CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/9/79 - New - WAW - 278187

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #7 except as circled.

3. Adjust Sear/Connector Engagement (.015 - .020) to correct Comparator Screen line, by turning Trigger Engagement Screw slowly clockwise. (To reduce Engagement).

(Install Lock Screw and tighten firmly.)

After correctly adjusting Sear/Connector Engagement

4. Hang Dead Weight Assembly to end of Trigger.

5. Adjust Trigger Pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (Fires).

(Install Lock Screw and tighten firmly.)

EQUIPMENT—TOOLS & GAGES

Comparator Fixture dead weight - 2.9 lbs. (M/600 only)

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Compartor. Australian Version. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
					OBSOLETE		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 7-1

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535384

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ..SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/9/79 - New - WAW - 278187

DESCRIPTIVE INFORMATION | NOTE: Operation is same as #7 except as circled.

9. Remove Trigger Sub-Assembly from Comparator Fixture.

10. Seal Trigger Engagement Screw Lock Screw and Trigger Stop screw only. Do not seal Trigger Screw Lock Screw Front.

EQUIPMENT—TOOLS & GAGES

NOTE: Adjust Comparator Projection System, as required, to maintain sharp clear inage of Fixture hole around entire Perimeter. Refer to page #7 of J & L Operating Manual.

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator. Australian Version. 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
					OBSOLETE		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 7-1

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535385

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/9/79 - New - WAW - 278187

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #7 except as circled.

3. Adjust Sear/Connector Engagement (.015 - .020) to correct Comparator Screen line, by turning Trigger Engagement Screw slowly clockwise. (To reduce Engagement).

Install Lock Screw and tighten firmly.

After correctly adjusting Sear/Connector Engagement

4. Hang Dead Weight Assembly to end of Trigger.

5. Adjust Trigger Pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (Fires).

Install Lock Screw and tighten firmly.

Obsolete 283006 7/7/83 RJS

EQUIPMENT - TOOLS & GAGES

Comparator Fixture dead weight - 2.9 lbs. (M/600 only)

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Compartor. Australian Version. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

RT NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 7-1

E MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

MACHINE Jones & Lamson Comparator TC-10

R2535386

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/9/79 - New - WAW - 278187

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #7 except as circled.

9. Remove Trigger Sub-Assembly from Comparator Fixture.

10. Seal Trigger Engagement Screw Lock Screw and Trigger Stop screw only. Do not seal Trigger Screw Lock Screw Front.

Obsolete 283006 7/7/83 RLS

EQUIPMENT—TOOLS & GAGES

NOTE: Adjust Comparator Projection System, as required, to maintain sharp clear inage of Fixture hole around entire Perimeter. Refer to page #7 of J & L Operating Manual.

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator. Australian Version. 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 7-1

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2

MACHINE Jones & Lamson Comparator TC-10

R2535387

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/9/79 - New - WAW - 278106~~ DATE - MRP - RLJ

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #12 except as circled.

3. Adjust Sear/Connector Engagement (.015 - .020) to correct comparator screen line, by turning Trigger Engagement Screw slowly clock-wise (to reduce engagement).

Install lock screw and tighten firmly.

After correctly adjusting Sear/Connector Engagement:

✓ 4. Hang dead weight assembly to end of Trigger.

5. Adjust Trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires)

Install lock screw and tighten firmly.

EQUIPMENT—TOOLS & GAGES

Comparator fixture dead weight - 4 lbs. (M/700 only)

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator 100%. Australian Version.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
FOR INFO ONLY, NOT PART OF PROCESS							
	PART No.						
	GA.						

PART NAME ~~Final Assembly~~ Trigger COOLANT SET UP TIME MODEL No. 700 OPER. No. [redacted]

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535388

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/9/79 - New - MAH - 278186~~
DATE - MCP - Rut

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
NOTE: Operation is same as #12 except as circled. 9. Remove Trigger Sub-Assembly from comparator fixture. 10 Seal Trigger Engagement Screw Lock Screw and Trigger Stop Screw only. Do not seal Trigger Screw Lock Screw front.	

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator 100%. Australian Version. FOR INFO ONLY, NOT PART OF PROCESS	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME T12665R ~~Pinel~~ Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. [redacted]
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2
MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6469

R2535389

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ...EMBLY SHEETS

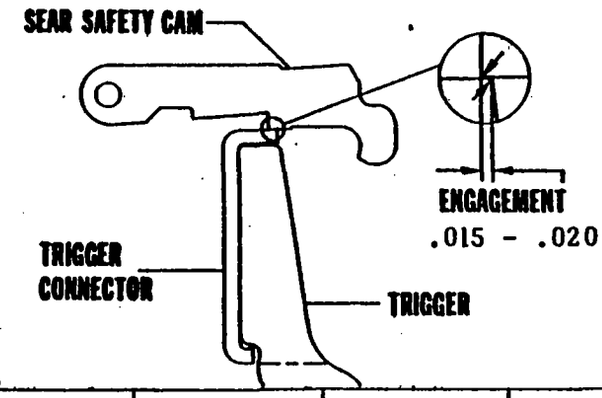
DATES ...D REASONS FOR REVISIONS 8/24/79 - New - WAW - 277805
10/9/79 - Corrected fixture no. - WAW - 278186

DESCRIPTIVE INFORMATION

1. Pick Trigger Sub-Assembly. Position in comparator fixture and clamp:
   - Housing must properly contact all locators.
   - Top of Housing must be flat on fixture.
   - Push with thumb on rear of Trigger (toward left). This seats Trigger firmly against end of Trigger Adjusting Screw.
2. Adjust fixture to locate Sear on "Set" line of comparator screen.

EQUIPMENT—TOOLS & GAGES

Comparator Fixture E-42271
Comparator Screen A-600-CL25



OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C.						
	STD. No.						
	EFF. DATE						
Adjust Trigger Sub-Assembly on Comparator 100%.							
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 12
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6469

R2535390

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS A :MBLY SHEETS

DATES AND REASONS FOR REVISIONS 8/24/79 - New - WAW - 277805

DESCRIPTIVE INFORMATION

3. Adjust Sear/Connector engagement (.015-.020), to correct comparator screen line, by turning Trigger Engagement Screw slowly clockwise (to reduce engagement).

   NOTE: Australian guns only: Install lock screw and tighten firmly.

   After correctly adjusting Sear/Connector Engagement :

4. Hang dead weight assembly to end of Trigger.

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).

   NOTE: Australian guns only: Install lock screw and tighten firmly.

EQUIPMENT—TOOLS & GAGES

Comparator fixture dead weight - 4 lbs. (M/700 only)

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 12

TYPE MACH. HRS. DEPT No. 61 PAGE 2 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535391

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS / EMBLY SHEETS

DATES AND REASONS FOR REVISIONS 8/24/79 - New - WAW - 277805

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
6. Re-adjust fixture to locate Sear on "Set Line" of comparator screen. 7. Remove dead weight assembly from Trigger. 8. Hold Trigger in fired position firmly with finger, and: • Set Over-Travel by turning Trigger Stop Screw slowly clockwise, until Trigger Connector touches correct line on comparator screen.	

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 12

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535392

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 8/24/79 - New - WAW - 277805

DESCRIPTIVE INFORMATION

9. Remove Trigger Sub-Assembly from comparator fixture.

10. Seal all three screws with "Duco" Cement, including screw slots.

NOTE: For Australian Guns Only:

- Seal Trigger Engagement Screw Lock Screw and Trigger Stop Screw Only. Do not seal Trigger Screw Lock Screw Front.

EQUIPMENT—TOOLS & GAGES

NOTE:
Realign Lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light Beam from condensing lens to projection lens must be parallel. Adjust as required.
Refer to Page 7 of J&L Operating Manual.

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Adjust Trigger Sub-Assembly on Comparator 100%.	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 12

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535393

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

11/3/78 - NEW - WW - 277413

10/9/79 - Added to note - WAW - 278187

DESCRIPTIVE INFORMATION

Inspect Sear Lift 100%

Procedure:

1. Push Slave Pins in Trigger Assembly Part Way Out, Toward Right Side of Trigger Assembly.

2. Raise Locating Pins in Gage half way, by pulling lever toward body.

3. Place Trigger Assembly over locating pins and clamp down. Make sure Assembly is Flat to the Gage Locating Surfaces.

EQUIPMENT--TOOLS & GAGES

Dial Base Gage #D-42614

NOTE: Clamps on Base Gage must be adjusted as required to locate Trigger Assembly flat to Gage while testing. Clamp pad must miss rivets.

OPERATION DESCRIPTION								
Inspect for sufficient Sear Lift. 100%	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

OBSOLETE

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS. DEPT. No. W 61 PAGE 1 OF 6

MACHINE

Form R. D. 6465

R2535394

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW 277413
10/9/79 - Added to element #6 - WAW - 278187

DESCRIPTIVE INFORMATION

4. Hold Trigger Assembly in position with Finger, and raise Locating Pins to full upward position.

5. Move Safety Lever to "OFF SAFE" Position.

6. Draw Dial Indicator into position with adjustment knob, until Dial Indicator READS ZERO ("O"). On both scales.

7. Move Safety Lever to "ON SAFE" Detented Position. READ Dial Indicator.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION								
Inspect for Sufficient Sear Lift. 100%	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

OBSOLETE

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 6
MACHINE

Form R. D. 6469

R2535395

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW - 277413

DESCRIPTIVE INFORMATION

MUST BE .008 TO .018 SEAR LIFT

- Reject if less that .008.
- Reject if more than .018.

(If Reading is within limits, continue:)

8. Push Safety lever to "OFF SAFE" Detented Position.

9. Re-Zero Dial (if necessary) using Adjustment Knob.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect For Sufficient Sear Lift.	OCC. No.						
	STD. HRS/C						
	STD. No.						
100%	EFF. DATE				OBSOLETE		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS DEPT. No. 61 PAGE 3 OF 6

MACHINE

Form R. D. 6461

R2535396

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW-277413

DESCRIPTIVE INFORMATION

10. Move Safety Lever from "OFF SAFE" Position toward "ON SAFE" Position TO LOCATE AND STOP Safety Lever at the *Forward most Null location.

* FORWARD MOST NULL LOCATION - is that "Just Stable" place between "On" and "Off" Safe - closest to "Off Safe" - where the Safety Lever will not spring forward to the "Off Safe" Position when released.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for Sufficient Sear Lift.	EFF. DATE						
100%						OBSOLETE	
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS. MACHINE DEPT. No. 61 PAGE 4 OF 6

Form R. D. 6469

R2535397

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW -277413
10/9/79 - Added removal - WAW - 278187

DESCRIPTIVE INFORMATION

- If the Null Location is overshot (where the Safety Lever was moved too far toward "On Safe"); then return to "Off Safe" and again approach Null Location from the "Off Safe" side.

Remove Trigger Assembly from Dial Base Gage.

11. Separate Trigger Assemblies, into labeled containers, according to Dial Readings at that "Forward Most Null Location".

- Less that .007 - Repair

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
					OBSOLETE		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14
TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 6
MACHINE

Form R. D. 6468

R2535398

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW-277413

DESCRIPTIVE INFORMATION

- .007 to .008 - Retest (Operation #16.5)
- Over .008 - Good (Continue to Op. #16)
- Over .018 - Repair

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION								
Inspect for Sufficient Sear Lift. 100%	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
						OBSOLETE		
	PART No.							
	GA.							

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS. MACHINE DEPT. No. 61 PAGE 6 OF 6

Form R. D. 6461

R2535399

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW - 277413
10/9/79 - Added to note - WAW - 278187

DESCRIPTIVE INFORMATION

Inspect Sear Lift 100%

Procedure:

1. Push Slave Pins in Trigger Assembly Part Way Out, Toward Right Side of Trigger Assembly.

2. Raise Locating Pins in Gage half way, by pulling lever toward body.

3. Place Trigger Assembly over locating pins and clamp down. Make sure Assembly is Flat to the Gage Locating Surfaces.

EQUIPMENT—TOOLS & GAGES

Dial Base Gage #D-42614

NOTE: Clamps on Base Gage must be adjusted as required to locate Trigger Assembly flat to Gage while testing. Clamp pad must miss rivets.

Obsolete
8-3006
7/7/83
RSD

OPERATION DESCRIPTION							
Inspect for sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14
TYPE MACH. HRS. DEPT. No. 16/61 PAGE 1 OF 6
MACHINE

Form R. D. 6465

R2535400

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW 277413
10/9/79 - Added to element #6 - WAW - 278187

DESCRIPTIVE INFORMATION

4. Hold Trigger Assembly in position with Finger, and raise Locating Pins to full upward position.

5. Move Safety Lever to "OFF SAFE" Position.

6. Draw Dial Indicator into position with adjustment knob, until Dial Indicator READS ZERO ("O"). On both scales.

7. Move Safety Lever to "ON SAFE" Detented Position. READ Dial Indicator.

EQUIPMENT—TOOLS & GAGES

Absolute
283 #6
7/7/83
RLS

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 6
MACHINE

Form R. D. 6465

R2535401

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW - 277413

DESCRIPTIVE INFORMATION

MUST BE .008 TO .018 SEAR LIFT

- Reject if less that .008.
- Reject if more than .018.

(If Reading is within limits, continue:)

8. Push Safety lever to "OFF SAFE" Detented Position.

9. Re-Zero Dial (if necessary) using Adjustment Knob.

EQUIPMENT—TOOLS & GAGES

Obsolete
283006
7/7/83
RRS

OPERATION DESCRIPTION							
Inspect For Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 6

MACHINE

Form R. D. 6465

R2535402

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW-277413

DESCRIPTIVE INFORMATION

10. Move Safety Lever from "OFF SAFE" Position toward "ON SAFE" Position TO LOCATE AND STOP Safety Lever at the *Forward most Null location.

* FORWARD MOST NULL LOCATION - is that "Just Stable" place between "On" and "Off" Safe - closest to "Off Safe" - where the Safety Lever will not spring forward to the "Off Safe" Position when released.

EQUIPMENT—TOOLS & GAGES

Obsolete
283006
7/7/83
RLS

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for Sufficient Sear Lift.	EFF. DATE						
100%							
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 6

MACHINE

Form R. D. 6465

R2535403

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

11/3/78 - NEW - WW -277413
10/9/79 - Added removal - WAW - 278187

DESCRIPTIVE INFORMATION

- If the Null Location is overshot (where the Safety Lever was moved too far toward "On Safe"); then return to "Off Safe" and again approach Null Location from the "Off Safe" side.

Remove Trigger Assembly from Dial Base Gage.

11. Separate Trigger Assemblies, into labeled containers, according to Dial Readings at that "Forward Most Null Location".

- Less that .007 - Repair

EQUIPMENT—TOOLS & GAGES

Obsolete
283006
1/7/83
RLS

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for Sufficient Sear Lift.	EFF. DATE						
100%							
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14

TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 6

MACHINE

R2535404

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/78 - NEW - WW-277413

DESCRIPTIVE INFORMATION

- .007 to .008 - Retest (Operation #16.5)
- Over .008 - Good (Continue to Op. #16)
- Over .018 - Repair

EQUIPMENT—TOOLS & GAGES

Obsolete
28006
7/7/83
RLS

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for Sufficient Sear	EFF. DATE						
Lift. 100%							
	PART No.						
	GA.						

PART NAME Final Assembly
TYPE

COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 14
MACH. HRS. DEPT. No. 61 PAGE 6 OF 6
MACHINE

Form R. D. 6465

R2535405

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

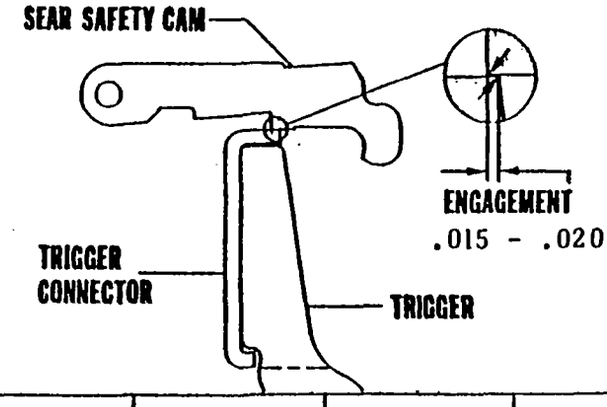
DATES AND REASONS FOR REVISIONS ~~8/24/79 - New - WAW - 277805~~
~~10/9/79 - Corrected fixture no. - WAW - 278186~~
DATE - MRP - RLT

DESCRIPTIVE INFORMATION

1. Pick Trigger Sub-Assembly. Position in comparator fixture and clamp:
   - Housing must properly contact all locators.
   - Top of Housing must be flat on fixture.
   - Push with thumb on rear of Trigger (toward left). This seats Trigger firmly against end of Trigger Adjusting Screw.
2. Adjust fixture to locate Sear on "Set" line of comparator screen.

EQUIPMENT—TOOLS & GAGES

Comparator Fixture E-42271
Comparator Screen A-600-CL25



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Trigger ~~Sub~~ Assembly on Comparator 100%.							
	PART No.	26345	32895				
	GA.	RH	LH				

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 155 ~~35~~
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6464

R2535406

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~8/24/79 - New - WAW - 277805~~ DATE - MRP - RLJ

DESCRIPTIVE INFORMATION

3. Adjust Sear/Connector engagement (.015-.020), to correct comparator screen line, by turning Trigger Engagement Screw slowly clockwise (to reduce engagement).

   NOTE: Australian guns only: Install lock screw and tighten firmly.

   After correctly adjusting Sear/Connector Engagement ;

4. Hang dead weight assembly to end of Trigger.

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).

   NOTE: Australian guns only: Install lock screw and tighten firmly.

EQUIPMENT - TOOLS & GAGES

Comparator fixture dead weight - 4 lbs. (M/700 only)

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Adjust Trigger ~~Sub~~ Assembly on Comparator 100%.	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 155

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535407

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~8/24/79 - New - WAW - 277805~~
DATE - MRP - RLT

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES
6. Re-adjust fixture to locate Sear on "Set Line" of comparator screen. 7. Remove dead weight assembly from Trigger. 8. Hold Trigger in fired position firmly with finger, and: • Set Over-Travel by turning Trigger Stop Screw slowly clockwise, until Trigger Connector touches correct line on comparator screen.	

OPERATION DESCRIPTION							
Adjust Trigger ~~Sub~~-Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 155 XC
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4
MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6468

R2535408

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~8/24/79 New WAW - 277805~~
DATE - MRP - RLJ

DESCRIPTIVE INFORMATION

9. Remove Trigger Sub-Assembly from comparator fixture.

10. Seal all three screws with "Duco" Cement, including screw slots.

NOTE: For Australian Guns Only:

- Seal Trigger Engagement Screw Lock Screw and Trigger Stop Screw Only, Do not seal Trigger Screw Lock Screw Front.

EQUIPMENT—TOOLS & GAGES

NOTE:
Realign Lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light Beam from condensing lens to projection lens must be parallel. Adjust as required.
Refer to Page 7 of J&L Operating Manual.

OPERATION DESCRIPTION							
Adjust Trigger ~~Sub~~ Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 155 78

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6461

R2535409

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION: C-1010

STD. PRACTICE No.:

TEMPERATURE: 1650°F — .70 % C. Potential

MAXIMUM LOAD: 2000 pcs.

TIME: 1 hour @ temp.

QUENCH: Oil

REMARKS:

INSPECT FOR: HEAT TREAT INSPECTION

STANDARD PRACTICE No.: HARDNESS LIMITS

APPEARANCE OF PARTS:

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 2/17/64 - New - NST - 9469 6/29/64 - Added 600 & 700 - NST - 260015 - 10/11/79 - Add max load - KRC - 278150					
	APPROVAL AND DATES					
Microcarb harden	GA. OR CAL. ~~M/600~~	M/600	~~M/700~~			
	PART No. ~~16719~~	15436	~~19461~~			
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE OF STD. OF STD.					

PART NAME: Trigger Connector — EQUIPMENT: — MODEL No. ~~M700~~ 600 — OPER. 5

DEPT. No. 51 — PAGE 1 — OF 1

R2535410

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION: C-1010

STD. PRACTICE No.:

TEMPERATURE: 1650°F

.70 % C. Potential

MAXIMUM LOAD: 2000 pcs.

TIME: 1 hour @ temp.

QUENCH: Oil

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE No.:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS: 2/17/64 - New - NST - 9469 6/29/64 - Added 600 & 700 - NST - 260015 - 10/11/79 - Add max load - KRC - 278150 APPROVAL AND DATES					
	GA. OR CAL.	~~H/50XB~~	~~H/600~~	~~H/700~~		
Microcarb harden	PART No.	~~16719~~	~~15436~~	~~19461~~		
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE OF STD. OF STD.					
	WIP#	13710				

PART NAME: Trigger Connector EQUIPMENT: MODEL No.: 700, 40XB OPER.: 5

DEPT. No.: 51 PAGE: 1 OF: 1

R2535411

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION C-1010

STD. PRACTICE No.

TEMPERATURE 350 - 375°F

MAXIMUM LOAD 2000 pcs.

TIME 30 min. @ temp.

QUENCH Air Cool

REMARKS

INSPECT FOR File Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION

Lindberg Draw

DATES AND REASONS FOR REVISIONS 2/17/64 - New - NST - 9469
6/29/64 - Added 600 & 700 - NST - 260015 10/11/79 - Add max load - KRC - 278150

APPROVAL AND DATES

GA. OR CAL.	~~[illegible]~~	M/600	~~M/700~~			
PART No.	~~16719~~	15436	~~19461~~			
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD.						
OF STD.						

PART NAME Trigger Connector EQUIPMENT MODEL No. 600 ~~[illegible]~~ OPER. 10

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R2535412

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION C-1010

STD. PRACTICE No.

TEMPERATURE 350 - 375°F

MAXIMUM LOAD 2000 pcs.

TIME 30 min. @ temp.

QUENCH Air Cool

REMARKS

INSPECT FOR File Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 2/17/64 - New - NST - 9469 6/29/64 - Added 600 & 700 - NST - 260015 10/11/79 - Add max load - KRC - 278150 APPROVAL AND DATES					
	GA. OR CAL.	~~M/400~~	~~M/600~~	~~M/700~~		
	PART No.	~~16719~~	~~25436~~	~~10461~~		
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
	OF STD. OR QTD.					
Lindberg Draw	WIP #	13710				

PART NAME Trigger Connector EQUIPMENT MODEL No. 700, 40XB OPER. 10

DEPT. No. 51 PAGE 1 OF 1

R2535413

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

4d 1

MATERIAL AND SPECIFICATION 1008 C-1010

STD. PRACTICE No.

TEMPERATURE 350°F

MAXIMUM LOAD 1500 /~~4000~~ pcs. - approx. 1/3 basket.

TIME 30 min. total

QUENCH Water

REMARKS

INSPECT FOR Color and oil

HEAT TREAT INSPECTION

STANDARD PRACTICE No. 165

HARDNESS LIMITS R 15N 88-92

APPEARANCE OF PARTS Straw color, clean, free of salt, well oiled for storage.

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS						
Lindberg ~~Bluing~~ Draw, water quench, wash, dry, and oil for storage.	2/17/64 - New - Thompson - 9469 6/29/64 - Added 600 & 700 - NST - 260015 10/11/79 Chg. load size - KRC - 278150						
	APPROVAL AND DATES						
GA. OR CAL.	~~500~~	H/600	~~H/700~~				
PART No.	~~16719~~	15436	~~19161~~				
OCC. No.							
STD. HRS/C							
STD. No.							
EFF. DATE OF STD.							

Electric Lindberg

PART NAME Trigger Connector EQUIPMENT ~~Gas Fired~~ MODEL No. 600 ~~H/600~~ OPER. 40

DEPT. No. 51 PAGE 1 OF 1

R2535414

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION 100% C-1010 STD. PRACTICE No.

TEMPERATURE 350° F

MAXIMUM LOAD 1500 /~~4000~~ pcs. - approx. 1/3 basket.

TIME 30 min. total

QUENCH Water

REMARKS

INSPECT FOR Color and oil HEAT TREAT INSPECTION

STANDARD PRACTICE No. 165 HARDNESS LIMITS R 15N 88-92

APPEARANCE OF PARTS Straw color, clean, free of salt, well oiled for storage.

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 2/17/64 - New - Thompson - 9469 6/29/64 - Added 600 & 700 - MET - 260015 10/11/79 Chg. load size - KRC - 278150 APPROVAL AND DATES					
Lindberg ~~Wash~~ Draw, water quench, wash, dry, and oil for storage.	GA. OR CAL. ~~50XB~~	~~#600~~	~~#700~~			
	PART No. ~~16739~~	~~15436~~	~~19461~~			
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
	OF STD. OF STD.					
	WIP # 13711					

Electric Lindberg

PART NAME Trigger Connector EQUIPMENT ~~Gas Fired Atmosphere~~ MODEL No. 700, 40XB OPER. 40

DEPT. No. 51 PAGE 1 OF 1

R2535415

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 10/24/79 Add 225 JCG

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.					
SPEED	FEED						

OPERATION DESCRIPTION	PART NO.	18750					
F.E. Center Test							

PART NAME SEAL COOLANT SET UP TIME MODEL No. 532-572 870-1100-760-742 OPER. No. 225

TYPE MACHINE DEPT No. 67 PAGE 1 OF 1

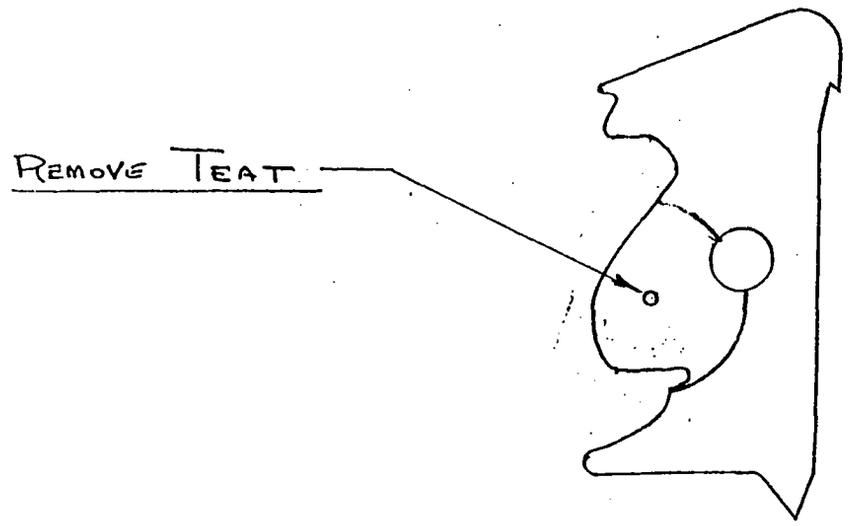
RD-6441

R2535416

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 10/29/79 - New - JAA - 278211

DESCRIPTIVE INFORMATION



Obsolete
278211
2/12/80

PART NAME SEAR COOLANT SET UP TIME MODEL No. 552-572-870-1100 760-742 OPER. No. 225

TYPE MACH. HRS. DEPT. No. 67 PAGE 1 OF 1

MACHINE

Form R. D. 6466

R2535417

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 10/29/79 - New - JAA - 278211

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES
SPEED	FEED		

Obsolete
278211
2/2/80

OPERATION DESCRIPTION — PART NO. 18750

File Center Teat

Exp. 1/24/80

552-572-870

PART NAME Sear — COOLANT — SET UP TIME — MODEL No. 1100-760-742 — OPER. No. 22-S

TYPE — MACHINE — DEPT. No. 67 — PAGE 1 OF 1

RD-6461

R2535418

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 10/31/78 - Revised - Changed OP # WW-277413 11.28.79 - CORRECTED SHIM NOTE, FIGURE #2, W ΔW

DESCRIPTIVE INFORMATION

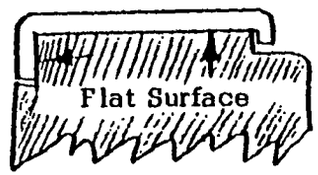


Fig. #1
Good

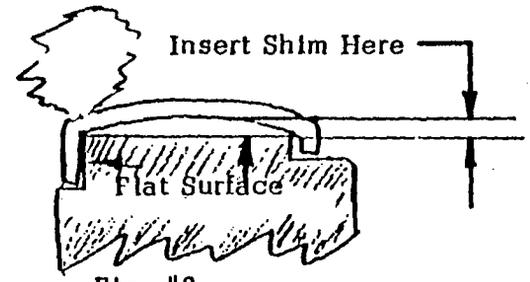


Fig. #2
Test Light Gap
With Shim

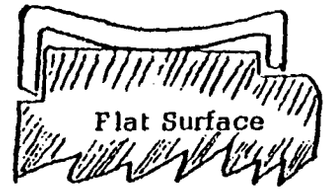


Fig. #3
Reject

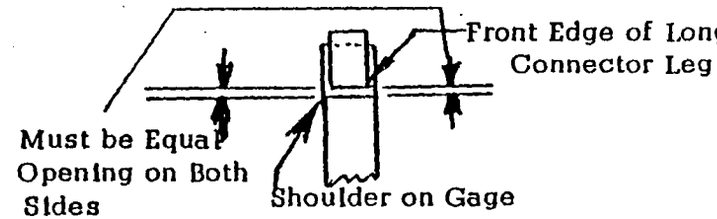


Figure #4

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 3-1
TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4
MACHINE

Form R. D. 6466

R2535419

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 8/24/79 - New - WAW - 277805 11-28-79 - CORRECTED SHIM NOTE, FIG #2, WAW

DESCRIPTIVE INFORMATION

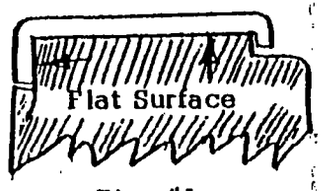


Fig. #1
Good

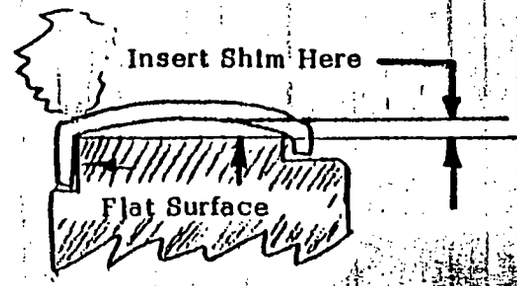


Fig. #2
Test Light Gap
With Shim

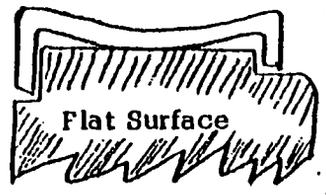


Fig. #3
Reject

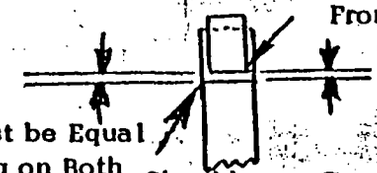


Fig. #4

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 4
TYPE MACH. HRS. / DEPT. No. 61 PAGE 4 OF 4
MACHINE

Form R. D. 6466

R2535420

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/4/78 - New - Gorski - 276863
11/6/78 - Chg. Exp. date - PRG - 276863
6/4/79 - Chg. Exp. date - DRL - 276863
12/3/79 - Chg. Exp. date - DRL - 276863

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Belt sand Finger Piece to meet	snap gage.	
Snap Gage	A-T-S - 6503	
Max 2.210		
Min. 2.190		SET UP ONLY

Operator
276863
5/30/80
DRL

OPERATION DESCRIPTION	PART NO.
Belt sand bottom of Trigger	15435

Exp. ~~11/24/78~~ ~~5/24/79~~ ~~11/24/79~~ 5/24/80

PART NAME Trigger (P.M.) COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 42-T
TYPE MACHINE Belt Sander DEPT. No. 02 PAGE 1 OF 1

R2535421

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

87

DATES AND REASONS FOR REVISIONS 3/13/73 - Added element 9;renumbered remaining elements - CP - 271731
3/15/79 - Add note to #1 - Hardy - 277612
2/8/80 - Remove note to #1 - MCH - 278204

DESCRIPTIVE INFORMATION

1. Pick Action from truck, position and clmap in vise.
2. Pick Trigger Assembly.
3. Insert Trigger Assembly into Receiver. (Must fit freely).
   a. File slot if necessary.
4. Pick Sear Pin and start. Drive in flush with inside of Bolt Stop cut.
5. Pick Bolt Stop Spring and position in Receiver.
6. Pick Bolt Stop and position in Receiver.
   a. Mist fit freely, file slot if necessary.
7. Pick Bolt Stop Pin, position and drive in.
8. Stake Bolt Stop Pin and Sear Pin.
9. Hold Trigger and press down on Sear, must NOT bind.

EQUIPMENT—TOOLS & GAGES

NOTE: Only correct components of good color not broken or deformed should be used.

Wiping Rod # 43447 Brass

Pin tight - Tester B-80652
Sear Retracts without hesitation.

OPERATION DESCRIPTION							
Assemble Action	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE

Form R. D. 6461

R2535422

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/13/73 - Revised operation - CP - 271731
9/20/74 - Added 14b - CP - 273376
9/29/77 - Added 16a - CP - 276299
2/5/78 - Chg. reamer dwg. - Hardy - 276628
11/29/79 - Add note to Item #12 - Hardy - 278285

DESCRIPTIVE INFORMATION

10. Pick Firing Pin Assembly, inspect, point not marred, Bolt Plug color O.K. No rust, or miscut.

11. Assemble to Bolt Group and remove "U" washer.

12. Check Firing Pin protrusion. NOTE: Check for right Serial No. on Bolt.

13. Insert Bolt into Action and lock down.

14. Try Safety
    a. Must be clearance between Sear and Trigger Connector with Safety on.
    b. With Bolt open pull Safety on. Close Bolt & lock down. Must lock down without catching on Safety. Bolt must not open until Safety is moved to off position.

15. (Vertical Sear engagement at least .015 visual).

16. Check for jar off by steady pressure on end of Firing Pin. Head, when rifle is cocked, with Safety in off position. (Use end of Hammer Handle.)
    a. Open and close Bolt forcibly three times. Trigger must not follow down.

EQUIPMENT—TOOLS & GAGES

NOTE: Lubricate Bolt Plug thread, rear of Bolt Lugs and Cocking Cam with gunslick.

Protrusion Gage B-10-52089

Taper reamer for front end of Firing Pin hole - A-88003

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE

Form R. D. 6465

R2535423

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

9

DATES AND REASONS FOR REVISIONS 3/27/75 - Retyped from 12/26/74 - Prosser - 273888 - Revised
8/12/75 - Removed 17a chg word. of 19 chg. adjust to weight & removed 20, renumber 21 && 22 - CP - 274202
10/8/76 - Added info to 18a - Joy - 275300

DESCRIPTIVE INFORMATION

~~Adjust Trigger Stop Screw to reduce overdraw.~~
~~Turn Stop Screw in until Action will not fire. With Safety off, hold Trigger back and turn Stop Screw out until Action fires, then slightly more than 1/8 and less than 1/4 turn more.~~
~~No detectable rearward Trigger play in excess of .010" after firing.~~

17a. Check notch escape by holding Trigger while closing Bolt slowly. Firing Pin must follow down.

18. Try Safety and Bolt Action. Adjust if necessary.
   a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety halfway off, pull Trigger, must not fire. Push Safety to OFF position, Firing must not follow down, Safety must return to OFF position under tension. Use downward pressure on Safety. Perform check three times.

19. Weight Trigger Pull (3 to 5 lbs.)
   a. Must be short & crisp, no creep or overdraw. Try 3 times.

~~20. Seal adjusting screws (two) with Dupont cement.~~

20. Pick correct Magazine Box, inspect for color, no rust.

21. Assemble Magazine Box to Action.

EQUIPMENT—TOOLS & GAGES

NOTE: - Cock Rifle - Hold down hard on Bolt Handle - Must fire when Trigger is pulled.

Trigger Pull scales B-70697

OPERATION DESCRIPTION							
Assemble Action (700 ADL)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4
MACHINE

W. D. 6465

R2535424

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

4

DATES AND REASONS FOR REVISIONS 6/16/76 - Added new - Joy - 275036
6/30/76 - Chg. .007 to .005 - Joy - 275083

DESCRIPTIVE INFORMATION

1. Pull safety to "on" position.
2. Close and lock Bolt down.
3. Try .~~007~~ .005 feeler between Sear and Connector.
   a. Must enter with no bind.
4. If clearance is less than .~~007~~ .005, Replace safety.

EQUIPMENT—TOOLS & GAGES

.~~007~~ .005 feeler gage or suitable shim.

OPERATION DESCRIPTION							
Assemble Action M/700 ADL	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175
TYPE ADL MACH. HRS. DEPT. No. 61 PAGE 4 OF 4
MACHINE

R2535425

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2535426

#8, #15
87

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/13/73 - Added element 9;renumbered remaining elements - CP - 271731
3/15/79 - Add note to #1 - Hardy - 277612
2/8/80 - Remove note to #1 - MCII - 278204

DESCRIPTIVE INFORMATION

1. Pick Action from truck, position and clmap in vise.
2. Pick Trigger Assembly.
3. Insert Trigger Assembly into Receiver. (Must fit freely).
   a. File slot if necessary.
4. Pick Sear Pin and start. Drive in flush with inside of Bolt Stop cut.
5. Pick Bolt Stop Spring and position in Receiver.
6. Pick Bolt Stop and position in Receiver.
   a. Mist fit freely, file slot if necessary.
7. Pick Bolt Stop Pin, position and drive in.
8. Stake Bolt Stop Pin and Sear Pin.
9. Hold Trigger and press down on Sear, must NOT bind.

EQUIPMENT—TOOLS & GAGES

NOTE: Only correct components of good color not broken or deformed should be used.

Wiping Rod # 43447 Brass

Operate fit must replacement of 1st pt.

Pin tight - Tester B-80652
Sear Retracts without hesitation.

OPERATION DESCRIPTION							
Assemble Action	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE

Form R. D. 6461

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

3.

DATES AND REASONS FOR REVISIONS 3/13/73 - Revised operation - CP - 271731
9/20/74 - Added 14b - CP - 273376
9/29/77 - Added 16a - CP - 276299
2/5/78 - Chg. reamer dwg. - Hardy - 276628
11/29/79 - Add note to Item #12 - Hardy - 278285

DESCRIPTIVE INFORMATION

10. Pick Firing Pin Assembly, inspect, point not marred, Bolt Plug color O.K. No rust, or miscut.

11. Assemble to Bolt Group and remove "U" washer.

12. Check Firing Pin protrusion. NOTE: Check for right Serial No. on Bolt.

13. Insert Bolt into Action and lock down.

14. Try Safety
    a. Must be clearance between Sear and Trigger Connector with Safety on.
    b. With Bolt open pull Safety on. Close Bolt & lock down. Must lock down without catching on Safety. Bolt must not open until Safety is moved to off position.

15. (Vertical Sear engagement at least .015 visual).

16. Check for jar off by steady pressure on end of Firing Pin. Head, when rifle is cocked, with Safety in off position. (Use end of Hammer Handle.)
    a. Open and close Bolt forcibly three times. Trigger must not follow down.

EQUIPMENT—TOOLS & GAGES

NOTE: Lubricate Bolt Plug thread, rear of Bolt Lugs and Cocking Cam with gunslick.

Protrusion Gage B-10-52089

Taper reamer for front end of Firing Pin hole - A-88003

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE

Form R. D. 6461

R2535427

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/27/75 - Retyped from 12/26/74 - Prosser - 273888 - Revised
8/12/75 - Removed 17a chg word. of 19 chg. adjust to weight & removed 20, renumber 21 && 22 - CP - 274202
10/8/76 - Added info to 18a - Joy - 275300

DESCRIPTIVE INFORMATION

~~Adjust Trigger Stop Screw to reduce overdraw~~
~~Turn Stop Screw in until Action will not fire. With Safety off, hold Trigger back and turn Stop Screw out until Action fires, then slightly more than 1/8 and less than 1/4 turn more.~~
~~No perceivable rearward Trigger play in excess of a kink after firing.~~

17b. Check notch escape by holding Trigger while closing Bolt slowly. Firing Pin must follow down.

18. Try Safety and Bolt Action. Adjust if necessary.
   a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety halfway off, pull Trigger, must not fire. Push Safety to OFF position, Firing must not follow down, Safety must return to OFF position under tension. Use downward pressure on Safety. Perform check three times.

19. Weight Trigger Pull (3 to 5 lbs.)
   a. Must be short & crisp, no creep or overdraw. Try 3 times.

~~20. Set adjusting screws (two) with "Proof" cartridge~~

20. Pick correct Magazine Box, inspect for color, no rust.

21. Assemble Magazine Box to Action.

EQUIPMENT—TOOLS & GAGES

NOTE: - Cock Rifle - Hold down hard on Bolt Handle - Must fire when Trigger is pulled.

Trigger Pull scales B-70697

OPERATION DESCRIPTION							
Assemble Action (700 ADL)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4
MACHINE

A. D. 6465

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 6/16/76 - Added new - Joy - 275036
6/30/76 - Chg. .007 to .005 - Joy - 275083

DESCRIPTIVE INFORMATION

1. Pull safety to "on" position.
2. Close and lock Bolt down.
3. Try .~~007~~ .005 feeler between Sear and Connector.
   a. Must enter with no bind.
4. If clearance is less than .~~007~~ .005, Replace safety.

EQUIPMENT—TOOLS & GAGES

.~~007~~ .005 feeler gage or suitable shim.

OPERATION DESCRIPTION							
Assemble Action M/700 ADL	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 175
TYPE ADL MACH. HRS. DEPT. No. 61 PAGE 4 OF 4
MACHINE

R2535429

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

U 25

DATES AND REASONS FOR REVISIONS 1/11/71 - Retyped from 12/23/70 - 269244
3/1/71 - Revised - Prosser - 269505
2/8/80 - Remove note from #1 - MCH - 278204
7/18/74 - Chg. dept. 64 to 41 - CP - 273249
4/4/78 - Chg. dept. to 61 - Hardy - 276772
3/15/79 - Add note to #1 - Hardy - 277612

DESCRIPTIVE INFORMATION

1. Pick Action from truck, position and clamp in vise.

2. Assemble Trigger Assembly
   Insert Trigger Assem. in Receiver.
   Must fit freely.
   File slot if necessary.

3. Pick Front and Rear Sear Pin and start - Drive in Front Sear Pin flush with inside of Bolt Stop cut.

4. Pick Bolt Stop Spring - Position in Receiver.

5. Pick Bolt Stop - position in Receiver must fit freely - file slot if necessary.

6. Pick Bolt stop Pin, position and drive in.

7. Stake Sear Pin and Bolt Stop Pin.

EQUIPMENT—TOOLS & GAGES

Only correct components of Good color, Not broke or deformed should be used.

Wiping Rod #43447 Brass

NOTE: Lubricate plug thread, rear of Bolt lugs, and Cocking Cam with Gunslick.

No Sear, safety Cam bind in Housing.
Pin Tight - Tester - B-80652

OPERATION DESCRIPTION	OCC. No.						
~~Final Assembly~~	STD. HRS/C						
Assemble Action .	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600, OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61/41 PAGE 1 OF 4
MACHINE Bench

Form R. I. 6461

R2535430

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 2/8/78 - Retyped & Filed W/ process no. 276636 - EB (U) 19

2/8/78 - Revised element 13 - Hardy - 276636

4/4/78 - Chg. dept. to 61 - Hardy - 276772

11/29/79 - Add note to no. 11 - Hardy - 278285

DESCRIPTIVE INFORMATION

8. Hold Trigger and press down on Sear, must not bind. - Sear retracts without hesitation.

9. Pick Firing Pin Assembly, inspect, point not mared, Bolt Plug color - Good - No rust or miscut.

10. Assemble to Bolt group and remove (U) Washer.

11. Check Firing Pin Protrusion. NOTE: Check for right Serial No. on Bolt. Protrusion Ga. B-10-52089

12. Insert Bolt into Action and lock down.

13. Try Safety.
   (a) Must be clearance between Sear and Trigger Connector with Safety on.
   (b) With Bolt open pull Safety on, close Bolt and lock down. Must lock down without catching on Safety. Bolt must not open until Safety is moved to off position.

14. (a) Vertical Sear engagement at least .015 (Visual)
   (b) Check for jar off by steady pressure on end of Firing Pin Head, when rifle is cocked, with Safety in off position (Use end of Hammer Handle)
   (c) Cock Rifle - Hold Bolt Handle down hard - Must fire when Trigger is pulled.
   (d) Open and close Bolt forcibly three times. Trigger must not follow down.
   (e) Check notch escape by holding Trigger while closing Bolt slowly - Firing Pin must follow down.

15. Try Safety and Bolt Action - Observe for slight rearward movement of Firing Pin Head when Safety is pushed on. Adjust if necessary.

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 175

TYPE MACH. HRS. DEPT. No. 141 61 PAGE 2 OF 4

MACHINE

Form R. D. 6466

R2535431

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/26/75 - Retyped from 3/26/75 - Added 16a. - Prosser - 273889
5/9/77 - Add info to element 15 - Joy - 275936
12/30/77 - Remove element 17,18 & renumber 16,17,18 - CP - 276522
4/4/78 - Chg. dept. to 61 - Hardy - 276772

DESCRIPTIVE INFORMATION

15. (cont.) a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety half way off, pull Trigger, must not fire. Push Safety to "OFF" position, Firing Pin must not follow down, Safety must return to off position under tension. (PERFORM CHECK THREE TIMES)

~~A/C/ Adjust Trigger Pull to 5 lbs. and Check Trigger Adjusting Screws. Trigger Pull Scales H B-10697/~~

~~AR/ See AN Adjusting Screws Data Sheet for Pull Scales/~~

16. Pick correct Magazine Assembly - Inspect for color, no rust.

17.. Assemble Magazine Assembly to Receiver with Screw.

18. Assemble Magazine Spring to Magazine Follower and position in. Magazine Assembly/

~~Trigger Pull Scales H B-10697/~~

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61 MM PAGE 3 OF 4
MACHINE

Form R. D. 6466

R2535432

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/17/76 - Added new - Joy - 275040
4/4/78 - Chg. dept. to 61 - Hardy - 276772

DESCRIPTIVE INFORMATION

Inspect for Safety lift

1. Pull Safety back to "on" position.
2. Close and lock Bolt down.
3. Hold Bolt stop and try, .007 feeler between Sear and Connector.
   a) Must enter with no bind.
4. If clearance is less than .007, replace Safety.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Assemble Action	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 175
TYPE MACH. HRS. DEPT. No. 61/ 61 PAGE 4 OF 4
MACHINE

R2535433

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

6

STD. PRACTICE No.

MATERIAL AND SPECIFICATION

TEMPERATURE 1650° 3 1/2 Hrs. .90C potential

MAXIMUM LOAD 2000 pcs

TIME 4 hrs total furnace time

QUENCH oil

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS clean, free of oil and soot

5/12/80 - add max load and total furnace time - KRC

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 3-30-66 - New Process - K & Chadwick 6/20/67 - Add Part #14269 - MM - 264959 12/28/77 - Add Moh. 600 #91470 - SB 276514 2/14/79 - Add Part #91470 - APPROVAL AND DATES PRG - 277609					
	GA. OR CAL.					
	PART No.					
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
	OF STD. OF STD.					
Micro-Carb Harden		91470				
		15666				
		14269			XP-100 - Moh. 600	

PART NAME Sear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. 700-600-40XB OPER. 45

DEPT. No. 51 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEA REAT SPECIFICATION

7

STD. PRACTICE No.

MATERIAL AND SPECIFICATION

TEMPERATURE 350° F. 480°F

MAXIMUM LOAD 2000 pcs

TIME 1 HOUR

QUENCH

REMARKS

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard R_c 50 Min.

APPEARANCE OF PARTS

5/14/80 - Add max load - KRC

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 3-30-66 - New Process - K & Chadwick 6/20/67 - Add Part 14269 - MM - 264959 12/28/77 - Add Moh. 600 #91470 SB 276514 2/14/79 - Add part #91470 - APPROVAL AND DATES PRG - 277609 3/12/80 REVISE OP #50 KRC
Lindberg Draw & Inspect for Rockwell Hardness	GA. OR CAL. / PART No. / OCC. No. / STD. HRS/C / STD. No. / EFF. DATE / OF STD. OF STD. 91470 15666 14269 XP-100 - Moh. 600

PART NAME Sear-Safety Cam Powder Metal EQUIPMENT MODEL No. 700-600-40XB OPER. 50-55

DEPT. No. 51 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

5/30/80 New Job

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.	
SPEED	FEED			
				MEDIA: SAND
				QUANTITY: 600 PCS
				TIME: 2 HRS

OPERATION DESCRIPTION	PART NO.
SAND TUMBLE	26585 32900

PART NAME _____ COOLANT _____ SET UP TIME _____ MODEL No. 700-40xB-700LH OPER. No. 30

TYPE _____ MACHINE OPEN BAIRD BBL. _____ DEPT. No. _____ PAGE _____ OF _____

RD-6461

R2535436

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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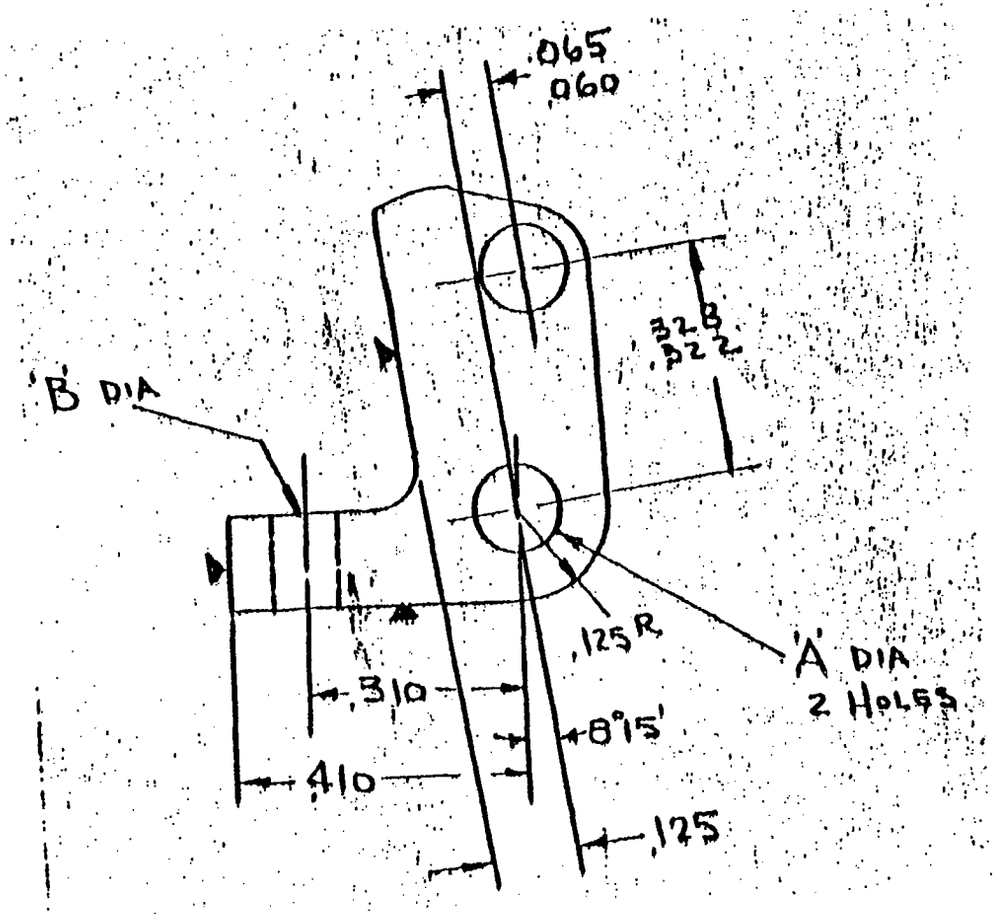
DATES AND REASONS FOR REVISIONS 6/4/80 New J.O.C.

