vendor

Material : Music Wire. Packing Slip to show material used for each shipment of parts.
 Heat Treatment : Stress Relieve
 Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)
 Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection: **

Gage No.	Type	Use	AOQL
Coates	"Elasticometer" with	Free Length	7%
B-51001T	- Pin	Solid Height	7%
B-51000T	- Ring	I.D. of Spring	7%
B-50127T	- Bushing	O.D. of Spring	7%
		Load at 80% Deflection	7%
Visual		Wind R.H.	7%
		Ends Squared and Ground	7%
		Seams, etc.	7%

**See Process Record - Inspection for procedure.

COMPILED BY: C.B. Buonassisi

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Sear Spring (Purchase ready for Assembly)

PART No. 17047

Date- 4-8-46

MATERIAL PROCUREMENT #1007 (Replaces #867)

Detailed Description

OBsolete

Remington Planning

Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring)
 Uses of Part : M/721-All Calibers; M/722-A 11 Calibers

Vendor

Material : Music Wire. Packing Slip to show material used for each shipment of parts.
 Heat Treatment : Stress Relieve (See footnote)
 Set : Remove by holding fully compressed for 24 hr.
 Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)
 Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection: **

Gage No.	Type	Use	AQQL
1. Coats	"Elasticometer" with	Free Length	7%
B-51001T - Pin		Solid Height	7%
B-51000T - Ring		I.D. of Spring	7%
B-50127T - Bushing		O.D. of Spring	7%
		Load at 80% Deflection	7%
2. Visual		Wind R.H.	7%
		Ends Squared and Ground	7%
		Seams, etc.	7%
3. Set sample by holding fully compressed for 24 hours			
4. Repeat step 1. Parts must meet drawing requirements at steps 1 and 4.			

**See Process Record - Inspection for procedure.

Note: As a matter of information only this part has been heat treated satisfactorily at Remington as follows:

COMPILED BY: G.B. Buonassisi

APPROVAL & DATE: 7/1/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Sear Spring (Purchase ready for Assembly)	PART No. 17047																																				
1007																																					
MATERIAL PROCUREMENT #367 (Replaces #349)																																					
Detailed Description 867																																					
Remington Planning OBSOLETE Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring) Uses of Part : M/721 - All Calibers; M/722 - All Calibers Vendor Material : Music Wire. Packing slip to show material used for each shipment of parts. Heat Treatment : Stress Relieve Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.). Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs. Acceptance Testing:* Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed. <u>Inspection:**</u> <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left; border-bottom: 1px solid black;">Gage No.</th> <th style="text-align: left; border-bottom: 1px solid black;">Type</th> <th style="text-align: left; border-bottom: 1px solid black;">Use</th> <th style="text-align: left; border-bottom: 1px solid black;">AOQL</th> </tr> </thead> <tbody> <tr> <td>Coates</td> <td>"Elasticometer" with</td> <td>Free Length</td> <td>7%</td> </tr> <tr> <td>B-51001 T Pin</td> <td></td> <td>Solid Height</td> <td>7</td> </tr> <tr> <td>B-51000 T Ring</td> <td></td> <td>I.D. of Spring</td> <td>7</td> </tr> <tr> <td>B-50137 T Bushing</td> <td></td> <td>O.D. of Spring</td> <td>7</td> </tr> <tr> <td></td> <td></td> <td>Load at 80% Deflection</td> <td>7</td> </tr> <tr> <td>Visual</td> <td></td> <td>Wind R.H.</td> <td>7</td> </tr> <tr> <td></td> <td></td> <td>Ends Squared and Ground</td> <td>7</td> </tr> <tr> <td></td> <td></td> <td>Seams, etc.</td> <td>7</td> </tr> </tbody> </table> **See Process Record - Inspection for procedure. *Revised 3/22/46		Gage No.	Type	Use	AOQL	Coates	"Elasticometer" with	Free Length	7%	B-51001 T Pin		Solid Height	7	B-51000 T Ring		I.D. of Spring	7	B-50137 T Bushing		O.D. of Spring	7			Load at 80% Deflection	7	Visual		Wind R.H.	7			Ends Squared and Ground	7			Seams, etc.	7
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COMPILED BY: C. B. Buonassisi	APPROVAL & DATE: <i>R.H. Hall 3/22/46</i>																																				
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																																					

OBSOLETE

MATERIAL PROCUREMENT #349867 (Replaces 349)

Detailed Description

Remington Planning

Pieces Required Per Assembly : 2 (1 Sear Spring - 1 Trigger Spring)
 Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : Music Wire Packing slip to show material used in each shipment.
 Heat Treatment : Stress Relieve
 Final Color : Parts to be bright, free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil.
 Packaging : ~~Purchase order no. and quantity~~
 Ship in containers of 5,000 to 10,000 pieces
 pieces to be shown on each container
 the gross wt of which must not exceed 20 lbs.
 Acceptance ~~TESTING~~ : Inspection of these parts will be based on statistical sampling tables of the Bell Telephone Laboratory by Dodge & Roming. Shipments will be accepted if the quality in each of the following gauges is sufficient to keep within the average outgoing quality limit specified.

INSPECTION (

Set 7

only differ in the side attach.

same as other attach. for manufacturing

PART: Sear Spring (Purchase ready for Assembly)	PART No. 17047																								
MATERIAL PROCUREMENT #867 (Replaces #349)																									
Detailed Description																									
Remington Planning OBSOLETE Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring) Uses of Part : M/721 - All Calibers; M/722 - All Calibers																									
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**See Process Record - Inspection for procedure. OBSOLETE *Revised 3/22/46																									
COMPILED BY: C. B. Buonassisi	APPROVAL & DATE: <u>R.H. Chase 3/22/46</u>																								
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																									

PART: Sear Spring (Purchase ready for Assembly)	PART No. 17047
MATERIAL PROCUREMENT #867 (Replaces #349)	
Detailed Description	
Remington Planning OBSOLETE Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring) Uses of Part : M/721 - All Calibers; M/722 - All Calibers	
Vendor	
Material	: Music Wire. Packing slip to show material used for each shipment of parts.
Heat Treatment	: Stress Relieve
Final Color	: Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).
Packaging	: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.
Acceptance Testing:*	
Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.	
<u>Inspection:**</u>	
<u>Gage No.</u>	<u>Type</u>
Coates	"Elasticometer"
	Free Length Solid Height I.D. of Spring O.D. of Spring Load at 80% Deflection
	<u>AOQL</u> 7% 7 7 7 7
Visual	Wind R.H. Ends Squared and Ground Seams, etc.
	7 7 7
**See Process Record - Inspection for procedure.	
*Revised 3/22/46	
COMPILED BY: C. B. Buonassisi	APPROVAL & DATE: <i>R.H. Grace 3/22/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

PART Sear Spring (Purchase ready for Assembly)

PART NO. 17047

MATERIAL PROCUREMENT #349

Detailed Description

Remington Planning

Pieces Required Per Assembly : 2 (1 Sear Spring - 1 Trigger Spring)
 Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : Music Wire
 Heat Treatment : Stress Relieve
 Final Color : Parts to be bright, free of rust, oiled for
 rust protection with light (SAE-20 or equiv.) oil.
 Packaging : Ship in containers of 5,000 to 10,000 pieces.

Acceptance Gages:

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each
 shipment of parts.

Gaging -

COMPILED BY B. C. Andrews

APPROVAL & DATE *R.H. Grace 11/12/45*

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

COIL SPRING THROBBER SPRING		PART No. 17047	
OPERATION: PURCHASE INSPECTION		OPER. No.: 1	
PROCESS RECORD — INSPECTION			
GAUGES			
TYPE	No.	USE	LIMITS
			MAX. MIN.
1. Rod Collar	B-51364W B-51365W	Set Sample 24 hours.	
2. Coates Elasticometer		Set up Elasticometer	
Pin	B-51001T	a. Place Bushing in platen	
Ring	B-51000T	b. Snap pin in anvil	
Bushing	B-50127T	c. Load beam with mean load 7# 9.5 oz.	
		d. Set markers on scale *(Includes 1" constant)	1-21/64" 1 1/2"
3.		a. Slip spring on pin. Must fit freely.	
		b. Check "Free Length" with pin length. Must be flush or longer.	.460
4.		a. Place ring on platen. Raise platen to "Solid Height." Lock platen. Check with ring. Ring is max. Solid Height.	.250
		b. Raise and lower ring over spring to check "freely in hole" at solid height.	.174
5.		a. Lower platen until balance arm is on zero. Move lever arm up and down several times to get true reading. Pointer on platen must fall between tolerance markers on scale.	
6. Visual		a. Check ends Check wind	
		Note: Only sample springs are to be set before assembly	
COMPILED BY: E. E. Wheat		APPROVAL & DATE: <i>[Signature]</i> 11/1/46	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.			

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PART: SEAR SPRING TRIGGER SPRING		PART No. 17047	
OPERATION: Purchase Inspection		OPER. No.: 1	
PROCESS RECORD — INSPECTION			
PROCESS RECORD — INSPECTION			
GAUGES		USE	LIMITS
Type	No.		Max. Min.
1. Rod Collar	B-51634W B-51635W	Set Sample 24 hours	
2. Coates Elasticometer Pin Ring Bushing	B-51001T B-51000T B-50127T	Set up Elasticometer a. Place bushing in platen b. Snap pin in anvil c-Load beam with mean load #7 13 3/4 oz. d. Set markers on scale *(includes 1" constant)	* 1 21/64" 1 1/4"
3.		a. Slip spring on pin. Must fit freely. b. Check "Free Length" with pin. Spring must be flush or longer.	.460
4.		a. Place ring on platen. Raise platen to "solid height". Lock platen. Check with ring. Ring is max, solid height. b. Raise and lower ring over spring to check "Freely in hole" at solid height	.250 .174
5.		a. Lower platen until balance arm is on zero. (Move lever up and down slightly several times for true reading) Pointer on platen must fall between tolerance markers on scales	
6. Visual		a. Check ends squared and ground check wind R. H.	
		<u>Note:</u> All springs must be set 24 hours before assembly.	
COMPILED BY: E.J. Wheat		APPROVAL & DATE: <i>MWKS 8/22/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: SEAR SPRING TRIGGER SPRING		PART No. 17047		
OPERATION: Purchase Inspection		OPER. No. 1		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
Type	No.		Max.	Min.
1. Rod Collar	B-51634W B-51635W	Set Sample 24 hours		
2. Coates Elasticometer	A-51365W	Set up Elasticometer		
Pin	B-51001T	a. Place bushing in platen		
Ring	B-51000T	b. Snap pin in anvil		
Bushing	B-50127T	c. Load beam with mean load #7 13 3/4 oz.		
		d. Set markers on scale *(includes 1" constant)	1 23/64"	1 1/4"
3.		a. Slip spring on pin. Must fit freely.		
		b. Check "Free Length" with pin. Spring must be finish or longer.		.460
4.		a. Place ring on platen. Raise platen to "solid height". Lock platen. Check with ring. Ring is max, solid height.	.250	
		b. Raise and lower ring over spring to check "Freely in hole" at solid height	.174	
5.		a. Lower platen until balance arm is on zero. (Move lever up and down slightly several times for true reading) Pointer on platen must fall between tolerance markers on scale.		
6. Visual		a. Check ends squared and ground check wind R. H.		
		Note: All springs must be set 24 hours before assembly.		
COMPILED BY: E.J. Wheat		APPROVAL & DATE: MKS 8/22/46		
REMINGTON ARMS COMPANY, INC. REVISED AUG 27 1946				

PART: Sear Spring Trigger Spring		PART No. 17047		
OPERATION: Purchase Inspection		OPER. No.: 1		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
Type	No.		Max.	Min.
1. Rod collar	B-51634W B-51635W	Set sample 24 hours		
2. Coates Elasticometer Pin Ring Bushing	B-51001T B-51000T <u>B-51027T</u> B-51027T	Set up Elasticometer a. Place bushing in platen b. Snap pin in anvil c. Load beam with mean load. 7# 13 3/4oz. d. Set markers on scale *(includes 1" constant)	1.21/64"	1 1/4"
3.		a. Slip spring on pin. Must fit freely. b. Check "Free length" with pin. Spring must be flush or longer.		.460
4.		a. Place ring on platen. Raise platen to "solid height". Lock platen. Check with ring. Ring is max. solid height. b. Raise and lower ring over spring to check "Freely in hole" at solid height	.250 .174	
5.		a. Lower platen until balance arm is on zero. (Move lever up and down slightly several times for true reading) Pointer on platen must fall between tolerance markers on scale.		
6. Visual		a. Check ends squared and ground check wind R. H.		
		<u>Note:</u> All springs must be set 24 hours before assembly.		
COMPILED BY: E. K. Wheat		APPROVAL & DATE: <i>MKL 1/1/56</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: Sear Spring
Trigger Spring

PART No. 17047

OPERATION: Purchase Inspection

OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
Type	No.		Max.	Min.
1. Rod collar	B-51634W B-51635W	Set sample 24 hours		
2. Coates Elasticometer Pin Ring Bushings	B-51001T B-51000T B-51027T	Set up Elasticometer a. Place bushing in platen b. Snap pin in anvil c. Load beam with mean load 7# 13 3/4oz. d. Set markers on scale *(includes 1" constant)	1 21/64"	1 1/4"
3.		a. Slip spring on pin. Must fit freely. b. Check "Free length" with pin. Spring must be flush or longer.		.460
4.		a. Place ring on platen. Raise platen to "solid height". Lock platen. Check with ring. Ring is max. solid height. b. Raise and lower ring over spring to check "Freely in hole" at solid height	.250 .174	
5.		a. Lower platen until balance arm is on zero. (Move lever up and down slightly several times for true reading) Pointer on platen must fall between tolerance markers on scale.		
6. Visual		a. Check ends squared and ground check wind R. H. <u>Note:</u> All springs must be set 24 hours before assembly.		
COMPILED BY: E. K. Wheat		APPROVAL & DATE: M/KS 7/1/EC		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: Sear Spring Trigger Spring		PART No. 17047		
OPERATION: Purchase Inspection		OPER. No.: 1		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
Type	No.		Max.	Min.
1. Rod collar	B-51634W B-51635W	Set sample 24 hours		
2. Coates Elasticometer Pin Ring Bushing	B-51001T B-51000T B-51027T	Set up Elasticometer a. Place bushing in platen b. Snap pin in anvil c. Load beam with mean load 7# 13 3/4oz. d. Set markers on scale *(includes 1" constant)	1 21/64"	1 1/4"
3.		a. Slip spring on pin. Must fit freely. b. Check "Free length" with pin. Spring must be flush or longer.		.460
4.		a. Place ring on platen. Raise platen to "solid height". Lock platen. Check with ring. Ring is max. solid height. b. Raise and lower ring over spring to check "Freely in hole" at solid height	.250	.174
5.		a. Lower platen until balance arm is on zero. (Move lever up and down slightly several times for true reading) Pointer on platen must fall between tolerance markers on scale.		
6. Visual		a. Check ends squared and ground check wind R. H.		
		<u>Note:</u> All springs must be set 24 hours before assembly.		
COMPILED BY: E. K. Wheat		APPROVAL & DATE: <i>MKL 7/1/66</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