LEW

DESCRIPTIVE INFORMATION



PART NAME Seal Block COOLANT SET UP TIME MODEL No. XP-100 OPER. No 5

TYPE MACH. HRS. DEPT. No. 75 PAGE 1 OF 1

MACHINE 6 Spindle Drill Press

R2535437

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KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

[redacted]

6/4/80 New JCG

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Spot drill (3.12MM-.126 dia.)	Std.	
~~[illegible]~~	~~Std.~~	
Reamer 1261263	RS-4 Std.	
#3. MM (.122 dia.) drill	Std.	
#42 (0935 dia.) spot drill	Std.	
#44 (086 dia.) drill	Std.	
Reamer (0938 dia.)	RS-2 Std.	
Drill Jig	D-85090	
Plug Gage "A" = .126 - .127 .254	~~T~~ D-80219-A	
Plug Gage "B" = .0942 = .0932	D-80252H	

OPERATION DESCRIPTION	PART NO.
Spot, drill and ream Gear Block Pin hole and Trigger Link Roller hole Spot, drill and ream Gear Block Stud hole.	~~2684~~ 15461

PART NAME Gear Block ~~Assembly~~ COOLANT SET UP TIME MODEL No XP-100 OPER. No 5

TYPE MACHINE 6 spindle drill press DEPT. No 75[illegible]671 PAGE 1 OF 1

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R2535438

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KINZER V. REMINGTON

1.09

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS [redacted] 6/4/80 New G.A.

[redacted]

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.						
SPEED / FEED							
File	Std.						

LEWY

OPERATION DESCRIPTION	PART NO. 1546 ~~26015~~
File to deburr	

PART NAME Gear Block ~~Assembly~~ COOLANT SET UP TIME MODEL No. XP 100 OPER. No. 8

TYPE MACHINE DEPT. No. ~~[redacted]~~ 75 PAGE 1 OF 1

RD-6461

R2535439

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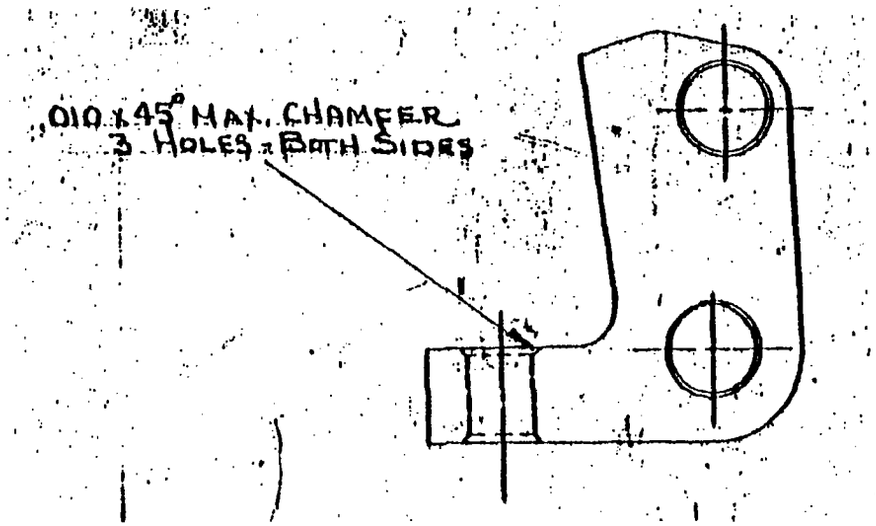
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/4/80 New J.O.

LEWY

DESCRIPTIVE INFORMATION



PART NAME SEAR BLOCK COOLANT SET UP TIME MODEL No. XP-100 OPER. No 10

TYPE MACH. HRS. DEPT. No. 75 PAGE 1 OF 1

MACHINE DRILL PRESS

R2535440

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORDS

DATES AND REASONS FOR REVISIONS [redacted]
6/14/80 New JOO

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.						
SPEED / FEED							
	C'bink 3/16 dia.	Std.					
	Holding Block						
	NOTE: .010 x 45° max, chamfer 3 holes						

OPERATION DESCRIPTION — PART NO. 1546 / ~~26845~~

C'sink ~~countersink~~ 3 holes - both sides.

PART NAME Gear Block ~~Assembly~~ — COOLANT — SET UP TIME — MODEL NO. XP-100 — OPER. NO. 10

TYPE — MACHINE Drill Press — DEPT. NO. 61.75 — PAGE 1 OF 1

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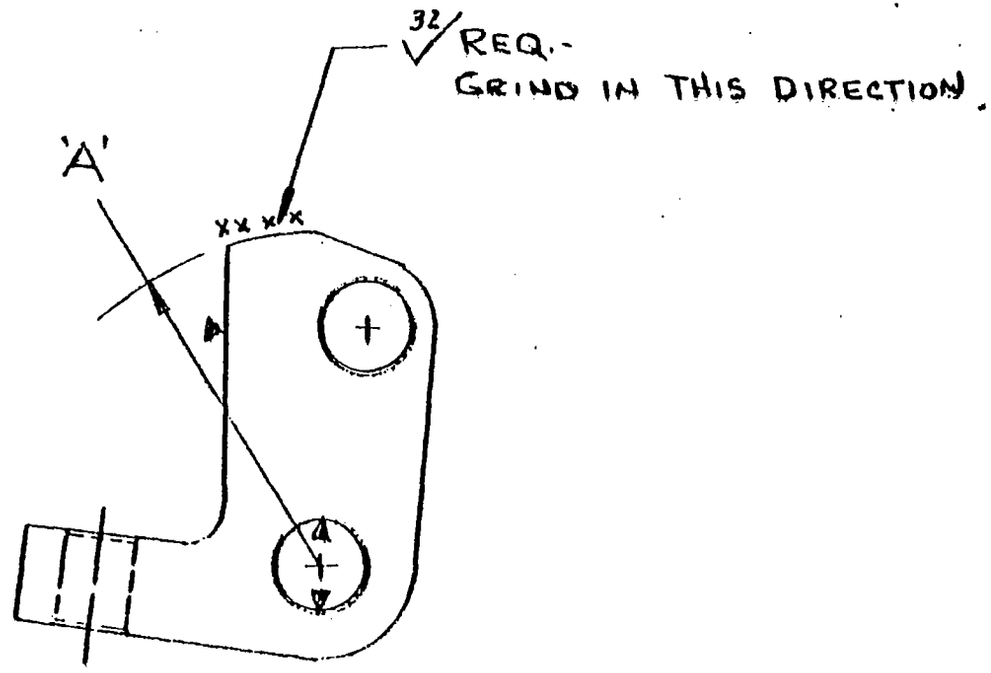
R2535441

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/4/80 New J.A.G.

DESCRIPTIVE INFORMATION



PART NAME Sear Block COOLANT SET UP TIME MODEL No. XP-100 OPER. No 15

TYPE MACH. HRS. DEPT. No. 67 PAGE 1 OF 1

MACHINE #2 B&S Surface Grinder

R2535442

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

[redacted] 6/4/80 New J.A.A.

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Grinding Wheel		
Grinding Fixture	D-85093	
Dial Base Ga. "A" - .454 - .452	D-85092	

OPERATION DESCRIPTION	PART NO.
Grind radius	~~26015~~ 15461

PART NAME Gear Block ~~Assembly~~ COOLANT SET UP TIME MODEL No. XP100 OPER. No. 15

TYPE MACHINE #2 B&S Surface Grinder DEPT. No. 67 ~~67-75~~ PAGE 1 OF 1

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R2535443

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS
6/4/80 New J.A.Q.

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED
LEWIS			

OPERATION DESCRIPTION	PART NO.
Wash and dry	~~26845~~ 15461

PART NAME Sear Block ~~Assembly~~ COOLANT SET UP TIME MODEL NO XP100 OPER NO 20

TYPE MACHINE DEPT NO 51 PAGE 1 OF 1

R2535444

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION: C-1018

STD. PRACTICE No.:

TEMPERATURE: 1600 °F

MAXIMUM LOAD:

TIME: 30 min.

QUENCH: Oil

REMARKS:

INSPECT FOR: File Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.:

HARDNESS LIMITS: File Hard

APPEARANCE OF PARTS: Clean, dry, free of salt

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS	APPROVAL AND DATES					
Cyanide Harden, oil quench, wash and dry.	6/4/8 New P. G. J.						
	GA. OR CAL.						
	PART No.	~~26815~~ 26815					
	OCC. No.	15461					
	STD. HRS/C						
	STD. No.						
	EFF. DATE OF STD.						

PART NAME: Sear Block ~~Assembly~~ EQUIPMENT: Cyanide Bath Furnace MODEL No. XP100 OPER. 25

DEPT. No 51 PAGE 1 OF 1

R2535445

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION: C-1018

STD. PRACTICE No.:

TEMPERATURE: 350 - 375°F

DENY

MAXIMUM LEAD:

TIME: 30 min. at temp.

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.:

HARDNESS LIMITS: Rockwell hardness 15N 88/92

APPEARANCE OF PARTS: Clean, free of salt, oiled.

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS [redacted]
Lindberg Draw and inspect hardness	6/4/80 New P. & G. J.

APPROVAL AND DATES

GA. OR CAL.						
PART No.	~~26815~~ 1546					
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD. or STD.						

PART NAME: Sear Block ~~Assembly~~ EQUIPMENT: Lindberg Furnace MODEL No. XP100 OPER. 30 - 35

DEPT. No. 51 PAGE 1 OF 1

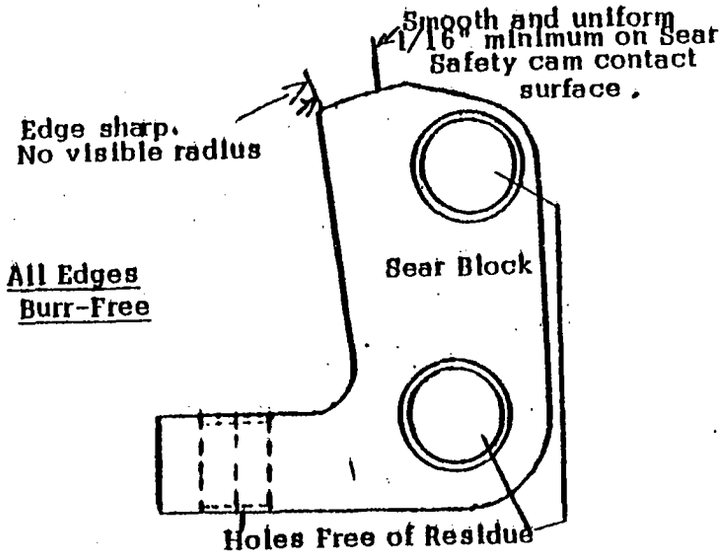
R2535446

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

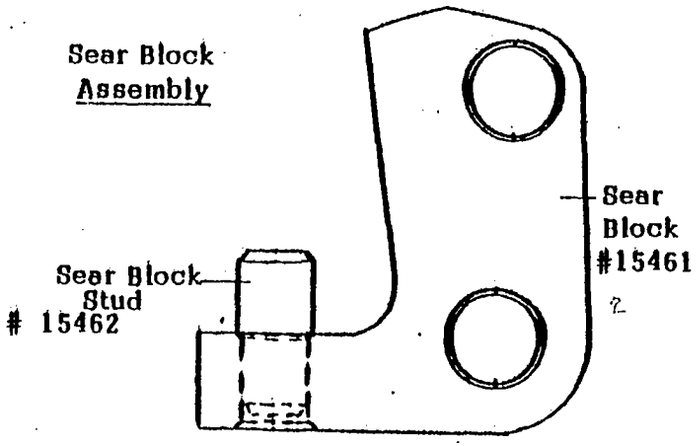
DATES AND REASONS FOR REVISIONS

6/5/80 MW J GC.

DESCRIPTIVE INFORMATION



H 2 Greenerd Press
C-86199 Fixture
C-86199-A Ram



PART NAME Sear Block Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 1

MACHINE

Form R. D. 6466

R2535447

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/5/80 New J.A.A.

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.
SPEED	FEED		
		Sear Block P.#15461	
		Sear Block Stud P.#15462	

APPROVAL AND DATES

1. Visually Inspect Sear Block
   - All holes must be free of residue. Clean with paper clip wire if necessary.
   - Sear safety cam contact surface must be:
     - Smooth
     - Burr-free
     - Rear edge must be sharp

   Check for burrs and smoothness with fingertip.

2. Start Sear block stud into Sear Block hole and position into fixture.

3. Pull handle on press to firmly seat Sear Block stud shoulder on Sear Block.
   - Sear Block Stud must be tight to Sear Block.

OPERATION DESCRIPTION	PART NO.	26845
Assemble Sear Block Assembly		

PART NAME Sear Block Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACHINE DEPT No. 15 PAGE 1 OF 1

RD. 8481

R2535448

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

29

DATES AND REASONS FOR REVISIONS

10/8/56 - Retyped - New forms - from 1/25/55
3/10/60 -Chg. dept. # - Byrnes - 254683
5/21/65 - Added 40XB - JWB - 260827
7/11/61 - Add 700 A & ADL - Carter - 256356
7/19/68 - Added pt. no. 14633 & chg. usage on 15481 - LBB - 2
2/5/62 - Added new part # - Thompson 257051
11/7/74 - Added 91128and usage - LBB - 273522
3/19/62 - Remove ADL & BDL - Hill - 257144 -

APPROVAL AND DATES 6/6/85 MEP Chg JGA

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.					
SPEED	FEED		~~721-722 40X 700 ADL BDL~~		~~40XB, 40XCT~~	~~700-AII~~	
			~~700 (2 Req) 700 BDL~~			~~40XB~~	
			~~(2 screws)~~	~~(1 screw)~~		~~40XC~~	
			~~XP-100~~			~~40XR~~	
						~~40XB-BR~~	

OPERATION DESCRIPTION	PART No.					
		17053	~~15481~~	~~14633~~	~~91128~~	
		15481	~~40XBIFR~~			
		14633				
		91128				
Wash and dry.						
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					

PART NAME Trigger Stop Screw & Trigger Engagement Screw SET UP
COOLANT TIME MODEL No. ~~721 - 722~~ XP-100 700 [redacted] 40XB OPER. No. 1
TYPE MACH. HRS DEPT. No. 51 [redacted] PAGE 1 OF

R2535449

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

30

DATES AND REASONS FOR REVISIONS

10/8/56 - Retyped - New forms - from 1/25/55 -
3/10/60 - Chg. dept. # - Byrnes - 254683
7/11/61 - Add 700 A & ADL - Carter - 256356 -
2/5/62 - Added new part # - Thompson - 257051
3/19/62 - Remove ADL & BDL - Hill - 257144
5/21/65 - Added 40XB - JWB - 260827
7/19/68 - Added pt. no. 14633 & chg. usage of 15481 - LBB - 26
11/7/74 - Added 91128 and usage - LBB - 273522 58

APPROVAL AND DATES 6/6/85 MKP Chg J. ac

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	~~721-722~~ 40XB ~~XP-100~~ ~~700 (2 screws)~~	~~700 ADL~~ ~~700 BDL~~ ~~40XB~~ ~~(1 screw)~~	~~40XB-40XBR~~	~~700 ADL~~ ~~40XB~~ ~~40XC~~ ~~40XBR~~ ~~40XB-BR~~	
SPEED FEED						

OPERATION DESCRIPTION	PART No.	17053 15481 14633 91128	~~15481 40XB-BR~~	~~91633~~	~~91128~~
Inspect to gage; inspect for dryness.	OCC. No.				
	STD. HRS/C				
	STD. No.				
	EFF. DATE				

PART NAME Trigger Stop Screw & Trigger Engagement Screw SET UP XP-100 ~~700~~ ~~721 - 722~~ -40XB OPER. No. 1-1
COOLANT TIME MODEL No.
TYPE MACH. HRS DEPT. No. 51 PAGE 1 OF 1

RD-8401

R2535450

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION	B-1113
STD. PRACTICE No.	#198
TEMPERATURE	1575 - 1600°F
MAXIMUM LOAD	1" in bottom of basket
TIME	10 min. @ temperature
QUENCH	Oil
REMARKS	

LEWY

INSPECT FOR	File hardness
HEAT TREAT INSPECTION	
STANDARD PRACTICE No.	163
HARDNESS LIMITS	
APPEARANCE OF PARTS	Steel gray color, clean, dry, free of salt.

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
High temperature, cyanide harden, oil quench, wash and dry.	6/6/75 MRP Chg P.G.J. 10-18-71 - Retyped from 7-19-68 - 270041 11/7/74 - Added 91128 & usage

APPROVAL AND DATES LBB - 273522-0

GA. OR CAL.	~~721-722~~	~~700~~	~~40XB-40XCF~~			
PART No.	17053	15481	14633	91128		
OCC. No.	~~XP-100~~					
STD. HRS/C						
STD. No.						
EFF. DATE				~~700 A11~~		
OF STD.				~~40XB~~		
OF STD.	~~(2 screws)~~	~~(1 screw)~~		~~40XC~~		
	~~M/700-40XB~~	~~700-40XBIFR~~		~~40XR~~		
				~~40XB-BR~~		

PART NAME Trigger Stop Screw & Trigger Engagement Screw EQUIPMENT Rem. Gas. Fired Cyanide Pot MODEL No 700-~~721-722~~ XP-100 OPER 2 - 3

Furnace DEPT. No. 51 PAGE 1 OF 1

ND-6464

R2535451

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – HEAT TREAT SPECIFICATION

22

MATERIAL AND SPECIFICATION	B-1113
TEMPERATURE	925 - 950°F
MAXIMUM LOAD	1/2" in bottom of basket
TIME	10 min. total time
QUENCH	Water
REMARKS	

STD. PRACTICE No.

TEMPERATURE TEMP

INSPECT FOR	Color and oil
STANDARD PRACTICE No.	165
APPEARANCE OF PARTS	Shiny black, color, clean, free of salt, well oiled for storage To Assembly - Dept. 62

HEAT TREAT INSPECTION

HARDNESS LIMITS

OPERATION DESCRIPTION

Nitro Black, water quench, wash and oil.

DATES AND REASONS FOR REVISIONS 11/7/74 - Added 91128 & usage - LBB - 273522
10-18-71 - Retyped from 7-19-68 - 270041 6/6/85 MPP chg P.C.J.

APPROVAL AND DATES

GA. OR CAL.	~~721-722~~	~~700~~	~~40XB-40XCF~~	~~91128~~		
PART No.	17053	15481	14633			
OCC. No.	~~XP-100~~					
STD. HRS/C		~~(1 Screw)~~		~~700 A11~~		
STD. No.				~~40XB~~		
EFF. DATE OF STD.				~~40XB~~		
				~~40XB~~		
	~~(2 screws)~~			~~40XB-BR~~		
	~~M/700~~	~~40XB1FR~~				
	~~40XB~~			~~722~~		

PART NAME Trigger Stop Screw & Trigger Engagement Screw EQUIPMENT Rem. Gas-Fired Nitre Black Furnace MODEL No. 700-~~721~~-40XB XP-100 OPER. 4 - 5

DEPT. No. 51 PAGE 1 OF 1

RD-6464

R253452

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

9/7/82 New J.O.G.

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	
		COATING		VIBRA-TITE LIQUID

1. Apply sealing compound to threads of Sear Block stop screw.
   - Threads must be evenly coated.
2. Let screws sit for *Approx. 45 min. This allows compound to partially dry before use.
3. **Assemble Sear Block Stop Screw into Sear Housing.**
   - **Turn screw too far in - then back off. (This seats the Vibra-Tite compound and removes excess). Remove freed compound from Housing with compressed air.**

* This time varies with area conditions.

OPERATION DESCRIPTION	PART NO.
COAT THREADS OF SEAR BLOCK STOP SCREW AND INSTALL	

PART NAME SEAR HOUSING SUB-ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 25

TYPE MACHINE DEPT No. 15 PAGE 1 OF 1

RD-6461

R2535453

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
R2535454

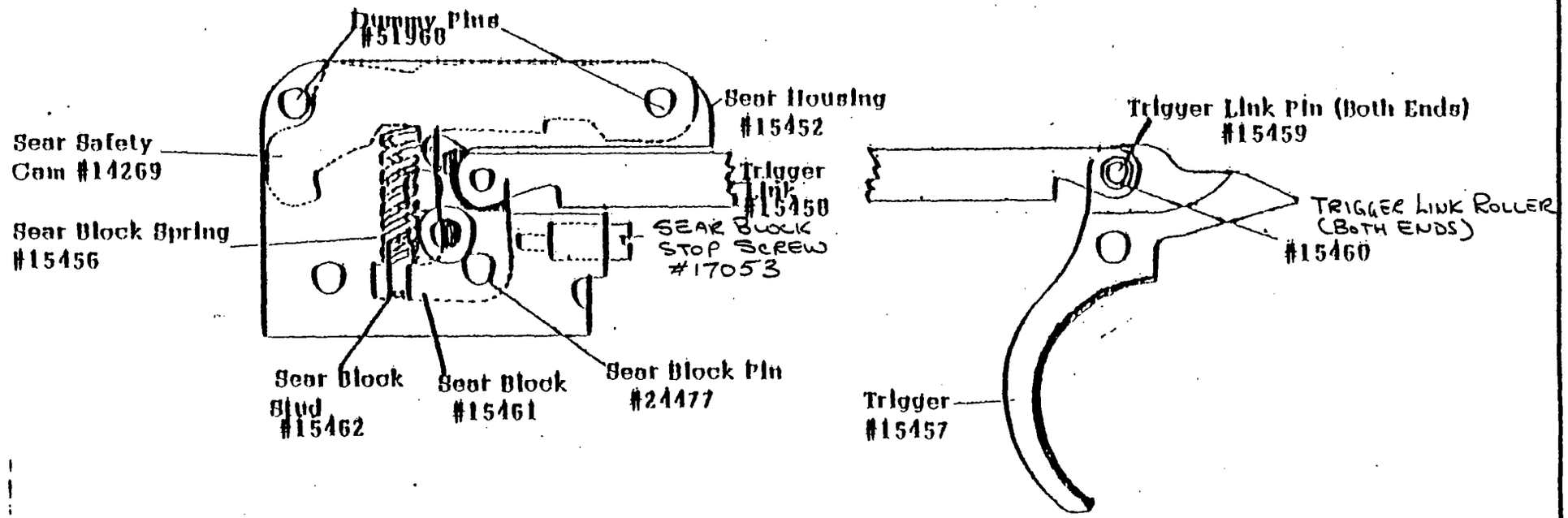
DATES AND REASONS FOR REVISIONS

6/9/80 New J.G.

LEVY

DESCRIPTIVE INFORMATION

SEAR HOUSING ASSEMBLY



PART NAME SEAR HOUSING ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 12

MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/9/80 Rev. AG

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Fixture	D-85455
		Crocus Cloth	STD.

1. Pick Sear Block Assembly.
2. Polish Sear Safety Cam contact surface.
   - Use new crocus cloth
   - Keep rear edge sharp.
3. Pick Roller.
   - Roller must be burr-free.
4. Insert Roller into Sear Block Assembly link pin hole.

OPERATION DESCRIPTION	PART NO.
Assemble Sear Housing Assembly	26790

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACHINE _____ DEPT No. 15 PAGE 2 OF 12

RD-6461

R2535455

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS

6/9/82 LENGTH.

DESCRIPTIVE INFORMATION

Trigger Link
#15450

Housing End Trigger End

PART NAME SEAR HOUSING ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No 055

TYPE MACH. HRS. DEPT. No. 15 PAGE 3 OF 12

MACHINE

R2535456

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS

6/9/88 REVISED LEW

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.
SPEED	FEED		

5. Pick Trigger Link.
   - Black Color
   - Ears must be straight (Both Ends) - Not Bowed In.
   - Holes must be counter-sunk (Both Ends).

6. Assemble Trigger Link (Housing End) over Sear Block.

7. Insert Trigger link pin (with head to the left) and swage end.
   - Swage must be on right side.
   - Swage must be flush or below surface.
   - Sear Block must freely rotate about pivot pin.

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 4 OF 12

MACHINE

RD-6463

R2535457

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS

6/9/80 New [illegible]

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.
SPEED	FEED	

APPROVAL AND DATES

8. Pick Trigger
   - Good black color.
   - Striations on Bow uniform.
   - Improved design at top front - machined slot omitted.

9. Insert one roller into link pivot hole
   - Roller must be burr-free

10. Assemble Trigger Link over Trigger.
    - Ears of Trigger link must be straight - not bowed in.

11. Insert Trigger Link Pin and Swage End.
    - Swage must be flush or below surface.
    - Trigger must fully rotate freely around pin and roller.

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 5 OF 12

MACHINE _____

RD-6463

R2535458

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

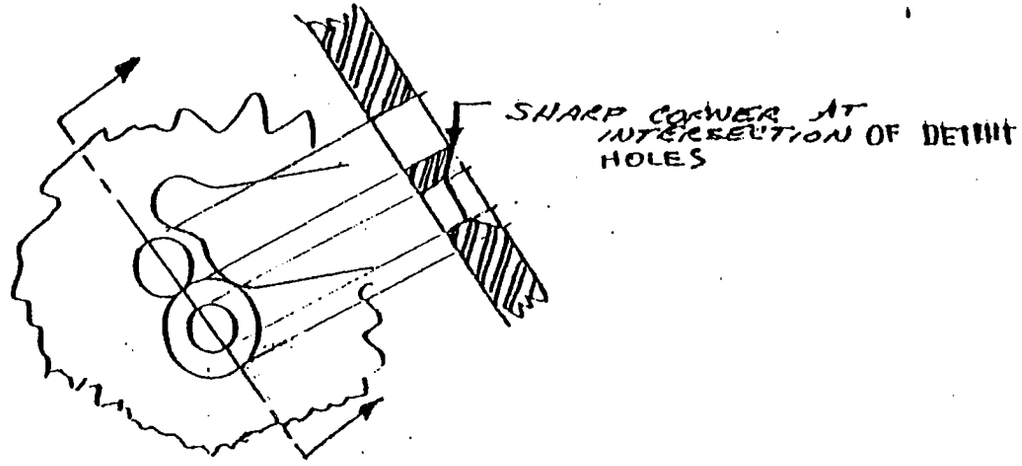
DATES AND REASONS FOR REVISIONS

6/9/85 REVISED

LEVY

DESCRIPTIVE INFORMATION

12. Pick Sear Housing
    - Black Color
    - Sharp Corner at Intersection of the two safety detent holes - No Flat
    - Uniform opening at top for Sear Safety Cam



PART NAME SEAR HOUSING ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 6 OF 12

MACHINE

R2535459

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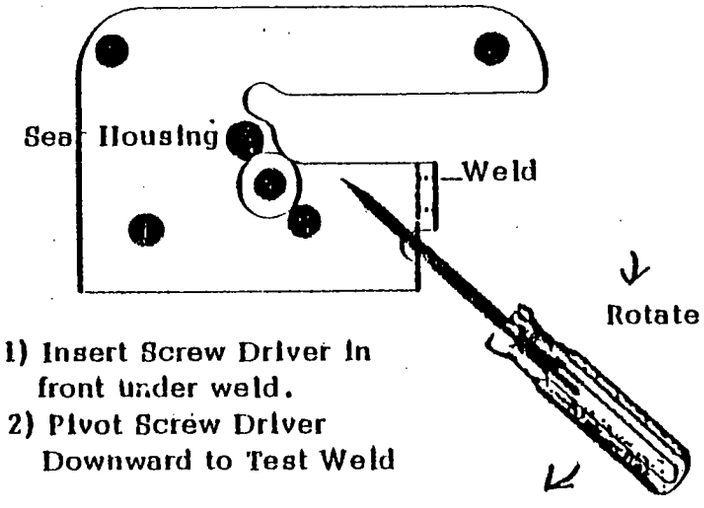
DATES AND REASONS FOR REVISIONS

6/9/80 [illegible]

DESCRIPTIVE INFORMATION

To Test Weld:



1) Insert Screw Driver In front under weld.
2) Pivot Screw Driver Downward to Test Weld

PART NAME SEAR HOUSING ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 7 OF 12

MACHINE

R2535460

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS

6/9/80 LEW

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.
SPEED	FEED		

APPROVAL AND DATES

13. Sear Housing Cont.
- Weld at front of housing must not interfere with Sear Block Screw Hole.

14. Test Weld
- Pry Sear Housing with medium force on screw driver to test for good weld.
- Weld must remain good. (Note Illustration 7)

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 8 OF 12

MACHINE

RD-6463

R2535461

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS

6/9/80 LEW

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.
SPEED	FEED		
		PIN PUNCH	A-35645

APPROVAL AND DATES

15. Assemble Trigger Link Assembly into Sear Housing, and insert Sear Block Pin. Drive Pin Left to Right.

This is easiest done by pivoting Sear Block Assembly fully forward - hold vertically - and place Sear Housing over it.

- Pin must be flush on right side and tight in housing.
- Sear Block Assembly and Trigger Link must be free in housing.

Hold Sear Housing. Move Link forward and backward.

- Link and Sear Block Assembly must move freely.

Press left end of Sear Block Pin firmly against bench block.

- **Pin must not move. Stake Housing at right side if required.**

PART NAME SEAR HOUSING ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 9 OF 12

MACHINE _____

RD-6463

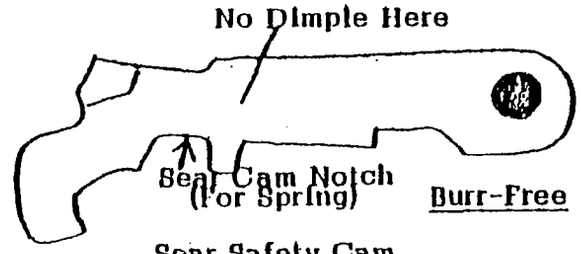
R2535462

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS

6/9/80 [illegible]

DESCRIPTIVE INFORMATION



Sear Safety Cam
#14269 Only

Do Not Substitute

PART NAME SEAR HOUSING ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 10 OF 12

MACHINE

R2535463

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS

6/9/80 NEW PART LEWY

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
		16. Pick Sear Safety Cam • There must be No Burrs on any surface.
		17. Assemble Sear Safety Cam into Sear Housing with front dummy pin.
		18. Drop Sear Block Spring into position on Sear Block Stud.
		19. Rotate Sear Safety Cam into position. • Sear Block Spring must be in position in Sear Cam Notch.

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 11 OF 12

MACHINE

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R2535464

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS

6/9/80 Rev. 9 96

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
SPEED / FEED	

APPROVAL AND DATES

20. Install Rear Dummy Pin over Sear Safety Cam.

21. Check for correct Sear Safety Cam freedom and Spring Force.

- Sear Safety Cam must not bind in Housing.

  Pull Link foreward and hold. Then,
  Depress Sear Safety Cam at top rear and release.

- Sear Safety Cam must **fully depress and return to full upward position against dummy pin.**

- Sear Block must fully rotate under Sear Safety Cam.

  Hold Sear Housing Pull Trigger Link and Release

- Sear Block must return under Sear Housing with Spring Force.

PART NAME SEAR HOUSING ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 12 OF 12

MACHINE

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R2535465

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
		LEWY VISUAL INSPECT For Chrome Plate		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L.

DATES AND REASONS FOR REVISIONS	
6/4/80 New JOA	MATERIAL:
	HEAT TREATMENT AT:
	COMPONENT CONDITION: FINISHED: SEMI-FIN.
	MODEL NO. XP-100
	PART NO. WIP# 16632
	BLANK DRAWING NO.
	PART NAME SEAL SAFETY CAM
	DEPT. NO. 92 PAGE 1 OF 1

RD-6991-1

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

R2535466

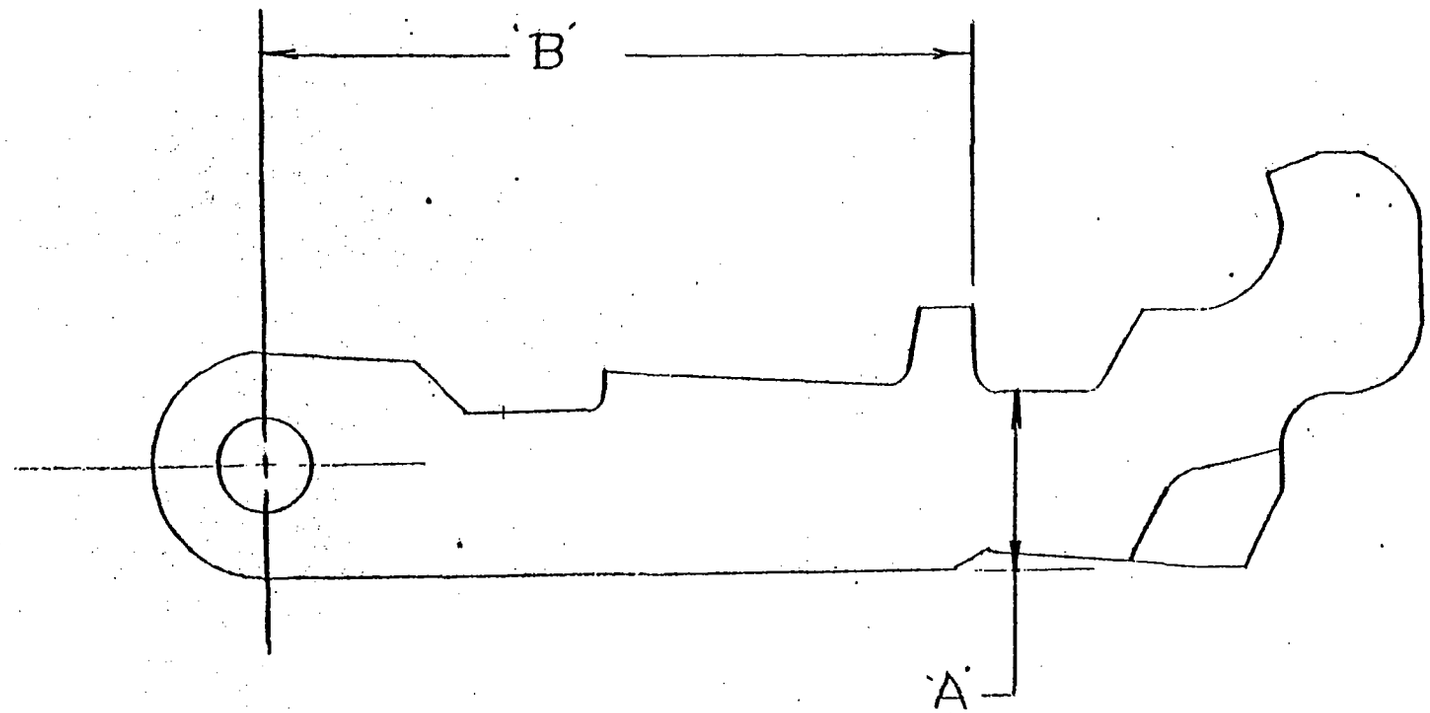
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS

2/4/85 Rev. 00

LEVY

DESCRIPTIVE INFORMATION



PART NAME SEAR SAFETY CAM COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 35

TYPE MACH. HRS. DEPT. No. 02 PAGE 1 OF 1

MACHINE

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/11/70 New Issue.

LEVY

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Vise Jaws	B-85029
		3" Vise	Std.
		Arbor 1" Dia	Std.
		Form Cutter	A-85361
		Dial Base Gage 'A' = .235/.225	C-85031
		Template 'B' = .945/.935	A-85032

OPERATION DESCRIPTION	PART NO.
Mill Spring Seat	WIP16691

PART NAME Seat Safety Cam COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 35

TYPE MACHINE DEPT No. 02 PAGE 1 OF 1

ND-8461

R2535468

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/11/86 New P.P.A.

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
SPEED / FEED	
File	Std.

OPERATION DESCRIPTION	PART NO.
Burr	WIP16681

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 40

TYPE MACHINE DEPT. No. 02 PAGE 1 OF 1

ND-8461

R2535469

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/11/10 New [illegible]

LEFT

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Vise Jaws	B-45453
		Arbor Cutter	A-45462
		Comparator Screen	C-XP-100-CL-35

OPERATION DESCRIPTION	PART NO.
Mill Radius	WIP16631

PART NAME Gear Safety Cam COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 42

TYPE MACHINE DEPT No. 75 PAGE 1 OF 1

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R2535470

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/11/80 NEW P.O.

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	
SPEED / FEED		
File	Std.	

OPERATION DESCRIPTION

Burr

PART NO. WIP1662L

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 43

TYPE MACHINE DEPT. No. 75 PAGE 1 OF 1

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R2535471

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION — STD. PRACTICE No.

TEMPERATURE 1650° F 3½ HRS. .90C POTENTIAL

MAXIMUM LOAD LEVY

TIME

QUENCH

REMARKS

INSPECT FOR — HEAT TREAT INSPECTION

STANDARD PRACTICE No. — HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS	APPROVAL AND DATES				
MICRO-CARB HARDEN	6/4/80 New P.I. G.J.					
	GA. OR CAL.					
	PART No.	WIP1663				
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE OF STD.					
	OF STD.					

PART NAME SEAR SAFETY CAM — EQUIPMENT — MODEL No. XP-100 — OPER. 45

DEPT. No. 51 — PAGE 1 OF 1

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R2535472

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION LEWY

STD. PRACTICE No.

TEMPERATURE 350° F

MAXIMUM LOAD

TIME

QUENCH

REMARKS

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard RC 50 Min

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS / APPROVAL AND DATES						
	6/11/80 New P.B.J.						
Lindberg Draw & Inspect For Rockwell Hardness	GA. OR CAL.						
	PART No.	W1P16681					
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	OF STD. OF STD.						

PART NAME Sear Safety Cam EQUIPMENT MODEL No. XP-100 OPER. 50-55

DEPT. No. 51 PAGE 1 OF 1

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R2535473

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/14/88 Routing LLW

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED

TIME: 1 HR

PCS: 1000

OPERATION DESCRIPTION

SAND TUMBLE

PART NO. WIP16631

PART NAME SEAR SAFETY CAM COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 56

TYPE MACHINE BAIRD BARREL DEPT. No. PAGE 1 OF 1

RD-6461

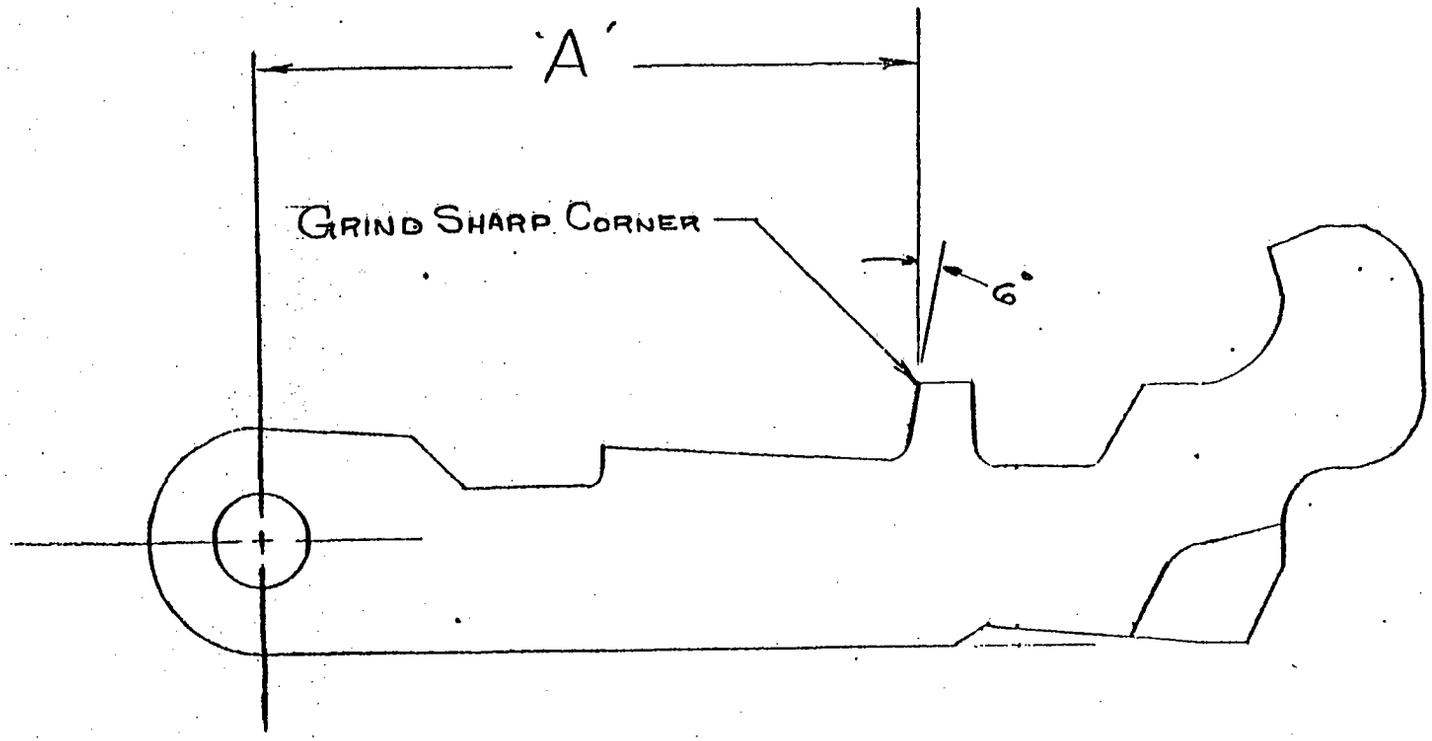
R2535474

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS

6/18 Rev J 44.

DESCRIPTIVE INFORMATION



PART NAME SEAL SAFETY CAM COOLANT SET UP TIME MODEL No. XP-100 OPER. No 62

TYPE MACH. HRS. DEPT. No. 67 PAGE 1 OF 1

MACHINE

R2535475

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

6/[illegible] LLW

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
		GRINDING FIXTURE	B-41453	
		NORTON WHEEL (WHITE SAUCER) 6" x 7/16 x 1 1/4" #38A100 M8VBE	Std.	NOTE: USE HORIZONTAL DRESSER TO GRIND AT 6° ANGLE
		GAGE A = .870/.866	C-44133	

OPERATION DESCRIPTION	PART NO.	APPROVAL AND DATES
GRIND CONNECTOR SURFACE	14269	

PART NAME SEAL SAFETY CAM COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 62

TYPE MACHINE DEPT No. PAGE 1 OF 1

RD-6461

R2535476

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HE TREAT SPECIFICATION

6

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 1650° , 3 1/2 Hrs. .90C potential

MAXIMUM LOAD 2,000 pcs.

TIME 4 hours total furnace time

QUENCH Oil

REMARKS

Retyped

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS Clean, free of oil and soot.

6/16/80 - Add max load & total furnace time - KRC -

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 3-30-66 - New Process - K & Chadwick #27895
Micro-Carb Harden	6/20/67 - Add Part #14269 - MM - 264959 12/28/77 - Add Moh. 600 #91470 - SB 276514
	2/14/79 - Add Part #91470 - APPROVAL AND DATES PRC - 277609 /9/29/80-UPDATE-MRP- RLS-279172

GA. OR CAL.						
PART No.						
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD.						
	91470					
	15666					
					- Moh. 600	

PART NAME Sear Safety Cam Powder Metal EQUIPMENT MODEL No. 700- 40XB OPER. 45

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RD-6464

R2535477

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

6

STD. PRACTICE No.

MATERIAL AND SPECIFICATION

TEMPERATURE 1650° 3 1/2 Hrs. .90C potential

MAXIMUM LOAD 2,000 pcs.

TIME 4 hours total furnace time

QUENCH Oil

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS Clean, free of oil and soot.

6/16/80 - Add max load & total furnace time - KRC -

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
Micro-Carb Harden	3-30-66 - New Process - K & Chadwick #278958 6/20/67 - Add Part #11269 - MM - 261959 12/20/77 - Add Mch. 600 #91470 - SB 276514 2/14/79 - Add Part #91470 - APPROVAL AND DATES PRO - 277609

GA. OR CAL.						
PART No.	WIP# 13707					
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD. or SIP.						
	~~91470~~					
	T5666					
	~~11269~~				~~XP-107 - Mch. 600~~	

PART NAME Gear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. 700-~~600~~-10XB OPER. 45

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HE TREAT SPECIFICATION

6.

STD. PRACTICE No.

MATERIAL AND SPECIFICATION

TEMPERATURE 1650° 3 1/2 Hrs. .90C potential

MAXIMUM LOAD 2,000 pcs.

TIME 4 hours total furnace time

QUENCH Oil

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS Clean, free of oil and soot.

6/16/80 - Add max load & total furnace time - KRC -

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
Micro-Carb Harden	3-30-66 - New Process - K & Chadwick #278958 6/20/67 - Add Part #11269 - MM - 264959 12/28/77 - Add Moh. 600 #91470 - SB 276514 2/14/79 - Add Part #91470 - APPROVAL AND DATES PRO - 277609

GA. OR CAL.						
PART No.						
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD. OF STP.						
	91470					
	~~11666~~					
	~~11269~~				~~XP-10~~ Moh. 600	

PART NAME Sear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. ~~700-600-4 OXP~~ OPER. 45

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

7

STD. PRACTICE No.

MATERIAL AND SPECIFICATION

TEMPERATURE 400° F

MAXIMUM LOAD

TIME 1 hour

QUENCH

REMARKS

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard R_c 50 Min.

APPEARANCE OF PARTS

6/16/80 - Add max load - KRC - #278958

DATES AND REASONS FOR REVISIONS 3-30-66 - New Process - K & Chadwick
6/20/67 - Add Part 14269 - MM - 264959 12/28/77 - Add Moh. 600 #91470 SB 276514
2/14/79 - Add part #91470 - APPROVAL AND DATES PRG - 277609

OPERATION DESCRIPTION	GA. OR CAL.						
Lindberg Draw. [illegible] Inspect for Rockwell hardness.	PART No. - [illegible] REF. DATE OF STD. or STD.	91470 ~~15666~~ ~~14269~~					

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

7

MATERIAL AND SPECIFICATION — STD. PRACTICE No.

TEMPERATURE 400° F

MAXIMUM LOAD

TIME 1 hour

QUENCH

REMARKS

INSPECT FOR Rockwell Hardness — HEAT TREAT INSPECTION

STANDARD PRACTICE No. — HARDNESS LIMITS File Hard R_c 50 Min.

APPEARANCE OF PARTS

6/16/80 - Add max load - KRC - #278958

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 3-30-66 - New Process - K & Chadwick 6/20/67 - Add Part 14269 - MM - 264959 12/28/77 - Add Mch. 600 #91470 SB 276514 2/14/79 - Add part #91470 - APPROVAL AND DATES PRG - 277609						
Lindberg Draw. ~~Allmanite~~ and Hardness Inspect for Rockwell hardness	GA. OR CAL.						
	PART No. - [illegible]	WIP #13707					
	OF STD. or STD.	~~quite~~ 15666 ~~11269~~				~~Rc 100 Min. 600~~	

PART NAME Sear-Safety Cam Powder Metal — EQUIPMENT — MODEL No 700-~~600~~-40XB — OPER. 50-55

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 2/14/79 - New - PRG - 277609
7/18/80 - Added B-45453 - DRL - 279186

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL. XP-100
		Vise Jaws	B-45453
141	4-5/8	Arbor Cutter	
		Comparator Screen	C-XP-100-CL-35
		M/D .020 from Blank	

OBSOLETE

OPERATION DESCRIPTION — PART NO. 14269

Mill Radius

(Part #14269)

PART NAME Sear Safety Cam — COOLANT — SET UP TIME — MODEL No. XP-100 — OPER. No. 42

TYPE — MACHINE — DEPT. No. 75 — PAGE 1 OF 1

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KINZER V. REMINGTON

PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from burrs. Chamfer both ends		
Mics.	Std.	Diameter	.1250	.1248
Mics.	Std.	Overall length	.870	.860

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS

9/26/80 - New sheet- original lost - CAK 27534

MATERIAL: Mfg. spec.

HEAT TREATMENT AT: - - -

COMPONENT CONDITION: FINISHED: X SEMI-FIN.

MODEL NO. 700, 40XB, 40X

PART NO. 24475

BLANK DRAWING NO. C-24475

PART NAME Bolt Stop Pin

DEPT. NO. 92 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Inspect for burrs and visual defects per model drawing		
		16/ finish on top and front of long leg		
Adj. snap gage	B-80010-V	Thickness of long leg		
Flush Pin Gage	C-53905	Check 90° angle on leg		
Receiving Gage	C-44522	Check for max width	.172	.162
Squareness Gage	C-44604	Visually inspect for flatness of inside surfaces of back and long leg of connector		
		Visually inspect for squareness of front edge of long leg.		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 3%

DATES AND REASONS FOR REVISIONS

9/26/80 - New sheet - changed part number - was 19461 (After grind by vendor) - CAK - 279534

MATERIAL: .08/.20 carbon steel
HEAT TREATMENT AT: Remington
COMPONENT CONDITION: FINISHED: SEMI-FIN. X
MODEL NO. 700
PART NO. 91937
BLANK DRAWING NO. C-91937
PART NAME Connector Blank "B"
DEPT. NO. 92 PAGE 1 OF 1

RD 4191-1 REMINGTON ARMS CO., INC., ILION, N.Y.

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECO[illegible]-INSPECTION

7

GAUGES TYPE	GAUGES NUMBER	USE	LIMITS MAX.	LIMITS MIN.
Visual		No burr permitted.		
Adj. Snap Gage	B-80024-Q	Material thickness.	.082	.078
Plug Gage	B-80202-D	Check small hole.	.1267	.1259
Plug Gage	B-80802-V	Check large hole.	.1593	.157[illegible]
Plug Gage	B-80154-K	Dia. for alignment Go End		.125
Plug Gage	B-80202-E	Check dia. "B"	.1335	.131[illegible]
Width Gage	A-50124	Check inside width.	.150	.140
Dial Ga. New	D-84592	~~Check Bolt Stop Arm & Nose~~ Cam Surface	.067 .930	.062 .920
			.296	.292
Wing Gage	A-54176	Must lay flat on arm of safety.		
Comp. Fixture	B-84617 new	Check height and position arm.		
Comp. Screen	D-700A-CL-8	Use with above.		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 3%

DATES AND REASONS FOR REVISIONS

10/9/63 - New form - Marley
5/5/77 - Remove Bolt Stop .920/.930, Add Cam Surface
.062/.067 - SB 275956
9/26/80 - Updated - CAK - 279534

MATERIAL: AISI C-1010
HEAT TREATMENT AT: Remington as an assembly
COMPONENT CONDITION: FINISHED: X SEMI-FIN.
MODEL NO. 700 40 XB
PART NO. 15370
BLANK DRAWING NO. C-15370
PART NAME Safety
DEPT. NO. 92 PAGE 1 OF 1

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

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES ECORDS

DATES AND REASONS FOR REVISIONS

7/2/62 - New - ZK - O'Connell
5/23/63 - Made regular
9/29/80-Remove XP-100 RLS-279124
7/11/63 - Chg. equipment reading - Fay - 258705
11/20/67 - Chg. dept/# - TMc - 265486

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Shado-graph Scale	
		Fairbanks - Morse Scale	
		P-K Twin Shell Blender	
		HVA "Star" iron pdw.	95.5% by weight
		Molybdenum pdw.	4.0% by weight
		Zinc Stearate	0.5% by weight

Blending Time - 1 hour

NOTE: - Weigh and blend metal powders and lubricants as per Chem. & Met. Std. Practice #283.

OPERATION DESCRIPTION	PART NO.
Weigh and blend metal powders, alloys, and lubricants	26795

PART NAME Safety Assembly COOLANT SET UP TIME MODEL NO. 600 OPER. NO. 5

TYPE Powder Metal MACHINE P-K Blender DEPT. NO. 07 PAGE 1 OF 1

RD-6461 POWDER METAL

R2535486

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES RECORDS

DATES AND REASONS FOR REVISIONS 7/2/62 - New - O'Connell - ZK -
5/23/63 - Made regular - 9/29/80-Remove XP-100 from Process-RLS-279124
2/28/64 - chg. step dimension - Fay - 9518 -
11/20/67- Chg. dept/# - TMc - 265486

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
640 Stokes Press		Pressing Speed - 12 pcs./min.
Std. Harper Trays		Green Density - 7.0 g/cc - 7.1 g/cc
Upper punch adapter	G-83561R	Green Weight - 6.2 to 6.3 grams
Upper punch	D-85212W	
Die	D-85212V	Green thickness - .315 - .318
Lower Outer punch	D-85212U	
Lower outer punch adapter	G-83561S	Step dimension - .078 - .077
Lower inner punch	D-85212N	
Lower inner punch adapter	G-83561M	Approximately Outer Fill - .721
		Approximately Inner Fill - .522
		Allow inner punch push back
		Compacting pressure - 45 - 50 T.S.I.

OPERATION DESCRIPTION	PART NO.	26795
Press		

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. M600 OPER. No. 10
TYPE Powder Metal MACHINE 640 Stokes DEPT No. 07 PAGE 1 OF 1

RD-6461 POWDER METAL

R2535487

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 7/2/62 - New - ZK - O'Connell 9/29/80-Remove XP-100 from Process-NLS-279124
1/10/63 - Removed gages and added mics - Layout # - ZK
5/23/63 - Made regular -
11/20/67 - Chg. dept;# - TMc - 265486

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
		Harper Furnace		Sintering Temp. - 2200°F
		Harper Trays		Sintering time - 1 hour
		Nitroneal Generator		Atmosphere Vol. - Approximately 400 C.F.H.
		Mics [illegible]	Std.	
		.085 - .080		
		.305 - .295		
		[illegible]		NOTE: Process Research to set-up final sintering specs. on first production run.
		Comparator Layout	B-XP100-CL-15	
		Chem. & Met. Testinf - Inspect as per Chem. & Met. Std. Practice #281		

OPERATION DESCRIPTION	PART NO.	26795
Sinter		

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 15
TYPE Powder Metal MACHINE Harper Furnace DEPT. No. 07 PAGE 1 OF 1

RD 6461 POWDER METAL

R2535488

PROCES[S] RECORDS

DATES	REASONS FOR REVISIONS
12/22/67	Chg. dept.# - WH - 265609
1/21/64	New - WH - 933[illegible]
9/29/80	Remove XP-100 from Process-RLS-2[illegible] 24

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED
Chip Size - #3½ Bonded			
Compound - 19D - 3 cups (1½ lbs.)			
#202 - 1 oz.			
No. Pcs. - 5000			
PROCESS - Wet chips and drain off excess - add compound and parts.			
TIME: - 3½ hrs.			
Small amounts of water will have to be added when compound becomes muddy and thick.			
TINSE: - Separate from chip and oil.			

OPERATION DESCRIPTION	PART NO.
Sweco Vibrate to radius edges	26795
(Safety thumb piece #15453)	

PART NAME Safety Assembly COOLANT Sweco Vibrator SET UP TIME MODEL No. 600 OPER. No. 19

TYPE POWDER METAL MACHINE DEPT. No. 07 PAGE 1 OF 1

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PROCESS RECORDS

7F

DATE AND REASONS FOR REVISIONS 2/22/71 - Retyped from 9/68 - 269244
9/29/80-Remove XP-100 from Process-RLS-279124

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.
SPEED	FEED	
		Degrease

OPERATION DESCRIPTION	PART NO.	26795
Clean Safety #15430 only Degrease		

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No - 600 OPER No 23
TYPE Powder Metal MACHINE DEPT No 79 PAGE 1 OF 1

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KINZER V. REMINGTON

PROCES[S] RECORDS

71

DATES A[ND] REASONS FOR REVISIONS 5/23/63 - Made regular - 9/29/80-Remover XP-100 from Process-[illegible]-27912[illegible]
4/19/68 - Chg. spot weld data - GES - 266142

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED	FEED						
		Machine Serial No.	28908				
		Bottom Platen	C-86272				
		Top Electrode	Taylor Winfield Part No.	B-327413E			
		Bottom Electrode	Taylor Winfield Part No.	B-327411B			
		Pressure - Lbs.	38#				
		Tap	P-1				
		Squeeze - Cycles	50				
		Hold - Cycles	49				
		Off - Cycles	20				
		Weld - Cycles	3				
		Weld Heat Control - %	80%				
		Temper	No (Off)				

OPERATION DESCRIPTION	PART NO.	APPROVAL AND DATES				
	26795					
Projection weld Safety Thumb-piece to Safety						

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 25

TYPE EB 3-8-30 MACHINE T.w.Welding Machine DEPT. No. 79 PAGE 1 OF 1

RD-8461 POWDER METAL

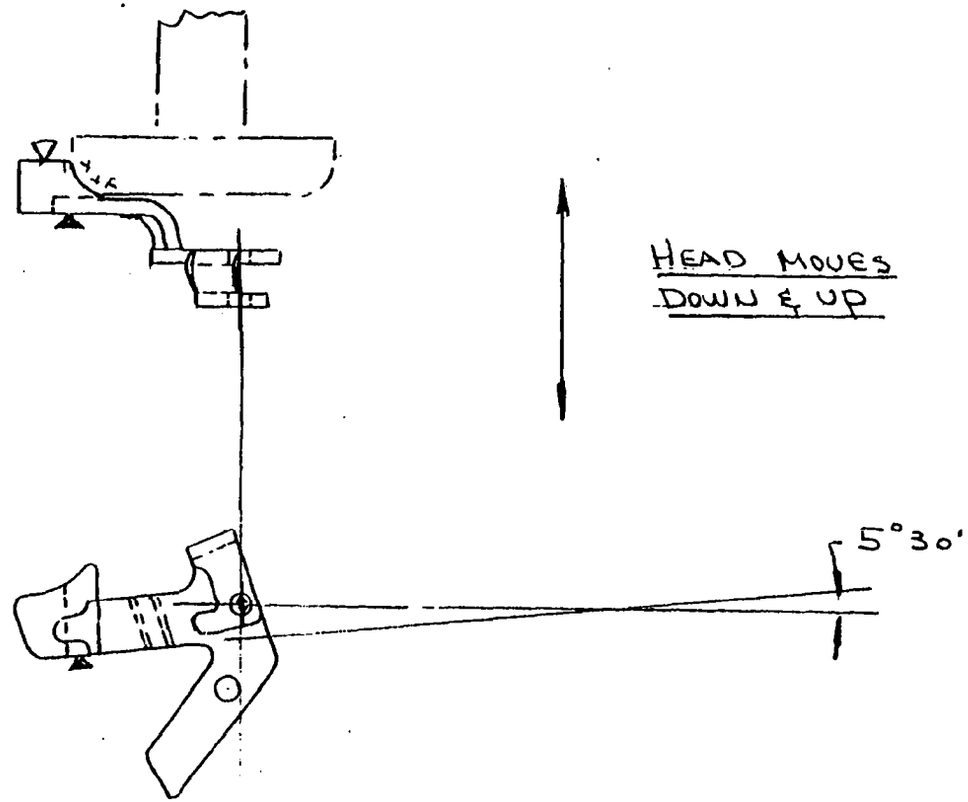
R2535491

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS — 9/29/80-Remove X-100 from Process-RLS-279124

6-28-62 - New - K
5/23/63 - Made regular -
4/21/65 - Chg. dept. # - FB -261459
11/1/66 - Chg. dept. # - MM, 264015

DESCRIPTIVE INFORMATION



PART NAME SAFETY ASSEMBLY — COOLANT — SET UP TIME — MODEL No 600 — OPER. No 35

TYPE POWDER METAL — MACH. HRS. — DEPT. No 75 — PAGE 1 OF 1

MACHINE

Form R. D. 6466

R2535492

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCE RECORDS

DATES AND REASONS FOR REVISIONS 9/29/80-Retyped- Removed XP-100 from Process-RLS-279124

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.	APPROVAL AND DATES
SPEED	FEED			
		Fixture	D-89331	
		Form "T" Cutter	A-85254	
		Tool Holder 1/2 dia. hole	Std.	
		Base Ga. "A" - .205 - .195 "B" - .870 - .880	D-85094	

OPERATION DESCRIPTION	PART NO.	APPROVAL AND DATES
	26795	
Mill radius bottom of thumb piece		

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 3 5

TYPE POWDER METAL MACHINE C inn 08 DEPT. No. 75 PAGE 1 OF 1

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KINZER V. REMINGTON

PROCESS RECORDS

DATES REASONS FOR REVISIONS

1/21/64 - Chg. reading - AJW - 9339
4/21/65- Chg. dept. # - FB - 261459
10/8/65 - Remove sample - JWB - 262166
12/31/63 - Reinstated operation - AJW - 9246
9/29/80-Remove XP-100 from Process- RLS-279124

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED							
Polishing Wheel							

OPERATION DESCRIPTION	PART NO.	26795					
Buff radius							

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 40

TYPE POWDER METAL MACHINE Polishing Jack DEPT. No. 79 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—H TREAT SPECIFICATION

MATERIAL AND SPECIFICATION: AISI - 1020 - Safety
P/M 3050 - Thumb Piece

STD. PRACTICE No.

TEMPERATURE: 1600

MAXIMUM LOAD:

TIME: 1/2 Hr.

QUENCH: Oil

REMARKS: .005 / .010 case Hang on Hooks

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.: 198

HARDNESS LIMITS

APPEARANCE OF PARTS: Clean, free of salts

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 7/2/62 - New - ZK 5/23/63 - Made regular 9/29/80-Remove XP-100 from Process-RLS-279124 3/19/79- Revised op. 45 - APPROVAL AND DATES KRC - 277707
~~Carbo-Nitride~~ harden Cyanide	GA. OR CAL. / PART No. 26795 / OCC. No. / STD. HRS/C / STD. No. / EFF. DATE / OF STD.

PART NAME: Safety Assembly — EQUIPMENT: Ajax Electric Pot or SC Gas Pots — MODEL No. 600 — OPER. 45

POWDER METAL — DEPT. No. 51 — PAGE 1 OF 1

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PROCESS RECORD—HEAT TREAT SPECIFICATION

6 1

MATERIAL AND SPECIFICATION — STD. PRACTICE No.

TEMPERATURE 1650° 3 1/2 Hrs. .90C potential

MAXIMUM LOAD 2,000 pcs.

TIME 4 hours total furnace time

QUENCH Oil

REMARKS

INSPECT FOR — HEAT TREAT INSPECTION

STANDARD PRACTICE No. — HARDNESS LIMITS

APPEARANCE OF PARTS Clean, free of oil and soot.

6/16/80 - Add max load & total furnace time - KRC -

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS					
	3-30-66 - New Process - K & Chadwick #278958					
	6/20/67 - Add Part #14269 - MM - 264959				12/28/77 - Add Moh. 600 #91470 - SB 276514	
	2/14/79 - Add Part #91470 - APPROVAL AND DATES PRG - 277609 /9/29/80-UPDATE-MRP-					
	GA. OR CAL.				RLS-279172	
Micro-Carb Harden	PART No.					
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
	OF STD. OF STD.					
		91470				
		15666				
					- Moh. 600	

PART NAME Sear Safety Cam Powder Metal — EQUIPMENT — MODEL No. 700- 40XB — OPER. 45 — DEPT. No. 51 — PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—H TREAT SPECIFICATION

STD. PRACTICE No.

MATERIAL AND SPECIFICATION: AISI - 1020 - Safety
P/M 3050 - Thumb Piece

TEMPERATURE: 350° F

MAXIMUM LOAD:

TIME: 1/2 hour at temp.

QUENCH: Air Cool

REMARKS:

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS: R 15N 88-92

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
Lindberg Draw and inspect	7/2/62 - New - ZK 5/23/63 Made regular 3/19/79 - Add Material Spec - KRC - 277707 9/29/80-Remove XP-100 from Process - RLS-279124

APPROVAL AND DATES

GA. OR CAL.						
PART No.	26795					
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
OF STD. OF STD.						

PART NAME: Safety Assembly EQUIPMENT: Lindberg MODEL No. 600 OPER. 50 & 55

POWDER METAL DEPT. No. 51 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD–HEAT TREAT SPECIFICATION

7

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 400° F

MAXIMUM LOAD

TIME 1 hour

QUENCH

REMARKS

Retyped

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard R_c 50 Min.

APPEARANCE OF PARTS

6/16/80 - Add max load - KRC - #278958

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 3-30-66 - New Process - K & Chadwick 6/20/67 - Add Part 14269 - MM - 264959 12/28/77 - Add Moh. 600 #91470 SB 276514 2/14/79 - Add part #91470 - APPROVAL AND DATES PRG - 277609 /9/29/80-UPDATE-MRP- RLS-279172
Lindberg Draw & Inspect for Rockwell Hardness	GA. OR CAL. PART No. OCC. No. STD. HRS/C STD. No. EFF. DATE OF STD. OF STD. 91470 15666 14269 - Moh. 600

PART NAME Sear-Safety Cam Powder Metal EQUIPMENT MODEL No 700- 40XB OPER. 50-55

DEPT. No. 51 PAGE 1 OF 1

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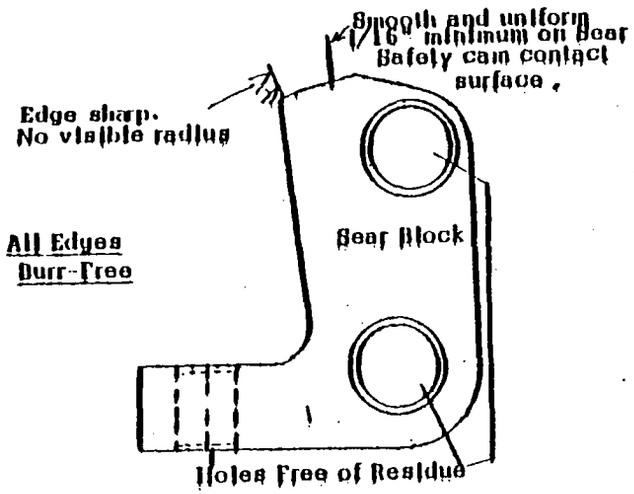
R2535498

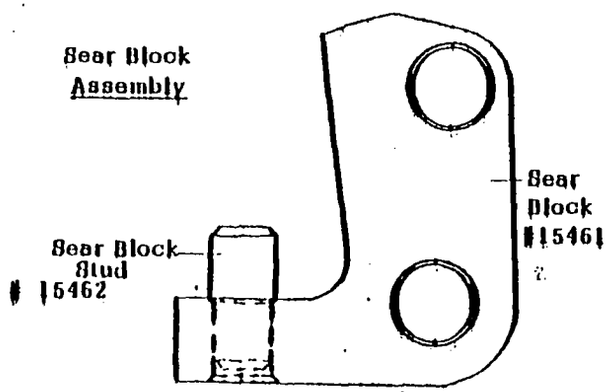
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - JAA - 279156

DESCRIPTIVE INFORMATION



#2 Greenerd Press
C-86199 Fixture
C-86199-A Ram



PART NAME Sear Block Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 1

MACHINE

Form R.D.6466

R2535499

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES CORDS

DATES AND REASONS FOR REVISIONS 9729780 - New - MRP - JAA - 279156

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
SPEED / FEED	
Sear Block Pt. #15461	
Sear Block Stud Pt. #15462	

APPROVAL AND DATES

1. Visually Inspect Sear Block
   - o All holes must be free of residue. Clean with paper clip wire if necessary.
   - o Sear Safety Cam contact surface must be;
     - o Smooth
     - o Burr-free
     - o Rear edge must be sharp

   Check for burrs and smoothness with fingertip.

2. Start Sear Block stud into Sear Block hole and position into fixture,

3. Pull handle on press to firmly seat Sear Block stud shoulder,
   - o Sear Block Stud must be tight to Sear Block.

OPERATION DESCRIPTION	PART NO.	26845
Assemble Sear Block Assembly		

PART NAME Sear Block Assembly COOLANT SET UP TIME MODEL No XP-100 OPER No 55

TYPE MACHINE DEPT No 15 PAGE 1 OF 1

RD-6481

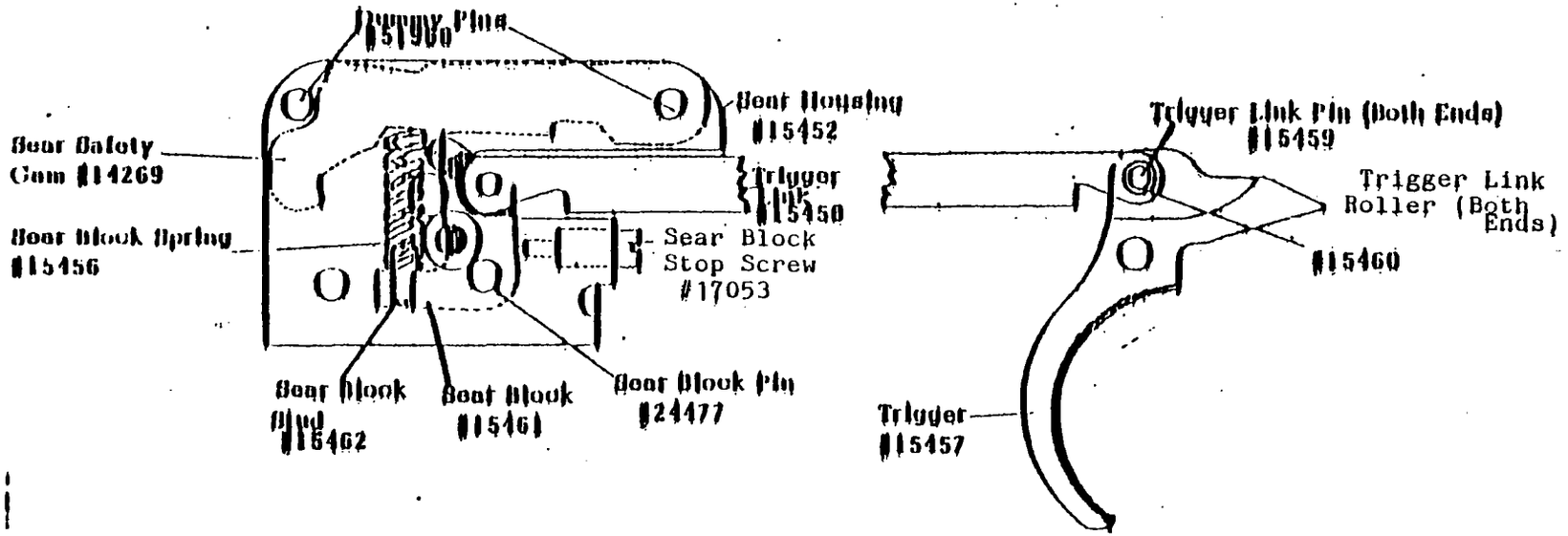
R2535500

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

SEAR HOUSING ASSEMBLY



PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 12

MACHINE

R2535501

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PROCESS ORDS

DATES AND REASONS FOR REVISIONS 9/28/80-NEW-MRP-JAA-279130

TOOLING, GAGES AND EQUIPMENT | GA. OR CAT.

GAGE	PROD		
		Fixture	D-85455
		Crocus Cloth	Std.

APPROVAL AND DATES

1. Pick Sear Block Assembly
2. Polish Sear Safety Cam contact surface.
   - Use new crocus cloth
   - Keep rear edge sharp
3. Pick Roller
   - Roller must be burr-free.
4. Insert Roller into Sear Block Assembly link pin hole.

OPERATION DESCRIPTION | PART NO. 26970

Assemble Sear
Housing Assembly

PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER No. 55

TYPE MACHINE DEPT No. 15 PAGE 2 OF 12

R2535502

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DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

Trigger Link
#15450

Housing End Trigger End

PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 3 OF 12

MACHINE

R2535503

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PROCESS RECORD

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MHP-JAA-27130

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES
SPEED	FEED		

5. Pick Trigger Link
   - Black Color
   - Ears must be straight (Both Ends)
   - Holes must be counter-sunk (Both Ends),

6. Assemble Trigger Link (Housing End) over Sear Block

7. Insert Trigger Link Pin (with head to the left) and swage end,
   - Swage must be on right side,
   - Swage must be flush or below surface,
   - Sear Block must freely rotate about pivot pin.

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 4 OF 12

MACHINE

RU-6463

R2535504

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PROCESS RECORD

DATES . . REASONS FOR REVISIONS 9729780-NEW-MRP-JAA-27, 30

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES
SPEED	FEED		
			8. Pick Trigger • Good Black color, • Striations on Bow uniform, • Improved design at top front - machined slot omitted, 9. Insert one roller into link pivot hole • Roller must be burr-free 10. Assemble Trigger Link over Trigger. • Ears of Trigger link must be straight - not bowed in, 11. Insert Trigger Link Pin and Swage End. • Swage must be flush or below surface, • Trigger must fully rotate <u>freely</u> around pin and roller,

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. MACHINE _____ DEPT. No. 15 PAGE 5 OF 12

RD-6468

R2535505

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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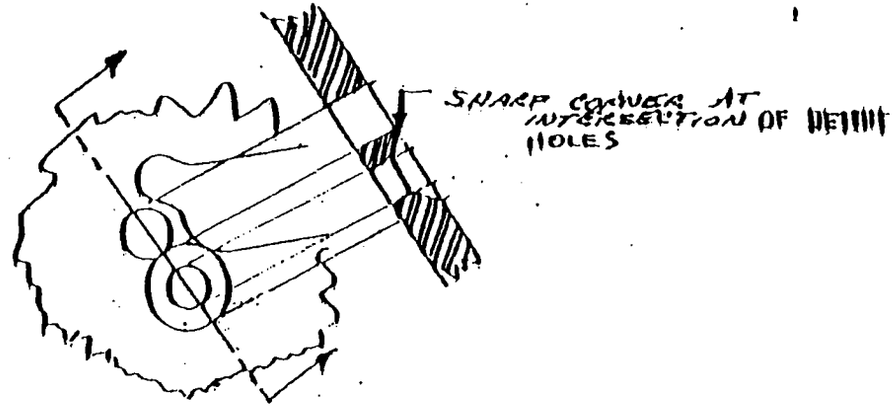
DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

12. Pistol Gear Housing
- Black Color
- Sharp Corner at Intersection of the two safety detent holes - No Flat
- Uniform opening at top for Gear Safety Cam



PART NAME Gear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 6 OF 12

MACHINE

R2535506

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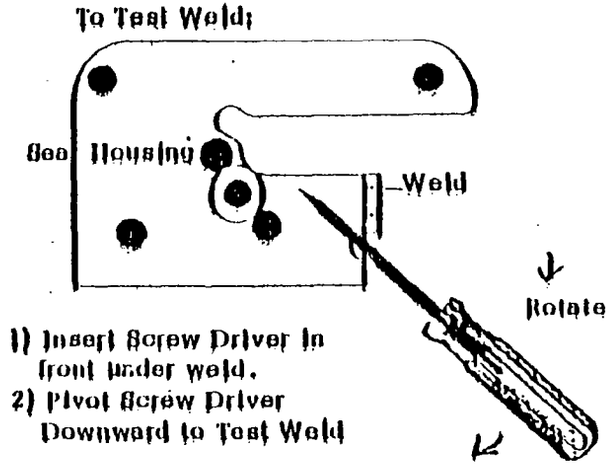
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION



PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 55
TYPE MACH. HRS. DEPT. No. 15 PAGE 7 OF 12
MACHINE

R2535507

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PROCESS RECORD

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-2/9130

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		

13. Sear Housing Cont.
- Weld at front of housing must not interfere with Sear Block Screw Hole.

14. Test Weld
- Pry Sear Housing with medium force on screw driver to test for good weld.
- Weld must remain good. (Note Illustration)

PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55
TYPE MACH. HRS. DEPT. No. 15 PAGE 8 OF 12
MACHINE

AD-6403

R2535508

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-27y130

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Pin Punch	A-35645	15. Assemble Trigger Link Assembly into Sear Housing, and insert Sear Block Pin. Drive Pin Left to Right. This is easiest done by pivoting Sear Block Assembly fully forward - hold vertically - and place Sear Housing over it. • Pin must be flush on right side and tight in housing. • Sear Block Assembly and Trigger Link must be free in housing. Hold Sear Housing. Move Link forward and backward. • Link and Sear Block Assembly must move freely. Press left end of Sear Block Pin firmly against bench block. • Pin must not move. Stake Housing at right side if required.

PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 9 OF 12

RD 8403

R2535509

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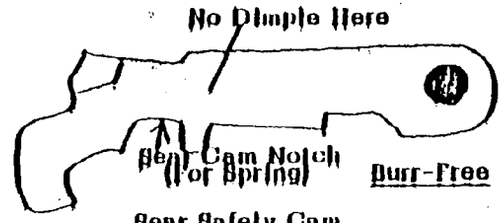
DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION



PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 10 OF 12

MACHINE

R2535510

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KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 9/20/80-NEW-MRP-JAA-279130

TOOLS GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES
BY HAND	FIXED		

16. Pick Sear Safety Cam
    - There must be No Burrs on any surface

17. Assemble Sear Safety Cam into Sear Housing with Front Dummy Pin.

18. Drop Sear Block Spring into position on Sear Block Stud.

19. Rotate Sear Safety Cam into position.
    - Sear Block Spring must be in position in Sear Cam Notch.

PART NAME Sear Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 55

TYPE _____ MACH. HRS. MACHINE _____ DEPT. No. 15 PAGE 11 OF 12

RD-6483

R2535511

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCF RECORD

DATES | REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-21,130

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		

20, Install Rear Dummy Pin over Sear Safety Cam.

21, Check for correct Sear Safety Cam freedom and Spring Force,

- Sear Safety Cam must not bind in Housing.

  Pull Link forward and hold, Then, Depress Sear Safety Cam at top rear and release,

- Sear Safety Cam must fully depress and return to full upward position against dummy pin.

- Sear Block must fully rotate under Sear Safety Cam.

  Hold Sear Housing Pull Trigger Link and Release

- Sear Block must return under Sear Housing with Spring Force,

PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 15 PAGE 12 OF 12

MACHINE

RD-4488

R2535512

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PROCE RECORDS

DATES AND REASONS FOR REVISIONS 7/11/63 - New - WH - 25b006
1/21/64 - Chg. reading - WH - 9339 9/29/80-Remove XP-100 from Process-RLS-279124

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED

CHIP #3½ Bonded

AMT. CHIP - 150 - 200 lbs.

NO. PCS. PER LOAD 800

PROCESS: Thoroughly wet chips with drain open. When water is drained off close drain and add about 2 quarts water. Add 1½ lbs. #19D & 1oz. 202 compound on chip - add parts - Vibrate 1 hour.

Flush clean with water and drain open.

SEPARATE FROM CHIP AND OIL.

OPERATION DESCRIPTION | PART NO. 26795

Sweco Vibrate

(To smooth edges and deburr around hole)

PART NAME Safety Assembly COOLANT SET UP TIME MODEL NO. 600 OPER. NO. 57

TYPE POWDER METAL MACHINE Sweco Vibrator DEPT. No. 79 PAGE 1 OF 1

RD-6461

R2535513

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PROCES RECORDS

DATES AND REASONS FOR REVISIONS 7/2/62 - New - ZK
5/23/63 - Made regular 9/29/80- Remove XP-100 from Process - RLS-279124

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED
Black Oxide color - Chem. & Met. Standard Practice #276			

OPERATION DESCRIPTION | PART NO. 26795

Black Oxide color

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 60

TYPE POWDER METAL MACHINE DEPT. No. 79 PAGE 1 OF 1

RD-6461

R2535514

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCES ECORDS

DATES AND REASONS FOR REVISIONS 12/16/77 - Make regular - JAA - 276326 9/29/80-UPDATE-MRP-RLS-279172
12/28/77 - Add Moh. 600 #91470 - SB - 276514
1/5/78 - Chg. dept. to 67 - JAA - 276544
9/27/78 - Add Gage & Wheel dresser - JAA - 277219
2/14/79 - Add part nos. & chg. "A" Dim. - PRG - 277609

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
Grinding Fixture	B-41453
Norton Wheel (White Saucer) 6" X 7/16" X 1-1/4" #38A100 M8VBE	Std.
~~Staking Fixture~~	~~D-~~
~~Comparator Chart~~	~~B-~~
Gage ~~(TDR #989)~~	C-44133
A - ~~.865 - .859~~ .870 - .866	
60 Wheel Dresser	D-44410

OPERATION DESCRIPTION	PART NO.
Grind Connector Surface ~~(600-700)~~ Part #15666,91470	15666 91470

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. Moh. 600 700 OPER. No. 62
TYPE MACHINE DEPT. No. ~~77~~ 67 PAGE 1 OF 1

R2535515

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PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 9/29/80 - New for MRP - RLJ - 279110

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
	Phenol	
	Applicator	
	Welding Fixture	
	Stamp (Fixture Number)	
	NOTE: Stock Assembly must dry for 35 mins. in Fixture and cure for 24 hrs. on rack.	

OPERATION DESCRIPTION	PART NO.	
	26805	221
	91765	7MM BR
Weld Stock Halves with Fore-ward and Rear Receiver Screw Escutcheons and Trigger Guard in place. Stamp Operator and Fixture numbers.		

PART NAME Stock Assembly. COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 70

TYPE MACHINE DEPT. No. 62 PAGE 1 OF 1

RD-6461

R2535516

PROCESS RECORDS

8

DATES AND REASONS FOR REVISIONS 12/14/77 - Made T & P regular - SDB - 276463
9/29/80-UPDATE -MRP-CHG. OP. #10 TO OP. #90 - RLS - 279125

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES					
OPER.	TASK							
		Assembly Fixture	D-43760					

OPERATION DESCRIPTION	PART NO.	
Assemble Safety Button to Safety and Stake		91496

PART NAME Safety Assembly COOLANT SET UP MODEL No. Xp-100 OPER. No. 90

TYPE MACHINE DEPT. No. 15 PAGE 1 OF 1

R2535517
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DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - RLJ - 279162

PART NAME Final Pistol Assembly
TYPE Level I Components
COOLANT
SET UP TIME
MODEL No. XP-100
OPER. No. 575
MACH. HRS.
DEPT. No. 15
PAGE 1 OF 37
MACHINE

COMPONENTS	221	MMBF				
	PART NUMBERS					
Barrel Assembly Complete	31560	31561				
Firing Pin Assembly	25500	----				
Bolt Stop	15446	91761				
Bolt Stop Spring	15413	----				
Bolt Stop Pin	24484	----				
Forward Receiver Screw	15447	----				
Forward Rec. Scr. Washer	15485	----				
Rear Receiver Screw	15450	----				
Rear Rec. Scr. Washer	15484	----				
Rear Sight Assembly	26840	None				
Rear Sight Nut	15418	None				
Receiver Plug Screw	17034	----	221(3)	MM(5)		
Rib	26785	None				
Rib Screw (2)	15417	None				
Sight Screw Washer (4)	16968	None				
Sight Screw (4)	15416	None				
Front Sight	15449	None				
Front Sight Ramp	None	91763				
Front Sight Ramp Screw	None	28505				
Safety Assembly	91496	----				
Safety Detent Ball	23222	----				
Safety Detent Spring	15432	----				
Safety Pivot Pin	17043	----				
Safety Snap Washer	17044	----				
Sear Housing Assembly	26790	----				
Sear Pin (2)	24476	----				
Stock Assembly	26805	91765				
Trigger Housing Assembly	16876	----				
Trigger Balance	15470	----				
Trigger Balance Pin	15471	----				
Trigger Balance Spring	15472	----				
Trigger Housing Screw	15474	----				
Trigger Pin	24483	----				
Rear Sight Wrench	15776	None				

REMARKS
FINAL ASSEMBLY

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R2535518

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80mp New - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

NOTE: Unless otherwise stated - All relative directions, (up, down, clockwise, etc.) are from shooter's point of view, with gun held in normal firing position.

1. Pick Barreled Action and Inspect:

- Good uniform black color
- No mars or scratches
- Proper roll marks
- Legible, uniform serial number
- Bore must be concentric to muzzle

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
			* NOTE: For 7MM BR, RAMAC 925471, See Sheet 37 of this Operation				
	PART No.	925470	925471*				
	GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

TYPE MACH. HRS. DEPT. No. 15 PAGE 2 OF 37

MACHINE

Form R. D. 6463

R2535519

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - BL91-279162

DESCRIPTIVE INFORMATION

2. Clamp in Vise.

3. Assemble three (3) Receiver Plug Screws into Receiver.
   - Edge of screws must be flush to Receiver (925470, 221, Only)

4. Pick Bolt Stop Spring. Place one end of spring into detent in bottom of bolt stop slot.

5. Pick Bolt Stop and Inspect:
   - Black Color
   - Free of burrs

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

TYPE MACH. HRS. DEPT. No. 15 PAGE 3 OF 37

MACHINE

Form R. D. 6465

R2535520

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9729780 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
6. Insert Bolt Stop into Receiver slot, fitting Bolt Stop Spring into slot in rear of Bolt Stop. 7. Pick Bolt Stop pin, Position and drive into Receiver from left to right: • End of pin must be just above flush with Bolt Stop. • Opposite end of pin must not protrude into Sear Housing slot.	

OPERATION DESCRIPTION								
Final Assembly	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 4 OF 37
MACHINE

Form R. D. 6465

R2535521

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Added file - WAW - 277931
9/29/80 - New - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES
8. Push upward on rear end of Bolt Stop and release slowly; • Bolt Stop must rotate freely and return fully. **File Receiver slot if necessary.** Repeat but release quickly under spring tension; • Bolt Stop Spring must remain in place. 9. Pick Trigger Housing and inspect: • Black color • No burrs or damage to inside surfaces which could interfere with proper Trigger rotation. If Trigger Housing is slightly closed in, spread with special holding plug, to align holes with Barrel Bracket holes.	

OPERATION DESCRIPTION								
Final Assembly	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 5 OF 37
MACHINE

Form R.D. 6465

R2535522

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Added tool number - WAW - 277931
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

10. Assemble Trigger Housing to Barrel Bracket with two (2) Trigger Housing Screws;

    - Trigger Housing ears must be flush to bottom and both sides of Barrel Bracket.

Reject for serious mismatch.

EQUIPMENT—TOOLS & GAGES

Special Holding Plug or B-86362

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 6 OF 37
MACHINE

Form R. D. 6465

R2535523

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Remove Item 11 - transfered to oper. 103 - WAW - 277931
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

[illegible]

12. Pick Sear Housing Assembly and inspect:

- Swaged end of Trigger Link Pin must be flush or below right side surface of Link on Sear Housing end.
- Ears of link must be straight.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Final Assembly	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 7 OF 37

Form R. D. 6403

R2535524

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RCJ - 279162

DESCRIPTIVE INFORMATION

12. Cont.
    - Link and Sear Block Assembly must move freely in housing.
    - Trigger must rotate freely.

13. Insert Sear Housing into Receiver and align Sear Pin holes of Receiver and Housing.

14. Pick Sear Pin and start, chamfered end first. Drive rear pin first, left to right, to just above flush with inside surface of Bolt Stop Slot (To clear Safety Assembly on opposite side.)

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

TYPE MACH. HRS. DEPT. No. 15 PAGE 8 OF 37

MACHINE

Form R. D. 6461

R2535525

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PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29780 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

Drive front pin, chamfered end first, left to right, to slightly below flush with inside surface of Bolt Stop Slot. (To clear Bolt Stop).

15. Push upward on rear end of Bolt Stop and release slowly;

- Bolt Stop must rotate freely and return fully without bind.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 9 OF 37

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R2535526

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Added Pin Punch - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES
16. Pick Trigger Pin. Align Trigger hole with Trigger Housing holes, 17. Position and drive pin through, left to right; • End of pin must be flush to slightly below at right side of Trigger Housing. 18. Pull Trigger several times and release slowly; • Trigger and Link must return freely and fully. Cont.	Pin Punch - A-35645

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535527

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Updated - MHP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
18. (Cont.) Push forward on Trigger to verify Trigger has returned fully. File and/or adjust to free Trigger if necessary. 19. Stake both sides of Trigger Housing to retain Trigger Pin. 20. Retighten Trigger Housing Screws. 21. Stake Barrel Bracket at Trigger Housing screw slots to prevent screws loosening.	Center Punch

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535528

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

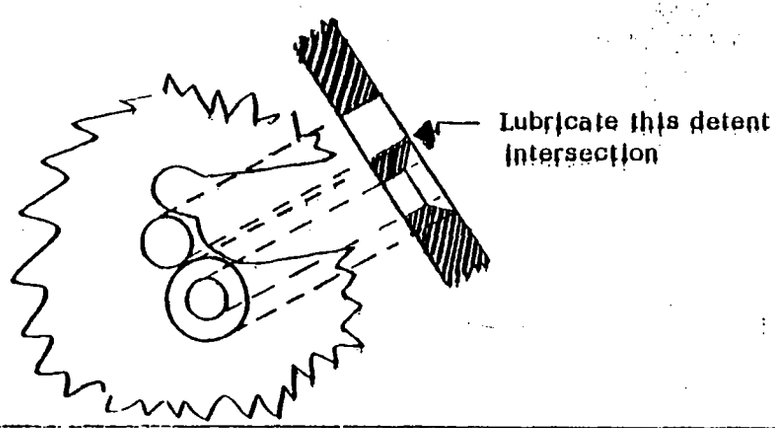
PROCESS RECORDS - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

22. Lubricate Sear Housing at detent holes' intersection:

- Only a small amount of lubricant is required.



EQUIPMENT - TOOLS & GAGES

Moly Kote Type 'GN' Paste

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

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R2535529

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

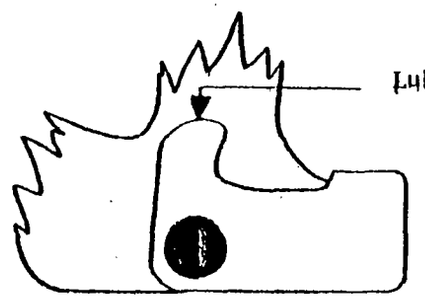
PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

23. Lubricate cam surface of SafetyA ssembly:

- Only a small amount of lubricant is required.



EQUIPMENT—TOOLS & GAGES

Moly Kote Type "GN" Paste

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
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	GA.						

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R2535530

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Add Pin Seating - WAW - 277931
9/29/80 - Update - MHP - 279162

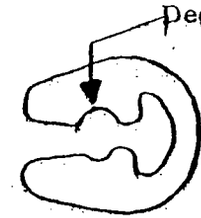
DESCRIPTIVE INFORMATION

24. Assemble:

Safety Assembly
Safety Detent Ball
Safety Detent Spring - Visually check for correct size dimple
Safety Pivot Pin - Seat pin head lightly against left side of Sear Housing.
Safety Snap Washer - Side with deep notch (for Safety Pivot Pin) must be on top.

- Safety Snap Washer must be completely contained within Pivot Pin groove.

EQUIPMENT - TOOLS & GAGES



Cont.

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
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PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535531

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

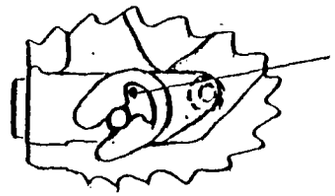
PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RCJ - 279162

DESCRIPTIVE INFORMATION

24. (Cont.)

- The raised end of dimple on Safety Detent Spring must be at the left of the opening, at the closed end of the Safety Snap Washer,



EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

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R2535532

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Updated - MHP - RLJ - 279162

DESCRIPTIVE INFORMATION

25. Function check Safety Assembly components.

Push Safety Thumb Piece fully forward beyond detent position:

- Safety must spring return to detent position.

Push Safety Thumb Piece fully rearward beyond detent position:

- Safety must spring forward to detent position.

Move safety from "On Safe" to "Off Safe" position and back. Do this twice:

- Safety must spring forward into "Off Safe" position when pushed.

Cont.

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
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R2535533

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Correct part name - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

25. (Cont.)

- There must be no hang-up or hesitation between detent positions.
- The flat arm of the Safety Assembly must work freely. It must not bind on housing, Receiver slot, Link, Trigger Link Pin, or Bear Block Pin.

Adjust if necessary.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION								
Final Assembly	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
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	GA.							

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R2535534

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW -277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES
26. Pull Trigger several times and release slowly; • Trigger must return freely and fully. Push forward on Trigger to verify Trigger has returned fully.	
27. Stake left side of Receiver, below both Sear Pins, and Bolt Stop Pin.	Center Punch

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Final Assembly	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535535

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Add lubrication element - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES
28. Pick Firing Pin Assembly and inspect; • Firing Pin point must not be marred, • Bolt Plug must have good color and appearance. No mars or scratches, • No rusty parts, • No miscut or incorrect parts. **Lubricate Bolt Plug threads and Locking Cam surface, before assembly into Bolt.**	**Molykote type "GN" paste**
29. Assemble Firing Pin Assembly to Bolt and remove washer, so that Bolt Final Assembly is in fired position.	
30. Check Firing Pin protrusion. • 0.045 Min. • 0.075 Max.	Protrusion Gage – #B-52089

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
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R2535536

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Added cycling bolt - WAW - 277931
11/2/79 - Increased adjustment - WAW - 278216
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
31. Place Final Bolt Assembly into rearward (cocked) detent position. 32. Move safety to "Off Safe" position, insert Bolt into Receiver. ~~Open and close Bolt several~~ Open and close Bolt several times to distribute lubricant and verify smooth operation. 33. Initially adjust Sear Safety Cam - Sear Block engagement. (Before Comparator) Turn Trigger Adjusting Screw in slowly until firing pin "just" falls; • Back out Trigger Adjusting Screw ~~1~~ 2 turns. (This produces ~~.020~~ .030 engagement.) Cont.	

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
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	STD. No.						
	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535537

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES
33. (Cont.) Visually check for correct engagement. 34. Initially adjust Sear Block overtravel. Re-cock action. Turn Sear Block Stop Screw in until Firing Pin will not fall when Trigger is pulled. Hold Trigger back and turn Sear Block Stop Screw out slowly until Firing Pin "just" falls. Cont.	

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
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	STD. No.						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535538

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
34. (Cont.) • Back out screw another 1/2 turn, (This produces extra overtravel between Sear Safety Cam and Sear Block after disengagement.) 35. Inspect for correct Sear Safety Cam - Sear Block clearance with shim, I. Put safety lever to "On Safe" position.	.002 tempered steel shim stock Note: Worn, burred or damaged shim, will bind. Replace shim frequently. Shim must be narrow enough to pass thru view hole in Sear Housing.

OPERATION DESCRIPTION							
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	STD. HRS/C						
	STD. No.						
Final Assembly	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535539

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

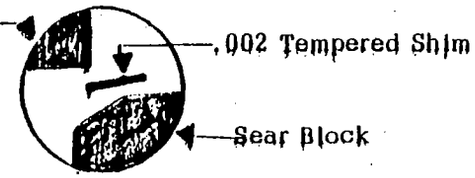
DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. (Cont.)

II. Insert .002 shim fully into view hole in left side of Sear Housing.

- Shim must be between Sear Safety Cam and Sear Block,



Cont.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
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PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

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R2535540

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

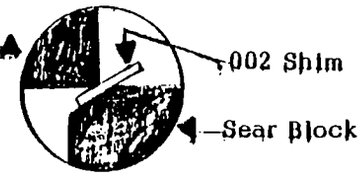
DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. (Cont.)

III. Move Safety lever to "Off Safe" position. Lightly pull on shim with thumb and finger:

- Shim must remain trapped between Sear Safety Cam and Sear Block.
- If shim is free - return to element #2.



Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 27724
9/29/80 - Update - MHP - HLJ - 279162

DESCRIPTIVE INFORMATION

35. Cont.

IV. Move Safety Lever from "Off Safe" position toward "On Safe" position, to locate and stop Safety Lever at the forward most null location;*

o If null location is passed (too far toward "On Safe"), then return to "Off Safe" position, and approach null location from the "Off Safe" position again.

Cont.

EQUIPMENT - TOOLS & GAGES

* Forward Most Null Location is that "just - stable" place between "On" and "Off" safe, closest to "Off Safe", where the Safety Lever will not spring forward to the "Off Safe" position when released.

OPERATION DESCRIPTION	OCC. No.						
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	GA.						

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R2535542

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/1/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. Cont.

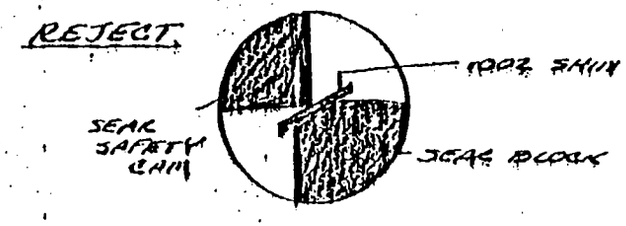
V. With the Safety Lever in the forward most null location, lightly pull on Shim with thumb and finger.

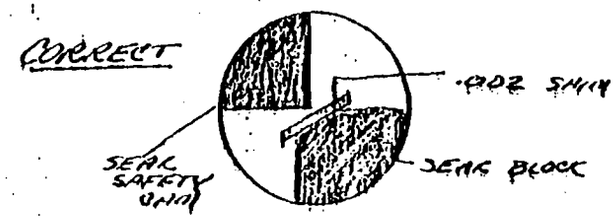
- If Shim binds or hangs up between Sear Safety Cam and Sear Block -

  Reject and rework as per process.

- If Shim removes freely, clearance is correct.

EQUIPMENT - TOOLS & GAGES





OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. Perform Trick Test,

I. Cock Pistol

II. Move Safety Lever to "On Safe" Position;

- There must be no bind,
- There must be a good sharp single detent.
- In the "On Safe" position, the Safety must have an observable "spring back", from the fullest rearward and forward positions.

III. Pull Trigger;

- There must be no click or catch in pull.
- Firing Pin must not fall.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
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	STD. No.						
Final Assembly	EFF. DATE						
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW
5/21/79 - Added to element V - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

IV. Release Trigger Slowly;

- Trigger must move to full forward position when released.

V. Move Safety Lever to "Off Safe" Position:

- Firing Pin must not fall.
- Pull Trigger, Firing Pin must fall.

VI. Re-cock Pistol

Position to the Forward Most Null Location.
(Previously defined in element #35, Page 24.

Two fingers may be necessary to position Safety)

Cont.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
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	GA.						

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - 279162 3/19/79 - Revised - WAW - 277724

DESCRIPTIVE INFORMATION	EQUIPMENT - TOOLS & GAGES
36. (Cont.) VIII. Pull Trigger Hard; • There must be no click or catch in pull, IX. Release Trigger Slowly: • Trigger must not bind, • Trigger must move to full forward position when released, • Firing Pin must not fall, X. Push Safety Lever to "Off Safe" Position: • Firing Pin must not fall. • Safety Lever must spring to "Off Safe" position by itself when pushed from the null location. Cont.	

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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	PART No.						
	GA.						

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

- In the "Off Safe" position, the Safety must have an observable "spring back" from the fullest forward and rearward position.

XI. Pull Trigger;

- Firing Pin must fall.

XII. Open action and close Bolt firmly to re-cock,

- Firing Pin must not fall.

XIII. Repeat steps 7 thru 12.

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36.(Cont.)
For the Third and Last Trial:

XIV. Move Safety to "On Safe" position,

XV. From the "On Safe" position, move the Safety Lever to the forward most null location. (Previously defined element #35, page 24.)

XVI. Pull Trigger hard,

XVII. Release Trigger slowly;

- There must be no click or catch in pull.

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Final Assembly	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

TYPE MACH. HRS. DEPT. No. 15 PAGE 31 OF 37

MACHINE

Form R. D. 6463

R2535548

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Delete element in item 18 - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (cont.)

XVII. (Cont.)

- Trigger must not bind.
- Trigger must return to full forward position when released,
- Firing pin must not fall,

XVIII. Push Safety Lever to "Off Safe" Position;

- Firing Pin must not fall.
- Safety must spring to "Off Safe" position when pushed from the null location.

~~W [illegible]~~

Cont.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION								
Final Assembly	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 32 OF 37

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R2535549

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD, ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Revised element 37 - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

XIX. Pull Trigger;

- Firing Pin must fall.

XX. Open Action and close Bolt firmly to re-cock.

- Firing Pin must not fall.

37. Put Safe in "Off Safe" position.
Re-cock action.
Push with steady pressure on the end of Firing Pin head. (Use suitable non - marring means);

- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
Final Assembly	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 33 OF 37
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R2535550

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
38. Check Notch Escape. Put Safe in "Off Safe" Position Hold Trigger Back. Close Bolt Slowly. • Firing Pin Must Follow Down. 39. Use dummy cartridges to check feeding, extraction and ejection. Adjust if necessary. 40. Assemble Rear Sight Nut and Rear Sight to Rib with Rear Sight Screw. (925470, 221, Only)	

OPERATION DESCRIPTION							
Final Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 34 OF 37

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R2535551

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ..SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Included washers - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

41. Assemble Rib to Barrel Assembly with 2 Rib Screws,

    Do not tighten, (925470, 221, Only)

42. Assemble Front Sight to Rib with Front Sight Screws and Sight Washers, (925470, 221, Only)

43. Assemble Rear Sight Screw and Sight Washer to Rib thru Rear Sight, (925470, 221, Only)

44. Position Rib in extreme rear position, and tighten all screws. (925470, 221, Only)

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

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R2535552

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/14/79 - Added letter "O" - WAW - 277906
5/21/79 - Modified element 45 - WAW - 277931
9/29/80 - Update - MHP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT - TOOLS & GAGES
45. Mark Assembler's identification on gun ticket. Hand stamp letter "O" on left rear horizontal flat of Receiver Tang.	1/16" Stamp
46. Pick correct ticket and fill in.	
47. If repairs from test are necessary, work must be done by the assembler who built and stamped the action.	

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Final Assembly	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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R2535553

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 2/26/80 - New Operation - ZJK - 278589
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

NOTE:
Same as Sheets 1-36 except for the following elements.

3. Assemble (5) Req, Plug Screws into Receiver.

40. OMIT - Assemble rear Sight Nut & Rear Sight to Rib with R. S. Screw.
41. OMIT - Assemble Rib to Barrel with 2 Rib Screws.
42. OMIT - Assemble Front Sight to Rib.
43. OMIT - Assemble Rear Sight Screw, etc. to Rib.
44. OMIT - Position Rib & tighten all screws.
44-5 Assemble Front Sight Ramp to Barrel with Front Sight Screw. (925471, 7MM BR, only)

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
(7MM BR Rem. only)							
	PART No.	925471					
	GA. 7MM BR						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 37 OF 37
MACHINE Bench

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R2535554

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 5/13/63 - Made regular
3/1/68 - Chg. reading - MT - 265929
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
Proof Test, Test and Target Pistol	Proof Test, Test Targeting Jack

OPERATION DESCRIPTION							
Proof Test, Test and Target	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	925470	925471				
	GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP100 OPER. No. 603
TYPE MACH. HRS. MACHINE DEPT. No. 85 PAGE 1 OF 1

R2535555

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Added word to item 1 - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

1. Pick **Barreled Action,**

2. Inspect for live ammunition;

   - Chamber must be empty.

3. Air-clean Sear Block and Sear Safety Cam thru Sear Housing opening.

   (Do this away from comparator)

EQUIPMENT – TOOLS & GAGES

J & L TC-10 Comparator with 20 power projection lens assembly.

Standard air line nozzle.

Comparator Template
A-XP-100-37 (See Pg. 7)

Comparator Fixture

NOTE: Realign lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light beam from condensing lens to projection lens must be parallel. Adjust as required. Refer to Pg. 7 of J & L Operating Manual.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Adjust Sear Housing Assembly on **Comparator** 100%.	EFF. DATE						
	PART No.	925470	925471				
	GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 7
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R2535556

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
4. Put Safety Lever in "OFF SAFE" position. 5. Place action in fixture and secure. 6. Push Bolt Stop to free position and secure with a non-marring means. 7. Close Bolt. 8. Move fixture to position Sear Safety Cam vertical surface to engagement set line of comparator overlay,	

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Adjust Sear Housing Assembly on Comparator 100%.	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
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KINZER V. REMINGTON

PROCESS RECORD, ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

9. Check Sear Safety Cam - Sear Block engagement (.015 - .020);

- Must be within tolerance lines of Comparator overlay.

A. If engagement is more than max. line;

Turn Trigger Adjusting Screw slowly clockwise (viewed from Muzzle end) until engagement comes within tolerance lines.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Adjust Sear Housing Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
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R2535558

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

9. (Cont'd.)