OBSOLETE

PART: "Sear & Trigger Spring"		PART No. 17047		
OPERATION: Purchase Inspection		OPER. No.: 1		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Coats "Elasticometer"		Set removed		
(1)	Pin B51001T Ring B51000T Bushing B51027T	Set up Elasticometer 1. Place bushing in platen 2. Snap pin in anvil 3. Load beam with mean load 7# 13 3/4 oz. 4. Set markers on scale († Constant)	1-21/64"	1 1/4"
(2)	Visual	(a) Slip Spring on Pin Must go "freely" (b) Check "Free Length" with Pin Length. Must be flush or longer.		.460
(3)		(a) Place Ring on Platen Raise Platen to "Solid Height" - Lock Platen- Check with Ring. (b) Raise & Lower Ring over Spring to check "Freely in Hole" at Solid Height	.250	
(4)		Lower platen until balance arm is on zero. Check platen pointer for tolerance on scale	.174	
(5)	Rod Collar B-51364-W B-51365-W	Set for 24 hours		
(6)		Repeat Steps (2), (3), (4)		
(7)	Visual	Check ends-Squared & Ground Check Wind-R.H.		
COMPILED BY: E. K. Wheat		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

OBSOLETE

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Sear Spring 17047Operation Entire Process

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

10/25/46
DateR. W. Helwood
Process EngineerPROCESS RECORDS TURNED OVER TO PLANTModel 721Component Sear Spring 17047Operation 1

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

11/25/46
DateC. B.
Process Engineer
R. Angell

OBSOLETE

PROCESS RECORD

TRIGGER

PART No. 17048

Revised

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____
DEPARTMENT

OBSOLETE

PART:

Trigger

PART No.

17048

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE

DESCRIPTION OF CHANGE

Revised

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Trigger (Purchase ready for Assembly)

PART No. 17048

OBsolete
11/29/46

5/22/46

MATERIAL PROCUREMENT - FINISHED COMPONENT

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor

Material : .08-.20 Plain Carbon Steel. Packing slip to show material used for each shipment of parts.

Heat Treatment : None

Final Color : ~~Black Oxide Color~~. Parts to be ^{bright} free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AQCL
1.	Visual	Defects	7%
2. B-80013-M	Adj. Snap	Material Thickness	7%
3. B-80002-R	Plug	Hole Dia.	3%
4. B-50317	Checking Fixture	Hole Position	3%
5. Standard Finish Blocks	Visual	Surface Finish	7%

M. H. Smith

R.H.

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

M. H. Smith 5/15/46

REMINGTON ARMS COMPANY, INC. - MILITARY DIVISION

PART: Trigger (Purchase ready for Assembly)

PART No. 17048

OBsolete*Finished Component*

MATERIAL PROCUREMENT #850 (Replaces #371)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : .08-.20 Plain Carbon Steel. Packing slip to show material used for each shipment of parts.

~~Surface Finish : #2 Commercial Cold Finished Surface satisfactory.~~

Heat Treatment : None

Final Color : Black Oxide Color. Parts to be free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection Type or Gage

1. Visual Inspect for Defects
2. Adj. Snap Gage B-80013-M
3. Plug Gage B-80002-R
4. Checking Fixture B-50317

INSPECTION:

	<u>GAGE No.</u>	<u>TYPE</u>	<u>USE</u>	<u>AQQL</u>
1.		VISUAL	DEFECTS	390
2.	B-80013-M	ADJ. SNAP	MAT'L THICKNESS	7
3.	B-80002-R	PLUG	HOLE DIA.	3
4.	B-50317	CHECKING FIXTURE	HOLE POSITION	3

*Revised 3/19/46

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

RH Lee 3/19/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Trigger (Purchase ready for Assembly)

PART NO. 17048

MATERIAL PROCUREMENT #850 (Replaces #371)

Detailed Description

OBSOLETE

Remington Planning

Pieces Required Per Assembly: 1
 Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : .08-.20 Plain Carbon Steel. Packing slip to show material used for each shipment of parts.
 Surface Finish : #2 Commercial Cold Finished Surface satisfactory.
 Heat Treatment : None
 Final Color : Black Oxide Color. Parts to be free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).
 Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:*

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

<u>Inspection Type or Gage</u>		AOQL %
1. Visual Inspect for Defects		3
2. Adj. Snap Gage	B-80013-M	7
3. Plug Gage	B-80002-R	3
4. Checking fixture	B-50317	3

*Revised 3/19/46

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

RH Lane 3/19/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART Trigger (Purchase ready for Assembly)

PART NO. 17048

OBsolete

850
MATERIAL PROCUREMENT ~~437~~

(Replaces 4371)

Detailed Description

Remington Planning

Pieces Required Per Assembly : 1

Uses of Part

: M/721 - All Calibers; M/722 - All Calibers

Vendor

Material

.08-.20 Plain Carbon Steel -
~~ASTM A-1020~~ Packing Slip &c

Surface Finish

: #2 Commercial Cold Finished Surface satisfactory.

Heat Treatment

: None

Final Color

: Black Oxide Color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil.

Packaging

: ~~Ship in containers of 5,000 to 10,000 pieces.~~

Acceptance Gages

1. Visual Inspect for Defects
2. Adj. Snap Gage B-80015-M 7%
3. Plug Gage B-80002-R 3%
4. Checking fixture B-50317 3%

Acceptance Testing

Chemical - Signed statement of analysis to accompany each shipment of parts.

Bagging

Inspection will be based on statistical sampling according to D & R Sampling Table 7 B.T.C. Shipments will be accepted if the quality on each of the following gages is sufficient to maintain the "Average O.P.R." listed.

COMPILED BY B. C. Andrews

APPROVAL & DATE R.H. Gress 11/16/48

REMINGTON ARMS COMPANY, INC., ILION, N.Y.

PART NO. 17048 (Purchased ready for assembly)

PART NO. 17048

MATERIAL PROCUREMENT #371

obsolete

Detailed Description

Remington

OBsolete

Pieces Required Per Assembly : 1
Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : AISI C-1020
Surface Finish : #2 Commercial Cold Finished Surface satisfactory.
Heat Treatment : None
Final Color : Black Oxide Color. Parts to be free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil.
Packaging : Ship in containers of 5,000 to 10,000 pieces.
Acceptance Gages:

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each shipment of parts.