B. If engagement is less than min. line:

Raise Bolt Handle (actually lowering handle while action is in the fixture) and turn Adjusting Screw counter clock-wise,

Close Bolt Handle (Sear Block will not always follow as Trigger Adjusting Screw is turned counter-clockwise with Bolt closed),

Return to 9A

10. Pull Trigger to drop Firing Pin.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Adjust Sear Housing Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
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R2535559

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

11. Move fixture to position Sear Safety Cam vertical surface to overtravel "set" line on Comparator overlay.

12. Hold Trigger back firmly against Stop Screw.

- Clearance between Sear Safety Cam and Sear Block must be within overtravel tolerance lines on Comparator overlay (.005 - .015).

A. If overtravel is less than min. line:

Turn Sear Block Stop Screw counter-clockwise until clearance is within tolerance lines.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION								
Adjust Sear Housing Assembly on Comparator 100%.	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
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R2535560

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Add to element 15 - WAW - 277931
9/29/80 - Update - MRP - 279162

DESCRIPTIVE INFORMATION	EQUIPMENT - TOOLS & GAGES
12. (Cont'd) B. If overtravel is more than max, line: Turn Sear Block Stop Screw clockwise until clearance is within tolerance lines. 13. Remove Bolt Stop means. 14. Remove Action from fixture. 15. Seal both screws with "Duco" cement, including screw slots. • **Cement must not interfere with link freedom.**	"Duco" Cement

OPERATION DESCRIPTION							
Adjust Sear Housing Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
TYPE MACH. HRS DEPT. No. 15 PAGE 6 OF 7
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Form R. D. 6469

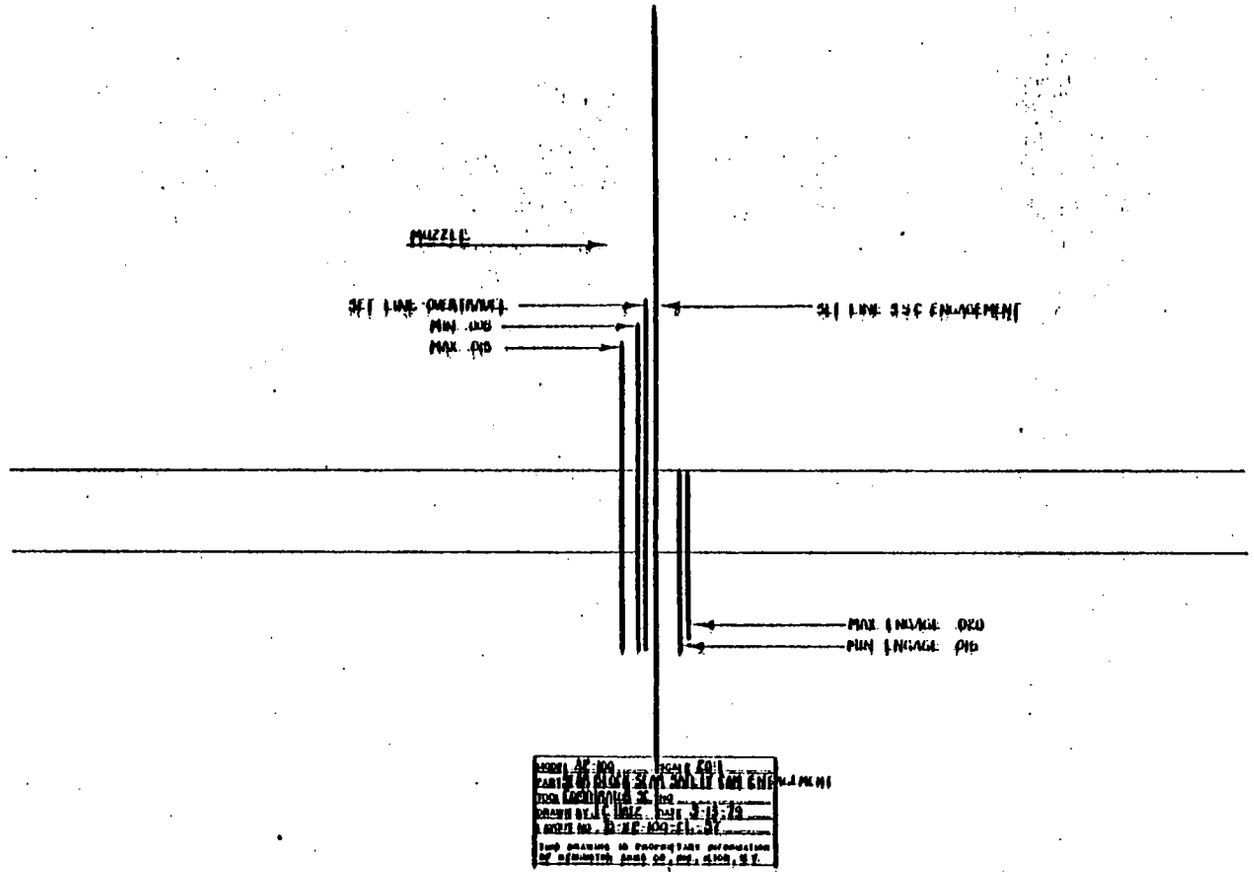
R2535561

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES	REASONS FOR REVISIONS
9/29,	4/23/79 - New - WAW ; - Update - MRP - RLJ - 279162

830

DESCRIPTIVE INFORMATION



PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620

TYPE MACH. HRS. DEPT. No. 15 PAGE 7 OF 7

MACHINE

Form R. D. 4464

R2535562

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Corrected name & added element - WAW - 277931
9/29/80 - Update - MAP - RLJ - 279162

DESCRIPTIVE INFORMATION

1. **Pick Barreled Action and inspect.**
   - No mars or scratches.
   - Legible proof, test, target stamps.

   Tighten Barreled Action in vise.
2. Insert Receiver Screw Washers in C'Bore on underside of Receiver.
3. Assemble Trigger Balance Pin and Spring to Trigger balance.

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION

Assemble Stock to Action.

OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
PART No.	925470	925471				
GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
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R2535563

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

4. Lubricate Trigger balance - See Illustration.

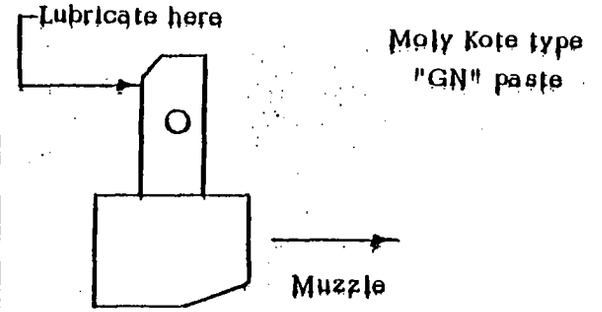
5. Select Stock Assembly and inspect:

   - Reasonably uniform medium lustre.
   - No splits, cracks or breaks.
   - No mars or scratches.
   - No missing parts.

6. Assemble Trigger balance sub-assembly to Stock:

   - Trigger balance must be installed correctly (See Illustration).

EQUIPMENT - TOOLS & GAGES



OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action.							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
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R2535564

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277801
5/21/79 - Added Bolt removal note - WAW - 277931
9/29/80 - Update - MHp - RCJ - 279162

DESCRIPTIVE INFORMATION

7. Assemble Stock Assembly to Action with forward and rear screws. **Bolt must be removed to expose rear screw.**

   - Trigger must be central in Trigger Guard. It must not touch at any point.
   - Receiver Tang must be fully seated in Stock at rear.
   - Safety must snap freely forward and rearward with no bind on Stock or Receiver.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action.							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Corrected number - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Perform trick test.

I. Cock Pistol

II. Move Safety Lever to "ON SAFE" position:

- There must be no bind,
- There must be a good, sharp single detent.
- In the "ON SAFE" position, the Safety must have an observable "spring back" from the fullest rearward and forward positions.

III. Pull Trigger:

- There must be no click or catch in pull.
- Firing pin must not fall.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION								
	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
Assemble Stock to Action,								
	PART No.							
	GA.							

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625

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R2535566

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Added item to V and corrected VIII - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont'd.

IV. Release Trigger Slowly;

- Trigger must move to full forward position when released.

V. Move Safety Lever to "OFF SAFE" position,

- Firing Pin must not fall.
- Pull Trigger, Firing Pin must fall,

VI. Re-cock Pistol

VII. Move Safety Lever from "OFF SAFE" position to the forward most null location. (Previously defined in Element #175, Page 24. Two fingers may be necessary to position Safety.),

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Assemble Stock to Action,	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
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R2535567

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont.

VIII. Pull Trigger Hard;

- There must be no click or catch in pull;

IX. Release Trigger slowly;

- Trigger must not bind,
- Trigger must move to full forward position when released,
- Firing Pin must not fall.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Assemble Stock to Action,	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625

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R2535568

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9729780 - Update - MRP - HLJ - 279162

DESCRIPTIVE INFORMATION

8. X. Push Safety Lever to "OFF SAFE" Position:

- Firing Pin must not fall.
- Safety Lever must spring to "OFF SAFE" position by itself when pushed from this null location.
- In the "OFF SAFE" position, the Safety must have an observable "spring back" from the fullest forward and rearward positions.

XI. Pull Trigger:

- Firing Pin must fall.

XII. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action,							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
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R2535569

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont.

XIII. Repeat Steps 7 thru 12 once.

FOR THE THIRD AND LAST TRIAL

XIV. Move Safety to "ON SAFE" position.

XV. From the "ON SAFE" position, move the Safety Lever to the forward most null location. (Previously defined Element 175, Page 24.)

XVI. Pull Trigger hard.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action.							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625

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R2535570

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD, ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont,

XVII. Release Trigger slowly;

- There must be no click or catch in pull,
- Trigger must not bind,
- Trigger must return to full forward position when released,
- Firing Pin must not fall,

XVIII. Push Safety Lever to "OFF SAFE" position,

- Firing Pin must not fall,
- Safety must spring to "OFF SAFE" position when pushed from the null location,

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Assemble Stock to Action,	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
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R2535571

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont.

XIX. Pull Trigger

- Firing Pin must fall.

XX. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Assemble Stock to Action,	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625

TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 10 OF 10

Form R. D. 6403

R2535572

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

See Sheets 2 thru 14 for Procedure

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Inspection							
	PART No.	925470	925471				
	GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 630

TYPE MACH. HRS. DEPT. No. 15 PAGE 1 OF 14

MACHINE

Form R. D. 6465

R2535573

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

I. Ammunition Inspection

Inspect Gun for live ammunition:

- Chamber must be empty and there must be no live ammunition present.

II. Receiver Roll Markings

Must be present, clear, distinct and visible above Stock.

Type	Location
• Remington - In Script	Left side, center.
• Model XP-100	Left side, below "Remington".
• Serial Number and alphabetic prefix	Left side, forward of above items.

III. Barrel Roll Markings

Must be present, clear, distinct and visible above side of Stock.

Type	Location
• Remington Arms Co., Inc. Ilion, New York Made in U.S.A.	Left side
• .221 Rem. Fireball	Left side, rear of above item.
• Des. 201, 366	Right side, toward rear,
• Pat. 3,255,545	Right side, below above item.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. DEPT. No. 15 PAGE 2 OF 14
MACHINE

Form R. D. 6466

R2535574

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

IV. Barrel Stamp Markings

Must be present, clear, distinct and visible above Stock.

Type	Location	Example
• Magnaflux mark	Right side, rear	▶
• Proof	Right side, near Barrel Bracket, above centerline of Barrel	REP
• Test and Target	Just forward of Proof Stamp	X
• Assembler	Left side, forward of Receiver, above centerline of Barrel	2

V. Bolt Markings

Must be present, clear and distinct.

Type	Location
• Bolt head pull test - Prick Punch	Right side Lug
• Proof mark - Prick Punch	Bottom of Bolt Handle
• Bolt Handle braze test - Prick Punch	Rear of Bolt Handle
• Magnaflux Bolt Assembly inspection - Prick Punch	Left side Lug
• Serial Number, must match Receiver, Last 4 digits	Bottom rear of Bolt body

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. MACHINE DEPT. No. 15 PAGE 3 OF 14

Form R D 6466

R2535575

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
2/26/80 - Added .221 Rem only - ZJK - 278589
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

VI. Barrel Finish

- Must be uniform, Black color, medium lustre finish - free of seams and stress marks,
- Muzzle crown must be reasonably smooth with no burrs, jams or deformation in bore,
- Bore must be concentric with muzzle O.D,

VII. Rib (.221 Rem. only)

- Barrel Rib, (Black Nylon), must present a reasonably uniform lustre, oiled, clean and free of breaks, splits, cracks or flashing,
- No bad scratches or abrasions,
- Rib tight to Barrel and screw slots not mutilated,
- Rib must conform to contour of Barrel full length. No excessive openings at sides,
- As viewed from rear, top of Rib must be straight and reasonably flat full length,

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. MACHINE DEPT. No. 15 PAGE 4 OF 14

Form R. D. 6466

R2535576

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
2/26/80 - Added .221 Rem. - ZJK - 278589
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

VIII. Sights

- Front sight screwed tightly to Barrel, central on Rib and parallel with line of sight - not bent, tipped or deformed, (.22) Rem. only)
- Rear Sight Ramp screwed tightly - reasonably central to Rib or Barrel
- Rear Sight Leaf reasonably central crosswise on ramp - set screw tight in position.
- Rear Sight Eye Piece - top approximately flush with top surface of Leaf - set screw tight.
- Rear Sight Assembly must be level, crosswise, with Front Sight and with line of sight, as viewed from rear - not tipped, twisted or bent.

IX. Receiver Finish

- All outside exposed surfaces must have a smooth, polished finish, uniform black in color, free of burrs, jams, or dents,
- Ejection port edges must not be sharp, chipped or marred,
- Receiver Plug Screws must be present in front (2) and top rear (1). Slots not mutilated,
- Gas escape hole must be present at front right side of Receiver and show a minimum of 1/2 of hole above Stock.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE MACH. HRS. DEPT. No. 15 PAGE 5 OF 14
MACHINE

Form R. D. 6466

R2535577

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9/29780 - Update - MRP - 279162

DESCRIPTIVE INFORMATION

X. Barrel and Receiver Fit

- Barrel, Barrel Bracket and Receiver must be tight at joint.
- Must be in alignment lengthwise.

XI. Stock Assembly

A. Stock and Trigger Guard

- Stock must present a reasonably uniform brown-grained medium lustre; clean and free of breaks, splits and cracks.
- Any dull spots must not sharply contrast.
- Slight acid marks (at sides of striations) permissible, but no blisters or bubbles.
- No bad scratches or abrasions.
- Trigger Guard must present good uniform black finish - not chipped or marred.
- Trigger Guard must fit well in Stock at sides and around ends.
- Molding mark inside guard must not be sharp - no protruding flash.
- Trigger opening clean, not broken through or chipped at edges.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 630
TYPE MACH. HRS. MACHINE DEPT. No. 15 PAGE 6 OF 14

Form R. D. 6468

R2535578

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9-29-80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XI. Stock Assembly - (Cont'd)

B. Striations

- Must be distinct, uniform and complete full length. Spacer and Grip Diamond not striated.

C. Checkering

- Must be distinct and good form - not abraded or flattened - complete on both sides of Grip.

D. Fore End Spacer and Tip

- Must be tight to Stock.
- Spacer must not be broken and must conform to contour of Stock and Tip.

E. Diamond Inserts

- Must be clean white in color and tight in Stock.
- Must be a good fit in cavities. No appreciable openings.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. DEPT. No. 15 PAGE 7 OF 14
MACHINE

R2535579

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
5/21/79 - Delete "Freq Float" test - WAW - 277931
9/29/80 - Update - MRP - BLJ - 279162

DESCRIPTIVE INFORMATION

XII. Stock Fit

A. To Receiver

- Receiver must fit tightly in Stock.
- Receiver Tang must seat fully in Stock at rear. It must not protrude beyond Stock at rear.
- Must be a good fit at both sides full length.

B. To Barrel

- Must show a reasonably uniform opening on both sides for full length forward of Barrel Bracket.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 630
TYPE Final Inspection MACH. HRS. DEPT. No. 15 PAGE 8 OF 14
MACHINE

Form H. D. 6166

R2535580

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9/29/00 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XIII. Bolt Assembly

- Bolt Plug and Firing Pin Head - Good smooth finish with uniform Black color.
- Bolt Handle, Bolt Body, Bolt Head have good smooth bright finish. No rust, excess braze, bad nicks or burrs. Rub marks on body are acceptable.
- Bottom "half ball" of "S" Bolt Handle - serrated with no burrs or sharp edges.
- Sear notch at front of Firing Pin Head - good smooth finish - no deep lines.
- Rear surfaces of Locking Lugs must be smooth - no deep lines.
- Gas escape hole must be present in bottom front.
- Bolt face must be smooth - no deep rings.
- Extreme front face of Bolt (shroud) must be smooth and flat.
- Extractor and rivet present - good claw - not broken or damaged.

Depress Ejector with hand punch and release:

- Must depress at least flush with Bolt face and return to forward position freely under spring tension
- Must be retained by Ejector Pin.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER No. 630
TYPE Final Inspection MACH. HRS. MACHINE DEPT. No. 15 PAGE 9 OF 14

Form R.D. 0406

R2535581

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
5/21/79 - Added to element XVI - WAW - 277931
2/26/80 - Added Gages - ZJK - 278589
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XIV. Heading

Cock Pistol. Place Heading Plug into Chamber. Move Bolt to forward position and rotate clockwise.

Do not use excessive force.

A. On Min. Plug B-85239 - .221 Rem.
B-45160 - 7MM BR Rem.
- Bolt must fully close.

B. On Max. Plug B-85240 - .221 Rem.
B-45161 - 7MM BR Rem.
- Bolt must not fully close.

XV. Function

With dummy cartridges, check for proper feeding, extraction and ejection.

XVI. Trigger Pull

MEASURE pull with spring scale:

- Gun must fire with 1 1/2 to 2 3/4 lbs. force.
- Trigger must be central in Trigger Guard. It must not touch at any point. Adjust if necessary.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 630
TYPE Final Inspection MACH. HRS. MACHINE DEPT. No. 15 PAGE 10 OF 14

Form R. D. 6466

R2535582

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
5/21/79 - Add to element 5 - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XVII. Perform Trick Test

1. Cock Pistol

2. Move Safety Lever to "ON SAFE" position;

   - There must be no bind.
   - There must be a good, sharp single detent.
   - In the "ON SAFE" position, the Safety must have an observable "spring back" from the fullest rearward and forward positions.

3. Pull Trigger

   - There must be no click or catch in pull.
   - Firing Pin must not fall.

4. Release Trigger slowly;

   - Trigger must move to full forward position when released.

5. Move Safety Lever to "OFF SAFE" position;

   - Firing Pin must not fall
   - Pull Trigger, Firing Pin must fall.

6. Re-cock Pistol

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. DEPT. No. 15 PAGE 11 OF 14
MACHINE

Form R D 6468

R2535583

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9/29780 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

7. Move Safety Lever from "OFF SAFE" position to the forward most null location (Two fingers may be necessary to position Safety).

   DEFINITION; Forward Most Null Location

   Is that "Just Stable" place, between "ON" and "OFF" Safe, closest to "OFF SAFE", where the Safety Lever will not spring forward to the "OFF SAFE" position when released.

8. Pull Trigger Hard;

   - There must be no click or catch in pull.

9. Release Trigger slowly:

   - Trigger must not bind.
   - Trigger must move to full forward position when released.
   - Firing Pin must not fall.

10. Push Safety Lever to "OFF SAFE" position:

    - Firing Pin must not fall.
    - Safety Lever must spring to "OFF SAFE" position by itself when pushed from the null position.
    - In the "OFF SAFE" position, the Safety must have an observable "spring back" from the fullest forward and rearward positions.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. DEPT. No. 15 PAGE 12 OF 14
MACHINE

Form R D 6166

R2535584

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
5/21/79 - Chg. wording in item XIX - WAW - 277931
9/29/80 - Update - MHP - RLJ - 279162

DESCRIPTIVE INFORMATION

XVII. Trick Test - (Cont'd)

18. Push Safety Lever to "OFF SAFE" position:

- Firing Pin must not fall.
- Safety must spring to "OFF SAFE" position when pushed from the null location.

19. Pull Trigger:

- Firing Pin must fall.

20. Open Action and close Bolt forcibly to re-cock.

- Firing Pin must not fall.

XIX. Stamp Receiver

If pistol meets all inspection requirements, stamp Assembler's mark and date code stamp on left rear side of Receiver.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 630
TYPE Final Inspection MACH. HRS. DEPT. No. 15 PAGE 14 OF 14
MACHINE

Form R. D. 6466

R2535585

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/15/79 - Revised - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XVII. Trick Test Cont.

11. Pull Trigger:

- Firing Pin must fall,

12. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall,

13. Repeat Steps 7 thru 12 once.

FOR THE THIRD AND IAST TRIAL

14. Move Safety to "ON SAFE" position,

15. From the "ON SAFE" position, move the Safety Lever to the forward most null location.

16. Pull Trigger hard

17. Release Trigger slowly

- There must be no click or catch in pull.
- Trigger must not bind,
- Trigger must return to full forward position when released.
- Firing Pin must not fall.

IL014 00321

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No 630
TYPE Final Inspection MACH. HRS. MACHINE DEPT. No. 15 PAGE 13 OF 14

Form R. D. 6406

R2535586

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

27

DATES AND REASONS FOR REVISIONS 6/13/61 - New Part - AJW - 256249 8/26/75 - Add bushings - Wrigley - 274224
4/1/63 - A.U. - 40XB - 258319 - Marley 7/13/79 - Chg. C-54661 to C-TS-7043 & add A-TS-7044 - DRL - 277994
8/27/64 - Correct reamer size - AJW - 260226 5/2/80 - Add deviation - DRL - 278800
4/27/65 - Chg. dept. # - FB - 261459 - 7/7/80 - Chg. Exp. date - DRL - 278800
8/27/70 - Chg. dept/ # - Power - 268985 11/2/80 - Revised for APPROVAL AND DATES MRP - RLS - 279423

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL			
		Jig	C-TS-7043			
		Bushing F-20-0T (.1200 ID)	Std.			
		Drill #31 (.120 Dia.)	Std.			
		Bushing	C-54661-A			
		Reamer (.1263)	RS-4			
		Plug Ga.	B-80154D			
		Pos. Ga. Deviation Tol. ± .0015	B-50317			NOTE: Place Trigger on Pin - Push in F.P. Block - Check Dial and flush pin
		Checking Fixture (Master)	A-TS-7044			

OPERATION DESCRIPTION	PART NO.	15280
Drill and Ream Trigger Pin hole Exp. 10/1/80		

Rejected

PART NAME Trigger COOLANT SET UP TIME MODEL No 700 -40XB OPER. No 28
TYPE Powder Metal MACHINE Drill Press DEPT. No 02 PAGE 1 OF 1

POWDER METAL.

R2535587

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #12 except as circled.

3. Adjust Sear/Connector Engagement (.015-.020) to correct comparator screen line, by turning Trigger Engagement Screw slowly clock-wise (to reduce engagement).

(Install lock screw and tighten firmly.)

After correctly adjusting Sear/Connector Engagement:

4. Hang dead weight assembly to end of Trigger.

5. Adjust Trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires)

(Install lock screw and tighten firmly.)

EQUIPMENT—TOOLS & GAGES

Comparator fixture dead weight - 4 lbs. (M/700 only)

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator 100%. Australian Version	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
For info only, not part of process							
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No.

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6468

R2535588

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #12 except as circled.

9. Remove Trigger Sub-Assembly from comparator fixture.

10. Seal Trigger Engagement Screw Lock Screw and Trigger Stop Screw only. Do not seal Trigger Screw Lock Screw front.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator 100%. Australian Version. For info only, not part of process	OCC. No.						
	STD. HRS/C						
	STD. NO.						
	EFF. DATE						
	PART NO.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No.

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6461

R2535589

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

NOTE: Operation is same as #10 except as circled.

Install:

- Same Connector as fitted to Trigger (Op. #8)
- Trigger Stop Screw - (Leave alone - oil)
- Trigger Spring
- Trigger Adjusting Screw (Well below flush with hole) (There must be adequate spring force on Connector while adjusting Trigger Engagement Screw).
- Trigger Engagement Screw (Well below flush with hole.)

EQUIPMENT—TOOLS & GAGES

See Page 1 for Australian substitution.

See Page 1 for Australian substitution.

OPERATION DESCRIPTION							
Assemble Trigger Sub-Assembly Stage one. Australian version. For info only, not part of process	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No.

TYPE MACH. HRS DEPT. No. 61 PAGE 1 OF 1

MACHINE

Form R.D. 8443

R2535590

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 7/28/78 - Added oper. #2 - JAA - 277039
11/3/80 - Revised for MRP - RLS - 279426

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED
Media: 1-1/8" Stars			
Compound: 501X or 19D (1 lb.)			
Add parts (1000 pcs.)			
Add water approx. 3" below media			
Time: 30 minutes			
Separate parts from media and oil.			

OPERATION DESCRIPTION	PART NO.	14630
Supersheen		

PART NAME Trigger Housing Spacer, Front COOLANT _____ SET UP TIME _____ MODEL No. 700 OPER. No 2
TYPE _____ MACHINE Sweco DEPT No. 79 PAGE 1 OF 1

R2535591

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

7

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 7/28/78 - New - JAA - 277038
11/3/80 - Revised for MRP - RLS - 279427

TOOLS, GAGES AND EQUIPMENT:	GA. OR CAL.	SPEED	FEED	APPROVAL AND DATES
Media: 1-1/8" Stars				
Compound: 501X or 19D (1 lb.)				
Add parts (1000 pcs.)				
Add water approx. 3" below media				
Time: 30 minutes				
Separate from media and oil				

OPERATION DESCRIPTION	PART NO. 14631
Supersheen	

PART NAME Trigger housing Spacer, Rear COOLANT SET UP TIME MODEL No. 700-40XR OPER No. 2
TYPE MACHINE Sweco DEPT No. 79 PAGE 1 OF 1

R2535592

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 9/21/65 - New - Kosler - 262114
4/19/68 - Add spot weld data - GES - 266143 -
3/20/70 - Added note - Bower - 268581 -
7/24/72 - Chg. fixture no1 and added pt. no. 32900 - LBB - 270975
11/3/80 - Revised for MRP - RLS - 279420

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
		Machine Serial No.	28908						
		Fixture	C-36311						
		Upper Electrode	R2-569						
		Lower Electrode	A-88049 *						* NOTE: Dept. 26 to reface electrode when necessary.
		Pressure - Gage (PSI)	44						
		Tap	P.8						
		Squeeze - Cycles	60 (1 inch between Electrodes)						
		Hold - Cycles	40						
		Off - Cycles	20						
		Weld - Cycles	3						
		Weld Heat Control - %	80%						
		Temper	Off						

OPERATION DESCRIPTION	PART NO.	26585	32900
Degrease Safety and Projection weld Safety Button to Safety			

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. 40XB-700 - 700 IH OPER. No. 10
TYPE EB-3-8-10 MACHINE Taylor - Winfield Welder DEPT. No. 79 PAGE 1 OF 1

BD 8461

R2535593

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

20

DATES AND REASONS FOR REVISIONS 3/9/74 - Revised - Bower - 272873
3/31/76 - Chg. 41 to 26 - Wrisley - 274817
11/3/80 - Revised for MRP - RLS - 279423

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
	MEDIA: #1-J Star Aluminum Oxide	
	CYCLE TIME: 2 hrs.	
	NO. PCS. - 500/compartment	
	COMPOUND: 19D (6 oz.)	
	Run for 2 hrs. in water media, and compound. Rinse thoroughly. Run in Immunol for 5 min. Rinse thoroughly. SEPARATE PARTS FROM MEDIA AND OIL.	

OPERATION DESCRIPTION	PART NO.
	15820
Supersheen (To deburr)	

PART NAME Trigger COOLANT SET UP TIME MODEL No. 700 & 40XB OPER. No. 26

TYPE MACHINE DB-2020 DEPT. No. 79 PAGE 1 OF 1

RD-6401

R2535594

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

71

DATES AND REASONS FOR REVISIONS 6/13/61 - New Part - AJW - 256249
4/1/63 - A.U. 40XB - 258319
11/3/80 - Revised for MRP - RLS - 279423

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED

OPERATION DESCRIPTION	PART NO.
Black Oxide	15280

PART NAME Trigger COOLANT SET UP TIME MODEL NO. 700 - 40XB OPER NO. 44
TYPE Powder Metal MACHINE DEPT. No. 79 PAGE 1 OF 1

ND 6441 POWDER METAL

R2535595

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 1650° 3½ hrs. .90C potential

MAXIMUM LOAD 2,000 pcs.

TIME 4 hours total furnace time

QUENCH Oil

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS Clean, free of oil and soot.

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 11/3/80 - Retyped from 278958 - CC 11/3/80 - Revised for MRP - FRW - 279397 APPROVAL AND DATES					
Micro-Carb Harden	GA. OR CAL.					
	PART No.					
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
	OF STD. OF STD.					
		91470				

PART NAME Sear Safety Cam EQUIPMENT MODEL No. Moh. 600 OPER. 45

Powder Metal DEPT. No. 51 PAGE 1 OF 1

RD-6464

R2535596

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 1650° 3½ hrs. .90C potential

MAXIMUM LOAD 2,000 pcs.

TIME 4 hours total furnace time

QUENCH Oil

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS Clean, free of oil and soot.

NEW - RLS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS ~~11/2/00 Retyped from 278958 GG~~ ~~11/3/00 Revised for MRP PRN - 279397~~ APPROVAL AND DATES						
	GA. OR CAL.						
Micro-Carb Harden	PART No.	WIP 92800					
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE OF STD.						
	OF STD.	~~01170~~					

PART NAME Sear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. Moh. 600 OPER 45

DEPT. No. 8551 PAGE 1 OF 1

RD-6464

R2535597

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 400° F

MAXIMUM LOAD

TIME 1 hour

QUENCH

REMARKS

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard R_a 50 Min.

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS NEW-RLS
Lindberg Draw.	APPROVAL AND DATES
~~Inspect for Rockwell hardness.~~	GA. OR CAL.
	PART No. WIP #92800
	OCC. No.
	STD. HRS/C
	STD. No.
	EFF. DATE
	OF STD. ~~01470~~

PART NAME Sear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. Moh. 600 OPER. 50-~~55~~

DEPT. No. 8551 PAGE 1 OF 1

BD 6464

R2535598

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – HE TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 400° F

MAXIMUM LOAD

TIME 1 hour

QUENCH

REMARKS

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard R_a 50 Min.

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS NEW-RLS	APPROVAL AND DATES					
~~Lindberg Draw.~~	GA. OR CAL.						
Inspect for Rockwell hardness.	PART No.	WIP # 92800					
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE OF STD. or etc.	~~01470~~					

PART NAME Sear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. Moh. 600 OPER. ~~30~~ 55

DEPT. No. ~~51~~ 9257 PAGE 1 OF 1

R2535599

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/14/79 - New - JAA - 277904
9/29/80-UPDATE-MRP-RLS-279172
11/3/80 - Revised for MRP - FRW - 279397

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
	Time - 1 Hr.	
	Pcs. - 1000	

OPERATION DESCRIPTION	PART NO.
	91470
Sand Tumble	

600

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. OPER. No. 56

TYPE MACHINE Open Barrel DEPT. No. 79 PAGE 1 OF 1

R2535600

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS ~~5/11/79 - New - RLS - 277004~~
~~9/30/80 - UPDATE MRP RLS 279178~~
~~11/3/80 - Revised for MRP - RLS - 279397~~
NEW - RLS

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
	Time - 1 Hr.	
	Pcs. - 1000	
OPERATION DESCRIPTION	PART NO.	
	WIP# 92800	
	~~92470~~	
Sand Tumble		
		600

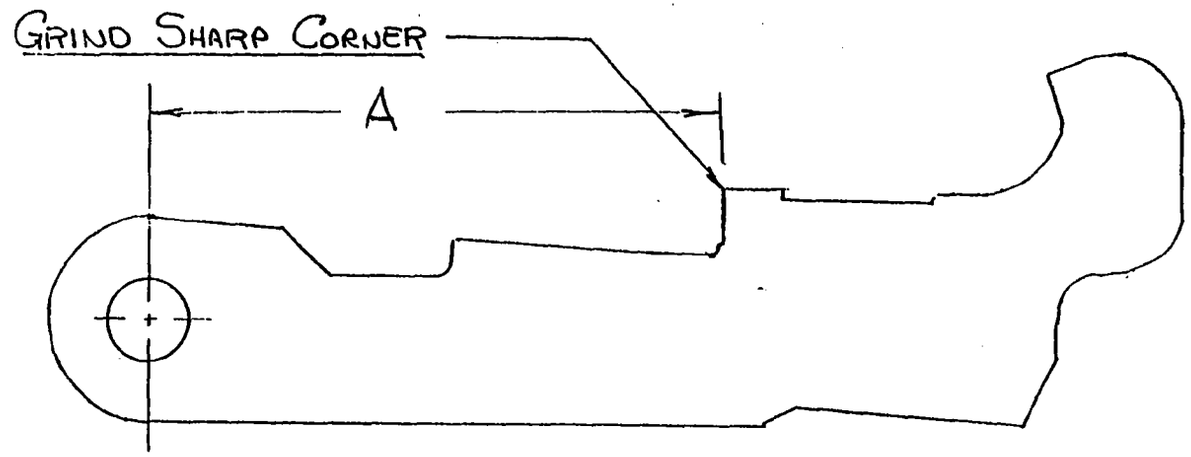
PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No OPER No. 56
TYPE MACHINE Open Barrel DEPT No 8579 PAGE 1 OF 1

R2535601

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 12/16/77 - New - JAA - 276326
12/28/77 - Add Moh. 600 - SB - 276514
2/14/79 - Add XP-100 - PRG - 277609
11/3/80 - Revised for MRP - FRW - 279397

DESCRIPTIVE INFORMATION



PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL NO. Moh. 600 OPER. NO. 62
TYPE MACH. HRS. DEPT. NO. 67 PAGE 1 OF 1
MACHINE

Form R. D. 6466

R2535602

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES_ RECORDS

DATES AND REASONS FOR REVISIONS 11/3/80 - Retyped from 277609 - CC
11/3/80 - Revised for MRP - FRW - 279397

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Grinding Fixture	B-41453	
Norton Wheel (White Saucer) 6" x 7/16" x 1¼" #38A100 M8VBE	Std.	
Gage A- .870 - .866	C-44133	
6° Wheel Dresser	D-44410	

OPERATION DESCRIPTION	PART NO.
Grind Connector Surface	91470

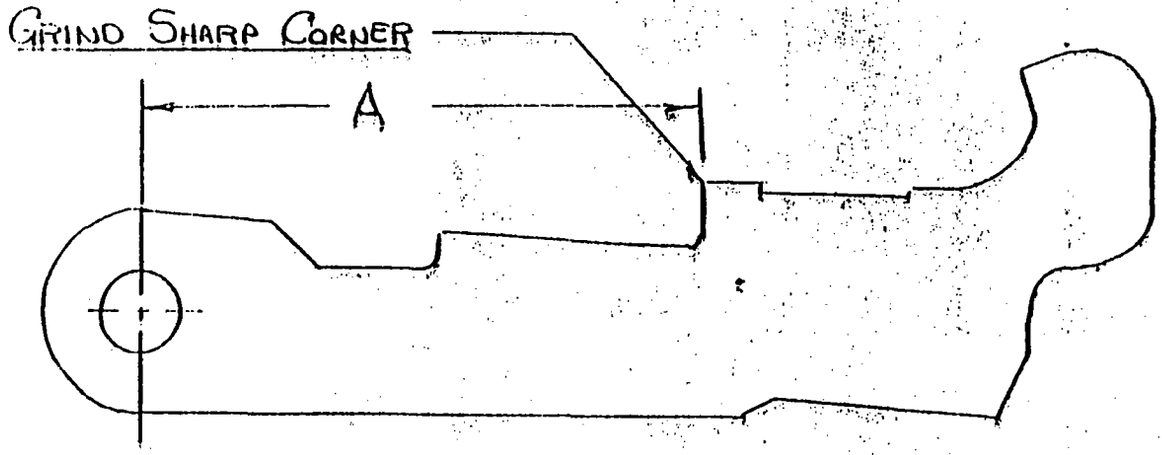
PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 62
TYPE MACHINE DEPT. No. 67 PAGE 1 OF 1

R2535603

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES & REASONS FOR REVISIONS ~~12/16/77 - New - JAA - 27630~~
~~12/20/77 - Add Mch. 600 - SB - 276514~~
~~2/14/79 - Add XP 100 - PRG - 277609~~
~~11/3/80 - Revised for MRP - PRW - 279397~~
NEW - RLS

DESCRIPTIVE INFORMATION



PART NAME Gear Safety Cam COOLANT SET UP TIME MODEL NO. Mch. 600 OPER. NO. 62
TYPE MACH. HRS. DEPT. NO. 8567 PAGE 1 OF X2
MACHINE

Form R. D. 6366

R2535604

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS ~~11/3/80 - Retyped from 277009 - CC~~
~~11/3/80 - Revised for MRP - FRW - 279307~~
NEW-RLS

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Grinding Fixture	B-41453	
Norton Wheel (White Saucer) 6" x 7/16" x 1¼" #38A100 M8VBE	Std.	
Gage A= .870 - .866	C-44133	
6° Wheel Dresser	D-44410	

OPERATION DESCRIPTION	PART NO.	
Grind Connector Surface	91470	

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 62

TYPE MACHINE DEPT No. 8567 PAGE X 2 OF X 2

R2535605

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

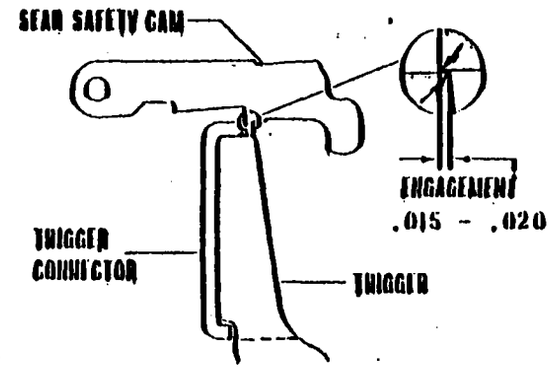
DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

1. Pick Trigger Sub-Assembly. Position in comparator fixture and clamp:
   - Housing must properly contact all locators,
   - Top of Housing must be flat on fixture,
   - Push with thumb on rear of Trigger (toward left). This seats Trigger firmly against end of Trigger Adjusting Screw.
2. Adjust fixture to locate Sear on "set" line of comparator screen.

EQUIPMENT—TOOLS & GAGES

Comparator Fixture B-42271
Comparator Screen A-600-C1.25



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Trigger Assembly on Comparator 100%							
	PART No.	26345	32895				
	GA.	RH	LH				

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 155
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE Jones & Lamson Comparator TC-10

R2535606

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

3. Adjust Sear/Connector engagement (.015 - .020), to correct comparator screen line, by turning Trigger Engagement Screw slowly clockwise (to reduce engagement).

   NOTE: Australian guns only; Install lock screw and tighten firmly.

   After correctly adjusting Sear/Connector Engagement;

4. Hang dead weight assembly to end of Trigger.

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).

   NOTE: Australian guns only: Install lock screw and tighten firmly.

EQUIPMENT—TOOLS & GAGES

Comparator fixture dead weight - 4 lbs. (M/700 only).

OPERATION DESCRIPTION							
Adjust Trigger Assembly on Comparator 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 155

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R. D. 6461

R2535607

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

6. Re-adjust fixture to locate Sear on "Set Line" of comparator Screen.

7. Remove dead weight assembly from Trigger.

8. Hold Trigger in fired position firmly with finger, and:
   - Set over-Travel by turning Trigger Stop Screw slowly clockwise, until Trigger Connector touches correct line on comparator screen.

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
Adjust Trigger Assembly on Comparator 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME: Trigger Assembly — COOLANT — SET UP TIME — MODEL No. 700 — OPER. No. 155

TYPE — MACH. HRS. — DEPT. No. 61 — PAGE 3 OF 4

MACHINE: Jones & Lamson Comparator TC-10

Form R. D. 6465

R2535608

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: 11/3/80-Revised MRP-RLJ-279453

DESCRIPTIVE INFORMATION

9. Remove Trigger Sub-Assembly from comparator fixture.

10. Seal all three screws with "Duco" Cement, including screw slots.

NOTE: For Australian Guns only:

- Seal Trigger Engagement Screw Lock Screw and Trigger Stop Screw Only. Do not seal Trigger Screw Lock Screw Front.

EQUIPMENT—TOOLS & GAGES

NOTE:
Realign Lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light Beam from condensing lens to projection lens must be parallel.
Adjust as required.
Refer to Page 7 of J&L Operating Manual.

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Trigger Assembly on Comparator 100%							
	PART No.						
	GA.						

PART NAME: Trigger Assembly — COOLANT — SET UP TIME — MODEL No. 700 — OPER. No. 155

TYPE — MACH. HRS. — DEPT. No. 61 — PAGE 4 OF 4

MACHINE: Jones & Lamson Comparator TC-10

Form R. D. 6461

R2535609

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

NOTE: Do All Elements 100%

1. Put Safety in "OFF SAFE" position.
   Check for:

   Trigger Retraction
   Pull Trigger and release:
   - Trigger and Connector must return freely to original position with spring force.

   Sear Freedom
   Pull Trigger and hold. Depress Sear fully and release:
   - Sear must move freely in housing without binding. The Sear must return fully upward under Sear Spring Force.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check completed Trigger Assembly 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	26345	32895				
	GA.	RH	LH				

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 165

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 3

MACHINE

Form R. D. 6465

R2535610

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

2. Operation of Safe

Push Safety Thumb Piece fully forward beyond detent position:

- Safety must spring-return rearward to detent position.

Push Safety Thumb Piece fully rearward beyond detent position:

- Safety must spring-return forward to detent position.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check completed Trigger Assembly 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 165

TYPE MACH. HRS. MACHINE DEPT. No. 61 PAGE 2 OF 3

Form R. D. 6465

R2535611

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
2/19/82 - Remove bolt lock arm - SB - 281143

DESCRIPTIVE INFORMATION

Move Safety from "on Safe" to "Off Safe" position and back. Do this twice:

- Safety must spring forward into "Off Safe" position when pushed.
- There must be no hang-up or hesitation between detent positions.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check Complete Trigger Assembly 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 165
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 3
MACHINE

Form R. D. 6465

R2535612

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

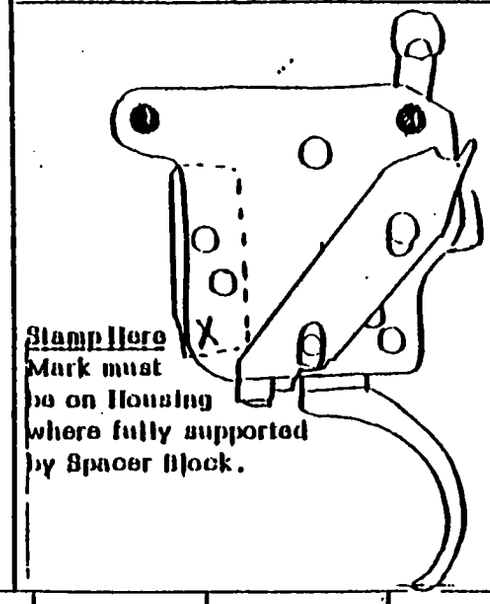
PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

1. Locate Trigger Assembly on stamping fixture.
2. Stamp lower left front corner (as shown) with correct assembler identification.
   - Use 1/16" size character

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION	OCC. No.						
Mark correctly assembled, adjusted and checked Trigger Assembly, with assembler's identification	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	26345	32895				
	GA.	RH	LH				

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 170

TYPE MACH. HRS. DEPT, No. 61 PAGE 1 OF 1

MACHINE

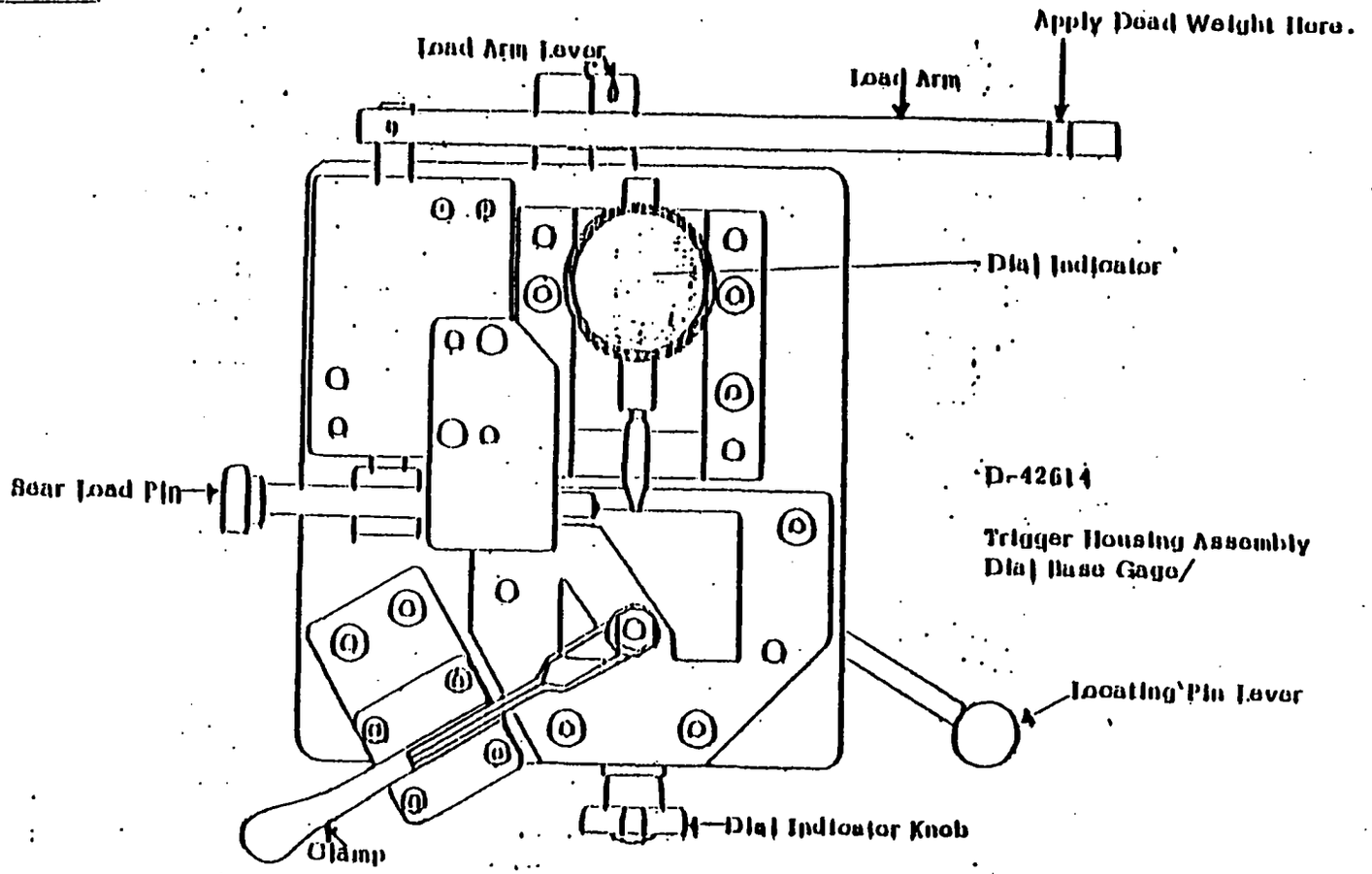
Form R. D. 6163

R2535613

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION



PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 175R

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1.

MACHINE

Form R. D. 6466

R2535614

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453

DESCRIPTIVE INFORMATION

NOTE:
Each repair Trigger Assembly is to go to Assembler who originally built it.

1. Make corrections as required.

2. Return Trigger Assembly to process at point where it will again receive all applicable adjustments and function checks.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Repair Rejected Trigger Assemblies.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	26345	32895				
	GA.	RII	LII				

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 175R

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

Form R. D. 6469

R2535615

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

Assemble Magazine Spacer to Magazine

EQUIPMENT—TOOLS & GAGES

003169

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Spacer	Grade	ADL	BDL	BDL	Varmint	Varmint	
(222 - .223 Rem. .17 Rem.)	Cal	222	17	222	222	223	
	Ramac	925760	925801	925701	925821	925825	
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL, 700 BDL OPER. No 560

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535616

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS .SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

1. Pick correct Stock.
   a. Inspect for good finish, mars slight, no checks. Grip outline reasonably uniform and square.
   b. Butt Plate black, rear face. No burrs, .005 max. opening at face, tight (finger test), screws not project badly, burrs at screw holes slight, .02 max. mismatch of Butt Plate and Stock either way.
2. Position Stock on Action.
3. Pick Trigger Guard, inspect for no sharp edges, color, mars or pits and position in Stock.
4. Pick front, center and rear Trigger Guard Screws, inspect for color, slot, threads and position in holes.
5. Tighten Trigger Guard Screws.
   a. Check wood margin at Ejection Port and at Receiver tang per sample. Opening between Stock and Receiver uniform, no bad chipping. Barrel must seat within 1.5" of front of Stock, vertical squeeze, no movement Guard Screws tight. .020 max. opening under Trigger Plate except at corners, .025 max. opening under Trigger Plate except at corners, .025 max. with Stock.
   b. Gas hole in Receiver 50% visible above Stock.
   c. At least half of side screws visible above Stock.
   d. Assemble Magazine Spring to Matazine Follower and assemble to Magazine.
   e. Check for Trigger clearance in Guard - .010 shim must go, both sides, disassemble and file Trigger Guard if necessary.

003170

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
Assemble Stock to Action	STD. No.						
	EFF. DATE						
(ADL)	Cal	222	22-250	6MM	243	25-06	270
	Ramac	925760	925762	925764	925766	925768	025770
	Cal	7MM EXP	30-06	308	7MM MAG		
	Ramac	925778	925772	925774	925776		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 565

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

MACHINE

R2535617

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

6. Turn Action in Vise.

7. Check Safety - No bind, clears wood.

8. Check Bolt - No bind, clears wood.

9. Check Trigger pull (3 to 5 lbs.) Scales B-70697

10. Use dummy Cartridges to check feeding.
Extraction and Ejection (Single load and full Magazine)
a. Adjust if necessary.

11. Stamp assemblers number on left side of Barrel rear.

12. Pick correct ticket and fill in rifle number etc.

13. Make all necessary repairs from test.

NOTE: Insert wiping rod in chamber end. Rod must have sufficient flannel to clean Bore. Wiping Rod # 43447 Brass

003171

PART NAME Final Assembly COOLANT SET UP TIME MODEL No 700 ADL OPER. No 565

TYPE MACH. HRS. DEPT. No 61 PAGE 2 OF 2

MACHINE

R2535618

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279174

DESCRIPTIVE INFORMATION	EQUIPMENT - TOOLS & GAGES
Same as Operation 575.	Same as Operation 575,

003179

OPERATION DESCRIPTION	OCC. No.	222	22-250	223	6MM	243	25-06
	STD. HRS/C	925821	925823	925825	925827	925829	925831
	STD. No.	7MM-08	308				
Assemble Action (Varmint)	EFF. DATE	925835	925833				
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 Varmint OPER. No. 590

TYPE MACHINE HRS. DEPT. No. 61 PAGE 1 OF 1

R2535619

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

1. Get, inspect and assemble front scope base with (2) scope base screws.
2. Get, inspect and assemble rear scope base with (2) scope base screws.
3. Assemble (4) Receiver plug screws.

EQUIPMENT—TOOLS & GAGES

003180

OPERATION DESCRIPTION	OCC. No.	222	22-250	223	6MM	243	25-06
	STD. HRS/C	925821	925823	925825	925827	925829	925831
	STD. No.	7MM-08	308				
Assemble scope base, front and rear and (4) Receiver plug screws. (Varmint)	EFF. DATE	925835	925833				
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 Varmint OPER. No. 592

TYPE MACHINE HRS. DEPT. No. 61 PAGE 1 1

R2535620

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

Same as operation 585.

EQUIPMENT—TOOLS & GAGES

003181

OPERATION DESCRIPTION	OCC. No.	222	22-250	223	6MM	243	25-06
	STD. HRS/C	925821	925823	925825	925827	925829	925831
	STD. No.	7MM-08	308				
Assemble Stock to Action	EFF. DATE	925835	925833				
(Varmint)							
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 Varmint OPER. No. 595

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535621

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS . . MBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

See Following Procedure

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Inspection ADL	OCC. No.						
	STD. HRS/C	All ADL Excluding Magnum					
	STD. No.						
	EFF. DATE						
		222	22-250	6MM	243	25-06	270
		925760	925762	925764	925766	925768	925770
		7MM EXP	30-06	308			
		925778	925772	925774			
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 635

TYPE MACH. HRS. DEPT. No. 55 PAGE 1 OF 5

MACHINE

R2535622

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

1. Safety
2. Stamps
3. Specifications
4. Gun Grades
5. Stock
6. Metal Parts, Finish
7. Reading
8. Safe
9. Stamp Final Inspection and code marks.

TO WAREHOUSE

PART NAME Final Assembly COOLANT SET UP MODEL NO. 700ADL OPER. NO. 635

TYPE Oper. Name-Final Inspection MACH. HRS. DEPT. No. 55 PAGE 2 OF 5

Sequence of Inspection Points (See Following) MACHINE

R2535623

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

Item:

1. Safety
   Inspect chamber and Magazine for NO LIVE AMMUNITION. Must see follower.

2. Stamps on Barrel
   Proof (Rep) (Important) and Test and Target Stamps on right side, rear.
   Magnaflux - Triangle with number in center on right side of Breech - Visible above stock.

3. Specifications

   Gun matches gun tag.

   Receiver Marking:

   Remington Model and Serial No., on left side.
   Model No. must be recognizable.

   Barrel Marking:

   Patent and Cal. on left side.
   (Cal. per gun tag)

   Bolt Marking: (Disassemble Bolt) Check Bolt Release, must be free. Check serial number - Must agree with Receiver number. Check for mars, finish - Brass in Bolt Head, Proof mark, underside of Bolt Handle. Check for Extractor in position. Only Extractor claw should be visible.

4. Gun Grades:

   ADL & BDL
   For other grades, see specification book.

5. Stock

   Mars slight, no checks.
   (continued next page)

PART NAME Final Assembly COOLANT SET UP TIME MODEL NO. 700ADL OPER NO 635

TYPE Oper. Insp - Final Inspection MACH. HRS. MACHINE DEPT. No. 55 PAGE 3 OF 5

R2535624

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New For MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

Trigger Guard Screws tight.

Assemble correct Rear Swivel if specified on gun tag.

Assemble Rear Telescope Mount with two Telescope Base Screws, 700 Varmint.

6. Front Sight Bead not jammed, Sights must be central,
Slight mars per Inspection Stds.
Crown good finish. Accept 1/16" light ring at bore. Uniform wall, No jams in bore at muzzle.

7. Min. and Max. heading plugs.

1. Insert Min. Plug in chamber, must close with no more than slight drag.

2. Insert Max. plug in chamber, Bolt must stand or lock with noticable pressure,

CAL.	MIN. PLUG	MAX. PLUG	CAL.	MIN. PLUG	MAX. PLUG
300 Win. Mag. (Shoulder)	B-06567	B-06568	222 Mag.	B-82433	B-83175
300 Win. Mag. C'bore	B-83053A	B-830530	264 Mag.) Shoulder	B-85241	B-85242
30-06)	B-73438	B-82327	7MM Mag.)		
270) (25-06)			C'bore	B-83053A	B-83053C
280	B-81578	B-82329	35 Rem.	B-TS-4333	B-84290
308	B-81229	B-82341	350 Rem.Mag.		
6mm	B-81268	B-82325	Shoulder	B-87369	B-87360
243	B-81229	B-82341	C'bore	B-87367A	B-87367C
222	B-81544	B-82320	22-250 Rem.	B-87465	B-87460
223	B-86081	B-86083	6.5MM Magnum shoulder	B-87369	B-87368
			.17 Rem.	B-30112	B-30113
			8MM Rem. Mag. Shoulder	B-43090-A	B-43090-B
			C'Bore	B-43099-A	B-43099-C

Remove Heading Plug

3. With Action in fired position, Lift Bolt while pressing foreward firmly, release handle, then close handle, Bolt must stay cocked.

4. Hold Bolt handle down hard - pull Trigger - Firing Pin must fall without drag or movement of Bolt Handle.

PART NAME Final Assembly COOLANT SET UP TIME MODEL NO. OPER NO 635

TYPE MACH. HRS. MACHINE DEPT. No. 55 PAGE 4 OF 5

R2535625

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
2/26/82 - Chg. process for new safe W/O anti-open arm - RLJ - 281152
3/29/82 - Removed Element #10 (Screwdriver Test); New Element 10 was 11 - RLJ - 281189

DESCRIPTIVE INFORMATION

8. Action:

1. Operate Bolt 3 times and fire, no bind, Bolt Handle raises and lowers easily.
2. Open and close Bolt forcibly 3 times. Trigger must not follow down.
3. Check for jar off by steady pressure on end of Firing Pin head, when rifle is cocked, with Safety in off position (Use end of Hammer Handle)

9. Safe, Gun cocked.

Clean sharp single detent.
Try Three Times: "On" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety halway off, pull Trigger, Must not fire. Push Safety to OFF position, Firing Pin must not follow down, Safety must return to OFF position under tension. Use downward pressure on Safety.
Bolt Handle must unlock with safety on.
Safety should snap in Detent in both "On" and "Off" position.
Check Trigger Pull - No creep (4 to 6 lbs. on M/660) Mohawk 600)
(3 to 5 lbs. on M/700)
With Bolt open, pull safety on, close Bolt & lock down. Bolt must lock down without catching on safety. Bolt must open with safety on.

10. Stamp Final Inspection and Code Marks on Left Side of Barrel, Rear sign gun tag.

To Warehouse

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700ADL OPER No. 633
TYPE MACH. HRS. DEPT. No. 55 PAGE 5 OF 5
MACHINE

Form R. D. 6466

R2535626

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 2/20/80 - New - DRL - 278580
11/3/80 - Revised for MRP - JAA - 279398
12/15/80 - ADDED DIAL GAGE - DRL.

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
2268	Hand	#42 Drill (.0935)	Std.						
		Geometric Die	D-85800A						
		Fixture	E-89082	(Fixture D-52025 can be used if necessary)					
		Chuck	Std.						
		NOTE:	Compress Assembly in fixture - Drill Firing Pin Cross Pin Hole. Drive in Firing Pin Cross Pin, insert "U" Spacer and remove from fixture.						
		DRAW FROM PART STORES:							
			22040	22041					
		Bolt Plug	17012	17012					
		Firing Pin	22020	22021					
		Firing Pin Cross Pin	17022	17022					
		Firing Pin Head	23320	23320					
		Main Spring	17029	17058					
		DIAL GAGE	D-45537	D-45537					
			NOTE:						

OPERATION DESCRIPTION	PART NO.	
Assemble Firing Pin, Main Spring, Bolt Plug and Firing Pin Head.		1. Use scrap material from M/510 safety for "U" Spacer to hold Firing Pin Head out of Bolt Head. 2. Use cloth pad under Bolt Plug before drilling to prevent marring.

PART NAME Firing Pin Assembly COOLANT Lard Oil SET UP TIME MODEL No. 700 OPER. No. 120
TYPE MACHINE Delta Drill Press DEPT. No. 75 PAGE 1 OF 1

R2535627

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

I. H/A-1

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. 150 - RLS - 279887

DESCRIPTIVE INFORMATION

NOTE: Do all elements 100%.

1. Inspect long inside Connector surface, and inside surface of long (top) leg for flatness.

   Hold Connector against flatness block with light finger pressure:

   - If no light shows between inside surfaces of back and long leg of Connector and block surface, Connector is good.
     (Continue) (See Figure #1, page 4)

EQUIPMENT—TOOLS & GAGES

Flatness Block: C-44604

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Assemble Trigger Assembly - Stage One. Inspect Connector 100%, inspect Trigger 100%, & check Connector to trigger fit 100%.	EFF. DATE						
	PART No.	26345	32895				
	GA.	RII	LII				

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 7
MACHINE

Form R. D. 6465

R2535628

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS .SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RLJ - 279887

DESCRIPTIVE INFORMATION

1. Cont'd.

   - If light gap shows, measure gap with a .006 shim. If gap accepts shim without moving Connector - Reject Connector. (See Fig. #2, Page 4.)
   - If Connector rocks on flatness block - reject Connector. (See Figure #3, Page 4.)
   - Front edge of long (top) leg, must be square with shoulder of flatness block. (See Fig. #4, Page 4.)

EQUIPMENT—TOOLS & GAGES

.006 Shim - Make new Shim as required.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 7
MACHINE

Form R. D. 6465

R2535629

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS R 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RLS - 279887

DESCRIPTIVE INFORMATION

2. Smooth top surface of long leg of Connector. Use Crocus Cloth.

Surface must be:

- Smooth
- Burr - Free at top and bottom corners and hole.
- Dead flat within 1/32" (minimum) of end.

Check for burrs and smoothness with fingertip.

Separate rejected Connectors into labeled containers based on reject reason.

EQUIPMENT—TOOLS & GAGES

NEW CROCUS CLOTH.

1/32 Min. Dead Flat

(This is the same as the wire diameter of a paperclip)

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 7

MACHINE

Form R. D. 6468

R2535630

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ- 279453
12/17/80 - Was Op. #150 - RLS - 279887

DESCRIPTIVE INFORMATION

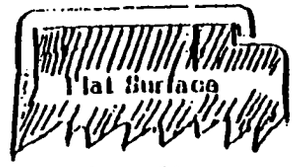


Fig. #1
Good

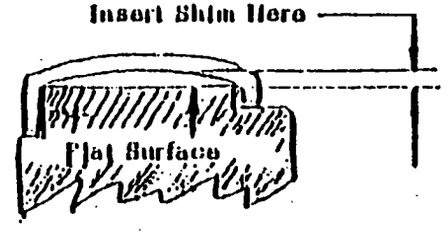


Fig. #2
Test Light Gap
With Shim

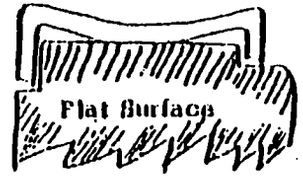


Fig. #3
Reject

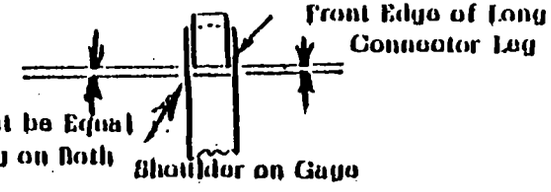


Fig. #4

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 7
MACHINE

Form R. D. 6466

R2535631

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80- Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RLS - 279887

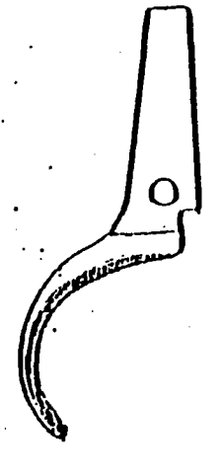
DESCRIPTIVE INFORMATION

1. Inspect Trigger.

Trigger Must Have:

- Good black color
- No bleed out (white material on surface)
- No burrs
- No cracks or damage at pivot hole.

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151

TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 7

MACHINE

Form R. D. 4463

R2535632

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

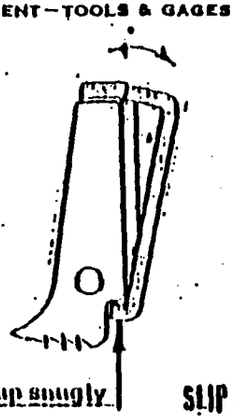
PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RLS - 279887

DESCRIPTIVE INFORMATION

1. Fit passed Connector to passed Trigger and check for Min. working clearance (Slip fit):
   - Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.
   - If additional clearance is needed, file bottom notch on Trigger. Filed surface must be flat and square with sides of trigger. Use filing fixture only. DO NOT FILE FREE HAND.

EQUIPMENT—TOOLS & GAGES



Filing Fixture - D-44608

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151
TYPE MACH. HRS. MACHINE DEPT. No. 61 PAGE 6 OF 7

Form R. D. 6165

R2535633

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

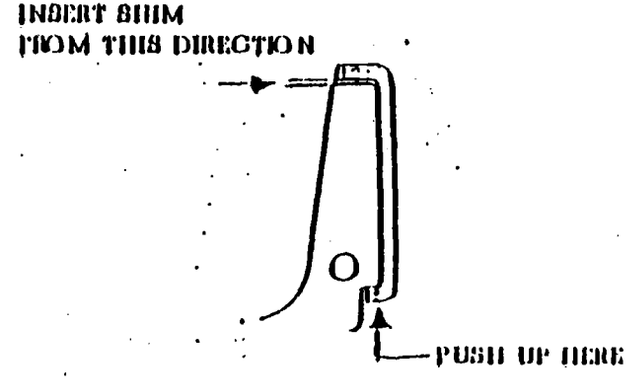
DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RLS - 279887

DESCRIPTIVE INFORMATION

2. With the same Trigger and Connector, check for Max. working clearance:
   - Push Connector tight to Trigger at bottom, and hold it parallel to sides of trigger.
   - Insert shim stock in clearance from front to back
     - .006 shim Must Not Go.
   - If shim enters without moving Connector, Scrap Trigger.

EQUIPMENT—TOOLS & GAGES

.006 Shim Stock, Make new shim when needed.



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 151
TYPE MACH. HRS. DEPT. No. 61 PAGE 7 OF 7
MACHINE

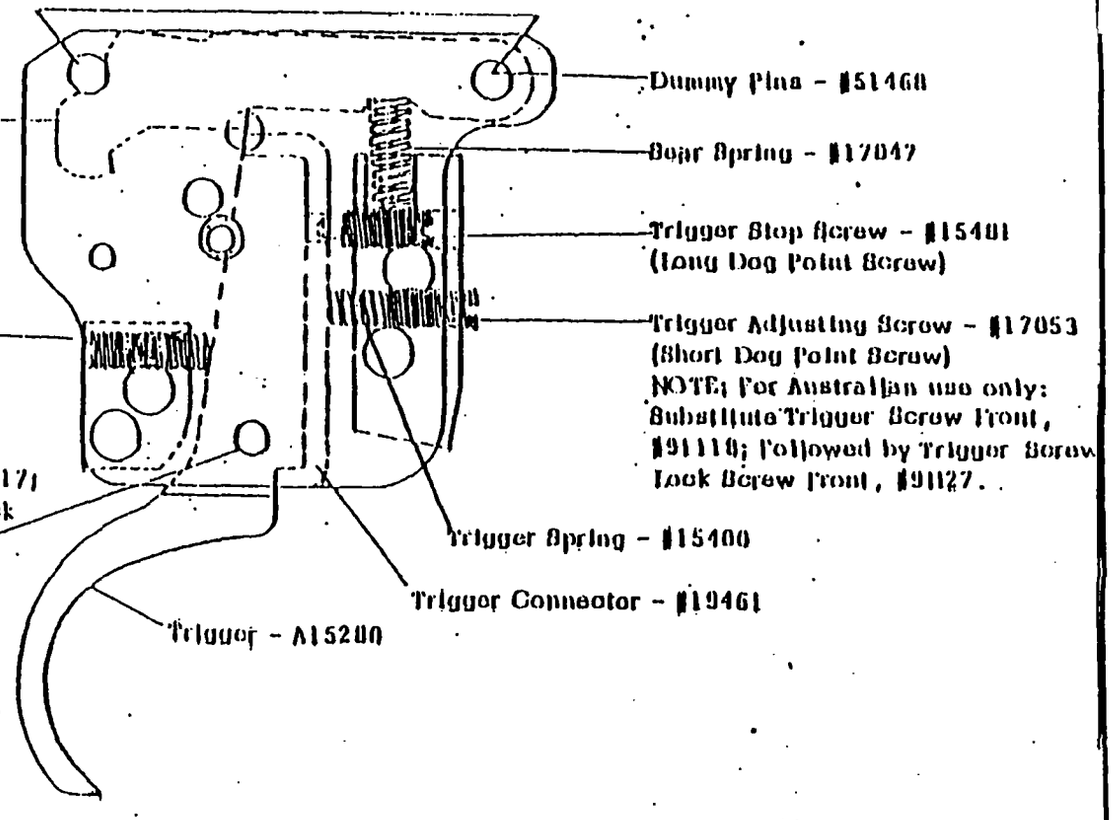
Form R. D. 6461

R2535634

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RLS - 279887

DESCRIPTIVE INFORMATION



NOTE: For Left Hand Version, substitute;
• Trigger Housing Assembly #32905

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 154
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE

Form R. D. 6466

R2535635

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS .SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RIS - 279887

DESCRIPTIVE INFORMATION

1. Inspect Trigger Housing:
   - Black color
   - No bleedout (White Material).
   - Check inside Housing - No burrs at holes.
   - Clean and free of excess oil and foreign material
2. Position Trigger in Housing and install Trigger Pin:
   - Pin Must be flush to housing on right side (Flush to housing on left side for left hand assembly).
   - Grip Trigger and rotate housing around Trigger Pin. Trigger must rotate freely in housing without bind.

EQUIPMENT—TOOLS & GAGES

Pin Holder Drive Punch
A - 35645

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Trigger Assembly - Stage Two							
	PART No.	26345	32895				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 154
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4
MACHINE

Form R. D. 6465

R2535636

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ..SE..MBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP RLJ-279453
12/17/80 - Was Op. #150 - RLS - 279887

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
3. Install: • Same Connector as fitted to Trigger (Op. #8) • Trigger Stop Screw - Flush with Hole. • Trigger Spring • Trigger Adjusting Screw - Flush with hole or below (except Australian). (There must be adequate spring force on Connector while adjusting Trigger Engagement Screw). • Trigger Engagement Screw - flush with hole (except Australian)	See Page 1 for Australian substitution. See Page 1 for Australian substitution.

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER No. 154
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4
MACHINE

Form R. D. 6469

R2535637

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Was Op. #150 - RIS - 279887

DESCRIPTIVE INFORMATION

4. Install Sear Spring and *Sear Safety Cam using Two Dummy pins.

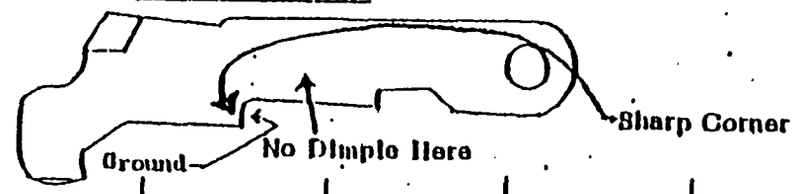
   - Sear must be flat - not bowed. Check 100% thru width gage.
   - Sear must not have dimple.
   - Sear must be ground at vertical contact surface with Connector.
   - Sharp Square Corner at Connector Contact Surface

   * Sear Safety Cam-Part #15666 does not have a recessed dimple.

EQUIPMENT—TOOLS & GAGES

Dummy Pins A-51468
Width gage: C-44522

Do not Substitute



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 154
TYPE MACH. HRS. DEPT No. 61 PAGE 4 OF 4
MACHINE

Form R. D. 6463

R2535638

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
12/17/80 - Chg. reading - RLS - 279887

DESCRIPTIVE INFORMATION

1. Pick correctly adjusted Trigger Sub-Assembly.
2. Assemble:

   Bolt Stop Release - Do not use twisted or bent parts.

   Safety Assembly

   Safety Detent Ball

   Safety Detent Spring - Visually check for correct size dimple.

   Safety Pivot Pin

   Safety Snap Washer - Side with deeper notch (for safety pivot pin) must be on top.

EQUIPMENT—TOOLS & GAGES

Deep Notch Must be on top.

OPERATION DESCRIPTION							
Assemble Trigger Assembly - Stage Three	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	26345	32895				
	GA.	RH	LH				

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 160

TYPE MACH.-HRS. DEPT. No. 61 PAGE 1 OF 3

MACHINE

Form R. D. 6163

R2535639

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80-Revise for MRP-RLI-279453
12/17/80 - Remove description - RLS - 279887

DESCRIPTIVE INFORMATION

- Safety Snap Washer must be completely contained within Pivot Pin Groove.
- The raised end of dimple on Safety Detent Spring must be at the left end of the opening at the closed end of Safety Snap Washer (refer to illustration).

3. Push Bolt Stop Release up and down to ends of Travel several times:
   - Bolt Stop Release must move smoothly and freely without bind.

   Adjust if Necessary

4. Place in pan.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 160
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 3
MACHINE

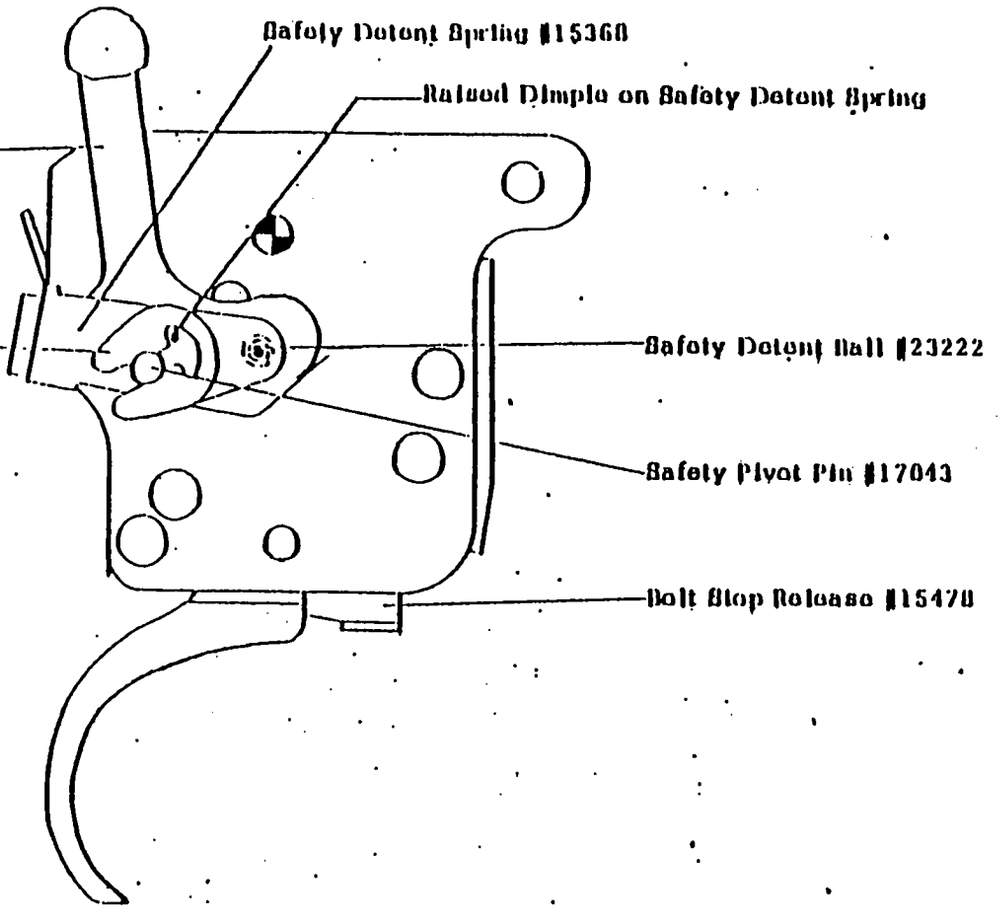
Form R. D. 6465

R2535640

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80-Revised for MRP-RLJ-279453
2/19/82 - Correct view (remove safety bolt lock arm); chg. safety assy. # - SB - 281143

DESCRIPTIVE INFORMATION



NOTE: For Left Hand Version, Substitute:

- Bolt Stop Release #90555
- Safety Assembly #92296
- Safety Detent Spring

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 160
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 3
MACHINE

Form R. D. 6466

R2535641

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 6/13/61 - New Part - AJW - 256249 12/22/80 - Add Holding Block - DRL - 279876
4/1/63 - A.U. - 40XB - Marley - 258319
4/27/65 - Chg. dept. # - FB - 261459
8/27/70 - Chg. dept. # - Bower - 268985
11/3/80 - Revised for MRP - RLS - 279423

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED
3/16" Dia. Drill	Std.		
NOTE: .010 x 45° c'sink			
Holding Block	D-45451		

OPERATION DESCRIPTION

C'sink both sides of hole to burr.

PART NO. 15280

PART NAME Trigger COOLANT SET UP TIME MODEL NO. 700 -40XB OPER. No. 32
TYPE Powder Metal MACHINE Drill Press DEPT. No. 02 PAGE 1 OF 1

RD 6461 POWDER METAL

R2535642

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 6/27/80 - ERP Change - RLJ - #270989

5/26/81 - Add Note -C- M.H. - 280508 [illegible] REMOVE + ADD MARK - D - MH

DESCRIPTIVE INFORMATION

1. Extractor must be shaped to Bolt Shroud by adjusting both ends of Extractor on all Calibers. Claw of Extractor must be checked on tension plug for Go & No Go.
   a) Assemble Extractor to Bolt with Extractor Rivet. (Bend Extractor with Extractor Shroud = 100%)
   b) Extractor must clear Min. tension plug and have tension on Max. tension plug.
   c) Stamp bolt with sub-assembler's identification stamp. D) Stamp. [illegible]
2. Max. Shell head plug must compress Extractor and bottom on face of plug.

EQUIPMENT—TOOLS & GAGES

Fixture	D-89097
Punch	C-71477-W
Tweezers	84391
Dental Grinder	Std.

LOCATOR, D-[illegible]

NOTE: Set Press to pressure - 2200 lbs.(appr .027 on Deflection gage - C-TS-1764. Too much pressure breaks Extractor, too little pressure poor swage.

OPERATION DESCRIPTION

Assemble Extractor to Bolt. Stamp bolt with sub-assembler's identification stamp.

OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
Ga. or Cal.	22-250	308	243	223	7mm-08	
Size 1	31545	31548	31551	31554	31557	
Size 2	31546	31549	31552	31555	31558	
Size 3	31547	31550	31553	31556	31559	
PART No.						
GA.						

PART NAME Barrel Assembly Complete COOLANT SET UP MODEL No. 788 OPER 525

TYPE Cente[illegible]ire MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

Hydraulic Press

R2535643

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

SAFETY BEFORE TEST - All Plant rules, Gallery rules and Job Safety keypoints are to be observed at all times.

I. Guns to be Proofed

A. All guns are to be proofed 100% after final assembly and prior to function testing.

1. Use special remote operated steel covered proofing device and approved booths only. (Do not proof rifles in shotgun proof booths)

II. Proofing Objective

A. To test each guns ability to withstand the proof round pressure without damage to the gun or distortion of the proof round.

III. Safety

A. Shooting pits are to be inspected each shift before shooting is started and inspection sheet is to be signed. (Refer to General Gallery Safety Rules, Section K.)

B. Open Action of all assembled guns.

PART NAME Gallery Proof COOLANT SET UP TIME MODEL No. 700 OPER. No. 600

TYPE Procedure and Specifications MACH. HRS. DEPT. No. 105 PAGE 2 OF 9

MACHINE

R2535644

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

III. Safety - (Cont'd.)

C. If proof round fails to fire when activated:

1. Pull large knob on side of proofing device and hold (black handle):

2. Push firing button on side of proofing device (green button).

3. If fails to fire second time, wait one (1) minute before opening steel doors to remove shell.

IV. Description and Sequence of Proof Test

A. Visual Inspection - Each gun prior to proof.

1. Mixed calibers (on same truck) must be sorted, leaving one (1) space between each different type.

2. Inspect all centerfire bores for obstruction with rod.

B. Proof Test

Note: The first rifle proofed is to be left off of the truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

R2535645

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test - (Cont'd.)

1. Pick up first gun from truck and inspect for:

a. Ammunition - Inspect chamber and magazine - both must be empty.

b. Caliber - To verify for shooting safety.

1. If the load has different calibers on it, place a red tag on the barrel of one gun on the truck to alert the testers and targerters of this condition.

c. Magnaflux Stamp - Must be present right rear side of Barrel.

d. Firing Pin Protrusion or Foreign Material at Face of Bolt:

1. Firing Pin must be retracted in the Bolt.

2. Bolt Face and Shroud must be free from any foreign material.

NOTE: Visually check the first gun from each side of the truck for obvious visual defects before and after proof test.

R2535646

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test

2. With action open, place assemble gun in proofing jack - muzzle in port.

3. Load one (1) proof round into chamber of barrel.

4. Close protective steel doors of proofing device.

   a. Closing of left hand door must activitate air cylinder which clamps stock into fixture.

   b. The stops on both doors must contact both relays to activate firing mechanism.

5. Pull large knob on side of proofing device and hold (to position triggering mechanism in fixture).

6. Push firing button on side of proofing device (to operate triggering mechanism).

7. If gun fails to fire, repeat procedure outlined in III - C, 1 - 3.

8. After firing, open doors to proofing device and retrieve fired case.

R2535647

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test

9. Check fired case for:

a. Primer indent - must be sufficient to fire round.

b. Possible ruptures - must not be ruptured or swelled.

c. Rings or roughness - slight rings are permissable - use fingernail test to determine if serious enough to reject.

NOTE: If primer blows, complete sequence 10 and 11 (below) and then check Receiver of gun for primer. If primer can be found, pass gun. If primer can't be found, reject gun and set it aside to reject truck.

10. Move Safety to "ON" position before removing gun from proofing device.

11. Inspect chamber and magazine for live ammunition before removing gun from port.

a. Chamber must be empty.

b. Follower must be visible

12. Remove gun from device and place on bench.

13. Stamp proof mark (REP), right rear side of Barrel on acceptable products only.

a. Bolt action rifles only - stamp prick punch on the underside of the bolt handle, in addition to the proof mark on the Barrel.

R2535648

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - IBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test

17. If gun fails proof test - fill out reject ticket and attach to gun.

18. Place gun back on truck.

19. Repeat test on next and succeeding guns.

V. Interpretation of Proof Test

A. Pass Gun

1. If there is no failure at proof.

a. Gun must be free of defects. (Not broken, cracked, split, chipped, deformed or show stress marks.

2. If fired case is within visual specifications as outlined in Item IX - B, 12.

3. If there are no serious visual defects found.

B. Reject Gun

1. If gun fails to withstand proof round pressure.

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

V. Interpretation of Proof Test - (Cont'd)

B. Reject Gun - (Cont'd)

2. If fired case fails to meet visual specifications.

3. If any serious visual defects are found before or after test.

VI. Safety After Proof Test

A. Safety

1. Move Safe to "ON" position before removing gun from shooting device.

2. Place the first gun proofed back onto the truck after complete load has been proofed.

B. Inspect Chamber and Magazine for Live Ammunition

1. Chamber must be empty.

2. Follower must be visible.

3. Repeat Items B 1 and 2 (above) on all guns upon completion of proof test.

C. Visually Inspect for Marring by Device or Port

1. Take first (1st) gun from each side of the truck, after test, and carefully check gun for possible damage from the jack or port.

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DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - IBM - 280596

DESCRIPTIVE INFORMATION

C. Visually Inspect for Marring by Device or Port - (Cont'd)

a. If any damage is found, stop testing and have the cause of damage corrected.

b. Resume testing only after correction has been made.

D. Move Entire Load to Next Operation

1. The Model 700 rejects will stay on the original truck when moved to the next operation (Function Test and Target)

R2535651

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

41

DATES AND REASONS FOR REVISIONS
4/21/65 - Chg. dept. # - FB - 261459
9/30/66 - Added 660 - JM - 263894
10/6/66 - Added new fixture and note - AJW - 263917
5/8/81 - Chg. Dept. # - JRH - 280469
2/10/65 - New - Marley - 261022
9/29/80 - Revised for MRP - FRW - 279138
2/10 81 - Removed Rethreading - DRL - 280157
7/7/81 - Add APPROVAL AND DATES note - DRL - 280668
8/29/77 - Added XP-100 & corrected Part number on Firing Pin Head - LBB - 276181

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	
2268	Hand	#42 Drill (.0935)	Std.	
		Geometric Die	D-858004	
		Fixture	E-89082	(Fixt, D-52025 can be used if necessary)
		Chuck	Std.	
		Locating Block	C-52025B	
		Draw		
		1. Firing Pin		15410
		1. Main Spring		15411
		1. Bolt Plug		15676
		1. Firing Pin Head		23321
		1. Firing Pin Cross Pin		17022
			NOTE: - 1.	Use scrap material from 510 Safety for "U" Spacer to hold the Firing Pin out of the Bolt Plug.
			2.	Use cloth Pad under Bolt Plug before drilling to prevent marring.
				A. Compress Assembly in Fixture - Drill Firing Pin Cross Pin hole, drive in Firing Pin Cross Pin, Insert "U" Spacer and remove from fixture.
			3.	Firing Pin Cross Pin must be through both sides of the Firing Pin Head.

OPERATION DESCRIPTION	PART NO.
Assemble Firing Pin, Main Spg. Bolt Plug and Firing Pin Head.	28600

PART NAME Firing Pin Assembly — COOLANT — SET UP TIME — MODEL NO XP-100 600 — OPER. NO 100
TYPE Delta Drill Press — MACHINE — DEPT. NO 02 — PAGE 1 OF 1

R253652

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 2/8/78 - Retyped & filed with process no. 276641 - EB
2/8/78 - Renumber to read 1) abd A-B - Hardy - 276641
4/4/78 - Chg. dept. to 61 - Hardy - 276772
7/28/81 - Chg. Reading on 1.-a. & Remove 3. -M.H. - 280647

DESCRIPTIVE INFORMATION

1. Extractor must be shaped to Bolt Shroud by adjusting both ends of Extractor on all Calibers. Claw of Extractor must be checked on tension plug for Go and No Go.
   a. Assemble Extractor to Bolt with Extractor Rivet. (Blend Extractor to Bolt Shroud.
   b. Extractor must clear min. tension plug and have tension on Max. tension plug.

2. Max. Shell head plug must compress Extractor and bottom on face of Bolt.

EQUIPMENT—TOOLS & GAGES

Fixture (R.H.)	D-84993
Punch	C-71477-W
Fixture (L.H.)	D-40295

Pressure approx. 2200 lbs.
.027 on Deflection Gage #TS-1764
too much pressure breaks Ext. - too little pressure poor swage.

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Assemble Extractor to Bolt Pinned Extractor.	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 95
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2
MACHINE

R2535653
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PROCESS RECORD

DATES AND REASONS FOR REVISIONS 7/18/74 - New operation - CP - 273249
4/4/78 - Chg. dept. to 61 - Hardy - 276772

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES					
SPEED	FEED		Shell Max.	Head Plug	Tension Plugs			
		222 Rem. .17 Rem	B-1-84831A		B-87034A			
		308-243, 25-06, 6MM	B-1-84831B		B-87034C			

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 95
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2
MACHINE

RD-6463

R2535654

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PROCESS RECORDS ASSEMBLY SHEETS

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DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
9/10/81 - Add RAMAC 925758 & 925799 - RLS - 280410
10/29/81 - Chg. ALL page No.'s on Op. 550 - MCH - 280762

DESCRIPTIVE INFORMATION

1. Pick Action from truck, position and clmap in vise.
2. Pick Trigger Assembly.
3. Insert Trigger Assembly into Receiver. (Must fit freely).
   a. File slot if necessary.
4. Pick Sear Pin and start. Drive in flush with inside of Bolt Stop cut.
5. Pick Bolt Stop Spring and position in Receiver.
6. Pick Bolt Stop and position in Receiver.
   a. Mist fit freely, file slot if necessary.
7. Pick Bolt Stop Pin, position and drive in.
8. Stake Bolt Stop Pin and Sear Pin.
9. Hold Trigger and press down on Sear, must NOT bind.

EQUIPMENT - TOOLS & GAGES

NOTE: Only correct components of good color not broken or deformed should be used.

Wiping Rod # 43447 Brass

Pin tight - Tester B-80652
Sear Retracts without hesitation.

OPERATION DESCRIPTION							
Assemble Action (ADL)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	Cal	222	22-250	6MM	243	25-06	270
	Ramac	925760	925762	925764	925766	925768	9 25770
	Cal	7MM EXP	30-06	308	7MM MAG		
	Ramac	925778	925772	925774	925776		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 550
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 5
MACHINE

R2535655

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from 280410 - M.B.
10/29/81 - Add New No. 11 & Chg. corresponding No.'s -MCH - 280762

DESCRIPTIVE INFORMATION

10. Pick Firing Pin Assembly, inspect, point not marred, Bolt Plug color O.K. No rust, or miscut.

11. Lubricate entire threads of Bolt Plug, rear of Bolt Lugs and Cocking Cam on Bolt Body with thin film of Molykote GN Paste. Apply with Lube Brush

12. Assemble to Bolt Group and remove "U" washer.

13. Check Firing Pin protrusion. NOTE: Check for right Serial No. on Bolt.

14. Insert Bolt into Action and lock down.

15. Try Safety.
    a. Must be clearance between Sear and Trigger Connector with Safety on.

EQUIPMENT—TOOLS & GAGES

NOTE: Lube Brush : Tin Ferrule, Natural Bristle type brush. 5 3/4 O.A. 3/8 W x AP 3/4" L

MG. Master - Carr # 7237T1
Or Equiv Permitted

Protrusion Gage B-10-52089

Taper reamer for Braze in Firing Pin hol- A-88003

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 550
TYPE MACH. HRS. MACHINE DEPT. No. 61 PAGE 2 OF 5

Form R. D. 6469

R2535656

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from 280410 - M.B.
10/29/81 - Add New No. 11 & Chg. corresponding No.'s - MCH - 280762
2/26/82 - Changed 15b for new safety - RLJ - 281152

DESCRIPTIVE INFORMATION

15. b. With bolt open, pull safety on. Close bolt & lock down. Must lock down without catching on safety. Bolt must open with safety in on position.

16. (Vertical Sear engagement at least .015 visual).

17. Check for jar off by steady pressure on end of Firing Pin Head, when rifle is cocked, with Safety in off position. (Use end of Hammer Handle.)
    a. Open and close Bolt forcibly three times. Trigger must not follow down.

18. Check notch escape by holding Trigger while closing Bolt slowly. Firing Pin must follow down.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Assemble Action	EFF. DATE						
(ADL)							
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 550
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 5
MACHINE

Form R. D. 6461

R2535657

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from 280410 - M.B.
10/29/81 - Add New No. 11 & Chg. corresponding No.'s - MCH - 280762

DESCRIPTIVE INFORMATION

19. Try Safety and Bolt Action. Adjust if necessary.
    a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety halfway off, pull Trigger, must not fire. Push Safety to OFF position. Firing must not follow down, Safety must return to OFF position under tension. Use downward pressure on Safety. Preform check three times.

20. Weight Trigger Pill (3 to 5 lbs.)
    a. Must be short & crisp, no creep or overdraw. Try 3 times.

21. Pick correct Magazine Box, inspect for color, no rust.

22. Assemble Magazine Box to Action.

EQUIPMENT—TOOLS & GAGES

NOTE: - Cock Rifle - Hold down hard on Bolt Handle - Must fire when Trigger is pulled.

Trigger Pull Scales B-70697

OPERATION DESCRIPTION							
Assemble Action (ADL)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 550
TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 5
MACHINE

Form R. D. 6469

R2535658

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from 280410 - M.B.
10/29/81 - Add New No. 11 & Chg. corresponding No.'s - MCH - 280762
5/28/82 - .006 was .005 - RLJ - 281522

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
23. Pull safety to "on" position. 24. Close and lock Bolt down. 25. Try .006 feeler between Sear and Connector a. Must enter with no bind. 26. If clearance is less than .006 replace safety.	.006 feeler gage or suitable shim.

OPERATION DESCRIPTION							
Assemble Action (ADL)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL OPER. No. 550
TYPE ADL MACH. HRS. MACHINE DEPT. No. 61 PAGE 5 OF 5

Form R. D. 6465

R2535659

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PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 11/5/80 - Retyped from 279423 - CC 11/16/81 - Remove deviation - DRL - 278800
11/5/80 - Chg. Exp. Date - DRL - 278800 11/18/81 - Remove expiration date - DRL - 278800
12/30/80 - Chg. Exp. Date - DRL - 278800
1/12/81 - Added ga. Limits - DRL - 280036
6/11/81 - Chg. Exp. Date - DRL - 278800

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
		Jig	C-TS-7043	
		Bushing F-20-8T (.1200 ID)	Std.	
		Drill #31 (.120 Dia.)	Std.	
		Bushing	C-54661-A	
		Reamer (.1263)	RS-4	
		Plug Ga. (.1254 - .1264)	B-80154D	
		Pos. Ga.	B-50317	NOTE: Place Trigger on Pin - Push in F. P. Block Check Dial and flush pin.
		Checking Fixture (Master)		

OPERATION DESCRIPTION | PART NO. 15280

Drill and Ream Trigger Pin hole.

PART NAME Trigger COOLANT SET UP TIME MODEL NO. 700, 40XB OPER. NO. 28
TYPE Powder Metal MACHINE Drill Press DEPT. NO. 02 PAGE 1 OF 1

R2535660

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
4/10/81 - Add RAMAC 925758 & 925799 - RLS - 280410
6/10/81 - Correct typo. - JBM - 280596
11/24/81 - Corr. Ramac 925803 - RLS - 280898

DESCRIPTIVE INFORMATION

1. See Gallery procedure

EQUIPMENT—TOOLS & GAGES

R.S. Windage Gage - A-82384

F.S. Gage - A-82421

Bending Tool - B-82825

Line 0 Sighter for new Rear Sight D-36871
R.S. Windage Gage for new Rear Sight A-41114
Locating Block R.H. C-41111-A
Locating Block L.H. C-41111-B

OPERATION DESCRIPTION							
	OCC. No.	222	22-250	6MM	243	25-06	270
	STD. HRS/C	925760	925762	925764	925766	925768	925770
	STD. No.	7MM EXP	30-06	308	7MM MAG		
Test and Target - Field Grade	EFF. DATE	925778	925772	925774	925776		
		17	222	22-250	6MM	243	25-06
		925801	925781	925783	925785	925787	925789
		270	270L.H.	7MM EXP	30-06	30-06L.H.	308
		925791	925811	925797	925793	925813	925795
		7MM MAG	7MM MAG LH	300 MAG	8MM MAG	7 MM - 08	
		925803	925815	925807	925809	925799	
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL, 700 BDL OPER. No. 610
TYPE MACH. HRS. DEPT. No. 85 PAGE 1 OF 20
MACHINE

Form R. D. 6465

R2535661

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

SAFETY BEFORE TEST: All Plant rules, Gallery rules and Job Safety Key Points are to be observed at all times.

I. Guns Tested and Targeted

A. All guns 100% are to be tested and targeted simultaneously after Proof.

B. Record results of testing and targeting on forms provided. (See Gallery Foreman for instructions)

II. Test and Target Objectives

A. Function: To check the ability of each gun to satisfactorily load, feed, close, lock, fire, unlock, open, extract and eject and for proper operation of the Safety.

B. Accuracy: To check the ability of each gun to satisfactorily meet specifications for point of impact and/or group size.

C. Visual: To check the ability of each gun to satisfactorily meet appearance specifications for front and rear sights and general overall presentability.

III. Shooting Range

A. Use accuracy device provided for this model.

1. Adjust and set device with master gun for each caliber and bullet weight used, as necessary.

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 700 OPER. No. 610
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 85 PAGE 2 OF 20
MACHINE 1

Form H. D. 6466

R2535662

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DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

III. Shooting Range -(Cont'd.)

B. Use Centerfire Targeting Range - 100 yards (300 ft.)

1. Use grid type targeting paper.

2. Use line-o-sighter and spotting scope as outlined in Item V "Description of Test/Target"

C. Setting of Master Guns

1. All set to zero by authorized personnel.

2. Use heavy grain bullet where two are specified.

IV. Specifications

A. Function Testing

1. Loading:

a. Magazine must accept total rounds specified for caliber - See Table IX - A thru C

b. Cartridges must be retained by rails in Receiver - must not "jump out".

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 700 OPER. No. 610

TYPE Procedure and Specifications MACH. HRS. DEPT. No. 85 PAGE 3 OF 20

MACHINE

Form R. D. 6466

R2535663

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd.)

A. Function Testing -(Cont'd.)

2. Feeding: (with Magazine loaded)

a. Must feed single (1) shell with each operating stroke of Bolt.

b. Must not double feed.

c. Shells must not stem chamber or Magazine.

d. Bolt must not override shells in Magazine.

- Single load with Magazine empty.

a. Same as "a" & "c" above.

3. Closing: At start of test, Magazine loaded to capacity, hold shells down in Magazine to start Bolt over shell column, release pressure on shells and close Bolt on empty Chamber.

a. Bolt must close over full Magazine with normal pressure (empty chamber).

b. Bolt must close with normal pressure (Shell in chamber).

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 700 OPER. No. 610
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 85 PAGE 4 OF 20
MACHINE

Form R. D. 5466

R2535664

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd.)

A. Function Testing - (Cont'd.)

4. Locking: With Bolt closed on empty chamber or with shell in chamber as in Item 3.

a. Bolt must lock up with normal pressure (shell in chamber or empty chamber).

b. Extractor must cam over shell rim without excessive pressure or bind.

5. Firing: After each full operating cycle of Bolt - Safe in "off" position.

a. Gun must fire when Trigger is pulled.

6. Unlocking: With Bolt in closed postiion and locked as in Items 3a, 3b, 4a, raise Bolt Handle counterclockwise to unlock.

a. Must unlock with normal pressure.

7. Opening: After unlocking.

a. Bolt must travel full stroke to rear position to stop with normal pressure.

b. Bolt must not pull out of Receiver.

8. Extraction: With fired case or live round in chamber - unlock and open Bolt to rear position.

a. Case or shell must be completely removed from chamber.

b. Case or shell must be retained in head of Bolt by Extractor - not fall out - until ejected.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd.)

A. Function Testing - (Cont'd.)

9. Ejection: With fired case or live round fully extracted from chamber.

a. Case or shell must be completely ejected from gun by ejector.

10. Case Inspection: One fired case from each gun must be visually inspected for indent and condition of fired case (chamber defects).

NOTES: 1. All guns 100%, shall be tested for function.

2. Functional items are applicable to all rounds fired.

3. Where two bullet types are specified, use the heavy grain bullet type on one side of the truck and use the light grain bullet type on the opposite side.

a. Do not mix bullet types in the same test gun.

B. Open Sights

- Normal Appearances

1. Front Sight Ramp and Sight

a. Ramp must be central on Barrel and straight with line of sight.

b. Must conform to barrel - good fit - no excessive opening at sides or ends - screwed tight to Barrel.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd.)

- Normal Appearances (Cont'd)

1. Front Sight Ramp and Sight

   a. Front Sight must be reasonably central on ramp - tight in dovetail - not bent, twisted, tipped or deformed.

2. Rear Sight Ramp and Sight

   a. Ramp must be central in barrel and straight with line of sight - level crosswise with Front Sight Ramp.

   b. Must conform to Barrel - good fit, no excessive opening at sides or ends, screwed tight to Barrel.

   c. Rear Sight and Eyepiece must be level crosswise with line of sight as viewed from rear - Not tipped, twisted or bent.

   d. Mark on elevating piece set to coincide with fourth mark from rear on rear sight ramp.

   e. Rear Sight Eyepiece good fit on dovetail of elevating slide - no excessive opening.

   f. Rear Sight Eyepiece positioned central crosswise with Windage Screw.

R2535667

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS: 11/3/80 - New for MRP - RLJ - 27947

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd.)

C. Acceptance Limits for Sight Line - (No Point of Impact)

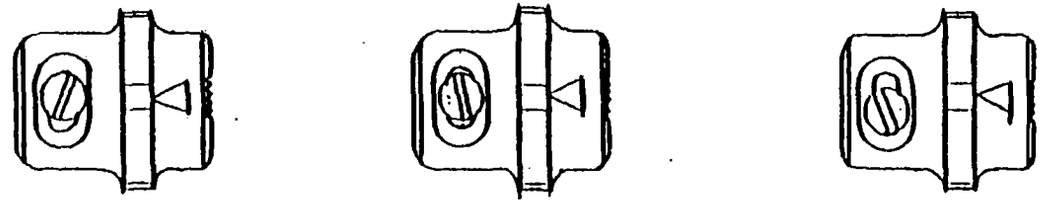
Caliber	Elevation		Windage	
	High	Low	Left	Right
All	2"	0"	9"	9"

NOTE: 1. Acceptance limits only apply when sights are positioned on the gun as described in Item IV - B. Sights must be capable of adjustment to 0" x 0". With point of impact within the sight limits described in Item IV-D, below:

D. Rear Sight

1. Elevation - Mark on elevating slide may be adjusted to any position on the ramp between the second line from the rear to the third line from the front of the ramp.

2. Windage - Eyepiece may be adjusted crosswise on elevating piece to any position with windage screw within the length of the adjusting slot. Must show full width of screw retaining shoulder - minimum - at side of screw after adjustment.



PART NAME: Gallery Test and Target | COOLANT | SET UP TIME | MODEL No. 700 | OPER. No. 610

TYPE: Procedures and Specifications | MACH. ITEM | DEPT. No. 05 | PAGE 8 of 20

MACHINE

R2535668

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP, RLJ

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd.)

E. Point of Impact

1. Definition - Using line-o-sighter, the mean average position of all shots fired in the group from point of aim should be within the limits set in Item IV-C, above.

F. Group Size - Definitions

1. Center to Center - Maximum extreme spread from center to center of holes farthest apart.

2. Inside to Inside - Maximum extreme spread from inside edges of holes farthest apart.

V. Description of Test/Target - Each gun as received, bolt in open position - Safe in "OFF" position.

NOTE: The first rifle tested and targeted is to be left off of truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

A. Test/Target Description

1. Remove tickets from guns and place on top of truck.

2. Pick up gun from truck and inspect for;

a. Safety - Inspect chamber and Magazine - both must be empty.

b. Caliber - To verify for shooters personal safety in selecting ammunition for test.

R2535669

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 270474
2/26/82 - Revised Item VA4 - JBM - 281157

DESCRIPTIVE INFORMATION

V. Description of Test/Target - (Cont'd.)

A. Test/Target Description - (Cont'd,

2. Pick up gun from truck and inspect for;

c. Proof Mark on Barrel (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.

d. Proof mark on bolt - (.) Prick punch mark must be present at bottom of bolt Handle.

e. Visual Defects - If not within specifications for items a - d, reject gun at this point.

f. Normal Sight alignment - as described in IV-B.

NOTE: Visually check the first gun from each side of the truck for marring by jack or device - Before and After it is test/targeted,

3. With safe in "OFF" position - close bolt crisply on empty chamber,

a. Firing pin must not follow down as bolt cams shut,

b. Must not fire on closing.

4. Move safe to "ON" position and raise bolt

a. Must raise or open

5. With safe still "ON" - pull trigger firmly.

a. Gun must not fire.

R2535670

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279174

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd.)

A. Test/Target - Description

6. With finger off trigger - move safe to "OFF" position.

7. Open and close bolt full stroke to cock firing pin.

8. Move safe to full rear "ON" position and then move to half way "OFF" position with thumb only. If possible

9. If safety stops at half-way position - pull trigger.

a. Gun must not fire.

b. Safety must not move to full "OFF" position.

10. If safety stops in halfway position, move safe to "OFF" position after pulling trigger.

a. Gun must not fire.

IMPORTANT - Perform Items V-A, 3-10 a total of three times

11. With Action open, position gun in device and clamp.

12. Lower line-o-sights and adjust device to point gun on target paper if necessary.

13. Remove line-o-sighter.

14. Load Magazine to capacity - see table #1 and #2, Item IX - for Magazine capacity by caliber.

R2535671

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP I + RLJ - 27947

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd.)