Daging -

COMPILED BY B. C. Andrews

APPROVAL & DATE

R.H. Grace 11/16/45

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FORS-END BUFFER		PART NO: 171		
OPERATION: Inspection				
PROCESS RECORD - INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
(1) Visual		For Defects A O Q L 5%		
(2) Dial Indicator Comparator Gage	B-80055	Gage .340 Step A O Q L 5%	.345	.335
(3) Adjustable Snap Gage	Special 52212	Gage .070 Width A O Q L 5%	.075	.065
(4) Plug Gage	B-80004	Gage .215 Slot A O Q L 5%	.220	.210
(5) Micrometers	Std.	Gage .410 Width " .520 " " .093 Thickness (Smallest Sample) A O Q L 5%	.405 .515 .088	.415 .525 .098
(6) Adjustable Snap Gage	B-80012	Gage step distance from end A O Q L 5%	L.161	L.151
OBSOLETE				
COMPILED BY: [Signature]		APPROVED BY: [Signature]		
DATE: 3-7-70		DATE: 3-10-70		
KINZER V. REMINGTON				

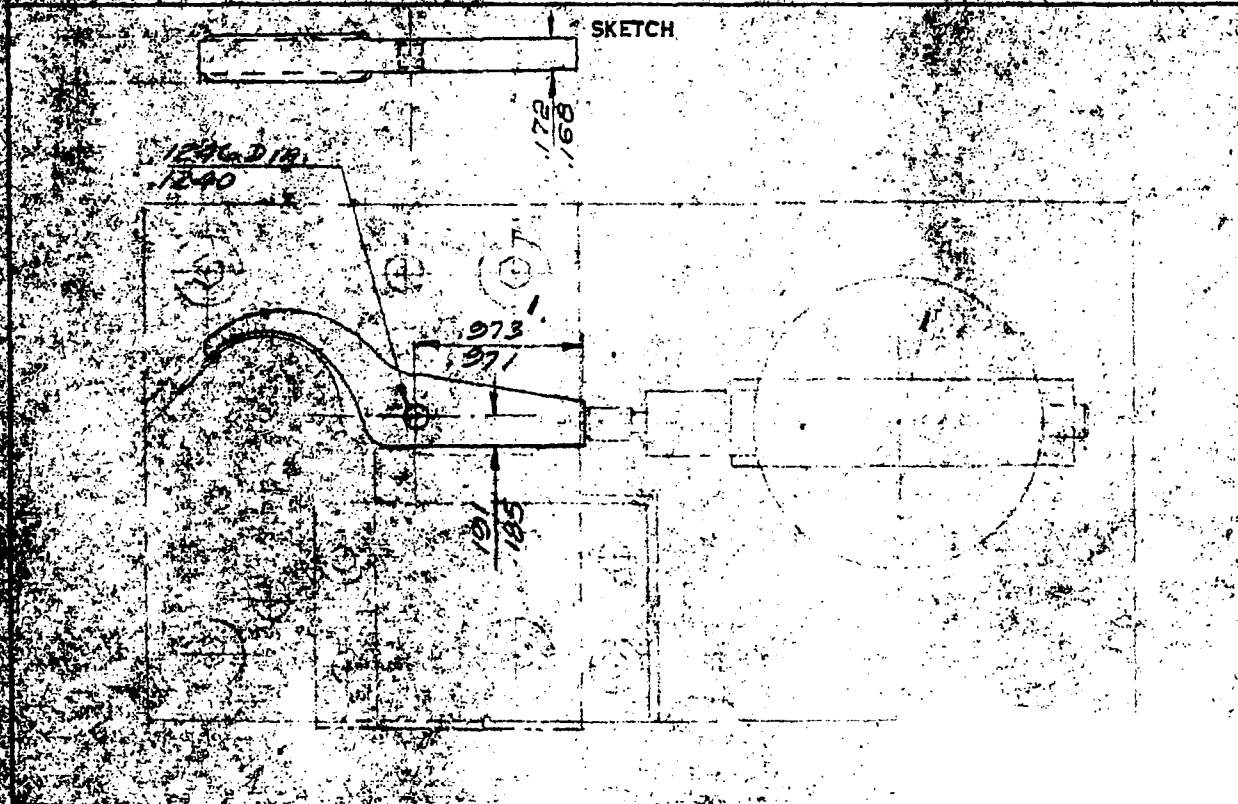
OBSCURE

OPERATION	PART NO. 17028
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OPERATION <i>Final Purchase Inspection</i>	OPER. No. 1
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PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
1.		VISUAL INSPECT FOR DEFECTS		
2.	ADJ. SNAP GAGE B-80013-M	CHECK THICKNESS	.172	.168
3.	PLUG GAGE B-80002-R	CHECK HOLE	.1246	.1240
4.	CHECKING FIXTURE B-80017	PLACE PART ON PIN LOCATING IN .1246 DIA HOLE. BRING SLIDE UP TO WORK TO CHECK .185 - .191 DIMENSION. READ INDICATOR TO CHECK .971 - .973 DIMENSION.		



DRAWN BY APPROVED BY	APPROVAL & DATE REMINGTON ARMS COMPANY, INC., ILION, N. Y.
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Form RT-118

PROCESS RECORDS. TURNED OVER TO PLANT

Model 721

Component Name Ingrin

Component No. 17048

Operation Ingrin, Reg. Mat. Proc - Semi, op # 122

The original vellums on this operation are being withdrawn
from Engineering Files to be turned over to the Plant.

1/24/47
Date

R. H. Selwood
Process Engineer

OBSOLETE

*Ret'd
Checked
8/20/46*

PROCESS RECORD

TRIGGER ADJUSTING SCREW

PART NO. 17049

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO: _____
DEPARTMENT

PART: (TEMPORARY) TRIGGER ADJUSTING SCREW		PART No. 17049	
SEQUENCE OF OPERATIONS			
18/3	SEQ. NO.	OPER. NO.	OPERATION
			DEPT.
1			MATERIAL PROCUREMENT
2		1	PURCHASE INSPECTION
3			TRANSFER TO PART STORES
COMPILED BY: M. H. SMITH		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. MILWAUKEE, WIS.			

H. H. SULLIVAN, INC.

Retyped & checked 8/20/46

PART: OBSOLETE		PART NO. 17049	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1	Form, Thread, Cut off and slot Head	
2	2	High Temperature Cyanide Harden, Water Quench, Wash and Dry	
3	3	Inspect for File Hardness	
4	4	Mix Black, Water quench, Wash, Dry and Oil for Storage	
5	5	Inspect for Color and Oil	
<u>Note:</u>		This Part will be Purchased ready for assembly until receipt of Bros Screw Machine Use Purchase Part Inspection Operation Only To Part Store	
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.			

Suggs Adj. Screw 17049

Registration Sheet obsoleted 1-27-47

M. H. Smell

See Barrel assembly 17000 for signed sheet

PART: TRIGGER ADJUSTING SCREW		PART No. 17049
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
OBSOLETE JAN 27 1947		
COMPILED BY:		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: UBSULL Trigger Adjusting Screw		PART NO. 17049
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
8/20/46		
COMPILED BY:		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

PART: Trigger Adjusting Screw	PART NO. 37049																		
5/23/46																			
MATERIAL PROCUREMENT - RAW MATERIAL																			
DELETED DEC 17 1946 Detailed Description Pieces Required Per Assembly : 2 Material Specification : 114K Material : B-1113 Size : 1/4" $\pm$.000" .002" dia. Bar Stock - Approx. 12" lengths Condition : Cold Drawn Weight Per 100 : Calculated: .517 lbs. Measured: Additional Uses of Material : None Uses of Part : M/721 - All calibers; M/722 - All calibers Identification of Material : Routing ticket to be marked Mat. Spec. #114K Remarks:	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 50%;">REV. No.</th> <th style="width: 50%;">DATE</th> </tr> </thead> <tbody> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </tbody> </table>	REV. No.	DATE																
REV. No.	DATE																		
COMPILED BY: B. C. [unclear]	APPROVAL & DATE: <i>[Signature]</i> 5/27/46																		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																			

PART: Trigger Adjusting Screw

PART No. 17049

5/23/46

MATERIAL PROCUREMENT - RAW MATERIAL

Detailed Description

Pieces Required Per Assembly : 2

Material Specification : 114K

Material : B-1113

Size : 1/4" $\pm$.000"
- .002" dia. Bar Stock - Approx. 12" lengths

Condition : Cold Drawn

Weight Per 100 : Calculated: .517 lbs. Measured; _____

Additional Uses of Material : None

Uses of Part : M/721 - All calibers; M/722 - All calibers

Identification of Material : Routing ticket to be marked Mat. Spec.
#114K

Remarks:

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

M. H. Smith 5/27/46

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

PART NO. 17049

PART NO. 17049

MATERIAL PROCUREMENT ~~#324~~ (replaces #324)

Detailed Description

Pieces Required Per Assembly : 2

Material Specification : 115K

Material : B-1113

Size 1 1/4" ^{+.000"}_{-.002"} dia. Bar Stock - Approx. 12' lengths

Condition Cold Drawn

Weight Per 100 : Calculated: .517 lbs. Measured:

Additional Uses of Material : None

Use of Part : M/721 - All calibers; M/722 - All calibers.

Identification of Material : Routing ticket to be marked Mat. Spec. #114K

Remarks:

~~*Revised 3/27/16~~

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. - NEW YORK

WARRANT FOR THE ARREST OF

RECEIVED BY THE COURT

RECEIVED BY THE COURT

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PART: Trigger Adjusting Screw

PART NO. 17049

CONFIDENTIAL

MATERIAL PROCUREMENT #324

Detailed Description

Pieces Required Per Assembly : 2

Material Specification : 114K

Material : B-1113

Size : .250 ^{+.000"}_{-.002"} dia. Bar Stock - Approx. 12' lengths

Condition : Cold Drawn

Weight Per 100 : Calculated: .517 lbs. Measured: _____

Additional Uses of Material : None

Uses of Part : M/721 - All calibers; M/722 - All calibers

Identification of Material : Routing ticket to be marked Mat. Spec. #114K

Remarks:

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

P. H. Goss 12/6/45

REMINGTON-UMC COMPANY, INC., MILWAUKEE, WIS.

PART: Trigger Adjusting Screw (Purchase ready for Assembly)

PART No. 17049

Date: 5-21-46

MATERIAL PROCUREMENT - FINISHED COMPONENT

Detailed Description *Insert to Plan*

Remington planning

Pieces Required Per Assembly: 2

Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor

Material : B-1115. Packing slip to show material used for each shipment of parts.

Heat Treatment : Case Harden. Temper (See Footnote)

Case Depth : .003 - .006"

Final Appearance : Black Oxide color, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AQCL
1.	Visual	Defects	7%
2. B-80026-W	Ring Thread	Threads	7%
B-80019-V	Setting Plug		
3. B-80055-W	Adj. Dial Snap	Diameter .104-.108	7%
B-80059-W	Setting Plug		
4. B-80015-X	Adj. Snap	Length	7%
5.	Grind and Etch	Case Measurement	7%

Note: As a matter of information only, this part has been heat treated satisfactorily at Remington as follows:

Harden - duPont Cyanide Bath: 1550-1600; 20 minutes; oil quench.

Temper - duPont Heat Coloring Bath: 900-1000; 10 minutes.

COMPILED BY: B.C. Andrews

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Trigger Adjusting Screw (Purchase ready for Assembly)

PART No. 17049

Date: 5-21-46

MATERIAL PROCUREMENT - FINISHED COMPONENT

Detailed Description

Obsolete

Production Planning

Pieces Required Per Assembly: 2

Uses of Part

: M/721 - All Calibers

M/722 - All Calibers

Vendor

Material

: Ballistics. Packing slip to show material used for each shipment of parts.

Heat Treatment

: Case Harden. Temper (See Footnote)

Case Depth

: .003 - .006"

Final Appearance

: Black Oxide color, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

Packaging

: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testings

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspections:

Gage No.	Type	Use	AQCL
1.	Visual	Defects	7%
2. B-80026-W	Ring Thread	Threads	7%
B-80019-V	Setting Plug		
3. B-80055-W-V	Adj. Dial Snap	Diameter .104-.108	7%
B-80039-W	Setting Plug		
4. B-80015-X	Adj. Snap	Length	7%
5.	Grind and Etch	Case Measurement	7%

Note: As a matter of information only, this part has been heat treated satisfactorily at Remington as follows:

Harden - duPont Cyanide Baths 1550-1600; 20 minutes; oil quench.

Temper - duPont Heat Coloring Baths 900-1000; 10 minutes.

COMPILED BY: B.C. Andrews

APPROVAL & DATE:

M. J. Smith 5/27/46

REMINGTON-ARMS COMPANY, INC. MILION, N. Y.

PART: Trigger Adjusting Screw (Purchase ready for Assembly)

PART NO. 17049

Date: 5-21-48

MATERIAL PROCUREMENT - FINISHED COMPONENT

Detailed Description

Remington Planning

Pieces Required Per Assembly: 2

Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor

Material : B-1115. Packing slip to show material used
for each shipment of parts.

Heat Treatment : Case Harden. Temper (See Footnote)

Case Depth : .003 - .006"

Final Appearance : Black Oxide color, free of rust, oiled with light rust proofing
oil (SAB-20 or equiv.).Packaging : Purchase Order Number and quantity of pieces to be shown on
each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testings

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AQCL
1.	Visual	Defects	7%
2. B-80028-W	Ring Thread	Threads	7%
B-80019-V	Setting Plug		
3. B-80035-V	Adj. Dial Snap	Diameter .104-.108	7%
B-80039-W	Setting Plug		
4. B-80015-K	Adj. Snap	Length	7%
5.	Grind and Etch	Case Measurement	7%

Note: As a matter of information only, this part has been heat treated satisfactorily at Remington as follows:

Harden - duPont Cyanide Baths: 1550-1600; 20 minutes; oil quench.

Temper - duPont Heat Coloring Baths: 900-1000; 10 minutes.

COMPILED BY: B.C. Andrews

APPROVAL DATE:

REMINGTON ARMS COMPANY INC. ILION, N. Y.

PART: Trigger Adjusting Screw (Purchase ready for Assembly)

PART No. 17049

MATERIAL REQUIREMENT #878

Detailed Description

Remington Planning

Pieces Required Per Assembly: 2

Uses of Part

: M/721 - All Calibers

M/722 - All Calibers

Vendor

Material : B-1113. Packing slip to show material used for each shipment of parts.

Heat Treatment : Case Harden. Temper (See Footnote).

Case Depth : .003 - .006"

Final Appearance : Black Oxide color, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing :

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AOQL
1.	Visual for Defects	Defects	7%
2. B-80026-W	Ring Thread	Threads	7%
B-80019-V	Setting Plug		
3. B-80035-W	Adj. Dial Snap	Diameter .104 - .108	7%
B-80039-W	Setting Plug		
4. B-80013-K	Adj. Snap	Length	7%
5.	Grind and Etch	Case Measurement	7%

Note: As a matter of information only, this part has been heat treated satisfactorily at Remington as follows:

Harden - DuPONT Cyanide Bath: 1550-1600; 20 minutes; oil quench.

Temper - DuPONT Heat Coloring Bath: 900-1000; 10 minutes.