A. Test/Target - Description

15. Hold cartridges down in Magazine, start bolt over Cartridge column and close bolt on empty chamber.

16. Open Bolt full stroke to rear position.

17. Assemble Firing Pin Trip Pin in device.

18. Close guard.

19. Close Bolt to feed shell into chamber and lock - to start test.

20. Fire gun by pushing (2) two buttons on device simultaneously.

21. Check each shot with spotting scope for gun "seating in" and position of shots on paper.

a. Adjust device if shots off paper or group too close to edge.

22. Operated action full cycle to extract, eject, and feed each shot.

23. Fire all rounds required for regular seating and targeting.

a. If additional rounds beyond Magazine capacity are required to meet accuracy specifications, single load and fire additional rounds.

b. If last shell in Magazine is not needed to satisfy accuracy specifications, feed shell into chamber, and extract and eject unfired round.

R2535672

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DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ ri 279!7!

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd.)

A. Test/Target - Description

24. Open Guard

25. Lower Line-o-sighter onto sights and check point of impact and group size.

a. Cross hairs in scope must line up with average position of shot pattern within point of impact specifications.

b. Spread of holes must be within group size specifications.

26. Remove line-o-sights.

27. Unclamp and remove gun from device.

28. Inspect chamber and magazine for live ammunition.

a. Chamber must be empty

b. Follower must be visible.

29. Place gun back on truck.

30. Repeat Test /Target on next and succeeding gun.

31. Replace gun tickets to barrels of guns.

R2535673

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP & RLJ - 27947H

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd.)

B. Test/Target Stamping - (Acceptable Product Only)

1. When all guns have been tested/targeted, move entire load to stamping bench,

2. Place stamp, right rear side of barrel, ahead of the Proof (REP) stamp,

a. Rejected guns are not to be stamped;

3. Replace gun to truck.

VI. Retest - None, unless ammunition, man, or method are questioned,

VII. Interpretation of Target - Test

A. Pass Gun

1. Within specifications for:

a. Visual items and,

b. Functional requirement and,

c. Point of impact within specified number of shots and,

d. Group size (on required guns) within specified number of shots and

e. Within limits on Eyepiece and Front Sight acceptance limits,

R2535674

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ n.279474

DESCRIPTIVE INFORMATION

VII. Interpretation of Target - Test

B. Reject Gun

1. Not within specifications:

a. For any one (1) or more of the items listed under A-) above.

b. Record all malfunctions on target and on reject ticket which is attached to gun.

1. Reject ticket to be written and attached to gun before next gun is test/targeted.

VII Safety After Test

A. Open Bolt

1. Move bolt to open position before removing gun from accuracy device.

B. Inspect Chamber and Magazine for live ammunition

1. Gun must be empty.

2. Follower must be visible.

NOTE: Perform "A" & "B" above on each individual gun immediately after shooting test. Repeat "B" for all guns on truck on completion of test.

C. Visual inspect for marring by device or port.

1. Take first gun from each side of truck, after test, and check for any possible damage to gun from the test.

PART NAME Gallery Test and Target COOLANT SET UP MODEL No. 700 OPER. No. 610
TYPE Procedures and Specifications MACH. ING. DEPT. No. 05 PAGE 15 OF 20
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R2535675

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
6/10/81 - Added Specs. for 7MM-08 Field Grade - JHM - 280598

DESCRIPTIVE INFORMATION

VIII. Safety After Test - (Cont'd.)

D. All guns are moved to Ammunition Inspection Area

1. See Job Safety Key Points for proper Ammunition Inspection Procedure.

IX. Ammunition Specifications and Rounds Required

A. Table I - Field Grade Rifles - Standard Barrel - (Front and rear sights assembled)

Caliber	Ammunition Type	Mag. Capacity	Minimum Rounds Required: Function Load	Test Fire	POI	Group Size
6 mm	100 gr. PSP-80 gr. HPPL	4	4	3	3 Rds.	3 to 5 Rds.
7 mm	175 gr. PSP-150 gr. PSP	3	3	3	"	"
7 mm EXP	165 gr. SP -	4	4	3	"	"
8 mm	220 gr. PSP - 185 gr. PSP	3	3	3	"	"
17	25 gr. HPPL	5	5	4	"	"
222	50 gr. PSP - 50 gr. HPPL	5	5	4	"	"
243	100 gr. PSP - 80 gr. HPPL	4	4	3	"	"
270	150 gr. SP - 130 gr. BRP	4	4	3	"	"
300	180 gr. PSP - 150 gr. PSP	3	3	3	"	"
300	180 gr. SP - 150 gr. PSP	4	4	3	"	"
2506	120 gr. PSP - 87 gr. HPPL	5	5	4	"	"
3006	180 gr. SP - 150 gr. PSP	4	4	3	"	"
22250	55 gr. PSP - 55 gr. HPPL	4	4	3	"	"
7MM-08	140 gr. PSP	4	4	4	"	"

R2535676

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
6/10/81 - Added Specs. for 7x57 - JBM - 280598

DESCRIPTIVE INFORMATION

IX. Ammunition Specifications and Rounds Required - (Cont'd)

B. Table 2 - Varmint Grade Guns - Heavy Barrel - (No Sights)

Caliber	Ammunition Type	Mag. Capacity	Minimum Rounds Required: Function Load	Test Fire	Group Size
6 mm	80 gr. HPPL	4	4	4	5 Rds.
222	50 gr. HPPL	5	5	5	"
223	55 gr. HPPL	5	5	5	"
243	80 gr. HPPL	4	4	4	"
308	150 gr. HPPL	4	4	4	"
2506	87 gr. HPPL	4	4	4	"
22250	55 gr. HPPL	4	4	4	"
7MM-08	140 gr. PSP	4	4	4	"

C. Table 3 - Classic Grade Guns - Standard Barrel - (No Sights Assembled)

Caliber	Ammunition Type	Mag. Capacity	Minimum Rounds Required: Function Load	Test Fire	Group Size
6mm	100 gr. PSP-80 gr. HPPL	4	4	4	3 to 5 Rds.
7mm	175 gr. PSP-150 gr. PSP	4	4	4	"
243	100 gr. PSP-80 gr. HPPL	4	4	4	"
270	150 gr. SP-130 gr. BRP	4	4	4	"
3006	220 gr. SP-150 gr. PSP	4	4	4	"
22250	55 gr. PSP-55 gr. HPPL	4	4	4	"
7MM-Mauser	175 gr. SP-140gr. PSP	4	4	4	"

R2535677

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
6/10/81 - Added Specs. for 7MM-08 - JBM - 280596

DESCRIPTIVE INFORMATION

X. Group Size Specifications

A. Table I - Field Grade Rifles - Standard Barrel - (Front and Rear Sights Assembled)

Calibers	Ammo. Type	Maximum Group Center to Center 1			Maximum Group Inside to Inside 1		
		3 Shots	4 Shots	5 Shots	3 Shots	4 Shots	5 Shots
6 mm	100 gr.	1.45	1.95	2.2	1.25	1.75	2.0
7 mm	175 gr. - 150 gr.	1.7	2.2	2.7	1.5	2.0	2.5
7 mm Exp.	165 gr.	2.5	3.0	3.5	2.2	2.7	3.2
8 mm	220 gr. - 185 gr.	2.5	3.0	3.5	2.2	2.7	3.2
17	25 gr.	1.45	1.95	2.2	1.25	1.75	2.0
222	50 gr.	1.45	1.95	2.2	1.25	1.75	2.0
243	100 gr. - 80 gr.	1.45	1.95	2.2	1.25	1.75	2.0
270	150 gr. - 130 gr.	1.7	2.2	2.7	1.5	2.0	2.5
300	180 gr. - 150 gr.	2.3	2.8	3.3	2.0	2.5	3.0
308	180 gr. - 150 gr.	2.5	3.0	3.5	2.2	2.7	3.2
2506	120 gr. - 87 gr.	1.45	1.95	2.2	1.25	1.75	2.0
3006	180 gr. - 150 gr.	2.5	3.0	3.5	2.2	2.7	3.2
22250	55 gr.	1.45	1.95	2.2	1.25	1.75	2.0
7MM-08	140 gr. PSP	1.7	2.2	2.7	1.4	1.9	2.4

1 - All Figures in Inches

R2535678

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
6/10/81 - Added Specs, for 7X57 - JBM - 280596

DESCRIPTIVE INFORMATION

X. Group Size Specifications - (Cont'd)

B. Table 2 - Varmint Grade Guns - Heavy Barrel - (No Sights)

Calibers	Ammo. Type	Maximum Group (5 Shots) Center to Center [1]	Maximum Group (5 Shots) Inside to Inside [1]
6 mm	80 gr. HPPL	1.5	1.3
222	50 gr. HPPL	1.5	1.3
223	55 gr. HPPL	1.5	1.3
243	80 gr. HPPL	1.5	1.3
308	150 gr. SPCL	2.0	1.8
2506	87 gr. HPPL	1.5	1.3
22250	55 gr. HPPL	1.5	1.3
7MM-08	140 gr. PSP	1.5	1.3

C. Table 3 - Classic Grade Guns - Standard Barrel - (No Sights Assembled)

Calibers	Ammo. Type	Maximum Group (5 Shots) Center to Center [1]	Maximum Group (5 Shots) Inside to Inside [1]
6 mm	100 gr. PSP	2.2	2.0
7 mm	175 gr. PSP-125 gr. PSP	2.7	2.5
243	100 gr. PSP-80 gr. HPPL	2.2	2.0
270	150 gr. SP-130 gr. PRP	2.7	2.5
3006	220 gr. SP-150 gr. PSP	2.2	3.2
22250	100 gr. PSP	2.2	2.5
7MM-Mauser	175 gr. SP 140 gr. PSP	2.7	2.5

1 - All Figures in Inches

PART NAME Gallery Test and Target COOLANT SET UP MODEL No. 200 OPER. No. 610
TYPE Procedures and Specifications MACH. TIME PERT. No. 05 PAGE 19 OF 20
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DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 27917H

DESCRIPTIVE INFORMATION

NOTES: (These notes pertain to Tables IX, A-C and X, A-C)

M/700 Field Grade Guns - Standard Barrel - (Front and Rear Sights Assembled)

1. Function Test all guns 100%,
2. Target all guns 100% for sight alignment to point of impact,
3. Inspect all guns 100% for group size,

M/700 - Varmint Grade and Classic Grade Guns - (No Sights)

1. Function Test all guns 100%,
2. Inspect all guns 100% for group size,

PART NAME Gallery Test and Target COOLANT SET UP MODEL No. 700 PREP. No. 610

TYPE Procedures and Specifications MACH. ING. DEPT. No. 05 PAGE 20 OF 20

MACHINE

R2535680

PROCESS RECO..D — INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		For defects.		
Snap Gage	B-80013-U	Material thickness.	.033	.029
Plug Gage	B-80002-W	Width of large hole.	.150	.146
Plug Gage	B-80002-U	Width of small hole.	.130	.126
Spec. Plug Gage	A-50142	Length of large hole.	.270	.260
Spec.Plug Gage	A-50141	Length of small hole.	.235	.225
Comp. Screen	D-700-CL-11	Check position of holes and outline - (1st position). Check .315 tab (2nd position).		
Comp. Fixture	C-85036			
Dial Comparator	Std.	Check height of coin.	.035	.031

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 7%

DATES AND REASONS FOR REVISIONS

10/9/63 - New form - Marley 279534

9/26/80 - Changed part number - was 15478 - CAK

2/3/82 - Changed material thickness - CAK - 281118

MATERIAL: AISI C-1010 or C-1020

HEAT TREATMENT AT: Remington

COMPONENT CONDITION: FINISHED: SEMI-FIN. X

MODEL NO. 700, 40XB

PART NO. 91917

BLANK DRAWING NO C-91917

PART NAME Bolt Stop Release Blank

DEPT. NO. 92 PAGE 1 OF 1

RD-6491-1

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

R2535681

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDE 3SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 5/13/63 - Made regular -
9/10/64 - Add crusher holder - C.H. 260282
9/9/76 - Chg. dept. no. 61 to 15 - Joy - 275236
2-18-82 added 7MM BARREL Tooling - K

DESCRIPTIVE INFORMATION

1. Pick Bolt Assembly and wash.
   a. Inspect for rust, mars, or slight scratches.
      1. Wire brush if rusty.
   b. Check for Magnaflux stamp on left lug and brass test mark on right lug and rear of Handle.
   c. No brass except thin line at joint.
   d. Bolt Lugs - No burrs, Recoil surfaces good finish, all edges chamfered.
   e. Extraction Cam - No bar burrs.
   f. Gas hole present.

2. Pick Barrel Assembly
   a. Good finish and color, mars slight, no seams.
   b. No sharp edges at Ejection Port or any exposed edges (Which might cause fingers injury).
   c. Gas hole present in Receiver.
   d. 3 Plug Screw holes present and tapped.
   e. Top plug screw holes in alignment.
   f. Barrel muzzle visual central. Outside of Barrel not visually bowed.

EQUIPMENT—TOOLS & GAGES

Fixture B-51580

Reamer .221 Rem. B-54136T
Reamer 7MM. Bar Rem B-45152
Reamer Shank .221 Rem B-900988
" " 7MM. Bar Rem B-900998-V

Heading dummy	Min.	Max.	Crusher Holder
.221 Rem.	B-85239	B-85240	B-85249
7MM-Bar Rem	B-45160	B-45161	B-85249

Crusher Holder for records only
Plug available at Quality Audit

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
Fit and head Bolt Assembly to Barrel Assembly	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP100 OPER. No. 40
TYPE .221 Rem. & 7MM BAREM MACH. HRS. DEPT. No. NW 15 PAGE 1 OF 2
MACHINE Spec, Chamber Mach. B-51529

Form R. D. 6405

R2535682

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD A MBLY SHEETS

DATES AND REASONS FOR REVISIONS 5/13/63 - Made regular -
9/9/76 - Chg. dept. no. 61 to 15 - Joy - 275236

DESCRIPTIVE INFORMATION

3. Check for correct marking
4. Fit Bolt Assembly to Barrel Assembly
5. Head
   a. Wash chips from Action in Varnolene tank

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Fit & head Bolt Assembly to Barrel Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP100 OPER. No. 40
TYPE MACH. HRS. MACHINE DEPT. No. 61/15 PAGE 2 OF 2

Form R. D. 6469

R2535683

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS [illegible] ASSEMBLY SHEETS

7

DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP - 273269
5/6/76 - Added package into. - CP - 274937
3/4/82 - CHGE DEPT NO - RJT

DESCRIPTIVE INFORMATION

OIL: - Mohawk 600

Solution - (10) parts Shell Solvent, wipe bore and metal parts with (1) part steel guard.

EQUIPMENT-TOOLS & GAGES

Tag: Mohawk 600

1. Select correct tag for Model.
2. Attach to Trigger Guard

M/600 Rifle Package (Mohawk Label)

	Dwg. No.	Part No.
Box Blank	D-P-1249	1249
Butt Insert	C-P-1251	1251
Muzzle Insert	C-P-1250	1250
Tape ($\frac{1}{2}$" x 12"-3M No. 898)	A-P-1234	1234

OPERATION DESCRIPTION

Oil, place price tag on Trigger Guard and assemble packing material and pack rifle. .zzz, -308-6MM and 243-22-250.

OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
PART No.						
GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 337

TYPE MACH. HRS. DEPT. No. 5576 PAGE 1 OF 1

MACHINE

Form R. D. 6463

R2535684

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

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DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP - 273269
3/4/82 - CH6 DEPT 00 - RW

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Unpack Guns							
	PART No.						
	GA.						

PART NA Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 338R

TYPE Center Fire ACH. HRS. DEPT. No. 4 5576 PAGE 1 OF 1

MACHINE

R2535685

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PROCESS RECORDS ASSEMBLY SHEETS

43

DATES AND REASONS FOR REVISIONS 7/26/74 - New - Prosser - 273269
3/4/82 - CHGE DEPT NO - RLJ

DESCRIPTIVE INFORMATION

To be used for guns taken from Warehouse for re-work.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Re-pack	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 339R
TYPE CH. HRS. DEPT. No. 55-76 PAGE 1 OF 1
MACHINE

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP 273269 -
3/4/82 — CHGE DEPT NO- RJ

DESCRIPTIVE INFORMATION

OIL: - - Mohawk 600

Solution - (10) parts Shell Solvent, wipe bore and metal parts with (1) part steel guard.

(1) part Steel Guard

EQUIPMENT—TOOLS & GAGES

TAG: Mohawk 600

1 - Select correct tag for Model.

2 - Attach to Trigger Guard

OPERATION DESCRIPTION							
Oil, place price tag on Trigger Guard and assemble Packing material and pack gun, label and tape, 2 tapes (Special Order Guns)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Johawk 600 OPER. No. 410
TYPE CH. HRS. DEPT. No. 55-76 PAGE 1 OF 1
MACHINE

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PROCESS RECORDS ASSEMBLY SHEETS

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DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP - 273269
3/4/82 - CHGE DEPT NO - RJT

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Make label when necessary	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Koh. 600 OPER. No. 575

TYPE CH. HRS. DEPT. No. 5576 PAGE 1 F. 1

MACHINE

R2535688

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PROCESS RECORDS ASSEMBLY SHEETS

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DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP - 273269
5/6/76 Added package into. - CP - 274937
3/19/82 - Change Department # - RLJ - 281202

DESCRIPTIVE INFORMATION

Oil: - Mohawk 600

Solution - (10) parts Shell Solvent, wipe bore and metal parts with (1) part steel guard.

EQUIPMENT-TOOLS & GAGES

Tag: Mohawk 600

1. Select correct tag for Model.
2. Attach to Trigger Guard

M/600 Rifle Package (Mohawk Label)

	Dwg. No.	Part No.
Box Blank	D-P-1249	1249
Butt Insert	C-P-1251	1251
Muzzle Insert	C-P-1250	1250
Tape (½" x 12"-3M No. 898)	A-P-1234	1234

OPERATION DESCRIPTION							
Oil, place price tag on Trigger Guard and assemble packing material and pack rifle. .222, .308-6MM and 243-22-250.	OCC. No						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 337
TYPE MACH. HRS. DEPT. No. 76 PAGE 1 OF 1
MACHINE

Form P D 6154

R2535689

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KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP - 273269
4/19/82 - Change Department # - RLJ - 281202

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OPC. No.						
	STD. HRS/C						
	STD. No.						
Unpack Guns	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 338R

TYPE Center Fire MACH. HRS. MACHINE DEPT. No. 76 PAGE 1 OF 1

Form R. D. 6165

R2535690

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/26/74 - New - Prosser - 273269
4/19/82 - Change Department # - RMJ - 281202

DESCRIPTIVE INFORMATION

To be used for guns taken from Warehouse for re-work.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
Re-pack	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 339A
TYPE MACH. HRS. DEPT. No. 76 PAGE 1 OF 1
MACHINE

Form R. D. 6469

R2535691

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP 273269 -
4/14/82 - Change Department # -- 281202

DESCRIPTIVE INFORMATION

OIL: - - Mohawk 600

Solution - (10) parts Shell Solvent, Wipe bore and metal parts with (1) part Steel guard.

(1) part Steel Guard

EQUIPMENT - TOOLS & GAGES

TAG: Mohawk 600

1 - Select correct tag for Model.

2 - Attach to Trigger Guard

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
Oil, place price tag on Trigger Guard and assemble Packing material and pack gun, label and tape, 2 tapes (Special Order Guns)	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Johawk 600 OPER. No. 410

TYPE MACH. HRS. DEPT. No. 76 PAGE 1 OF 1

MACHINE

Form R. D. 6461

R2535692

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/26/74 - New - CP - 273269
1/19/82 - Change Department # - RLJ - 281202

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Make label when necessary	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 575

TYPE MACH. HRS. DEPT. No. 76 PAGE 1 OF 1

MACHINE

Form R. D. 6469

R2535693

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 11/3/80 - Retyped from 277609 - CC
1/3/80 - Revised for MRP - FRW - 279395
4/22/82 - Add M/700 Only to Title - RLJ - 281285

TOOLS GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPARE / PERM		
Grinding Fixture	D-41453	
Norton Wheel (White Saucer) 6" x 7/16" x 1¼" #38A100 M8VBE	Std.	
Gage A = .870 - .866	C-44133	
6° Wheel Dresser	D-44410	

OPERATION DESCRIPTION	PART NO.
Grind Connector Surface Part #15666 M/700 Only	15666

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. 700 OPER. No. 62
TYPE MACHINE DEPT No. 67 PAGE 1 OF 1

80 0401

R2535694

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PROCESS RECORD—INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Finish		
Mics.	Std.	Diameter	.1564	.1560

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 7%

DATES AND REASONS FOR REVISIONS

6/23/80 - Retyped from 275096 - Updated - CAK - 279387

5/7/82 - Added SEVEN LWT - CAK - 281464

MATERIAL: Mfg. Std.

HEAT TREATMENT AT: - - -

COMPONENT CONDITION: FINISHED: X SEMI-FIN.

MODEL NO. 600,XP-100,40XB,700, SEVEN LWT

PART NO. 23222

BLANK DRAWING NO. B-23220

PART NAME Safety Detent Ball

DEPT. NO. 92 PAGE 1 OF 1

BD-6491-1

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

R2535695

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free of burrs, mars, etc.		
Comparator Screen	721-CL-138	Check mean contour		
Comparator Fixture	B-50156			
Mics.	Std.	Check shaft diameter	.1245	.1225
Max ring gage	B-80014-S	Part must pass through	.191	

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 7%

DATES AND REASONS FOR REVISIONS

9/26/80 - Retyped from 3/28/63 - Changed part number - was 17043 - CAK - 279389

5/7/82 - Added SEVEN LWT - CAK - 281464

MATERIAL: .08/.20 C. steel

HEAT TREATMENT AT: Remington

COMPONENT CONDITION: FINISHED: SEMI-FIN. X

MODEL NO. 600, 700, XP100, 40XB, SEVEN LWT

PART NO. 91918

BLANK DRAWING NO. B-91918

PART NAME Safety Pivot Pin Blank

DEPT. NO. 92 PAGE 1 OF 1

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

R2535696

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PROCESS RECORD – INSPECTION

GAUGES TYPE	GAUGES NUMBER	USE	LIMITS MAX.	LIMITS MIN.
1. Visual Inspect	for defects			
2. Adj. Snap Ga.	B-80013W			
3. Functional Rec. Ga.	A-50002			
Check thickness			.021	.019
		See if part enters gage. It must seat correctly to pass inspection.		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (BAR #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 7%

DATES AND REASONS FOR REVISIONS 2/1279

3-16-65 - Retyped New form from 3-28-63 - JJM
9/12/75 - changed H.T. Specs IDB 214323
9/26/80 - Updated - CAK - 279389
5/7/82 - Added SEVEN-LWT - CAK - 291241

MATERIAL: C-1095 C.R. Spring Steel Harden & Temp.
HEAT TREATMENT AT: R 66-69
COMPONENT CONDITION: FINISHED: X SEMI-FIN.
MODEL NO. 700, XP100, M/600, 40XB, SEVEN LWT
PART NO. 17044
BLANK DRAWING NO. A-17044
PART NAME Safety Snap Washer
DEPT. NO. 92 PAGE 1 OF 1

D-4491-1 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535697

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PROCESS REC D—INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from burrs		
Mics.	Std.	Diameter	.1250	.1248
Mics.	Std.	Overall length	.720	.710
Scale	Std.	Chamfer one end	.060	.040

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS

6/23/80 - New - CAK - 229389

5/7/82 - Added SEVEN LWT - CAK - 251404

MATERIAL: Mfg. Spec.

HEAT TREATMENT AT: - - -

COMPONENT CONDITION: FINISHED: X SEMI-FIN.

MODEL NO. XP-100,700,600,40XB,40X, SEVEN LWT

PART NO. 24476

BLANK DRAWING NO. C-24475

PART NAME Sear Pin

DEPT. NO. 92 PAGE 1 OF 1

RD 6491-1 Rev. 577 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535698

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PROCESS RECO)-INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from burrs Chamfer on both ends		
Mics	Std.	Length	.365	.355
Mics	Std.	Diameter	.1250	.1248

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS

6/15/80 - Updated - CAK -379030

5/7/82 - Added SEVEN LWT - CAK -381464

MATERIAL: Mfg spec

HEAT TREATMENT AT:

COMPONENT CONDITION: FINISHED: x SEMI-FIN.

MODEL NO. 788,581,582,541-S, SEVEN LWT

PART NO. 24477

BLANK DRAWING NO. C-24475

PART NAME Sear Pin

DEPT. NO. 92 PAGE 1 OF 1

RD-6491-1 Rev 5/7 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535699

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KINZER V. REMINGTON

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PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
		1. Use suitable equipment		
		2. Check to inspection and manufacturing data on model drawing.		
		3. Use ring B-68582-K to check step #1 on model drawing		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS

9/26/80 - Retyped from 3/28/63 - new form - CAK - 3.7.2.5.3.1

5/7/82 - Added SEVEN LWT - CAK - 28/4/64

MATERIAL: Music wire

HEAT TREATMENT AT: none

COMPONENT CONDITION: FINISHED: X SEMI-FIN.

MODEL NO. 600, 700, 40XB, SEVEN LWT

PART NO. 17047

BLANK DRAWING NO. A-17047

PART NAME Sear Spring

DEPT. NO. 92 PAGE 1 OF 1

RD-6191-1 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535700

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PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free of burrs - noticeable defects		
Mics	Std.	Body Diam.	.096	.094
Comp. Screen	B-700-CL-23	Outline of Part		
Comp. Fixture	Std.			

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100lbs.

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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS 5-1-70-New-AJU-268734
2/5/71 - Make regular - Urtz - 269424
5/7/82 - Added SEVEN LWT - CAK -28144d

MATERIAL: Steel
HEAT TREATMENT KK None
COMPONENT CONDITION: FINISHED: X SEMI-FIN.
MODEL NO. 700 - 40XB, SEVEN LWT
PART NO. 14632
BLANK DRAWING NO. A-14632
PART NAME Trigger Housing Rivet
DEPT. NO. 92 PAGE 1 OF 1

REMINGTON ARMS CO., INC., BRIDGEPORT, CONN.

R2535701

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PROCESS RECORD—INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
		1. Do not set for inspection		
		2. Use suitable equipment		
		3. Check to inspection and manufacturing data on model drawing		
Visual		a. Check ends = open ends ground		
		b. End coil outside diameter not to exceed O.D. of spring		
		c. Check wind = L.H.		
Comparator & standard "Vee" Block		= Check 90° angle of ground ends		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS

3/28/80 - Retyped from 8/15/63 - Updated - CAK -
9/26/80 - Updated - CAK - 27.8807
5/7/82 - Added SEVEN LWT - CAK - 28144

MATERIAL: Music Wire (stress relieve
HEAT TREATMENT AT: none
COMPONENT CONDITION: FINISHED: X SEMI-FIN. 5%
MODEL NO. 700 , 40XB, SEVEN LWT
PART NO. 15400
BLANK DRAWING NO. A-15400
PART NAME Trigger Spring
DEPT. NO. 92 **PAGE** 1 **OF** 1

RD-6491-1 Rev. 5/77 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535702

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES RECORDS

DATES AND REASONS FOR REVISIONS 9/26/79 - Retyped & filed with process no. - 278165 - EB
9/26/79 - Chg. depth .240 to .242 & add plug ga. number - JAA - 278165
11/3/80 - Revised for MRP - RLJ - 279424
12/30/80 - Chg. A,B&C to #33 Drill - JAA - 280034
5/17/82 - Add Seven LW - CAK - 281453

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	Mon 600 700 R.H. Seven LW	700 L.H.				
SPEED / FEED							
	Drill Jig	C-36326					
	Drill #33 (.113 Dia) A,B&C	Std.					
	Plug Ga. .112 - .114	B-80202BB					
	Drill - #24 (.152) - "D"	A-44979					
	Plug Ga. - .151 - .155 dia.	B-80121-U					
	Depth = .242 = .300						

OPERATION DESCRIPTION	PART NO.						
		26655	32905				
Drill Adjusting Screw holes (3) and Sear Spring hole.							

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No Mon 600 Seven LW 700R.H.-700 L.H. OPER. No 55
TYPE MACHINE 4 Spindle Drill Press DEPT No. 8579 PAGE 1 OF 1

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R2535703

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PROCESS RECORDS

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DATES AND REASONS FOR REVISIONS 7/14/70 - Retyped from 6/5/70 - 268830
11/5/70 - Remove "A" - chg. part # - Urtz - 269172 4/20/72 - Added 700 LH - Marley - 270639
11/11/70 - Chg. dept/# - Urtz - 269187 11/3/80 - Revised for MRP - RLJ - 279424
2/5/71 - Make regular - AJU - 269420 - Chg. dept. # 4/7/81 Add RPM - JAA - 280264
6/8/71 - Removed temp. no. - JM - 269775 5/17/82 - Add APPROVAL AND DATES Seven LW - CAK - 281453

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	700 R.H. Seven LW	700 LH				
		Holding Fixture		C-36318	C-36318				
1350RPM		Tap #6 - 40 NF-2		A-88021	A-88021				
		Th'd Plug Ga.		B-80223-W	B-80223-W				
		Plug Gage .118 Go		B-80179EE	B-80179-EE	Trigger Spring hole B-			
		NOTE: Use #780 Oil							

OPERATION DESCRIPTION	PART NO.						
Tap Adjusting Screw holes (3)		26655	32905				

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. Seven LW 700 R.H. - 700 LH OPER. No. 60
TYPE MACHINE Haskins Tapper DEPT. No. 8579 PAGE 1 OF 1

RD-6481

R2535704

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PROCESS RECORDS - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
4/10/81 - Add RAMAC 925758 & 925799 - RLS - 280410
10/29/81 - Remove NOTE - MAH - 280762
5/28/82-ADD 257 RBT-RLJ-281495

DESCRIPTIVE INFORMATION

1. Pick Action from truck - Position and clamp in vise,
2. Pick Bolt Stop - Position in Receiver (Must fit freely) (File slot if necessary)
3. Pick Trigger Assembly.
4. Insert Trigger Assembly in Receiver (Must fit freely) (File slot if necessary)
5. Pick Sear Pin and start (Drive in flush with inside of Bolt Stop cut.)
6. Stake Sear Pin.
7. Pick Bolt Stop Spring - Position in Receiver.
8. Position Trigger Assembly - Pick Bolt Stop Pin and assemble to Receiver.
9. Hold Trigger & press down on Sear - Must NOT bind.
10. Pick Firing Pin Assembly, inspect, point not marred, Bolt Plug color O.K., no rust or miscut.

EQUIPMENT-TOOLS & GAGES

NOTE:- Pins tight - Tester B-80652

Only correct components of good color, not broke or deformed should be used.

003172

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Action (BDL & Classic)	BDL	17	222	22-250	6MM	243	25-06
		925801	925781	925783	925785	925787	925789
		270	270L.H.	7MM EXP	30-06	30-06L.H.	308
		925791	925811	925797	925793	925813	925795
		7MM MAG	7MM MAG L.H.	300 MAG	8MM MAG	7 MM - 08	
		925803	925815	925807	925809	925799	
	Classic	22-250	6 MM	243	270	30 - 06	7 MM Mag
		925854	925858	925860	925868	925866	925872
	PART No.					257 RBT	7 x 57
	GA.					925850	925758

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 BDL Classic OPER. No. 575
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE

R2535705

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from- 280410-MB
10/29/81 - Add New No. 11 & Chg. corresponding No.'s - MCH - 280762
2/26/82 - Changed 15b for new safety - RLJ - 281152

DESCRIPTIVE INFORMATION

11. Lubricate entire threads of Bolt Plug, rear of Bolt Lugs and Cocking Cam on Bolt Body with thin film of Molykote GN paste. Apply with Lube Brush

12. Assemble to Bolt group and remove (U) washer,

13. Check Firing Pin protrusion, NOTE: Ckeck for right Serial No. on Bolt.

14. Insert Bolt into Action and lock down,

15. Try Safety.
    a. Must be clearance between Sear and Trigger Connector with Safety on,
    b. With bolt open, pull safety on. Close bolt & lock down. Must lock down without catching on safety, Bolt must open with safe on.

EQUIPMENT—TOOLS & GAGES

003173

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 BDL - Classic O PER. No. 575
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4
MACHINE

R2535706

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from - 280410 -MB
10/29/81 - Add New No. 11 & Chg. corresponding No.'s - MCH - 280762

DESCRIPTIVE INFORMATION

16. Check Vertical Sear engagement at least .015. Visual
    a. Check for jar off by steady pressure on end of Firing Pin Head, when rifle is cocked, with Safety in off position. (Use end of Hammer Handle).

17. Check notch escape by holding Trigger while closing bolt slowly. Slight detectable Trigger play after firing.

18. Try Safety and Bolt Action - Adjust if necessary.
    a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety halfway off, pull Trigger, must not fire, Push Safety to "OFF" position. Firing Pin must not follower down, Safety must return to "OFF" position under tension. Use downward pressure on Safety. Preform check three times. Trigger Pull Scales B- 70697

EQUIPMENT - TOOLS & GAGES

Trichtest

003174

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 BDL Classic OPER. No 575

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE

R2535707

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 10/29/81 - Retyped from 280410 -MB
10/29/81 - Add New No. 11 & Chg. corresponding No.'s - MCH - 280762
5/18/82 - .006 was .005 - RLJ - 281460

DESCRIPTIVE INFORMATION

19. Weight Trigger pull (3 to 5 Lbs,)
    A. Must be short & crisp, no creep over overdraw, Try 3 times.

20. Pull Safety to "ON" position,

21. Close and lock Bolt down.

22. Try .006 feeler between Sear and Connector.
    a. Must enter with no bind,

23. If clearance is less than .006, replace Safety.

EQUIPMENT—TOOLS & GAGES

.006 feeler gage or suitable shim.

003175

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 BDL Classic OPER. No 575
TYPE BDL MACH. HRS. DEPT. No. 61 PAGE 4 OF 4
LINE

R2535708

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474 5/28/82-ADD 257 RBT-RLJ-281495
4/10/81 - Add RAMAC 925758 & 925799 - RLS - 280410
9/21/81 - Obs. step #4 - MCH - 280751
11/24/81 - Corr. Ramac 925778 - RLS - 280898
3/25/82 - Chg. reading - RLS - 281164

DESCRIPTIVE INFORMATION

1. Get Barrel Assembly from truck and place in holding block on bench.
2. Pick-up and assemble (4) plug screws to top of Receiver with vacuum screwdriver.
3. Turn Barrel Assembly on side.

5. Barrel Assembly aside in truck.

EQUIPMENT—TOOLS & GAGES

Standard Sq. 85 Foredom Driver with intergal vacuum pump #SDA 0501
Bit
Special Finder
Headless set screw tray
Bench

003176

OPERATION DESCRIPTION	OCC. No.	22-250	6MM	243	270	30-06	7MM Mag
	STD. HRS/C	925854	925858	925860	925864	925866	925872
	STD. No.						
Assemble (4) Receiver plug screws.	EFF. DATE	222	22-250	6MM	243	25-96	270
		925760	925762	925764	925766	925768	925770
		7MM EXP	30-06	308	7MM MAG	7 MM - 08	
(ADL, BDL & Classic)		925778	925772	925774	925776	925799	
		17	222	22-250	6MM	243	25-06
		925801	925781	925783	925785	925787	925789
		270	270 L.H.	7MM EXP	30-06	30-06 L.H.	308
		925791	925811	925797	925793	925813	925795
	PART No.	7MM MAG	7MM MAG LH	300 MAG	8MM MAG	257 RBT	7 x 57
	GA.	925803	925815	925807	925809	925850	925758

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 580
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1
MACHINE

R2535709

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474
4/10/81 - Add RAMAC 925758 & 925799 - RLS - 280410
11/24/81 - Corr. Ramac 925791 - RLS -280898
5/28/82-ADD 257 RBT-RLJ-281495

DESCRIPTIVE INFORMATION

1. Pick correct Stock.
   a. Inspect for good finish, mars, no checks - Grip outline uniform and dquare. Grip Cap black - checkering, see sample,
   b. Butt Plate black, rear face must show white all the way around edge. No burrs at screw holes - .020 max. mismatch of Butt Plate or Stock either way,
   c. Assemble correct front Swivel Screw.
2. Pick correct Magazine - inspect for color, no rust,
3. Assemble Magazine to Receiver. (Good color, no mars,)
4. Assemble Trigger Guard to Stock and assemble to Action with front and rear Trigger Guard Screws,
   a. Check for Trigger clearance in Guard, .010 shim must go, both sides. Disassemble & file Guard if necessary.
5. Assemble Magazine Spring to Magazine Follower to Floor Plate. Adjust Floor Plate to Latch properly. (See sample.)
6. Check wood margin at Ejection Port and Receiver tang, per sample. Opening between Stock and Receiver uniform, no bad chipping. Barrel must seat within 1.5 inches of Front of Stock, Vertical squeeze - no movement, Guard Screws tight - See sample for MAX. opening between Stock and Floor Plate.

EQUIPMENT—TOOLS & GAGES

0031177

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
Assemble Stock to Action.	STD. No.						
	EFF. DATE						
(BDL & Classic)	BDL	17	222	22-250	6MM	243	25-06
		925801	925781	925783	925785	925787	925789
		270	270L.H.	7MM EXP	30-06	30-06L.H.	308
		925791	925811	925797	925793	925813	925795
		7MM MAG	7MM MAG LH	300 MAG	8MM MAG	7 MM - 08	
		925803	925815	925807	925809	925799	
	Classic	22 -250	6 MM	243	270	30 - 06	7 MM MAG
		925854	925858	925860	925864	925866	925872
	PART No.					257 RBT	7 x 57
	GA.					925850	925758

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 BDL Classic OPER. No. 085
TYPE M. HRS. DEPT. No. 61 PAGE 1 OF 2

R2535710

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474

DESCRIPTIVE INFORMATION

6. Con't.
Gas hole in Receiver 50% visible above Stock, at least half of side screws visible above Stock.

7. Check Safety - No bind - clears wood.

8. Check Bolt - No bind - clears wood.

9. Check Trigger pull (3 to 5 lbs.)

10. Use dummy Cartridges to check feeding. Extraction and Ejection adjust if necessary.
(Single load and full Magazine.)

11. Stamp assemblers number on left side of Barrel at rear.

12. Pick correct ticket and fill in rifle number etc.

13. Make all necessary repairs from test.

NOTE: Bolt Insert Rod in Chamber end. Rod must have sufficient flannel to clean bore, Wiping Rod #43447

003178

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 BDL Classic OPER. No. 585
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2
LINE

R2535711

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - New for MRP - RLJ - 279474 5/28/82-ADD 257 RBT -RLJ-281495
12/23/80 - Correct Pt. # - RLS - 279913
4/10/81 - Add RAMAC 925758 & 925799 - RLS - 280410
6/10/81 - Added Procedure - JBM - 280596
7/9/81 - Correct Ramac # - RLS - 280672

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C	Classic	22-25092585	6MM925058	243 925860	270 925864	30-0692586(
		"	7MM MAG 925872		7 x 57 925758		257 925850
	STD. No.	ADL	222 925760	22-25092576	2 6MM925769	243 925766	25-06925768
	EFF. DATE	"	270 925770	7MMEXP925778	30-0692577	2 308 925779	7MMMAG925776
Proof Test		BDL	17 925801	222 925781	22-25092578	6MM 925785	243 925787
		"	25-06925789	270 925791	270L 925811	7MMEXP925797	30-0692579
		"	30-06L92581	308 925795	7MMMAG925803	7MMML925815	300MAG925807
		"	8MMMAG925809	7 MM-08 925799			
		Varmint Spe	222 925821	22-250925823	223 925829	6MM925827	243 925829
		"	25-06925831	7MM-08925835	308 925833		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 600
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 85 PAGE 1 OF 9
MACHINE

Form R. D. 6463

R2535712

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

SAFETY BEFORE TEST - All Plant rules, Gallery rules and Job Safety keypoints are to be observed at all times.

I. Guns to be Proofed

A. All guns are to be proofed 100% after final assembly and prior to function testing.

1. Use special remote operated steel covered proofing device and approved booths only. (Do not proof rifles in shotgun proof booths)

II. Proofing Objective

A. To test each guns abilty to withstand the proof round pressure without damage to the gun or distortion of the proof round.

III. Safety

A. Shooting pits are to be inspected each shift before shooting is started and inspection sheet is to be signed. (Refer to General Gallery Safety Rules, Section K.)

B. Open Action of all assembled guns.

PART NAME Gallery Proof COOLANT SET UP TIME MODEL No. 700 OPER. No. 600
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 105 PAGE 2 OF 9
MACHINE

R2535713

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

III. Safety - (Cont'd.)

C. If proof round fails to fire when activated:

1. Pull large knob on side of proofing device and hold (black handle);

2. Push firing button on side of proofing device (green button).

3. If fails to fire second time, wait one (1) minute before opening steel doors to remove shell.

IV. Description and Sequence of Proof Test

A. Visual Inspection - Each gun prior to proof.

1. Mixed calibers (on same truck) must be sorted, leaving one (1) space between each different type.

2. Inspect all centerfire bores for obstruction with rod.

B. Proof Test

Note: The first rifle proofed is to be left off of the truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

R2535714

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 – Added Procedure – JBM – 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test – (Cont'd)

B. Proof Test – (Cont'd.)

1. Pick up first gun from truck and inspect for:

a. Ammunition – Inspect chamber and magazine – both must be empty.

b. Caliber – To verify for shooting safety.

1. If the load has different calibers on it, place a red tag on the barrel of one gun on the truck to alert the testers and targerters of this condition.

c. Magnaflux Stamp – Must be present right rear side of Barrel.

d. Firing Pin Protrusion or Foreign Material at Face of Bolt:

1. Firing Pin must be retracted in the Bolt.

2. Bolt Face and Shroud must be free from any foreign material.

NOTE: Visually check the first gun from each side of the truck for obvious visual defects before and after proof test.

R2535715

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test

2. With action open, place assemble gun in proofing jack - muzzle in port.

3. Load one (1) proof round into chamber of barrel.

4. Close protective steel doors of proofing device.

   a. Closing of left hand door must activitate air cylinder which clamps stock into fixture.

   b. The stops on both doors must contact both relays to activate firing mechanism.

5. Pull large knob on side of proofing device and hold (to position triggering mechanism in fixture).

6. Push firing button on side of proofing device (to operate triggering mechanism).

7. If gun fails to fire, repeat procedure outlined in III - C, 1 - 3.

8. After firing, open doors to proofing device and retrieve fired case.

R2535716

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test

9. Check fired case for:

a. Primer indent - must be sufficient to fire round.

b. Possible ruptures - must not be ruptured or swelled.

c. Rings or roughness - slight rings are permissable - use fingernail test to determine if serious enough to reject.

NOTE: If primer blows, complete sequence 10 and 11 (below) and then check Receiver of gun for primer. If primer can be found, pass gun. If primer can't be found, reject gun and set it aside to reject truck.

10. Move Safety to "ON" position before removing gun from proofing device.

11. Inspect chamber and magazine for live ammunition before removing gun from port.

a. Chamber must be empty.

b. Follower must be visible

12. Remove gun from device and place on bench.

13. Stamp proof mark (REP), right rear side of Barrel on acceptable products only.

a. Bolt action rifles only - stamp prick punch on the underside of the bolt handle, in addition to the proof mark on the Barrel.

R2535717

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - IBM - 280596

DESCRIPTIVE INFORMATION

IV. Description and Sequence of Proof Test - (Cont'd)

B. Proof Test

17. If gun fails proof test - fill out reject ticket and attach to gun.

18. Place gun back on truck.

19. Repeat test on next and succeeding guns.

V. Interpretation of Proof Test

A. Pass Gun

1. If there is no failure at proof.

a. Gun must be free of defects. (Not broken, cracked, split, chipped, deformed or show stress marks.

2. If fired case is within visual specifications as outlined in Item IX - B, 12.

3. If there are no serious visual defects found.

B. Reject Gun

1. If gun fails to withstand proof round pressure.

R2535718

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

V. Interpretation of Proof Test - (Cont'd)

B. Reject Gun - (Cont'd)

2. If fired case fails to meet visual specifications.

3. If any serious visual defects are found before or after test.

VI. Safety After Proof Test

A. Safety

1. Move Safe to "ON" position before removing gun from shooting device.

2. Place the first gun proofed back onto the truck after complete load has been proofed.

B. Inspect Chamber and Magazine for Live Ammunition

1. Chamber must be empty.

2. Follower must be visible.

3. Repeat Items B 1 and 2 (above) on all guns upon completion of proof test.

C. Visually Inspect for Marring by Device or Port

1. Take first (1st) gun from each side of the truck, after test, and carefully check gun for possible damage from the jack or port.

R2535719

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/10/81 - Added Procedure - JBM - 280596

DESCRIPTIVE INFORMATION

C. Visually Inspect for Marring by Device or Port - (Cont'd)

a. If any damage is found, stop testing and have the cause of damage corrected.

b. Resume testing only after correction has been made.

D. Move Entire Load to Next Operation

1. The Model 700 rejects will stay on the original truck when moved to the next operation (Function Test and Target)

R2535720

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 6/3/82 - New - RLJ - 281460

DESCRIPTIVE INFORMATION

1) pick-up rifles from final assemblers rack.
2) Check for live ammo.
3) Check bolt release function while removing bolt.
4) Bolt number to match receiver serial number.
5) Hold trigger rearward and check sear for bind.
6) If a defect is found in steps 3, 4 or 5, return Rifle to assembler, if not, continue to step 7.
7) Insert special dial gage into receiver and measure sear - connector clearance. clearance must be.006 or more. If under .006, return to assembler for new trigger assembly.
8) Truck passed Rifles to gallery.

EQUIPMENT - TOOLS & GAGES

Special dial gage D-44581
bondhus balldriver hex tool 5/64"
Cat. # 10604, series # 106

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C	Cingalo	22-25092505	1-0[illegible]925050	293 925060	270 925060	30-0692506[illegible]
	STD. No.	"	7[illegible]-MM0-925	22	7 x 57 9257[illegible]		
	EFF. DATE	AHL	222 925760	22-2509257[illegible]	2-0[illegible]925769	293 925766	25-0692576[illegible]
Check sear - lift with dial gage		"	270 925770	7[illegible]XI92577	0-30-0692577	2 308 92577[illegible]	7[illegible]M692576
		BBL	17 925003	222 925701	22-2509257[illegible]	GMM 925705	293 925707
		"	25-00925709	270 925791	270 925011	7[illegible]XI92579	30-0692579
		"	30-0692501	308 925795	7[illegible]M692500	7[illegible]L925015	30[illegible]M692506
		"	0[illegible]M692500	7 MM-08 [illegible]25799			
		Varmint Bbl	222 925021	22-2509250[illegible]	3 223 92502[illegible]	G[illegible]925027	293 925029
		"	25-06925031	7MM-0092506	308 925031		
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 597
TYPE Inspection MACH. HRS. DEPT. No. 61 PAGE 1 OF 1
MACHINE Bench

Form R. D. 6469

R2535721

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECOI. —INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from burrs - noticeable defects		
Comp. Screen	D-700-CL-24			
Comp. Fixture	B-36301			
Plug Gage	Std.	Dia. of "A" hole - 3 places	.126	.125
Plug Gage	Std.	Dia. of "B" hole - 4 places	.103	.101
Plug Gage	B-80219-R	Dia. of "D" hole - 1 place	.1247	.1237
Pinning Gage	C-36471	FOR VENDOR USE ONLY (1 GAGE)		
Mics.	Std.	Check material thickness	.064	.060

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS 5-1-70-New-AJU-268737

9/26/80 - Changed part number - was 30781 - CAK - 272534

2/17/81 - Changed part number back to 30781 - CAK 280217

5/7/82 - Added SEVEN LWT - CAK - 281464

10/21/82 - Added material thickness - CAK - 282003

MATERIAL: C-1010 or C-1020

HEAT TREATMENT None

COMPONENT CONDITION: FINISHED: X SEMI-FIN.