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

B.H. Chase 3/28/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Trigger Adjusting Screw (Purchase ready for Assembly)

PART No. 17049

OBSOLETE

MATERIAL PROCUREMENT #878

Detailed Description

Remington Planning

Pieces Required Per Assembly: 2

Uses of Part : M/721 - All Calibers;
M/722 - All Calibers

Vendor

Material : B-1113. Packing slip to show material used for each shipment of parts.

Heat Treatment : Case Harden. Temper (See Footnote).

Case Depth : .002 - .006"

Final Appearance : Black Oxide color, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing :

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AOQL
1.	Visual for Defects		7%
2. B-80026-W	Ring Thread	Threads	7%
B-80019-V	Setting Plug		
3. B-80035-W	Adj. Dial Snap	Diameter .104 - .108	7%
B-80039-W	Setting Plug		
4. B-80013-K	Adj. Snap	Length	7%
5.	Grind and Etch	Case Measurement	7%

Note: As a matter of information only, this part has been heat treated satisfactorily at Remington as follows:

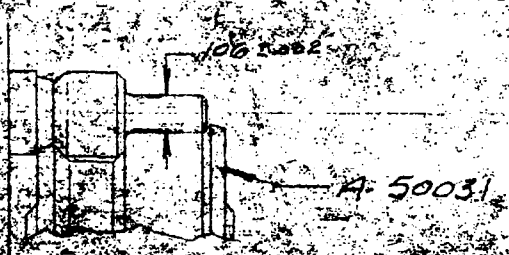
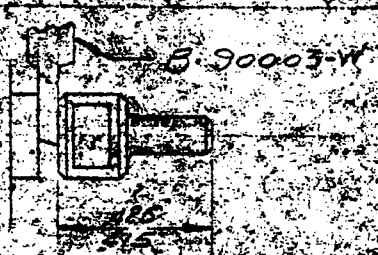
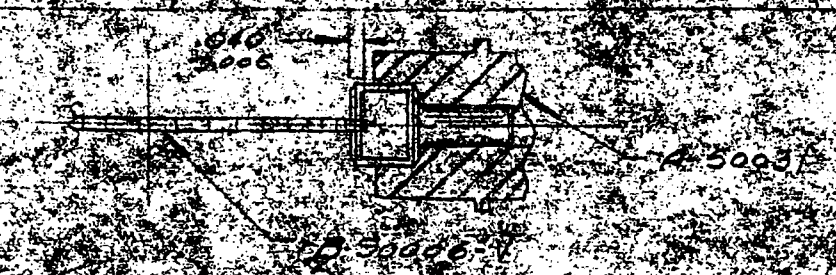
Harden - DuPONT Cyanide Bath: 1550-1600; 20 minutes; oil quench.
Temper - DuPONT Heat Coloring Bath: 900-1000; 10 minutes.

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

P.H. Grace 3/28/46

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

PART: TRIGGER ADJUSTING SCREW		PART No. 17049
OPERATION: HEAD, CUTOFF & SLOT HEAD		OPER. No.: 1
OBSOLETE DEC 17 1946 PROCESS RECORD — ILLUSTRATION SKETCH		
①		
②	 Handwritten signature Handwritten signature	
③		
④		
⑤		
DATE: 12/17/46 BY: [Signature] REVISED		

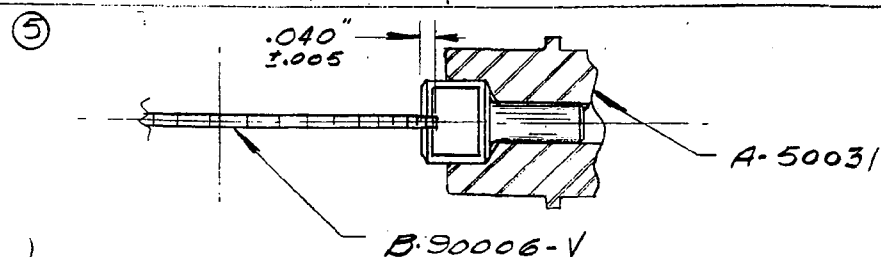
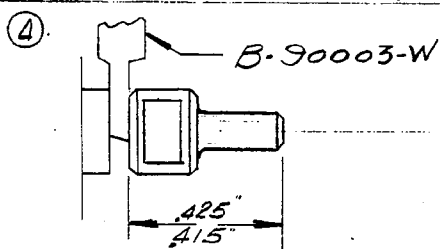
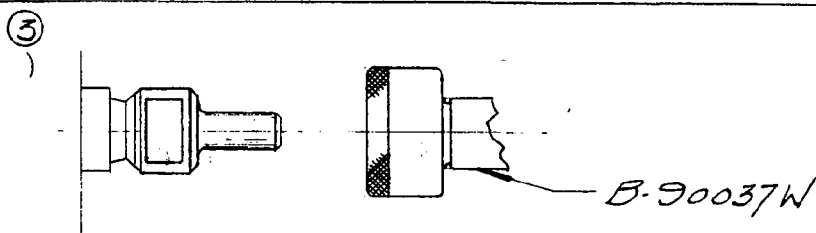
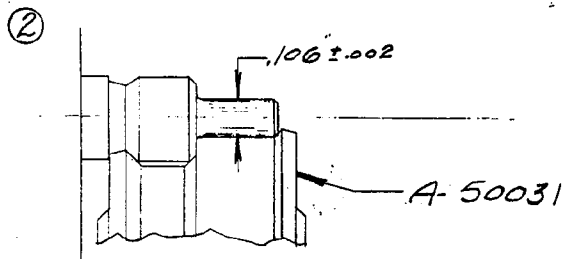
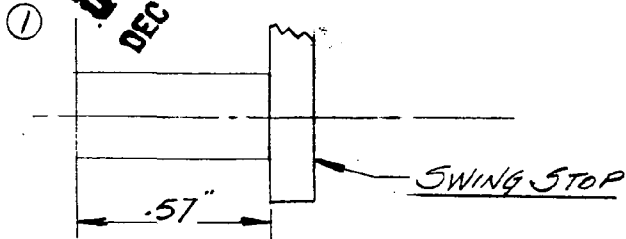
PART: TRIGGER ADJUSTING SCREW

PART No. 17049

OPERATION: FORM, THREAD, CUTOFF & SLOT HEAD

OPER. No.: 1

PROCESS RECORD — ILLUSTRATION SKETCH



COMPILED BY: P.B.C.

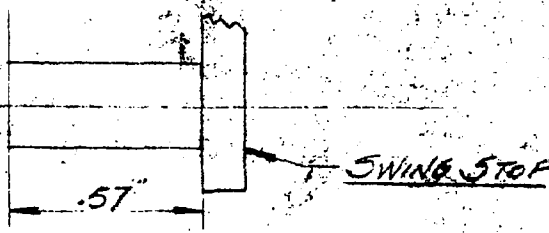
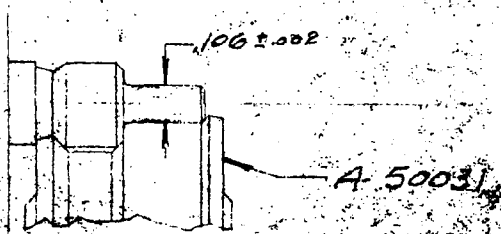
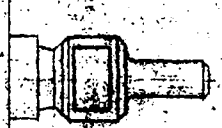
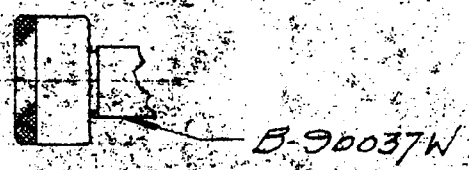
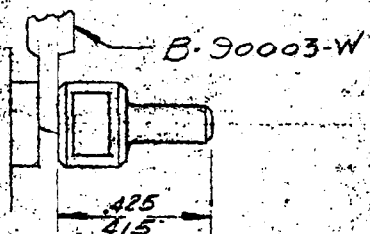
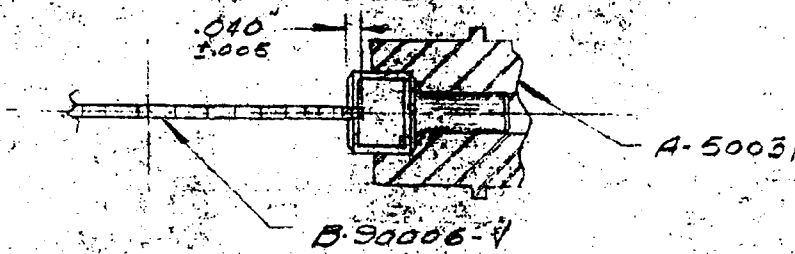
APPROVAL & DATE:

TWK 8/22/46.

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBSOLETE

8/20/46 11/11/46

PART: <u>TRIGGER ADJUSTING SCREW</u>	PART No. <u>17049</u>
FORM: <u>THREAD CUTOFF & SLOT HEAD</u>	
OPER. No.: <u>1</u>	
PROCESS RECORD — ILLUSTRATION SKETCH	
①  ②  ③   ④  ⑤ 	
COMPILED BY: <u>PBC</u>	APPROVAL & DATE:
REMINGTON-ARMS COMPANY, INC., ILION, N. Y.	

PART: TRIGGER ADJUSTING SCREW				PART No. 17049	
OPERATION: Form, Thread, Cut-off & Slot Head				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: 1000 H. B. & S. A. Auto. Set. Machine-36 Spindle Speeds					
MAX. PROD. PER HOUR: 405				COOLANT:	
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No.	No.
			Set of 3 Cam:		
			Lead	C-50042W	
			Form	C-50042V	
			Cut-off	C-50042U	
1) Feed Stock To Swing Stop	2670				Spr. Collet Feed Finger B-90034V B-90031U
2) Form	2670	.00085	Cir. Form Tool	A-50023	
3) Thread			Thd. Chasers	B-90038W	Die Head B-90037
ON	534	.0357	1-28 N.P. 2		
OFF	2670	.0357			
4) Cut-off	2670	.0015	Cir. Cut-off Tool	B-90003V	
5) Slot Head	2670		Slot Bushing	A-50031	
			Slot Cutter	B-90006V	
			Thread		
			Setting Thread Gage	B-80026W	
			Setting Plug	B-80019V	
			Diameter (.108-.104)		
			Adj. Dial Snap		
			Gage	B-80035W	
			Setting Plug	B-80039W	
			Length		
			Adj. Snap Gage	B-80013K	
INSPECTED BY: H. B. NEED			APPROVAL & DATE: 7/11/48		
REMNENTON ARMS COMPANY, INC. REVISOR					

PART: TRIGGER ADJUSTING SCREW				PART No. 17049	
OPERATION: Form, Thread, Cut-off & Slot Head				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: #00G H. S. B. & S. A uto. Scr. Machine-36 Spindle Speeds					
MAX. PROD. PER HOUR: 405			COOLANT:		
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES
STEPS	SPEED	FEED	TYPE	No.	
			Set of 3 Cams: Lead Form Cut-off	C-50042W C-50042V C-50042U	
1) Feed Stock To Swing Stop	2670				Spr. Collet Feed Finger B-90034V B-90031U
2) Form	2670	.00085	Cir. Form Tool	A-50023	
3) Thread ON OFF	534 2670	.0357 .0357	Thd. Chasers $\frac{1}{4}$ -28 N.F. 2	B-90038W	Die Head B-90037W
4) Cut-off	2670	.0015	Cir. Cut-off Tool	B-90003V	
5) Slot Head	2670		Slot Bushing Slot Cutter	A-50031 B-90006V	
			<u>Thread</u> Ring Thread Gage Setting Plug	B-80026W B-80019V	
			<u>Diameter(.108-.104)</u> Adj. Dial Snap Gage Setting Plug	B-80035W B-80039W	
			<u>Length</u> Adj. Snap Gage	B-80013K	
COMPILED BY: N. M. REED			APPROVAL & DATE: <i>M/K 8/22/46</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

ABSOLUTE

PART: TRIGGER ADJUSTING SCREW

PART NO. 170-10

OPERATION: FORM, THREAD, CUT OFF & SLOT HEAD

OPER. NO. 1

PROCESS RECORD

EQUIPMENT: #00G H.S. B. & S. AUTO. SCR. MACH. - 36 SPINDLE SPEEDS

MAX. PROD. PER HOUR: 405

COOLANT:

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
			SET OF THREE CAMS: LEAD FORM CUT-OFF	C-50042-W C-50042-V C-50042-U		
1) FEED STOCK To SWING STOP	2670				SPR. COLLET FEED FINGER	B-90034-U B-90031-U
2) FORM	2670	.00085	CIR. FORM TOOL	A-50023		
3) THREAD ON OFF	534 2670	.0357 .0357	TND CAMMERS 4-28 N.P.S.	B-90038-W	DIE HEAD	B-90037-W
4) CUT-OFF	2670	.0015	CIR. CUT-OFF TOOL	B-90003-V		
5) SLOT HEAD	2670		SLOT BUSHING SLOT CUTTER	A-50031 B-90006-V		
			THREAD RING TND. GAGE SETTING PLUG DIAMETER (.0214) ADJ. DIAL SWAP G. G. SETTING PLUG LENGTH ADJ. SWAP GAGE	B-80026-W B-80019-V B-80035-W B-80039-W B-80013-K		

COMPLETED BY

APPROVAL BY DATE

REMINGTON-UMC COMPANY, INC. ILION, N. Y.

PART: TRIGGER ADJUSTING SCREW M/721-722				PART No. A-17049	
OPERATION: FORM, THREAD, CUT-OFF & SLOT HEAD				OPER. No.: 1	
PROCESS RECORD					
EQUIPMENT: *00G H.S. B. & S. AUTO. SCR. MACH. - 36 SPINDLE SPEEDS					
MAX. PROD. PER HOUR: 405			COOLANT:		

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
			SET OF THREE CAMS: LEAD FORM CUT-OFF	C-50042-W C-50042-V C-50042-U		
1) FEED STOCK TO SWING STOP	2670				SPR. COLLET FEED FINGER	B-90034-U B-90031-U
2) FORM	2670	.00085	CIR. FORM TOOL	A-50023		
3) THREAD ON OFF	534 2670	.0357 .0357	THD. CHASERS 1/4-28 N.F.R.	B-90038-W	DIE HEAD	B-90037-W
4) CUT-OFF	2670	.0015	CIR. CUT-OFF TOOL	B-90003-V		
5) SLOT HEAD	2670		SLOT. BUSHING SLOT. CUTTER	A-50031 B-90006-V		
			<u>THREAD</u> RING THD. GAGE B-80026-W SETTING PLUG B-80019-V <u>DIAMETER (108.104)</u> ADJ. DIAL SNAP GA. B-80035-W SETTING PLUG B-80039-W <u>LENGTH</u> ADJ. SNAP GAGE B-80013-K			

COMPILED BY: H.M. Reed.	APPROVAL & DATE:
--------------------------------	------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: (TEMPORARY) TRIGGER ADJUSTING SCREW		PART No. 17049	
OPERATION: PURCHASE INSPECTION		OPER. No.:	
PROCESS RECORD — INSPECTION			
GAUGES		USE	LIMITS
Ty	No.		Max
			Mtn.
Ring Thread	B-80026W	Check Thread	Not Go
Setting Plug	B-80019V		Go
Adj. Dial Snap	B-80035V	Check Diam. of Point	.108 .104
Setting Plug	B-80039W		
Adj. Snap Gage	B-80013K	Check Overall Length	.425 .415
1" Micrometer	B-80126	Check Length of Head	.185 .175
Visual		Centrality and condition of slot	

SKETCH

1

THREAD

1/4-28-N.F. 2

.2500 } MAX. DIA.