MODEL NO. 700 - 40XB - 600, SEVEN LWT

PART NO. 30781

BLANK DRAWING NO. C-30781

PART NAME Trigger Side Plate (Left)

DEPT. NO. 92 PAGE 1 OF 1

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

R2535722

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from burrs - noticeable defects		
Comp. Screen	D-700-CL-24	Position of holes		
Comp. Fixture	B-36301			
Plug Gage	Std.	Dia. of "A" hole - 3 places	.126	.125
Plug Gage	Std.	Dia. of "B" hole - 4 places	.103	.101
Plug Gage	Std.	Dia. of "C" hole - 1 place	.145	.141
Plug Gage	B-80219-R	Dia. of "D" hole - 1 place	.1247	.1237
Plug Gage	Std.	Dia. of "G" hole - 1 place	.103	.101
Pinning Gage	C-36471	FOR VENDOR USE ONLY - (1 GAGE)		
Mics.	Std.	Check material thickness	.064	.060

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS 5-1-70-New-AJU-268737

9/26/80 - Changed part number - was 30780 - CAK - 279534

5/7/82 - Added SEVEN LWT - CAK - 282464

10/21/82 - Added matl. thickness - CAK - 282003

MATERIAL: C-1010 or C-1020

HEAT TREATMENT AT: Remington

COMPONENT CONDITION: FINISHED: SEMI-FIN. X

MODEL NO. 700 - 40XB - 600, SEVEN LWT

PART NO. 32785

BLANK DRAWING NO. C-32785

PART NAME Trigger Side Plate (Right) Blank

DEPT. NO. 92 PAGE 1 OF 1

R2535723

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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DATES AND REASONS FOR REVISIONS 9/29/80 - Revised for M. - FRW - 279121
10/21/80 - Correct part #'s on Bolt Head - CC - 279121
10/2/81 - Chg. page # - RLS - 280813
11/1/82 - Added 7 LW, Chg. page # - Bottini - 281957

DESCRIPTIVE INFORMATION	M/700 22-250 Rem. 243 Win. 6MM Rem. 7MM-08 Rem. 308 Win. 7.62 Nato 40XB 22-250 Rem. 243 Win. 6MM Rem. 25-06 Rem. 7.62 Nato 30-06 40XB-BR 22 BR Rem. 6MM BR Rem. 308 Win.	M/700 25-06 Rem. 270 Win. 7MM Exp. Rem. 7MM Mauser 30-06 40XC 308 Win.	M/700 264 Win. Mag. 7MM Rem. Mag. 300 Win. Mag. 8MM Rem. Mag. 375 H&H Mag. 458 Win. Mag.	40XB 7MM Rem. Mag. 300 Win. Mag. 30-338	M/700 17 Rem. 222 Rem. 223 Rem. 40XB 222 Rem. 40XB-BR 222 Rem. 223 Rem. 6 X 47
--- Indicates Same Part#					
* Max Head					

Bolt Body Assembly	33255	*28831	33256	*28830	33257	*28834	33258	*28835	33259	*28837
Bolt Body	20201	---	20200	---	20200	---	20201	---	20201	---
Bolt Head	15479	*28815	15479	*28815	15706	*28817	15706	*28817	15851	*28819
Ejector Washer	17011	---	---	---	---	---	---	---	---	---
Bolt Pin	18758	---	---	---	---	---	---	---	---	---
Bolt Body Brazing Slug	18493	---	---	---	---	---	---	---	---	---

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 7 LW, 700, 600, XP100, 40XB, 40XC OPER. No.
TYPE MACH. HRS. DEPT. No. PAGE 1 OF 8
MACHINE

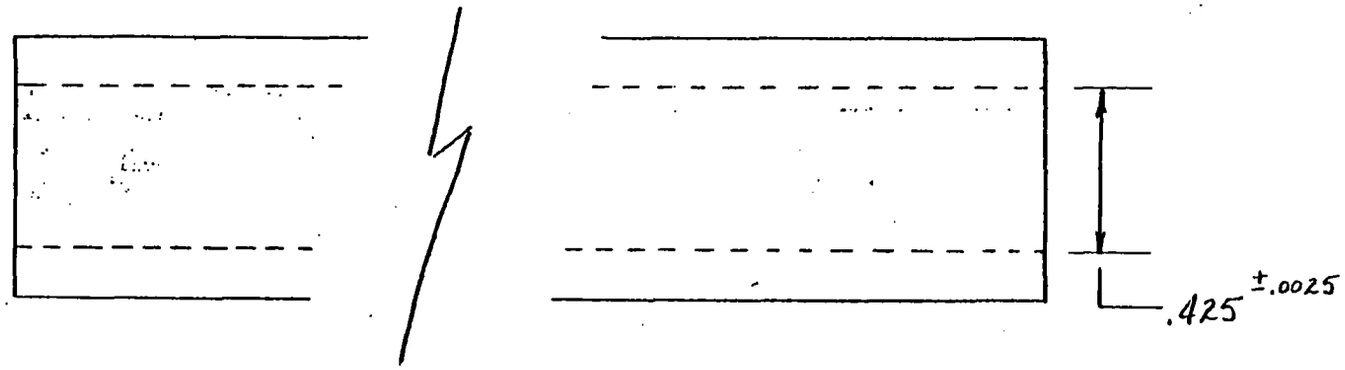
Form R. D. 6466

R2535724

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 4/21/77 - New - RLS - 275875
9/29/80-Update-MRP-FRW-279123
10/2/81 - Was Bolt Body - RLS - 280813
11/1/82 - Add 7 LW,Chg. dept. # - Bottini - 281957

DESCRIPTIVE INFORMATION



PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 700,600,XP-100 , 7 LW OPER. No. 95
TYPE MACH. HRS. DEPT. No. 85 60 PAGE 1 OF 1
MACHINE

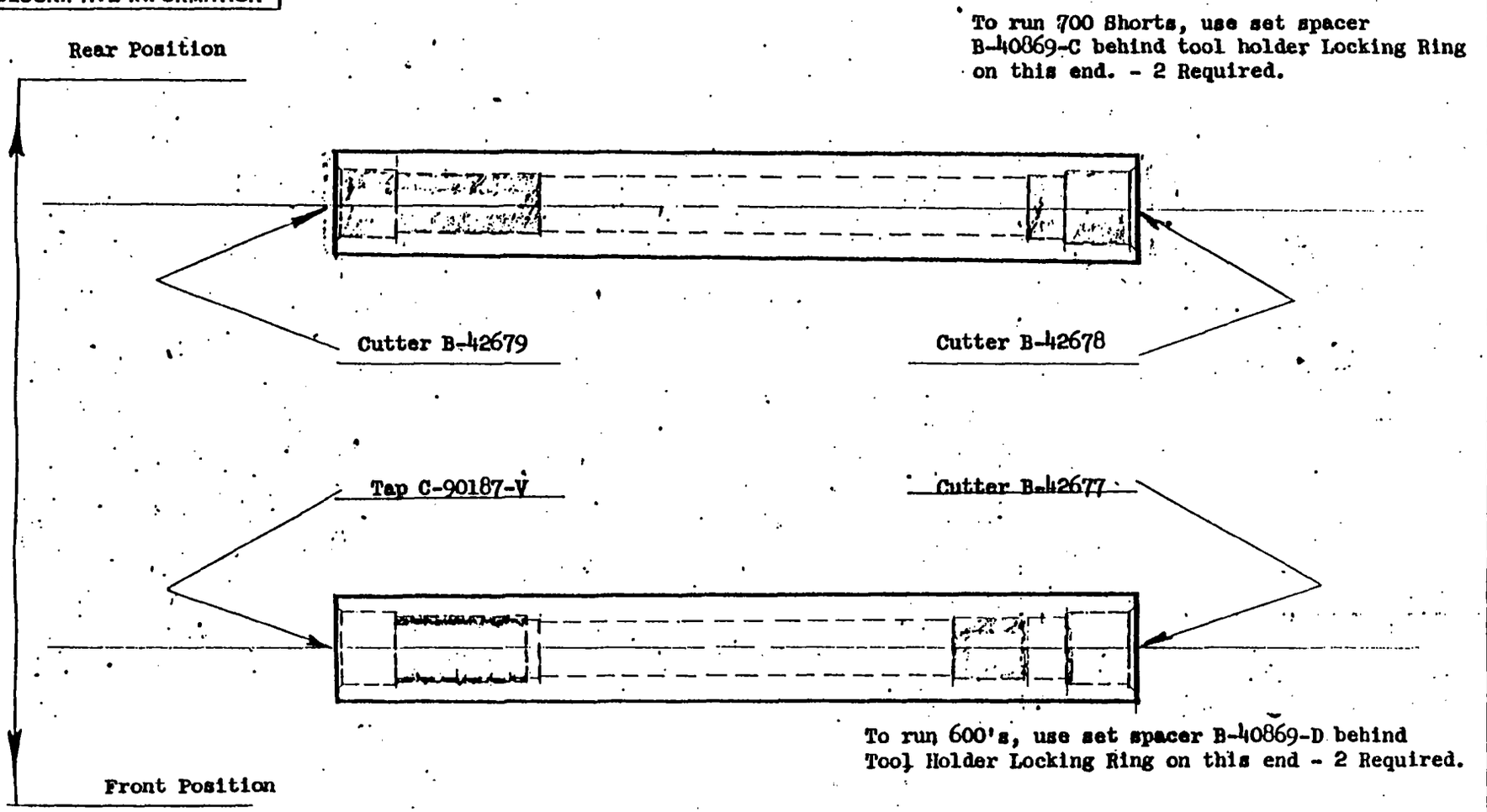
Form R. D. 6466

R2535725

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 10/3/75 - New process - RLJ - 274354
9/29/80-Update-MRP-FRW-279123
10/2/81 - Was Bolt Body - RLS - 280813
11/1/82 - Add 7 LW. Chg. dept. # - Bottini - 281957

DESCRIPTIVE INFORMATION



PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 700 - 600 XP-100,7 LW OPER. No. 100
TYPE MACH. HRS. DEPT. No. 85 60 PAGE 1 OF 1
MACHINE Hause Special Machine

Form R. D. 6466

R2535726

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

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DATES AND REASONS FOR REVISIONS 6/5/72 - New operation for L.H. - MEG - 270805
8/24/72 - Add note - MG - 271043 11/1/82 - Chg. dept. # - Bottini - 281957
10/19/73 - Chg. M/700 part nos. - DJA - 272485
8/29/78 - Correct part nos. - RLS - 277136
9/29/80 - Revised for MRP - FRW - 279121

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Assembling Fixture	D-53890
		Adapter	D-53890-A
		Thread Qual. Loc. Plug	C-51989-N
		Thread Qual. Gage	D-54018
		Thread Qual. Plug Gage	B-40288
		To be used with D-54018	
		NOTE: When assembling washer the radius in the hole of washer should be to the rear of the Bolt. Washer must be seated flat.	

NOTE: Bolt Bodies must be blown clean with air hose before Assembling to heads.

NOTE: 3 Tons Pressure must be used in Assembling Head to Body.

NOTE: 6000# equals .075 deflection on Ga. TS-1764

OPERATION DESCRIPTION	PART NO.	
Assemble Ejector Washer and Bolt Head to Bolt Body Part #'s 33246, 33247 WIP #28833, 28836		NOTE: In Gage D-54018 Gas Escape hole must be up and marks on Plug B-40288 must line up with block.
		33246
		33247
	WIP #	28833
		28836

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 700 L.H. OPER. No. 107

TYPE MACHINE Dennison Multi-Press DEPT No. 8560 PAGE 1 OF 1

RD 8461

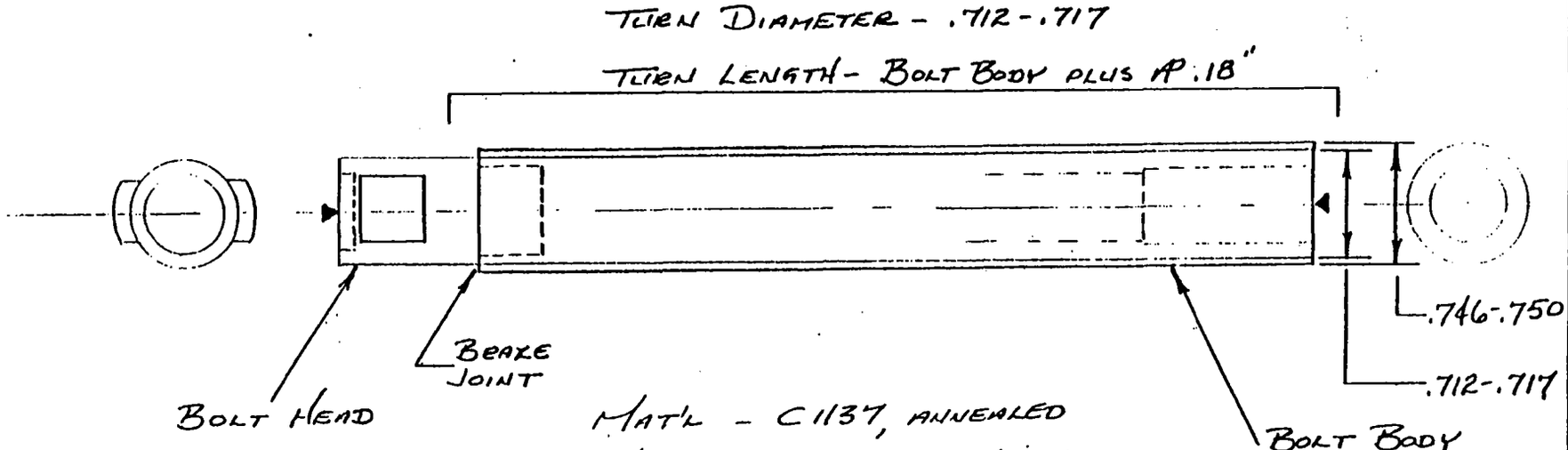
R2535727

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 9/19/77 - New - Bush - 276256
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7 LW, Chg. dept # - Bottini - 281957

DESCRIPTIVE INFORMATION

Bolt Body Assembly



Mat'l - C1137, annealed
Maximum runout - .004 TIR
Maximum out of round - .0005
Maximum taper - .001

C-20200
C-20201
C-15407

PART NAME Bolt Body Assy COOLANT Water Sol SET UP TIME 7 LW MODEL No. 700, 600, XP100, 40XB, 40XC OPER. No. 131
TYPE MACH. HRS. DEPT. No. 8560 PAGE 1 OF 1
MACHINE Burkhard M-1800 Turning Center

Form R. D. 6466

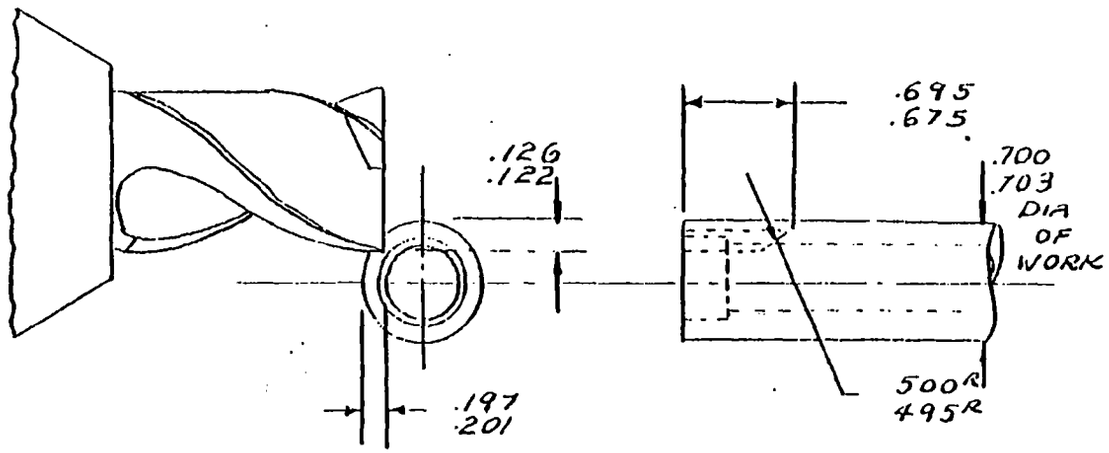
R2535728

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

13

DATES AND REASONS FOR REVISIONS 1/19/62 - Mov -Cook - 256964
2/2/62 - Remove A&ADL - Cook - 257018
3/8/62 - Add Magnum #26827- Cook - 257225
5/29/63 - Added 600 & XP100 - Stafford - 258547
10/17/63 - Chg. operation 35 to 36 - RLS - 9030
11/29/66 - Added models, chg. dept. # - RLS - 263974
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7LW,Chg. dept. # - Bottini - 281957

DESCRIPTIVE INFORMATION



OPER # 35

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 600, 700, XP100, 7LW, 40XB, 40XC OPER. No. 136
TYPE MACH. HRS. DEPT. No. 85 60 PAGE 1 OF 2
MACHINE

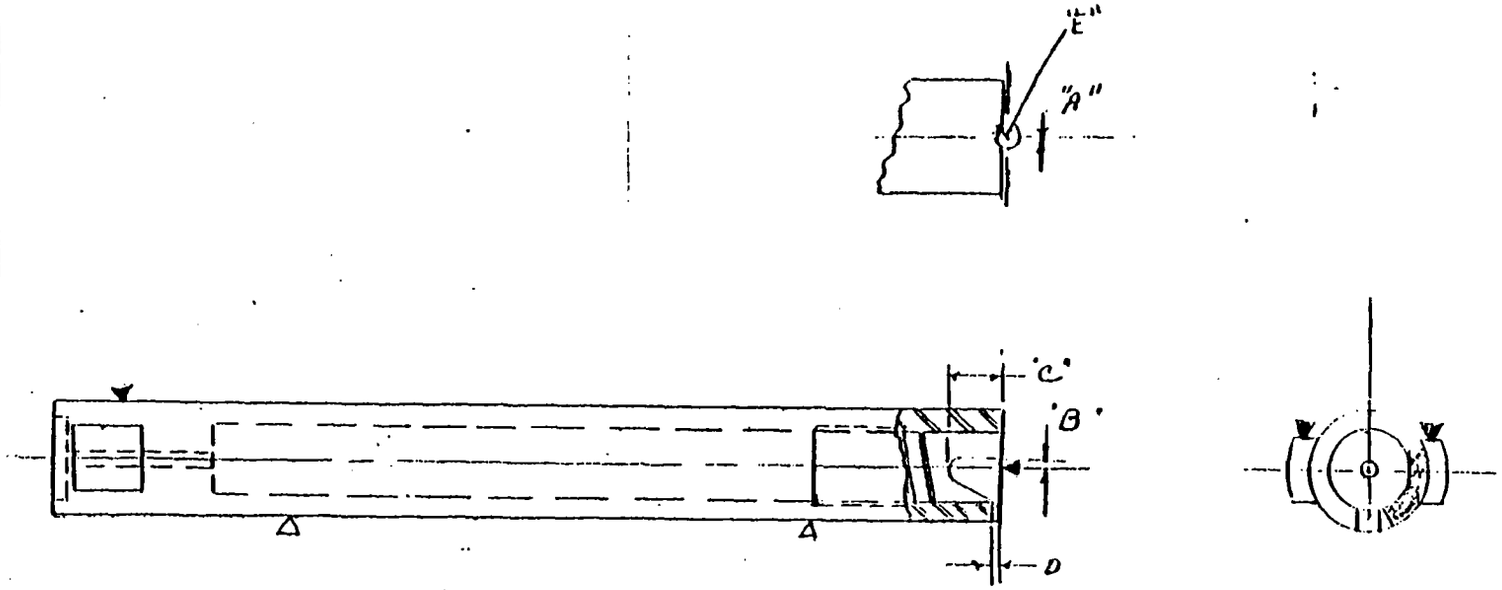
Form R. D. 6466

R2535729

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/19/62 - New operation - Hill - 257926 10/19/73 - Remove O-8 Cinn. - DJA - 272485
5/29/63 - Added 600 & XP100 Stafford - 258547 11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957
10/17/63 - Chg. operation 44 to 36 - DLB - 9030
11/29/66 - Added models, chg. dept. # - RLS - 263974
9/29/80 - Revised for MRP - FRW - 279121

DESCRIPTIVE INFORMATION



PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 7LW, 600, 700, XP100, 40XB, 40XC OPER. No. 136
TYPE Mill Locking Notch Radius and Burr MACH. HRS. DEPT. No. 8560 PAGE 2 OF 2
MACHINE

Form H. D. 6466

R2535730

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 6/5/72 - New operation for left hand - MEG - 270805
10/19/73 - Chg. 700 Part Nos. - DJA - 272485
11/1/82 - Chg. dept. # - Bottini - 281957
10/14/77 - Eliminate wash & add Dasco 1087 - JAB - 276331
8/29/78 - Correct Part nos. - RLS - 277136
9/29/80 - Revised for MRP- FRW - 279121

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	Long
		Fixture		G-39904
		Top Locator		D-39904-D
		Bottom Locator		D-39904-B
		Top "V" Block		D-39904-4
		Bottom "V" Block		D-39904-2
Mill	Safety Cut			
		Kwiklock Holder		
		TIHL - 9B-4		Std.
		Kwik Lok Adapter		
		TIEA 4-8		Std.
		"T" Cutter		A-80741
		Dial Gage for Position		E-39985
		195 ± .002 Dial		E-39985-V
		Dial Gage for Depth		E-39985
		.121 ± .002 Dial		E-39985-W
		Gage for Runout		A-50452
		.675 - .695		

OPERATION DESCRIPTION	PART NO.	33246
		33247
mill Safety cut, Cocking notch and radius and burr.	WIP #	28833
		28836
Part #33246, 33247		
WIP #28833, 28836		

APPROVAL AND DATES

PART NAME Bolt Body Assembly COOLANT Dasco 1087 SET UP TIME MODEL No. 700 L.H. OPER. No. 140
TYPE MACHINE Rem. Special Machine G-75044 DEPT No. 8560 PAGE 1 OF 2

NO 6461

R2535731

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 11/1/82 - Chg. dept. # - Bottini - 281957

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES				
MILL COCKING NOTCH AND RADIUS AND BURR								
		Kwik Lok Holder TIHL-9B-4	Std.			NOTE: Gage 1 out of 10 pcs. on gage C-53158 and E-39985		
		Kwik Lok Adapter TIEA-4-6	Std.					
		End Mill .199 dia.	A-82445					
		Dial Gage for Position of radius ± .003	C-53158					
		Top "V" Block	C-53158-F					
		Dial Ga. Position of Cocking notch .0975 ± .0035 - Dial	E-39985 E-39985-Z					
		Dial Ga. Depth of Cocking notch .270 ± .005 Dial	E-39985 E-39985-X					
		Dial Ga. Depth of radius .0325-.0025 - Dial + .0075	E-39985 E-39985-Y					
		Setting Master	C-39985-8					
		Dial Ga. for squareness of position of Cocking notch (Set-up only)	D-85979			NOTE: Difference in Dial reading between each lug may not vary more than .007		
		Center	D-85979-A					

PART NAME Bolt Body Assembly COOLANT Dasco 1087 SET UP TIME MODEL No. 700 L.H. OPER. No. 140

TYPE MACH. HRS. DEPT. No. 8560 PAGE 2 OF 2

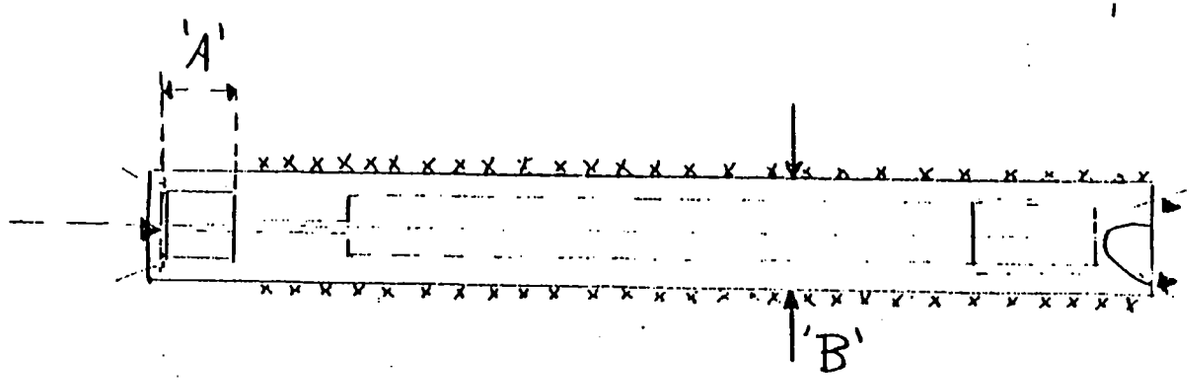
MACHINE

R2535732

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1-27-71 Tie-up - Angular Plunge Grind op. alternate to op 72 - 11/1/82
6/5/72 - Make 74A regular - add left hand - MDG - 270005
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957

DESCRIPTIVE INFORMATION



PART NAME BOLT BODY ASSEMBLY COOLANT SET UP TIME 7LW MODEL No 600, 700, XP100, 40XB, 40XC OPER. No. 174
TYPE ANGULAR PLUNGE GRIND CYCL. GRINDER MACH. HRS. DEPT. No. 8560 PAGE 1 OF 2
MACHINE

Form R. D. 6466

R2535733

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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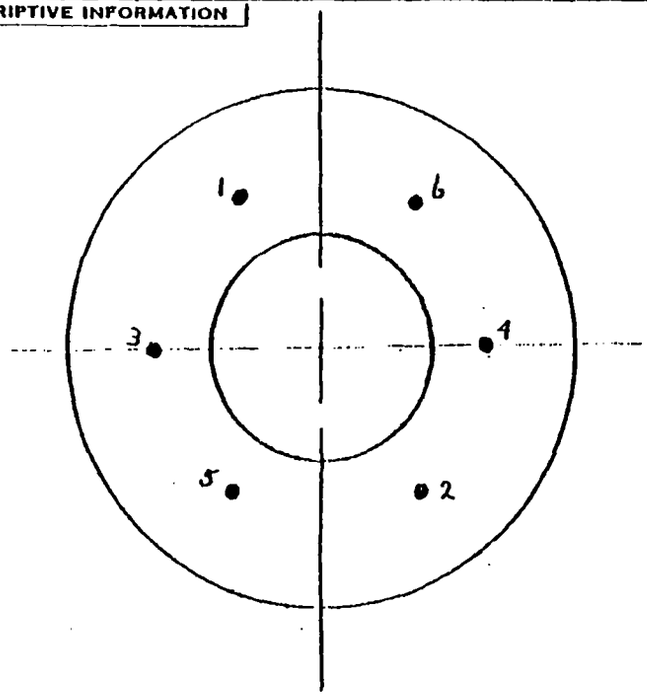
DATES AND REASONS FOR REVISIONS 7-27-72 Used Angular Plunge Grind - TJPG

5/5/72 - Added info. - Greene - 270705
6/5/72 - Chg. from alternate to reg. - & add left hand M/700 - MEG - 270805
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957

DESCRIPTIVE INFORMATION



Order of tightening
1-2-3-4-5-6

Wheel Torquing Procedure

See instruction manual pages 6-1, 6-2 and 6-3 for mounting wheel on wheel mount and mounting wheel on the spindle,

Use Torque wrench to tighten six collet assembly screws on wheel mount. Tighten screws diametrically opposite each other to 15 foot lbs. Repeat to 25 foot lbs. DO NOT EXCEED 25 FOOT LBS.
Check Torque after first 8 hours of operation and every two weeks thereafter.

Use Torque wrench to tighten the six holding screws through the wheel mount and into the end of the spindle. Tighten screws to 40 foot lbs. by the same procedure as used in the wheel mounting instruction above.

ARMSTRONG ARMALOY - (Superior Distributors)
Reflex Torque Wrench - 1/2" Square Drive #62152 Cat. #SR 50
Hex Driver and Bit #59080 Cat. #SA-16

PART NAME BOLT BODY ASSEMBLY COOLANT SET UP TIME 7LW, MODEL NO. 600, 700, XP100, 40XB, 40XC OPER. No. 174
TYPE ANGULAR PLUNGE GRIND MACH. HRS. DEPT. No. 8560 PAGE 1 OF 3
CLAW, BRIDGE MACHINE

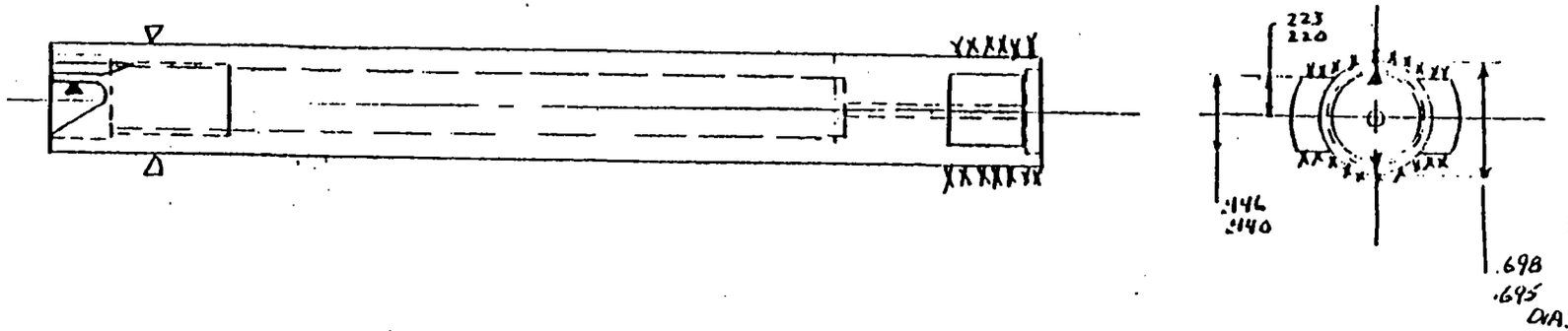
Form R. D. 6166

R2535734

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/19/62 - New - H111 - 257926
5/29/63 - Added 600 & XP100 - Stafford - 250547
11/29/66 - Added models, chg. dept. # - R.B - 263974
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7IW - Chg. dept. # - Bottini - 281957

DESCRIPTIVE INFORMATION



PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL NO. 7IW, 600, 700, XP100, 40XB, 40XC OPER. No. 179
TYPE GRIND LUGS TOP AND BOTTOM MACH. HRS. DEPT. No. 85 60 PAGE 1 OF 1
THOMPSON TYPE "B" 10A30 AUTO SURFACE GRINDER MACHINE

Form R. D. 6466

R2535735

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

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DATES AND REASONS FOR REVISIONS 6/5/72 - New operation left hand M/700 - MEG - 270805
6/22/72 - Chg. grinding wheel designation & add note - MEG - 270888 7/12/78 - Revise Part No's - RLS - 277054
8/23/73 - Add headstock center - DJA - 272303 8/29/78 - Correct Part nos. - RLS - 277136
10/19/73 - Chg. 700 part nos. - DJA - 272485 9/29/80 - Revised for MRP - FRW - 279121
10/18/77 - Add Dasco 1087 - Bush - 276337 11/1/82 - Chg. dept. # - Bottini - 281957

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.			SPEED	FEED
Grind Fixture	D-40348	D-40348			
Grind Wheel Formed	ME81925 *	12" Dia.			
Overall Form Min. Dec.	C-53694	C-53694			
Adjacent Snap Ga. .446-.440	B-001301I	B-001301I			
Center Nose	B-06659-B	B-06659-C			
Adjacent Snap Ga. Dia. of Bolt Head .690-.695	B-00100-M	B-00100-M			
Headstock Center	A-41634	A-41634			
Location Center	A-06873	A-06873			
(Visual Inspect for blend					
(between Lugs and Body .003 Max.					
(Mismatch allowable					
Dial Gage .223 - .220(Setup only)	D-05979	D-05979			
Center	D-05979-A	D-05979-A			
Wheel Truing Diamond Roll	C-30508	C-30508			
Coolant - Dasco 1087	Mix 50 parts	water to 1 part	Dasco		
Grinding Dog	C-06460	C-06460			
			* NOTE: If formed wheel ME81925 not available, use 38A80I6VBE Type 1		
Grinding Dog Driver	B-41235	B-41235			

OPERATION DESCRIPTION	PART NO.		
	WIP #	28833	28836
Grind Lugs Top & Bottom			
Part # 33246, 33247		33246	33247
WIP #28833, 28836			

PART NAME Bolt Body Assembly COOLANT Dasco 1087 SET UP TIME MODEL No. 700 L.H. OPER. No. 182
TYPE MACHINE Thompson Auto Surface Grinder DEPT No. 8560 PAGE 1 OF 1

RU-6461

R2535736

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/10/70 - New - CAR - 276885
11/3/80 - Revised for MRP - FRW - 279397
11/3/82 - [redacted] - JBM
[redacted] - ADDED NOTES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED							
Select sample for Chem. & Met. inspection.							
NICKEL TEST:							
1) VISUAL FOR							
A) PITTING							
B) RAINBOW EFFECT							
C) PEELING							
2) SCRATCH TEST WITH NICKEL FOR ADHESION.							
3) SPOT TEST WITH COPPER SULFATE FOR PLATE QUALITY							

OPERATION DESCRIPTION	PART NO.						
[redacted]					91470		
Sample inspect plating.							

PART NAME Saer Safety Cam (P.M.) COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 59
TYPE MACHINE DEPT. No. 92 PAGE 1 OF 1

R2535737

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS / EMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/29/82 - New - JBM

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
LABEL PAN WITH RED TAG MARKED "READY FOR PLATE"	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91470					
	GA.						

PART NAME SEAR, SAFETY CAM (Powder Metal) COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 57

TYPE MACH. HRS. DEPT. No. 79 PAGE 1 OF 1

MACHINE

Form R. D. 6465

R2535738

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Inspect for defects.		
Plug gage	B-80002-V	Check hole dia.	.128	.126
Width Gage	A-50125	Check inside ears.	.310	.300
Comp. Fixture		Check Contour		
Comp. Screen	B-700A-CL-7	Use with above.		
Mics.	Std.	Check thickness.	.021	.019
Mics.	Std.	Check height of dimple	.020	.010

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 3%

DATES AND REASONS FOR REVISIONS

8/15/63 - Retyped from 8/28/61 - J. Chesebrough
8/22/73 - Changed Heat Treat Specs. - LBB 272318
6/2/77 - Add part no 90557 & 700 LH - SB - 276003
3/28/80 - Revised - CAK - 279291
9/26/80 - Updated - CAK - 279534
5/7/82 - Added SEVEN LWT - CAK 282147
12/1/82 - Obsolete 90557, Add 92546 - SB 283142

MATERIAL: AISI C-1095
HEAT TREATMENT AT: Vendor
COMPONENT CONDITION: FINISHED: X SEMI-FIN.
MODEL NO. 700, 700LH, SEVEN LWT
PART NO. 15368 92546
BLANK DRAWING NO. B-15368, B-92546
PART NAME Safety Detent Spring
DEPT. NO. 9992 PAGE 1 OF 1

RD-6191-1

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

R2535739

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES / REASONS FOR REVISIONS ~~12/30/82 - New TPM 20210~~
NEW-RLS

DESCRIPTIVE INFORMATION	EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
Label pan with red tag marked " Ready for Plate "	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
		WIP #92800					
	PART No.	~~91470~~					
	GA.						

PART NAME Sear Safety Cam (Powder Metal) PLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 57
TYPE MACH. HRS MACHINE DEPT. No. 8579 PAGE 1 OF 1

Form R. D. 6465

R2535740

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 5/10/78 - New - CAK - 276885
11/3/80 - Revised for MRP - FRW - 279397
12/30/82 - Added notes JBM - 282165

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	SPEED	FEED

Select sample for Chem. & Met. inspection.

Nickel Test:
1. Visual for
A. Pitting
B. Rainbow effect
C. Peeling

2. Scratch test with nickel for adhesion.

3. Spot test with copper sulfate for plate quality.

OPERATION DESCRIPTION	PART NO.
Sample inspect plating.	91470

PART NAME Saer Safety Cam (P.M.) COOLANT SET UP TIME MODEL No. Moh.600 OPER. No. 59

TYPE MACHINE DEPT. No. 92 PAGE 1 OF 1

R2535741

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

18

DATES AND REASONS FOR REVISIONS ~~5/10/78 — New — CHK — 076082~~
~~11/3/80 — Revised for MRP — IRM — 279397~~
~~12/30/82 — Added notes IRM — 282165~~
NEW - RLS

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
	Select sample for Chem. & Met. inspection.	
	Nickel Test:	
	1. Visual for	
	A. Pitting	
	B. Rainbow effect	
	C. Peeling	
	2. Scratch test with nickel for adhesion.	
	3. Spot test with copper sulfate for plate quality.	

OPERATION DESCRIPTION	PART NO.	
Sample inspect plating.	MIP #92801	~~91470~~

PART NAME Sacr Safety Cam (P.M.) COOLANT SET UP TIME MODEL No Moh.600 OPER No. ~~50~~

TYPE MACHINE DEPT No. 91 92 PAGE 1 OF 1

R2535742

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND RE ONS FOR REVISIONS 1/4/83 - Make Regular -K - [illegible]2163

DESCRIPTIVE INFORMATION

1. See Gallery procedure

EQUIPMENT—TOOLS & GAGES

R.S. Windage Gage - A-82384

F.S. Gage - A-82421

Bending Tool - B-82825

Line O sighter for new Rear Sight D-36871
R.S. Windage Gage for new Rear Sight A-41114
Locating Block R.H. C-41111-A
Locating Block L.H. C-41111-B

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Test and Target - Field Grade	PART No.	924788	924786	924784	924782	924780	
	GA.	308	7mm-08	6mm	243	222 Rem.	

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 7 LWT OPER. No.

TYPE MACH. HRS. DEPT. No. 8085[illegible] PAGE 1 OF 18

MACHINE

R2535743

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K 282163

DESCRIPTIVE INFORMATION

SAFETY BEFORE TEST: All Plant rules, Gallery rules and Job Safety Key Points are to be observed at all times.

I. Guns Tested and Targeted

A. All guns 100% are to be tested and targeted simultaneously after Proof.

B. Record results of testing and targeting on forms provided. (See Gallery Foreman for instructions)

II. Test and Target Objectives

A. Function: To check the ability of each gun to satisfactorily load, feed, close, lock, fire, unlock, open, extract and eject and for proper operation of the Safety.

B. Accuracy: To check the ability of each gun to satisfactorily meet specifications for point of impact and/or group size.

C. Visual: To check the ability of each gun to satisfactorily meet appearance specifications for front and rear sights and general overall presentability.

III. Shooting Range

A. Use accuracy device provided for this model.

1. Adjust and set device with master gun for each caliber and bullet weight used, as necessary.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 282163

DESCRIPTIVE INFORMATION

III. Shooting Range - (Cont'd)

B. Use Centerfire Targeting Range - 100 yards (300 ft.)

1. Use grid type targeting paper.

2. Use line-o-sighter and spotting scope as outlined in Item V "Description of Test/Target"

C. Setting of Master Guns

1. All set to zero by authorized personnel.

2. Use heavy grain bullet where two are specified.

IV. Specifications

A. Function Testing

1. Loading:

a. Magazine must accept total rounds specified for caliber - See Table IX - A thru C.

b. Cartridges must be retained by rails in Receiver - must not "jump out".

c. If,using normal force, the bolt will not close over a live round in the chamber, perform the following test:

i) Insert the appropriate expanding dummy into the chamber while the gun is held in the test device:

PART NAME Gallery Test and Targeting COOLANT SET UP TIME MODEL No. 7 LWT OPER. No. 610

TYPE Procedures and Specifications MACH. HRS. DEPT. No. 8085 PAGE 3 OF

MACHINE

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R2535745

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KINZER V. REMINGTON

DATES AND F SONS FOR REVISIONS 1/4/83 - Make REgular - K - 82163

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd)

A. Function Testing - (Cont'd)

2. Feeding: (with Magazine loaded)

a. Must feed single (1) shell with each operating stroke of Bolt.

b. Must not double feed.

c. Shells must not stem chamber of Magazine.

d. Bolt must not override shells in Magazine.

e. Single load with Magazine empty.

a. Same as "a" & "c" above.

3. Closing: At start of test, Magazine loaded to capacity, hold shells down in Magazine to start Bolt over shell column, release pressure on shells and close Bolt on empty Chamber.

a. Bolt must close over full Magazine with normal pressure (empty chamber).

b. Bolt must close with normal pressure (Shell in chamber).

c. IF, using normal force, ...

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 7 LWT OPER. No. 610

TYPE Procedures and Specifications MACH. HRS. DEPT. No. 8085 PAGE 4 OF 18

MACHINE

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Refer to : page 4 (7 LWT)
page 4 (700 ADL '83)
page 6 (788)
page 4 (700 ADL, 700 BDL)

INSERT THE FOLLOWING INTO (4) PROCESS RECORDS

CLOSING

a.

b.

c. IF, USING NORMAL FORCE, THE BOLT WILL NOT CLOSE OVER A LIVE ROUND IN THE CHAMBER, PERFORM THE FOLLOWING TEST :

i) INSERT THE APPROPRIATE EXPANDING DUMMY INTO THE CHAMBER WHILE THE GUN IS HELD IN THE TEST DEVICE :

CALIBER	USE DUMMY NUMBER
30-06, .270, 25-06	C-45930
7MM-08, .308, .243	C-46194
6MM REM.	C-46195
7MM REM. MAG.	C-46196
.222 REM.	C-46197
.223 REM.	C-46198
.22-250 REM.	C-46199
300 WIN. MAG.	C-46200
.17 REM.	C-46201
ALL OTHERS	NO EXPANDING DUMMY

(STORAGE CABINET IS D-46202).

ii) CLOSE AND OPERATE THE BOLT

— — — IF BOLT CLOSES HARD OVER THE EXPANDING DUMMY, REJECT THE GUN FOR C.H. AND RECORD THE MALFUNCTION ON THE WHITE TICKET (RD6654) AND THE PINK TEST SHEET (RD 6642).

— — — IF THE BOLT DOES NOT CLOSE HARD OVER THE EXPANDING DUMMY, DO NOT REJECT THE

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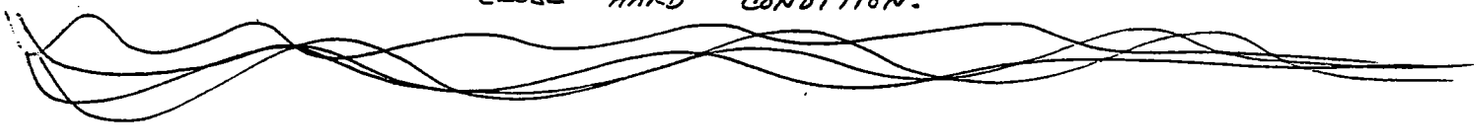
GUN FOR "CLOSES HARD". THIS INDICATES THAT OVERSIZE AMMUNITION CAUSED THE APPARENT "CLOSE HARD" CONDITION.



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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd)

A. Function Testing - (Cont'd)

4. Locking: With Bolt closed on empty chamber or with shell in chamber as in Item 3.

a. Bolt must lock up with normal pressure (shell in chamber or empty chamber)

b. Extractor must cam over shell rim without excessive pressure or bind.

5. Firing: After each full operating cycle of Bolt - Safe in "OFF" position.

a. Gun must fire when Trigger is pulled.

6. Unlocking: With Bolt in closed position and locked as in Items 3a, 3b, 4a, raise Bolt Handle counterclockwise to unlock.

a. Must unlock with normal pressure.

7. Opening: After unlocking.

a. Bolt must travel full stroke to rear position to stop with normal pressure.

b. Bolt must not pull out of Receiver.

8. Extraction: With fired case or live round in chamber - unlock and open Bolt to rear position.

a. Case or shell must be completely removed from chamber.

b. Case or shell must be retained in head of Bolt by Extractor - not fall out - untill ejected.

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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd)

A. Function Testing - (Cont'd)

9. Ejection: With fired case or live round fully extracted from chamber.

a. Case or shell must be completely ejected from gun by ejector.

10. Case Inspection: One fired case from each gun must be visually inspected for indent and condition of fired case (chamber defects).

NOTE: 1. All guns 100%, shall be tested for function.

2. Functional items are applicable to all rounds fired.

3. Where two bullet types are specified, use the heavy grain bullet type on one side of the truck and use the light grain bullet type on the opposite side.

a. Do not mix bullet types in the same test gun.

B. Open Sights

Normal Appearances

1. Front Sight Ramp and Sight

a. Ramp must be central on Barrel and straight with line of sight.

b. Must conform to barrel - good fit - no excessive opening at sides or ends - screwed tight to Barrel.

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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd)

Normal Appearances - (Cont'd)

1. Front Sight Ramp and Sight

c. Front Sight must be reasonably central on ramp - tight in dovetail - not bent, twisted, tipped or deformed.

2. Rear Sight Ramp and Sight

a. Ramp must be central in Barrel and straight with line of sight - level crosswise with Front Sight Ramp.

b. Must conform to Barrel - good fit, noexcessive opening at sides or ends, screwed tight to Barrel.

c. Rear Sight and Eyepiece must be level crosswise with line of sight as viewed from rear. Not tipped, twisted or bent.

d. Mark on elevating piece set to coincide with fourth mark from rear on rear sight ramp.

e. Rear Sight Eyepiece good fit on dovetail of elevating slide - no excessive opening.

f. Rear Sight Eyepiece positioned central crosswise with Windage Screw.

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DATES AND R IONS FOR REVISIONS 1/4/83 - Make Regular - K - 2163

DESCRIPTIVE INFORMATION

IV. Specifications - (Cont'd)

C. Acceptance Limits for Sight Line - (No Point of Impact)

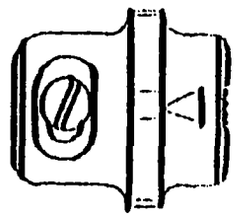
Caliber	Elevation		Windage	
	High	Low	Left	Right
All	2"	8"	9"	9"

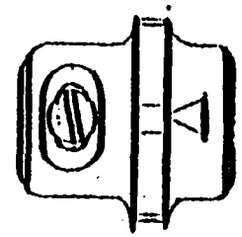
NOTE: 1. Acceptance limits only apply when sights are positioned on the gun as described in Item IV - B. Sights must be capable of adjustment to 0" x 0". With point of inpact within the sight limits described in Item IV - D, below.

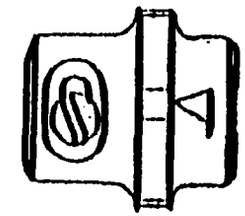
D. Rear Sight

1. Elevation - Mark on elevating slide may be adjusted to any position on the ramp between the second line fron the rear to the third line from the front of the ramp.

2. Windage - Eyepiece may be adjusted crosswide on elevating piece to any position with windage screw within the length of the adjusting slot. Must show full width of screw retaining shoulder - minimum - at side of screw after sdjustment.







PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 7 LWT OPER. No. 610

TYPE Procedure and Specifications MACH. HRS. DEPT. No. 8085 PAGE 8 OF 18

MACHINE

Form R. D. 6466

R2535752

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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

IV. Specifications -(Cont'd)

E. Point of Impact

1. Definition - Using line-o-sighter, the mean average position of all shots fired in the group from point of aim be within the limits set in Item IV - C, above.

F. Group Size - Definitions

1. Center to Center - Maximum extreme spread from inside edges of holes farthest apart.

2. Inside to Inside - Maximum extreme spread from inside edges of holes farthest apart.

V. Description of Test/Target - Each gun as received, bolt in open position - Safe in "OFF" position.

NOTE: The first rifle tested and targeted is to be left off of truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

A. Test/Target Description

1. Remove tickets from guns and place on top of truck.

2. Pick up gun from truck and inspect for:

a. Safety - Inspect chamber and Magazine - both must be empty.

b. Caliber - To verify for shooters personal safety in selecting ammunition for test.

Form R. D. 6466

R2535753

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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

V. Description of Test/Target - (Cont'd)

A. Test/Target Description - (Cont'd)

2. Pick up gun from truck and inspect for:

c. Proof Mark on Barrel (REP) must be present, right rear side of Barrel, ahead of Magnaflux stamp.

d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt Handle.

e. Visual Defects - If not within specifications for items a - d, reject gun at this point.

f. Normal sight alignment - as described in IV-B.

NOTE: Visually check the first gun from each side of the truck for marring by jack or device - Before and After it is test/targeted.

3. With safe in "OFF" position - close Bolt crisply on empty chamber.

a. Firing pin must not follow down as Bolt cams shut.

b. Must not fire on closing.

4. Move safe to "ON" position and raise Bolt.

a. Must raise or open.

5. With safe still "ON" - pull Trigger firmly.

a. Gun must not fire.

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd)

A. Test/Target - Description

6. With finger off Trigger - move safe to "OFF" position.

7. ~~Open and close Bolt full stroke to cock firing pin.~~

8. Move safe to full rear "ON" position and then move to half way "OFF" position with thumb only, if possible.

9. If safety stops at half-way position - pull Trigger.

   a. Gun must not fire.

   b. Safety must not move to full "OFF" position after pulling trigger.

10. If safety stops in halfway position, move safe to "OFF" position after pulling trigger.

    a. Gun must not fire.

IMPORTANT - Perform Items V-A, 3-10 a total of three times.

11. With Action open, position gun in device and clamp.

12. Lower line-o-sights and adjust device to point gun on target paper if necessary.

13. Remove line-o-sighter.

14. Load Magazine to capacity - see table #1 and #2, Item IX - for Magazine capacity by caliber.

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DATES AND .SONS FOR REVISIONS 1/4/83 - Make Regular - K . 82163

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd)

A. Test/Target - Description

15. Hold cartridges down in Magazine, start Bolt over Cartridge column and close Bolt on empty chamber.

16. Open Bolt full stroke to rear position.

17. Assemble Firing Pin Trip Pin in device.

18. Close guard.

19. Close Bolt to feed shell into chamber and lock - to start test.

20. Fire gun by pushing (2) two buttons on device simmultaneously.

21. Check each shot with spotting scope for gun "seating in" and position of shots on paper.

    a. Adjust device if shots off paper or group too close ot edge.

22. Operated action full cycle to extract, eject, and feed each shot.

23. Fire all rounds required for regular seating and targeting.

    a. If additional rounds beyond Magazine capacity are required to meet accuracy specifications, single load and fire additional rounds.

    b. If last shell in Magazine is not needed to satisfy accuracy specifications, feed shell into chamber, and extract and eject unfired round.

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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 282163

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd)

A. Test/Target - Description

24. Open Guard.

25. Lower Line-o-sighter onto sights and check point of impact and group size.

    a. Cross hairs in scope must line up with average position of shot pattern within point of impact specifications.

    b. Spread of holes must be witnin group size specifications.

26. Remove line-o-sights.

27. Unclamp and remove gun from device.

28. Inspect chamber and magazine for live ammunition.

    a. Chamber must be empty.

    b. Follower must be visible.

29. Place gun back on truck.

30. Repeat Test/Target on next and succeeding gun.

31. Replace gun tickets to Barrels on guns.

Form R. D. 6466

R2535757

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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

V. Description of Test and Target - (Cont'd)

B. Test/Target Stamping - (Acceptable Product Only)

1. When all guns have been tested/targeted, move entire load to stamping bench.

2. Place stamp, right rear side of barrel, ahead of the Proof (REP) stamp.

a. Rejected guns are not to be stamped.

3.Replace gun to truck.

VI. Retest - None, unless ammunition, man, or method are questioned.

VII. Interpretation of Target - Test

1. Within specifications for:

a. Visual Items and,

b. Functional requirement and,

c. Point of impact within specified number of shots and,

d. Group size (on required guns) within specified number of shots and,

e. Within limits of Eyepiece and Front Sight acceptance limits.

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 7 LWT OPER. No. 610

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DATES AND REASONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

VII. Interpretation of Target - Test

B. Reject Gun

1. Not within specifications:

a. For any one (1) or more of the listed under A-1 above.

b. Record all malfunctions on target and on reject ticket which is attached to gun.

1. Reject ticket to be written and attached to gun before next gun is test/targeted.

VIII. Safety After Test

A. Open Bolt

1. Move Bolt to open position before removing gun from accuracy device.

B. Inspect Chamber and Magazine for live ammunition

1. Gun must be empty.

2. Follower must be visible.

NOTE: Perform "A" & "B" above on each individual gun immediately after shooting test. Repeat "B" for all guns on truck on completion of test.

C. Visual Inspect for marring by device or port:

1. Take first gun from each side of truck, after test, and check for any possible damage to gun from the test.

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 7 LWT OPER. No. 610

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DATES AND SONS FOR REVISIONS 1/4/83 - Make Regular - K - 282163

DESCRIPTIVE INFORMATION

VIII. Safety After Test - (Cont'd)

D. All guns are moved to Ammunition Inspection Area

1. See Job Safety Key Points for proper Ammunition Inspection Procedure.

IX. Ammunition Specifications and Rounds Required

A. Table 1 - Field Grade Rifles - Standard Barrel - (Front and rear sights assembled)

Caliber	Ammunition Type	Mag. Capacity	Minimum Rounds Required			
			Function Load	Test Fire	POI	Group Size
6mm	100 gr. PSP-80 gr. HPPI	4	4	3	3 Rds.	3 to 5 Rds.
222	50 gr. PSP- 50 gr. HPPI	5	5	4	3 Rds.	3 to 5 Rds.
308	180 gr. SP-150 gr. PSP	4	4	3	3 Rds.	3 to 5 Rds.
243	100 gr. PSP-80 gr. HPPI	4	4	3	3 Rds.	3 to 5 Rds.
7mm-08	140 gr. PSP	4	4	4	3 Rds.	3 to 5 Rds.

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R2535760

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DATES AND SONS FOR REVISIONS 1/4/83 - Make Regular - K - 82163

DESCRIPTIVE INFORMATION

NOTES: (These notes pertain to Tables IX, A-C and X, A-C)

Field Grade Guns - Standard Barrel - (Front and Rear Sights Assembled)

1. Function Test all guns 100%.
2. Target all guns 100% for sight alignment to point of impact.
3. Inspect all guns 100% for group size.