.2438 }

.2268 } P. DIA.

.2237 }

.185

.175

.108

.104

.425

.415

COMPILED BY: M.H.H.

APPROVAL: M.H. SMITH

DATE: 5/13/46

REMINGTON ARMS COMPANY, INC. MILTON, N.Y.

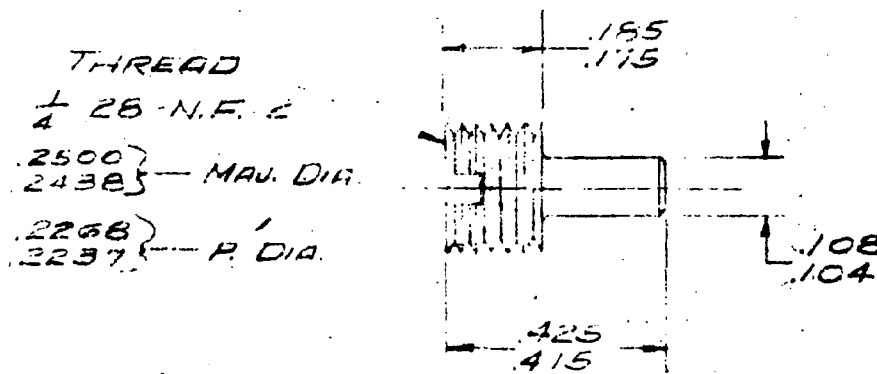
Revised
OBsolete
11/2/46

PART: (TEMPORARY) TRIGGER ADJUSTING SCREW		PART No. 17049
LOCATION: PURCHASE INSPECTION		OPER. No.: 1

PROCESS RECORD -- INSPECTION

GAUGES		USE	LIMITS	
Type	No.		Max	Min.
Ring Thread Gage	B-80026W	Check Thread	Not Go	Go
Setting Plug	B-80019V			
Adj. Dial Snap	B-80035V	Check Diam. of Point	.108	.104
Setting Plug	B-80039W			
Adj. Snap Gage	B-80013K	Check Overall Length	.425	.415
1" Micrometer		Check Length of Head	.185	.175

SKETCH



COMPILED BY: <i>MAN</i>	APPROVAL & DATE: <i>MR. S. D. H. 3/13/46</i>
REMINGTON ARMS COMPANY, INC. MOON TOWN, OHIO	

OBsolete

(TEMPORARY)
PART: TRIGGER ADJUSTING SCREW

PART No.

17049

OPERATION: PURCHASE INSPECTION

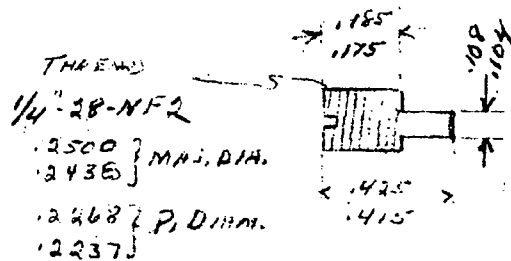
OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
RING THREAD GA. SETTING PLUG	B-B0016-W B-B0019-V	CHECK THREAD	NOT GO	GO
ADJ. DIAL SNAP SETTING PLUG	B-B0035-W B-B0039-W	CHECK DIAM. OF POINT	.108	.104
ADJ. SNAP GA.	B-B0013-K	CHECK OVERALL LENGTH	.425	.415
1" MICROMETER		CHECK LENGTH OF THREAD	.185	.175

Type

SKETCH



resketch

COMPILED BY:

APPROVAL & DATE: *M. H. Smith* 5/13/42

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: ~~(TEMPORARY)~~
TRIGGER ADJUSTING SCREW

PART No.
17049

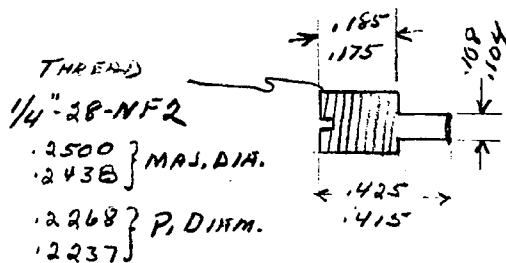
OPERATION: PURCHASE INSPECTION

OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
RING THREAD GA. SETTING PLUG	B-80016-W B-80019-V	CHECK THREAD	NOT GO	GO
ADJ. DIAL SNAP SETTING PLUG	B-80035-W B-80039-W	CHECK DIAM OF POINT	.108	.104
ADJ. SNAP GA.	B-80013-K	CHECK OVERALL LENGTH	.425	.415
1" MICROMETER		CHECK LENGTH OF HEAD	.185	.175

SKETCH



COMPILED BY:

APPROVAL & DATE:

M. V. Smith 5/13/48

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Trigger Adjusting Screw

PART No. 17049

OBSOLETE

OPERATION: High Temperature Cyanide Harden, Water Quench, Wash and Dry

OPER. No.: 2

HEAT TREAT SPECIFICATION #11

EQUIPMENT: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep

DETAILED DESCRIPTION

MATERIAL SPECIFICATION No.: 114K

MATERIAL: B-1113

TEMPERATURE: 1575 - 1600°F.

CONTAINER: 7-1/2" dia. x 6" deep basket

MAXIMUM LOAD: - H. T.: 3,500 pieces = approximately 1-1/2" depth in basket

TIME: 10 minutes at temperature

QUENCH: Water

Max. Load - Wash: 3,500 pieces

STANDARD PRACTICE: #195

REMARKS: This part is heat treated to avoid deformation of screw slot and threads in assembling and disassembling.


 File Test

HEAT TREATMENT INSPECTION

Oper. No.: 3

Operation: Inspect for File Hardness

Standard Practice: #163

Hardness Limits: File Hard

Appearance of Part: Steel grey color, clean, free of salt.

Next Oper. No.: 4

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

R. H. Shaw 11/28/45

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

Form 1-118

OK

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Trigger Relj. Screw 17049

Operation Face Shut, Temporary - Sequence, Registered, material
Procurement & Operation #1

The original ozalids on this operation are being withdrawn
from Engineering Files to be turned over to the Plant.

10/25/46.
Date

R. W. Chalmers
Process Engineer

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Trigger Adj. Screw 17049Operation Mnt. Proc. op # 1 - purchase inspect

The original ozalids on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

11/21/46
Date

C. Brown
Process Engineer

Form RT-118

PROCESS RECORDS TURNED OVER TO PLANTModel 721Component Name Trigger Adj. ScrewComponent No. 17049Operation Cyanide # 2, Nitro Black # 4

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

FEB 2 1947
Date

C. Brown
Process Engineer