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. 7 LWT OPER. No. 610

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MACHINE

Form R. D. 6466

R2535761

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PROCESS RECORD – INSPECTION

GAUGES TYPE	GAUGES NUMBER	USE	LIMITS MAX.	LIMITS MIN.
Visual		Check for burrs and visual defects.		
Mics	Std.	Check overall length	.442	.432
Thread Ring Ga.	R-80227-AA	Check #6-40 UNF-3A		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 3%

DATES AND REASONS FOR REVISIONS 10-31-74-New-LBB 213521
9/26/80 - Changed part number - was 91128 - CAK
5/7/82 - Added SEVEN LWT - CAK - 281464
2/8/83 - Change thread from Class 2 to 3A - SB 282351

MATERIAL: .08/.20 Carbon Steel
HEAT TREATMENT AT: Remington
COMPONENT CONDITION: FINISHED: SEMI-FIN. X
MODEL NO. 700ALL, 40XB, 40XC, 40XR, 40XB-BR,
PART NO. 91922 SEVEN LWT
BLANK DRAWING NO. B-91922
PART NAME Trigger Engagement Screw Blank
DEPT. NO. 9992 PAGE 1 OF 1

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KINZER V. REMINGTON

4 3

PROCESS RECORD – INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Check for Burrs & Visual Defects		
Mics	Std.	Check overall length	.542	.532
		Check Small diameter	.065	.060
Thread Ring Ga.	B-80227-W	Check #6-40 NF2 Thread		
Ring Gage	A-52821	Check Length of unthreaded end	.130	.120

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 3%

DATES AND REASONS FOR REVISIONS 4/23/67 Retyped from 8/30/63 & revised LBB - 264769
10-31-74 - Revised usage - LBB 273529
9/26/80 - Changed part number - was 15481 - CAK
5/7/82 - Added SEVEN LWT - CAK - 281464
2/8/83 Change B-80025-M to B-80227-W - SB-283[illegible]

MATERIAL: .08/.20 Plain Carbon Steel
HEAT TREATMENT AT: Remington
COMPONENT CONDITION: FINISHED: SEMI-FIN. X
MODEL NO. 700, SEVEN LWT
PART NO. 91926
BLANK DRAWING NO. A-91926
PART NAME Trigger Stop Screw Blank
DEPT. NO. 9992 PAGE 1 OF 1

RD-6491-1 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535763

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 4/21/77 - New - RLS - 275875 11/1/82 - Add 7 LW, Clg. dept. # - Bottini - 281957
5/3/77 - Add information - RLS - 275906 2/22/83 - Add WIP #92652,51,54,55,53,56,57 - RLS - 282323
5/25/77 - Correct Runout Gage information - RLS - 275973
9/29/80-Update-MRP-FRW-279123
10/2/81 - Was Bolt Body - RLS - 280813

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED 3500 FEED 3½ Gundrill	B-43682	Coolant Pump pressure 500 PSI
Adjusting Screw		
Drill Bushing	B-43681	A reading of 25 PSI will indicate a clogged filter and must be replaced.
Plug Gage .4225-.4275	B-43704	
Runout Gage .010 TIR		
Olympic. inspection bench center		Model No. 80 - 312
Dial indicator	Federal	C8I
Collet		
Tail Stock center		
Air Chuck		

OPERATION DESCRIPTION	PART NO.				
		33255	WIP 28831	28696	WIP 92652
		33256	WIP 28830	28697	WIP 92651
		33257	WIP 28834	28698	WIP 92654
Gundrill full length		33258	WIP 28835	28695	WIP 92655
		33259	WIP 28837	28735	WIP 92653
		26710	WIP 28832	28737	WIP 92656
		26780	WIP 28838	28738	WIP 92657
		33246	WIP 28833		
		33247	WIP 28836		

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No 700,600,XP-100,7 LW OPER. No 95
TYPE MACHINE De Hoff DEPT. No 8560 PAGE 1 OF 2

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R2535764

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PROCE[illegible] RECORD

6

DATES AND REASONS FOR REVISIONS 4/21/77 - New - RLS - 275875 10/2/81 - Was Bolt Body - RLS - 280813
5/9/77 - Add information - RLS - 275906 11/1/82 - Add 7 LW, Chg. dept. # - Bottini - 281957
5/25/77 - Correct Cartridge Information - RLS - 275973
3/8/78 - Add Tail Stock Cylinder - CFC - 276703
9/29/80-Update-MRP-FRW-279123

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Ben - Tek Seal	#BT - 69
		Chip Box Bushing	ASA # F - 48 - 12
		Coolant Gland - Deublin with Ell	1106 - 8
		Filter Cartridge 10 Micron	#FP-1-W D-4659
		Imperial Eastman SAE 100 RI Hose #D 708 with fittings #BJ08 - 08 MB 1/2 NPT	
		Tail Stock Cylinder	Modern Air #0320 - 040

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 700,600,XP-100, 7 LW OPER. No. 95
TYPE MACH. HRS. DEPT. No. 85 60 PAGE 2 OF 2
MACHINE

RD-6463

R2535765

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PROCEL RECORDS

282139

DATES AND REASONS FOR REVISIONS 10/3/75 - New - RLJ - 274354 1/5/83 - Chg.length ga. C-89372 to C-89732 - DRL-
9/29/80-Update-MRP-FRW-279123 2/22/83 - Add WIP 92652,51,54,55,53,56,57 - RLS - 282323
10/2/81 - Was Bolt Body - RLS - 280813
11/1/82 - Add 700,7 LW & Part #, Chg. dept # - Bottini - 281957
12/29/82 - Add part # 28738 - RLS - 282170

TOOL SPEED	TOOL FEED	GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES: 700 Long	700 Short	600, XO-100	7 LW		
		Special Machine		D-75923	D-75923	C-75923	C-75923		
		Fixture		D-75923-2	D-75923-2	D-75923-2	D-75933-2		
		Special Cutter		B-42677	B-42677	B-42677	B-42677		
		Special Cutter		B-42678	B-42678	B-42678	B-42678		
		Special Cutter		B-42679	B-42679	B-42679	B-42679		
		Special Tap		C-90187-V	C-90187-V	C-90187-V	C-90187-V		
		Alternate Tap		A-TS-6175	A-TS-6175	A-TS-6175	A-TS-6175		
		Set Spacer		--	B-40869-C	B-40869-D	B-40869-D		
		Floating Holders (4-Required)		Scully - Jones #39610 JAB					
		Length Gage		C-89732	C-89732	C-89732	C-89732		
		Depth C'bore, Rear		A-51177	A-51177	A-51177	A-51177		
		Plug Ga. - Dia., Rear		B-80007-W	B-80007-W	B-80007-W	B-80007-W		
		Thd. Plug, P.D. & Depth		B-80216-W	B-80216-W	B-80216-W	B-80216-W		
		Thd. Plug, Functional		B-87417	B-87417	B-87417	B-87417		
		Depth C'bore, Front (Rough)		A-87272	A-87272	A-87272	A-87272		
		Depth c'bore, Front (Finish)		C-51184	C-51184	C-51184	C-51184		
		Plug Ga. Dia. - Front		B-80007-H	B-80007-H	B-80007-H	B-8007-H		
		Chamfer Ga. - Front		B-87415	B-87415	B-87415	B-87415		
		Alignment Ga. - Front		A-86034	A-86034	A-86034	A-86034		

OPERATION DESCRIPTION	PART NO						
		33256	33255	26710	28735		
		33257	33258	26780	28737		
C'bore face both ends & tap		33246	33259	WIP#28832	WIP 92653		
		33247	WIP#28831	WIP#28838	WIP 92656		
		WIP#28830	WIP#28835	28738			
		WIP#28834	WIP#28837	WIP 92657			
		WIP#28833	28696				
		WIP#28836	28695				
		28697	WIP 92652				
		28698	WIP 92655				
		WIP 92651					
		WIP 92654					

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. XP-100,700,7 LW OPER. No. 100

TYPE MACHINE Hause Special Machine DEPT No. 85 60 PAGE 1 OF 1

80 9461

R2535766

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 11/1/82 - Add 7 LW, Part #, Chg. dept. # - Bottini - 281957
12/29/82 - Add part #28738 - RLS - 282170
2/22/83 - Add WIP 92652,51,54,55,53,56,57 - RLS - 282323

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
		Assembling Fixture	D-53890	D-53890					
		Adapter	D-53890-W	D-53890-U					
		Thd. Qual. Loc. plug	C-51989-M	C-51989-M					
		Thd. Qual. Gage	D-54018	D-54018					
		Thd. Qual. Plug Ga. To be used with D-54018	B-51961	B-51961					
		NOTE: When assembling washer the radius in the hole of the washer should be to the rear of the Bolt. Washer must be seated flat.	NOTE: Bolt Bodies must be blown clean with air hose before Assembling to heads.						
			NOTE: 3 tons pressure to be used in assembling head to body.						
			NOTE: 6000# equals .075 deflection on Gage TS-1764.						
		NOTE: In gage D-54018 Gas Block.	Escape hole must be down and marks on plug B-51961 must line up with 28735						

OPERATION DESCRIPTION	PART NO.			
Assemble Ejector Washer & Bolt Head to Bolt Body Part #'s 28696,7,8,5,28735, 28737,26780,33255,6,7,8,9, 28738,26710		26710	28737	WIP 92652
		33255	26780	" 92651
		33256	28695	" 92654
		28696	33259	" 92655
		28697		" 92653
		33257	28738	" 92656
		33258		" 92657
		28698		
WIP #28832,28838,28831,28830, 28834,28835,28837 WIP #92652,92651,92654,92655, 92653,92656,92657	WIP #	28832	28838	
		28831	28837	
		28830		
		28834		
		28835		

PART NAME Bolt Body Assembly COOLANT SET UP TIME 7 LW,700,600,XP-100,40XB,40XC MODEL No OPER No 105

TYPE MACHINE Dennison Multi-Press DEPT No 8560 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES RECORDS

DATES AND REASONS FOR REVISIONS 1/22/79 - Retyped & filed with process no. 277537 - EB
1/22/79 - Add note, remove arbor press - DRK - 277537
2/22/83 - Add WIP 92652,51,54,55,53,56,57 - RLS - 282323
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7 LW, Chg. dept. # - Bottini - 281957
12/29/82 - Add part #28738 - RLS - 282170

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES 700 RH	R.H.	R.H.	R.H.	700 L.H.
		#13 H.S. Drill (.185 dia.)		Std.				Std.
		Comb. Step Drill						
		.182 x .093		A-54191				A-54191
		Depth Gage		A-54192				A-54192
		Drill Jig		D-54174				D-42145
						NOTE:	Insert Pin A-18758 into Bolt Body Assembly using Hammer while Assembly is still in drill jig.	
						NOTE:	Press in Pin A-18758 in "V" Block B-06685 with a #2 Greenard Arbor Press.	
						NOTE:	For right hand Gas Escape hole is up. For left hand Gas Escape hole is down	

OPERATION DESCRIPTION	PART NO.					
		33255	WIP 28831	28696	WIP 92652	33246
		33256	" 28830	28697	" 92651	33247
Spot drill 3/16" deep, Step drill to depth & press in Bolt Pin.		33257	" 28834	28698	" 92654	WIP 28833
		33258	" 28835	28695	" 92655	WIP 28836
		33259	" 28837	28735	" 92653	
		26710	" 28832	28737	" 92656	
	WIP #	26780	" 28838	28738	" 92657	

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL NO. 7 LW 600, 700, XP100, 40XB, 40XC OPER. No. 110
TYPE MACHINE 3 SPDL Leland Gifford Inv. # 1214 DEPT. No. 8560 PAGE 1 OF 1

RD-6461

R2535768

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 800° F

MAXIMUM LOAD

TIME 30 min. @ temp.

QUENCH Air

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 11/1/82 - Add 7 LW, Chg. dept. # - Bottini - 281957 2/22/83 - Add WIP #92651 thru 92657 - RLS - 282323					
	APPROVAL AND DATES					
Burn off	GA. OR CAL. 33255	WIP 28831	28696	WIP 92652		
	PART No. 33256	" 28830	28697	" 92651		
	OCC. No. 33257	" 28834	20698	" 92654		
	STD. HRS/C 33258	" 28835	28695	" 92655		
	STD. No. 33259	" 28837	28735	" 92653		
	EFF. DATE 26710	" 28832	28737	" 92656		
	OF STD. 26780	" 28838	28738	" 92657		
	OF STD. 33246	" 28833				
	33247	" 28836				

PART NAME Bolt Body Assembly EQUIPMENT Electric Lindberg 7 LW, XP-100, 40XB, 40XC MODEL No. 600, 700 OPER. 112

DEPT. No. 8551 PAGE 1 OF 1

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION — **STD. PRACTICE No.**

TEMPERATURE 2050° F

MAXIMUM LOAD 40 pcs.

TIME

QUENCH

REMARKS Ihsert copper slug in Ejector hole, check for Ejector Washer, and place in trays, head of Bolt upon Brick Spacers.

INSPECT FOR Braze. Ring copper must show all around joint between head and body.

STANDARD PRACTICE No. — **HARDNESS LIMITS**

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS: 11/1/82 - Add 7 LW,Chg. dept. # - Bottini - 281957 2/22/83 - Add WIP #92651 thru 92657 - RLS - 282323					
	APPROVAL AND DATES					
Insert Bolt Body Brazing Slug and furnace braze. Inspect braze.	GA. OR CAL. 33255	WIP 28831	28696	WIP 92652		
	PART No. 33256	" 28830	28697	" 92651		
	OCC. No. 33257	" 28834	28698	" 92654		
	STD. HRS/C 33258	" 28835	28695	" 92655		
	STD. No. 33259	" 28837	28735	" 92653		
	EFF. DATE 26710	" 28832	28737	" 92656		
	OF STD. OF STD. 26780	" 28838	28738	" 92657		
	33246	" 28833				
	33247	" 28836				

PART NAME Bolt Body Assembly — **EQUIPMENT** G.E. Drycolene Furnace Metal Trays 7LW,XP100,40XB,40XC — **MODEL No.** 600,700 — **OPER.** 115 & 120

Refactory Brick Spacers

DEPT. No. 8551 — **PAGE** 1 — **OF** 1

RD.6404

R2535770

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HE/ TREAT SPECIFICATION

MATERIAL AND SPECIFICATION — **STD. PRACTICE No.**

TEMPERATURE

MAXIMUM LOAD

TIME

QUENCH

REMARKS

NOTE: Deplate only until all copper has been removed from exterior of Bolt Head.

(Operator to use own judgement as to length of time required)

CAUTION: Do not deplate any longer than necessary as this will reduce the strength of the braze.

INSPECT FOR — **HEAT TREAT INSPECTION**

STANDARD PRACTICE No. — **HARDNESS LIMITS**

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
Cyanide Deplate	11/1/82 - Add 7LW, Clg. dept # - Bottini - 281957 2/22/83 - Add WIP #92651 thru 92657 - RLS - 282323

APPROVAL AND DATES

GA. OR CAL.						
PART No.	33255	WIP 28831	28696	WIP 92652		
OCC. No.	33256	" 28830	28697	" 92651		
STD. HRS/C	33257	" 28834	28698	" 92654		
STD. No.	33258	" 28835	28695	" 92655		
EFF. DATE	33259	" 28837	28735	" 92653		
OF STD. or STD.	26710	" 28832	28737	" 92656		
	26780	" 28838	28738	" 92657		
	33246	" 28833				
	33247	" 28836				

PART NAME Bolt Body Assembly — **EQUIPMENT** 7 LW, XP100, 40 XB, 40XC — **MODEL No.** 600, 700 — **OPER.** 125

DEPT. No. 8551 — **PAGE** 1 — **OF** 1

R2535771

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 11/18/82 - Remove ga. #A-50337; added Fed Univ. dial comp. - DRL - 282038
11/29/82 - Correct - DRL - 282038
2/22/83 - Add WIP #92651 thru 92657 - RLS - 282323

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
2190	4.5	Turning Template	B-86206	
Blue	Yellow	Driver	C-38162	
		Tailstock Center	A-81722	
		Headstock Center	A-43949	
		Tool Holder for Post	Aloris CX^2	
		Snap Gage .712 - .717	B-80167Q	
		Concentricity Gage - Bolt		
		Federal Universal Dial		
		Comparator - Model #100B-20		
		Head Limits .004 TIR	B-80050W	
		Center Attachment	B-80050V	
		Tool Holder KSBR-12	Std.	
		Insert SNU-422	K5H	
		Chip Breaker CBS	Std.	

OPERATION DESCRIPTION	PART NO.				
Turn O.D. and remove ring left by turn.		33255	WIP 28831	28696	WIP 92652
		33256	" 28830	28697	" 92651
		33257	" 28834	28698	" 92654
		33258	" 28835	28695	" 92655
		33259	" 28837	28735	" 92653
		26710	" 28832	28737	" 92656
		26780	" 28838	28738	" 92657
		33246	" 28833		
		33247	" 28836		

PART NAME Bolt Body Assembly COOLANT Dasco 1087 SET UP TIME 7LW, MODEL No. 600,700,XP100, 40XB 40XC OPER. No. 131
TYPE _____ MACHINE Burkhard M-1800 - Lathe DEPT No. 60 PAGE 1 OF 1

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R2535772

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	Long	Short	M/600			
		Fixture		E-51114	E-51114	E-51114			
		Locator		E-51114E	E-51114F	E-51114G			
		Top "V" Block		E-51114K	E-51114K	E-51114K			
		Locating "V" Block		E-51114M	E-51114M	E-51114M			
				NOTE: Was	Parts In Immunol				
Mill	Safety	Cut							
		Kwik Lok Holder							
		#TIIIL - 9B-4		Std.	Std.	Std.			
		Kwik Lok Adapter							
		#TIIA 4-8		Std.	Std.	Std.			
		"T" Cutter		A-00741	A-00741	A-00741			
		Dial Gage for .196 ± .002 position		E-52000	E-52000	E-52000			
		Dial Gage for .121 ± .002 depth		E-52000	E-52000	E-52000			
					28695				

OPERATION DESCRIPTION	PART NO.							
		33256	33255	26710				
		33257	33258	28737				
WIP #92651-2-3-4-5-6-7		28697	33259	26700				
		28698	28696					
Mill Safety cut,	WIP #	28830	28831	28832				
Cocking notch and radius		28834	28835	28838				
and burr.			28837	28738				
28735, 28737, 28738		WIP 92651	WIP 92652	WIP 92653				
Part #26710, 26780		WIP 92654	WIP 92655	WIP 92656				
33255-6-7-8-9				WIP 92657				
WIP #28832, 28838, 28831,								
28830, 28834, 28835,								
28837, 28696, 7, 8, 5								

PART NAME Bolt Body Assembly COOLANT Draco 1087 SET UP TIME MODEL NO 7LW, 600, 700, XP100, 40XB, 40XC OPER NO 136

TYPE MACHINE Rem. Special #75539 DEPT NO 8560 PAGE 1 OF 2

R2535773

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 4/12/71 - Retyped from 9/3/70 - 269615
7/20/71 - Add gage #D-85979 & locating centers - MEG - 269895 9/29/80 - Revised for MRP - FRW - 279121
9/20/72 - Add note to gage 1 out of 10 pcs. - MEG - 271138 11/1/82 - Add 7LW,Chg. dept. # - Bottini - 281957
10/14/77 - Added Dasco 1087 - JAD - 276331
8/29/78 - Correct Part nos. - RLS - 277136

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES			
		Gage for .675 - .695 runout	A-50452	A-50452	A-50452		
						NOTE: Gage 1 out of 10 pcs. on Ga. C-53150 and Ga. E-52080	
Mill	Cocking notch and radius and burr						
		KWIKLOK Holder #TIIIL - 9B-4	Std.	Std.	Std.		
		KWIK LOK Adapter #TIPA-4-6	Std.	Std.	Std.		
		End Mill .199 dia.	A-02445	A-02445	A-02445		
		Dial Gage for Position of radius ± .003	C-53158	C-53158	C-53158		
		Top "V" Block	C-53158D	C-53158D	C-53158D		
		Locating "V" Block	C-53158E	C-53158E	C-53158E		
		Dial Gage for position of Cocking notch .0975 ± .0035	E-52080	E-52080	E-52080		
		Dial Gage for depth of Cocking notch .270 ± .005	E-52080	E-52080	E-52080		
		Dial Gage for depth of radius .0325 + .0025 - .0075	E-52080	E-52080	E-52080		
		Top "V" Block	E-52080E	E-52080E	E-52080E		
		Locating "V" Block	E-52080EE	E-52080EE	E-52080EE		
		Setting Master	C-86943	C-86944	C-86945		
		Gage Contour	E-52080T (Use as template to check on Master form only)	E-52080T (DO NOT USE DIAL)	E-52080T	(Set-up only)	
		Alternate Cam Follower	A-TS-5655	A-TS-5655	A-TS-5655		
		*NOTE: - Save used end mill A-02445 for Oper. #20-5 (Mill primary cam) on M/788 Bolt Body.					
		Dial Ga. for squareness of Pos. of Cocking notch (Set-up only) Center	D-85979 D-85979-A for all Bolts except 222,223&221 Calibers more than .007 D-85979-B for 222,223 &221 Cal.	D-85979	D-85979	(Note: Dial reading at each Locking Lug may not vary	

PART NAME Bolt Body Assembly COOLANT Dasco 1087 SET UP TIME 7LW MODEL No. 600, 700, XP100, 40XB, 40XC OPER. No. 136
TYPE MACH. HRS. DEPT. No. 8560 PAGE 2 OF 2
MACHINE

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

10

DATES AND REASONS FOR REVISIONS
10/19/73 - New operation - DIA - 272485
11/8/73 - Add file sample and machine info. - DIA - 272562
12/4/73 - Remove filing from operation - DIA - 272626
4/9/74 - C-42010 was C-41517 - DIA - 272969
8/29/78 - Correct Part nos. - RLS - 277136
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add ZLW, Chg. dept. # - Battini - 281957
2/22/83 - Add WIP #92651,52,54,55, Remove Pt. # 28735 &
APPROVAL AND DATES 28737 - RLS - 282323

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	R.H.
		Fixture (Rt. & Left Hand)	D-41516	
		Cutter (Rt. & Left Hand)	C-42010	
		Base Gage (Rt. Hand)	E-41519	
		Base Gage (Left Hand)	E-41520	

NOTE: - On Base gages E-41519 and E-41520 gage as follows:

Dial "W" - Run to deviation tolerance of -.007 to -.011 for position control of slot.

Dial "Z" - Run to gage for depth control

Dial "Y" - Use to control width of cut, for reference only, reading should be reciprocal of Dial "W"

Machine Set-up:
100 RPM
Feed - Set 18
Cycle - 45 seconds.

OPERATION DESCRIPTION	PART NO.				
Mill Guide slot Part #28695-6-7-8 Part #33255-6-7-8-9, 33246, 33247 WIP #28831,28830,28834, 28835,28837, 28833, 28836 WIP #92651-2,92654-5		33255	WIP 28831	28696	WIP 92652
		33256	" 28830	28697	" 92651
		33257	" 28834	28698	" 92654
		33258	" 28835	28695	" 92655
		33259	" 28837		
		33246	" 28833		
		33247	" 28836		

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. ZLW 600, 700, XP100, 40XB, 40XC OPER. No. 145

TYPE MACHINE Nichols 12 PMC DEPT. No. 8560 PAGE 1 OF 1

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R2535775

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

1/

DATES AND REASONS FOR REVISIONS 12/4/73 - New operation - NJA - 272626 28737 & 28738 - RLS - 282323
8/29/78 - Correct Part nos. - RLS - 277136
9/29/80 - Revised for MRP - FRW -279121
11/1/82 - Add 7LW,Chg. dept. # - Bottini - 281957
2/22/83 - Add WIP 92651-2,92654-5 - Remove Pt. #

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED							
File; Extra Narrow Pillar #2 6" x 3/16"	Std.						
File Sample	73-43						

OPERATION DESCRIPTION	PART NO.						
		33255	WIP 28831	28696	WIP 92652		
		33256	" 28830	28697	" 92651		
		33257	" 28834	28698	" 92654		
		33258	" 28835	28695	" 92655		
File lead angle at bottom - rear		33259	" 28836				
Part #28695-6-7-8		33246	" 28837				
Part #33255-6-7-8-9		33247	" 28833				
WIP #28831,28830,28834, 28835,28837,28833, 28836							
WIP 92651-2,92654-5							

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 7LW 600, 700, XP100, 40XB, 40XC OPER. No. 147

TYPE MACHINE Bench DEPT No. 8560 PAGE 1 OF 1

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R2535776

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS

12/17/75 - Added new operation - RLJ - 274508
9/19/77 - Revise note - Rush - 276252
2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323
9/29/78 - Correct Part nos. - RLS - 277136
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957

TOOLS AND GAGES AND EQUIPMENT	GA. OR CAL.
Reamer .4215 dia.	B-42662
Plug Gage - "Must Go"	A-40700

APPROVAL AND DATES

NOTE: Use normal gaging frequency. There is a 100% inspection as part of oper. 45 in Bolt Assembly process.

OPERATION DESCRIPTION	PART NO				
Ream inside diameter of Firing Pin hole.	33255	WIP 28831	28696	WIP 92652	
	33256	" 28830	28697	" 92651	
	33257	" 28834	28698	" 92654	
	33258	" 28835	28695	" 92655	
	33259	" 28837	28735	" 92653	
	26710	" 28832	28737	" 92656	
	26780	" 28838	28738	" 92657	
	33246	" 28833			
	33247	" 28836			

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 7LW 600, 700, XP100, 40XB, 40XC OPER. No. 148

TYPE MACHINE 4 Spindle Delta D/P DEPT. No. 8560 PAGE 1 OF 1

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R2535777

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HE/ TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE

MAXIMUM LOAD

TIME

QUENCH

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 11/1/82 - Add 7LW,Chg. dept. # - Bottini - 281957 2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323 APPROVAL AND DATES					
	GA. OR CAL.	33255	WIP 28831	28696	WIP 92652	
	PART No.	33256	" 28830	28697	" 92651	
	OCC. No.	33257	" 28834	28698	" 92654	
	STD. HRS/C	33258	" 28835	28695	" 92655	
	STD. No.	33259	" 28837	28735	" 92653	
	EFF. DATE	26710	" 28832	28737	" 92656	
	OF STD. or SIP.	26780	" 28838	28738	" 92657	
		33246	" 28833			
		33247	" 28836			
Wash						

PART NAME Bolt Body Assembly EQUIPMENT 7LW XP100 40XB 40XC MODEL No. 600,700 OPER. 150

DEPT. No. 8560 PAGE 1 OF 1

R2535778

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HE. TREAT SPECIFICATION

MATERIAL AND SPECIFICATION — STD. PRACTICE No.

TEMPERATURE: 1100° F

MAXIMUM LOAD

TIME: Regular Cycle

QUENCH

REMARKS

INSPECT FOR — HEAT TREAT INSPECTION

STANDARD PRACTICE No. — HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
Anneal in Rochwell Furnace	11/1/82 - Add 7LW Chg. dept. # - Bottini - 281957 2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323

APPROVAL AND DATES

GA. OR CAL.	33255	WIP 28831	28696	WIP 92652		
PART No.	33256	" 28830	28697	" 92651		
OCC. No.	33257	" 28834	28698	" 92654		
STD. HRS/C	33258	" 28835	28695	" 92655		
STD. No.	33259	" 28837	28735	" 92653		
EFF. DATE	26710	" 28832	28737	" 92656		
OF STD. or SIP.	26780	" 28838	28738	" 92657		
	33246	" 28833				
	33247	" 28836				

PART NAME Bolt Body Assembly — EQUIPMENT Rockwell Furnace — MODEL No. 7LW XP100,40XB,40XC 600,700 — OPER. 155

DEPT. No. 8551 — PAGE 1 OF 1

RII-8404

R2535779

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

STD. PRACTICE No. #199

MATERIAL AND SPECIFICATION	137K (Head) 117K (Body) 8640 C-1137
TEMPERATURE	Carbon Potential - .45 - 1575° F
MAXIMUM LOAD	170/Rack
TIME	2 Hours @ Temp. - 2½ Hours total furnace time.
QUENCH	Oil
REMARKS	Fixture: D-44682 44637 44683

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 11/1/82 - Add 7LW.Chg. dept. # - Bottini - 281957 2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323					
	APPROVAL AND DATES					
	GA. OR CAL.	33255	WIP 28831	28696	WIP 92652	
Degrease, mocro harden, quench and degrease.	PART No.	33256	" 28830	28697	" 92651	
	OCC. No.	33257	" 28834	28698	" 92654	
	STD. HRS/C	33258	" 28835	28695	" 92655	
	STD. No.	33259	" 28837	28737	" 92653	
	EFF. DATE	26710	" 28832	28735	" 92656	
	OF STD. or SIP.	26780	" 28838	28738	" 92657	
		33246	" 28833			
		33247	" 28836			

PART NAME Bolt Body Assembly EQUIPMENT L&N Microcarb Furnace MODEL No 7LW XP100,40XB,40XC OPER. 160

DEPT. No. 8551 PAGE 1 OF 1

R2535780

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION	137K (Head) 117K (Body) 8640
STD. PRACTICE No.	#203
TEMPERATURE	650 - 800
MAXIMUM LOAD	
TIME	1 Hour at temp.
QUENCH	
REMARKS	* Temperature to be adjusted to obtain Re-Specs.

INSPECT FOR		HEAT TREAT INSPECTION
SP 164	Rockwell Test	Body Rc 37-42 Head Rc 37-46

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS 11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957 2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323					
	APPROVAL AND DATES					
	GA. OR CAL.	33255	WIP 28831	28696	WIP 92652		
Lindberg Draw	PART No.	33256	" 28830	28697	" 92651		
	OCC. No.	33257	" 28834	28698	" 92654		
Inspect	STD. HRS/C	33258	" 28835	28695	" 92655		
	STD. No.	33259	" 28837	28735	" 92656		
	EFF. DATE	26710	" 28832	28737	" 92653		
	OF STD. or SIP.	26780	" 28838	28738	" 92657		
		33246	" 28833				
		33247	" 28836				

PART NAME Bolt Body Assembly EQUIPMENT Electric Lindberg Furnace MODEL No. 7LW XP100,40XB,40XC 600,700 OPER. 165 & 170

DEPT. No. 8551 PAGE 1 OF 1

RII-6464

R2535781

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

97

DATES AND REASONS FOR REVISIONS 9/29/80 - Retyped from 277136 - CC
9/29/80 - Revised for MRP - FRW - 279121
9/8/82 - Added Gage # A - 53664 To Operation Description - DRL - 281687
11/1/82 - Add 7LW Clg dept. # - Bottini - 281957
2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES			
					222	Mag.	
		Grinding Wheal 30" x 5" x 12"	D-40662	(All Calibers)			NOTE: Before loading part on centers in machine carefully use air hose and blow out shrouded Bolt faces to remove any residue or chips resulting from previous operations, or storage.
		Tooling Layout	D-TS-6159	(All Calibers)			
		Work Cradle - Layout	D-40748	(All Calibers)			
		Holder - Double Dia.	C-40749	(All Calibers)			
		Gage - Double Dia.	D-40750	(All Calibers)			
		Diamond Nib-Dressing Tool	D-40806				NOTE: Mix 50 parts water to 1 part Dasco.
		Profile Cam	C-40754	(All Calibers)			
		Profile Cam Follower	C-40800				
		Center - Footstock	D-40751	(All Calibers)			
		Work Driver Center	C-40753-B		C-40753-A	C-40753-C	
		Ring Ga. - Go	A-53664		A-53664	A-53664	
		Dial Dese Gage (Set-up only) "A" ± .0015	C-40341		C-40341	C-40341	

OPERATION DESCRIPTION	PART NO.				
Angular plunge grind up to Bolt Lugs and inspect for Bolt Head separation. Inspect 100% for maximum fillet behind lug with Gage # A-53664	33255	WIP 28831	28696	WIP 92652	
	33256	" 28830	28697	" 92651	
	33257	" 28834	28698	" 92654	
	33258	" 28835	28695	" 92655	
	33259	" 28837	28735	" 92653	
	26710	" 28832	28737	" 92656	
	26780	" 28838	28738	" 92657	
	33246	" 28833			
	33247	" 28836			

PART NAME Bolt Body Assembly COOLANT Dasco 10% SET UP TIME MODEL No 7LW 600, 700, XP100, 40XB, 40XC OPER No 174

TYPE MACHINE Clng. 10 x 18 Series 420 30" Plunge Center Type Grinder DEPT No 85 60 PAGE 1 OF 1

R2535782

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

28 1

DATES AND REASONS FOR REVISIONS 5/5/72 - New - Greene - 270705
6/5/72 - Chg. from alternate to reg. - Add 700 L.H. chg. coolant mixture - MDT - 270805
12/5/72 - Chg. page # - Greene - 271381 — 9/29/80 - Revised for MRP - FRW - 279121
10/18/77 - Add Dasco 1007 - Bush - 276337 — 11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957
8/29/78 - Correct Part nos. - RLS - 277136

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES		
		Snap Ga. - No Go	B-80151-W	B-80151-W	B-80151-W	
		Dial Snap Ga. "B" .698 - .695	B-80264-M	B-80264-M	B-80264-M	
		Concentricity Gage (Set-up only) .002 T.I.R. Max.	B-80050	B-80050	B-80050	
			NOTE: Gage (3) consecutive pieces in (60) and use for check of all pieces which do not clean up.			
			NOTE: Any visible opening between Bolt Head and Bolt Body is cause for rejection unless completely filled with brass.			
			Coolant = Dasco (1) part to (50) parts water.			

PART NAME Bolt Body Assembly — COOLANT Dasco 1007 — SET UP TIME — MODEL No. 7LW 40XB, 40XC 600, 700, XP100, — OPER. No. 174
TYPE — MACH. HRS. MACHINE — DEPT. No. 8560 — PAGE 2 OF 4

RD 6463

R2535783

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 12/5/72 - New sheet added - MEU - 271381
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7LW, Chg. dept. # - Bottini - 281957

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES					
SPEED	FEED							
		CONTROL SETTINGS						
		Dress Rate	Set 6½		NOTE: Dress rate, dress time and surface finish established at factory runoff test due to condition of diamonds, or other variables the dress rate, dress time and surface finish may vary.			
		Dress Time	2.0 Min.					
		Surface Finish	20 RMS					
		Standard (16-32 RMS)						
		Stock Removal - Coarse	.035					
		Medium	.004					
		Fine	.001					
		Feed Rate Setting - Coarse	8					
		Medium	7½					
		Fine	10					
		Tarry	7					
		Truing Compensation	.0008					
		Grind Time	.41 Min.					

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 7LW, 600, 700, XP100, 40XB, 40XC OPER. No. 174
TYPE MACH. HRS. DEPT. No. 85 60 PAGE 3 OF 4
MACHINE Cincinnati Angular Plunge Grinder

R2535784

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 12/5/72 - New sheet added - MEI - 271301
9/29/80 - Revised for MRP - FRW - 279121
11/1/82 - Add 7LW, Chg. dept # - Bottini - 281957

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED							
	Spare Parts for Electrical maintenance Cincinnati Plunge Grinder Serial #35422A35Y						
	Spare Parts Kit	3-588-0052A					
	Diagnostic Test Board	3-531-2284-A					
	SLOSVN Stepping Motor	1-599-0139					
	Reducer	405508					
	The above items are inventoried in Stores - Bldg. 50-2						
	Cyclon nozzle tip for Polycon Filter System available in stores. Requires changing after nozzle tip will accept a 3/16" dia. plug						

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL NO. 7LW, 600, 700, XP100, 40XB, 40XC OPER. NO. 174
TYPE MACH. HRS. DEPT. No. 8560 PAGE 4 OF 4
MACHINE Cincinnati Angluar Plunge Grinder

RD-6463

R2535785

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 12/29/82 - Add part #28738 - RLS - 282170
2/22/83 - Add WIP 92651 thru 92657 - RLS - 282323

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED							
Grinding Fixture		D-40348	D-40348	D-40348	D-40348	D-40348	D-40348
Grinding Wheel (Formed)		ME-01925 *		12" dia. - 1" thick		5" dia. hole	(Norton)
Overall Form Min. Rec.		C-53694	C-53694	C-53694	C-53694	C-53694	C-53694
Adjacent Snap Ga. .446-.440		B-80130H	B-80130H	B-80130H	B-80130H	B-80130H	B-80130H
Center Nose		B-86659B	B-86659B	B-86659D	B-86659C	B-86659B	B-86659D
Dia. of Bolt Head							
Adj. Snap Ga. .698-.695		B-80100M	B-80100M	B-80100M	B-80100M	B-80100M	B-80100M
Visual Inspect for blend between lugs and body .003 max. allowable mismatch.							
Locating Center		A-86073	A-86073	A-86073	A-86073	A-86073	A-86073
Dial Gage .223 - .220		D-85979	D-85979	D-85979	D-85979	D-85979	D-85979
(Set up only) Center		D-85979A	D-85979A	D-85979B	D-85979A	D-85979A	D-85979B
Grinding Dog Driver		B-41235	B-41235	B-41235	B-41235	B-41235	B-41235
Grinding Dog		C-86460	C-86460	C-86460	C-86460	C-86460	C-86460
Wheel Truing diamond roll		C-38508	C-38508	C-38508	C-38508	C-38508	C-38508
Coolant - Dasco 1087		Mix 50 parts	water to 1 part		Dasco		
Headstock Center		A-41634	A-41634	A-41634	A-41634	A-41634	A-41634
		NOTE: Grinder is to be set at 3 notches per dress and at 20 passes per dress					

OPERATION DESCRIPTION	PART NO.						
WIP 92651-2-3-4-5-6-7		33256	33255	33259	33257	26710	26780
		28697	28696	28695	28698	28735	28737
							28738
Grind Lugs top and bottom					33258		
28735,28737,28738 Part #26710,26780, 33255-6-7-8-9			* NOTE: - If formed wheel use 38A80L6VBE		ME01925 not available, Type 1 12" x 1" x 5"		
WIP #28832,28838,28831, 28830,28834,28835, 28837, 28695,6,7,8	WIP #	28830	28831	28837	28834	28832	28838
		WIP 92651	WIP 92652	WIP 92655	28835	WIP 92653	WIP 92656
					WIP 92654		WIP 92657

PART NAME Bolt Body Assembly COOLANT Dasco 1087 SET UP TIME MODEL NC 7IW,600,700,XP100, 40XB,40XC OPER. No 179

TYPE MACHINE Thompson Type B 10 x 30 Auto Surface Grinder DEPT No 8560 PAGE 1 OF 1

R2535786

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 11/1/82 - Add 7 LW, Chg. dept. # - Bottini - 281957
2/22/83 - Add 92651 thru 92657 - RLS - 282323

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED							
8" Pillar File	Std.						
File Handle	Std.						
Belt Sand Grinder - 2 inch	Std.						
File Sample Dated 2/19/64	#63-35	#63-35					
Bolt must turn freely in master Bbl. and Rec. assembly							

OPERATION DESCRIPTION	PART NO.						
File chamfer on corners of Bolt Lugs and break sharp corner on bottom front edge of Bolt Head.	33255	WIP 28831	28696	WIP 92652			
	33256	" 28830	28697	" 92651			
	33257	" 28834	28698	" 92654			
	33258	" 28835	28695	" 92655			
	33259	" 28837	28735	" 92653			
	26710	" 28832	28737	" 92656			
	26780	" 28838	28738	" 92657			
	33246	" 28833					
	33247	" 28836					

PART NAME Bolt Body Assembly COOLANT SET UP TIME MODEL No. 7LW,600,700,XP100,40XB,40XC OPER. No. 185
TYPE MACHINE Bench DEPT No. 8560 PAGE 1 OF 1

R2535787

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/19/82 - Make regular - ZJK - 282052
5/9/83 - Add Note - RLJ - 282759

DESCRIPTIVE INFORMATION

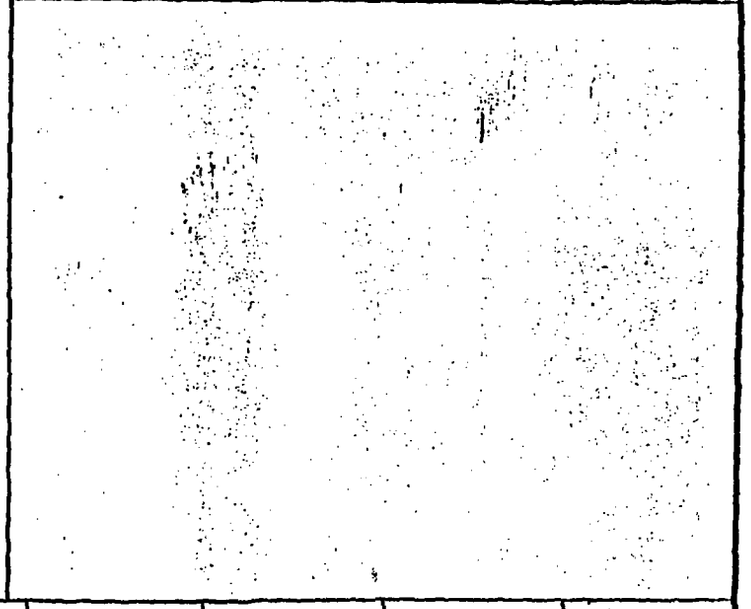
25. Try .006 feeler between sear and connector,

    a. Must enter with no bind,

26. If clearance is less than .006 replace safety,

NOTE: Avoid marring guns!
Do not load gun trucks beyond their intended capacity.

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION							
Assemble Action (ADL '83)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL '83 OPER. No. 550
TYPE MACH. HRS. DEPT. No. 8761 PAGE 5 OF 5
MACHINE

R2535788

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

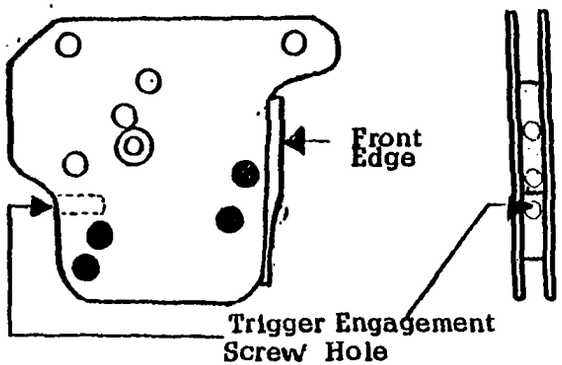
DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised, Changed Op. # - WW - 277413~~

6-15-83 NEW - WAS Op 2 IN F.A. - RLS

DESCRIPTIVE INFORMATION

1. Position Trigger Housing Assembly on its front edge.
2. Clean (using compressed air hose) housing and Trigger Engagement Screw Hole.
3. Spray Trigger Engagement Screw Hole with "Locquic Primer T" (Aerosol Can).
   - NOTE: Housings must Air Dry (Do Not Use Compressed Air Hose) at least Five (5) minutes after spraying with primer.
4. To Trigger Sub-Assembly.

- NOTE: Use Red Plastic Valve - Finger Piece and Plastic Tube from can of "Inhibisol" on can of "Locquic"



OPERATION DESCRIPTION	OCC. No.						
Clean and Prime Trigger Engagement Screw Hole.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 25

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

Form R D 6461

R2535789

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised, changed Op. # - Wt. - 277413~~
6-15-83 NEW - WAS OP 3.1 IN F.A. -RLS

DESCRIPTIVE INFORMATION

NOTE: Do All Elements 100%.

1. Inspect long inside connector surface, and inside surface of long (top) leg for flatness.

Hold Connector against flatness block with light finger pressure.

- If no light shows between inside surfaces of back and long leg of connector, and block surface; connector is good. (continue) (See Figure #1, Page #4).

EQUIPMENT—TOOLS & GAGES

Flatness Block - C-44524

OPERATION DESCRIPTION							
Inspect connectors 100%.	OCC. No.						
	STD. HRS/C						
Scrap all defectives.	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~3.1~~ 10

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE

R2535790

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised, changed Op. # WW-277413~~
~~10/9/79 Revised shim WW - 278187~~
6-15-83 NEW - WAS OP 3.1 IN F.A-RLS

DESCRIPTIVE INFORMATION

- If light gap shows, measure gap with a .006 shim. If gap accepts shim without moving connector - Reject connector. (See Figure #2, Page #4.)
- If connector rocks on flatness block - reject connector. (See Figure #3, Page 4).
- Front edge of long (top) leg, must be square with shoulder of flatness block.

  (See Figure #4, Page #4).

EQUIPMENT-TOOLS & GAGES

.006 Shim - Make new shim as required.

OPERATION DESCRIPTION							
Inspect Connectors 100%.	OCC. No.						
	STD. HRS/C						
	STD. No.						
Scrap all Defectives.	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~3.1~~ 10

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE

R2535791

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised, Change Op. # WW 277413~~
~~10/9/79 - Delete element #2 WAW 278187~~
6-15-83 NEW - WAS OP. 3.1 IN F.A. - RLS

DESCRIPTIVE INFORMATION

~~Receiving Gage // Check Conductor for maximum length~~

~~All conductors must pass Receiving Gage // Try New Width~~
~~Do not force parts into gage~~

3. Smooth top surface of long leg of Connector. Use Crocus Cloth.

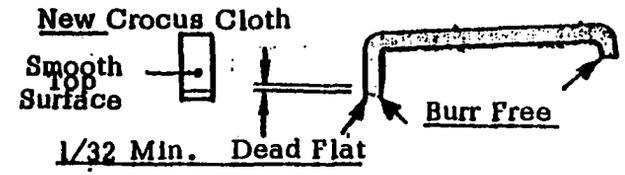
Surface must be:

- Smooth
- Burr -Free at top and bottom corner
- Dead flat within 1/32" minimum of end.

Check for burrs and smoothness with finger tip.

EQUIPMENT—TOOLS & GAGES

~~Receiving Gage // C-14512~~



(This is the same as the Wire Diameter of a Paperclip)

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect Connectors, 100%	EFF. DATE						
Scrap all Defectives.							
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~3.1~~ 10
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4
MACHINE

R2535792

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised - Changed OP # WW-277413~~
~~3/9/80 - Corrected Shim note, Fig. #2 - WAW - 278463~~
6-15-83 NEW - WAS OP 3.1 IN F.A. - RLS

DESCRIPTIVE INFORMATION

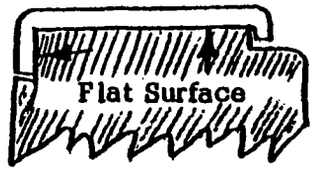


Fig. #1
Good

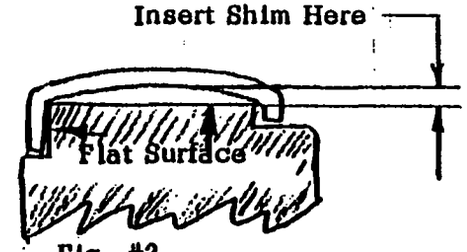


Fig. #2
Test Light Gap
With Shim

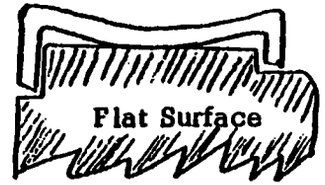


Fig. #3
Reject

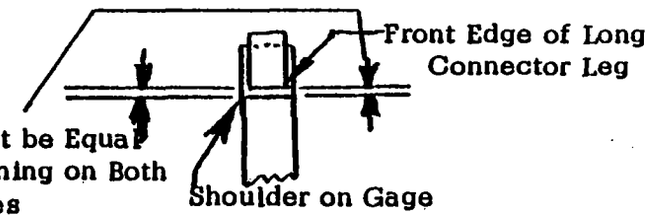


Figure #4

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~3.1~~ 10
TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4
MACHINE

Form R. D. 6466

R2535793

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW - 277413~~

~~10/9/79 Added element - WW - 278187~~

6-15-83 NEW - WAS 3.3 TH F.A. - RLS

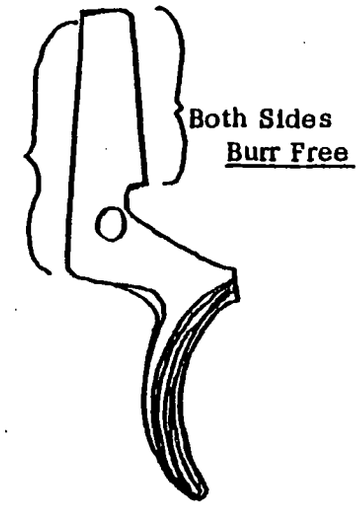
DESCRIPTIVE INFORMATION

1. Inspect Trigger.

   Trigger Must Have:

   - Good Black Color
   - No Bleed Out (White Material on Surface)
   - No Burrs on Sides
   - No cracks or damage @ pivot hole.

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION	OCC. No.						
Inspect Trigger.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~15~~ 3.3

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

Form R. D. 6461

R2535794

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW 277413~~
~~10/9/79 - Delete "Fall Off" check - WAW 278107~~
6-15-83 NEW - WAS OP 4 IN F.A. - RLS

DESCRIPTIVE INFORMATION

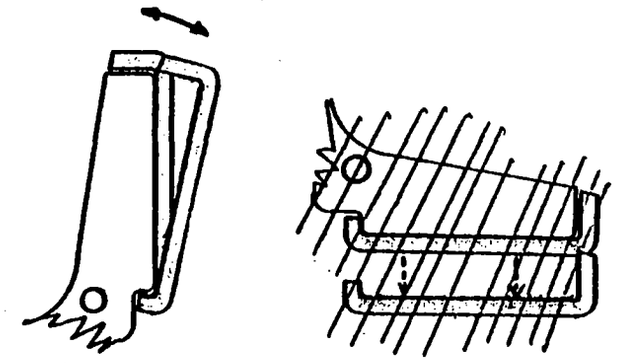
1. Fit passed Connector to passed Trigger and check for Min. working clearance (slip fit).

   - Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.

   ~~Connector must fall off Trigger when Trigger is held horizontally.~~

   - If Binding occurs, file bottom notch on Trigger to remove bind. Filed surface must be flat and square with sides of Trigger. **Use filing fixture only, not freehand.**

EQUIPMENT—TOOLS & GAGES



SLIP FIT MIN.

Filing Fixture - D-44521

OPERATION DESCRIPTION	OCC. No.						
Check Connector to Trigger Fit.	STD. HRS/C						
	STD. No.						
100%	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Finger~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 20-4
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2
MACHINE

Form P D 6455

R2535795

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW - 277413~~
~~10/9/79 - Added to 1st element - WW - 278187~~
6-15-83 NEW - WAS OP 4 IN F.A. - RLS

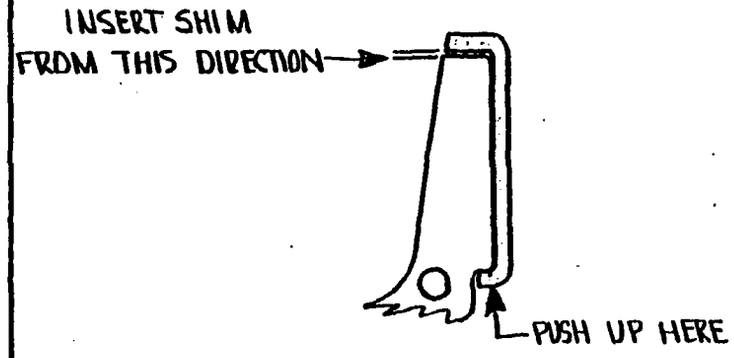
DESCRIPTIVE INFORMATION

2. With the Same Trigger and Connector, Check for Max. Working Clearance.

- Push Connector tight to Trigger at bottom and hold it parallel to sides of Trigger.
- Insert Shim Stock in clearance from front to back
  - .006 Shim Must Not Go.
- If Shim Enters without moving Connector, Scrap Trigger.

EQUIPMENT—TOOLS & GAGES

.006 Shim Stock. Make new shim as required.



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Check Connector To Trigger Fit. 100%							
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 20-4
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2
MACHINE

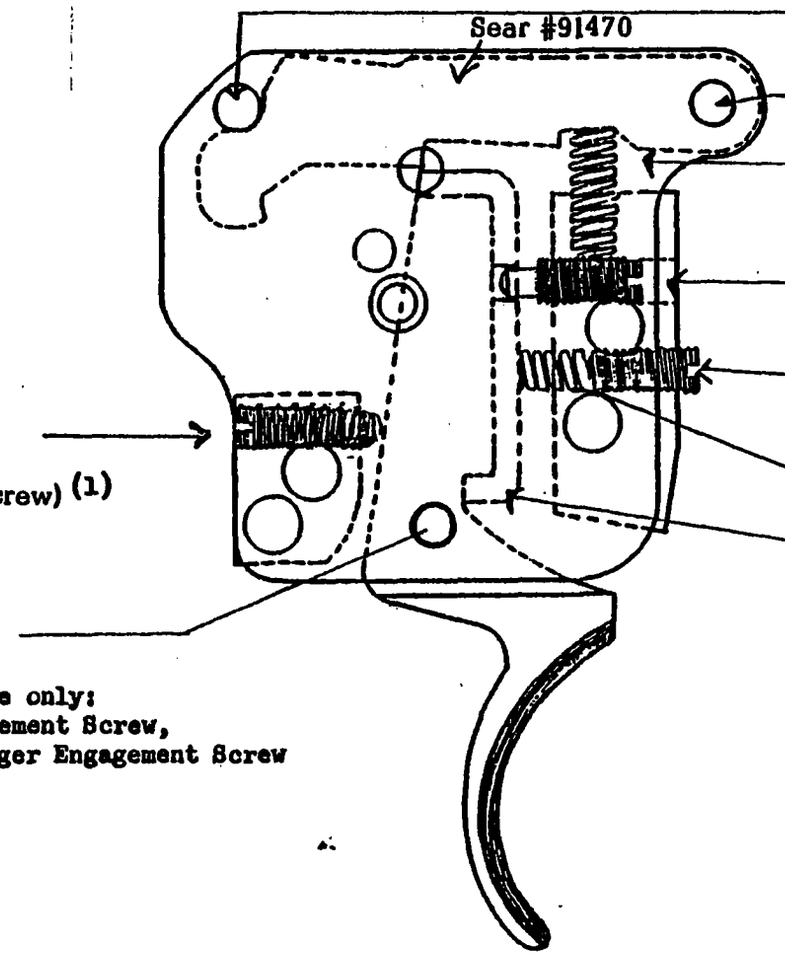
Form R. D. 6469

R2535796

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised Chang~~ p. # ~~WW 277413~~
~~10/9/79 - Added Australian WAW 278187~~
6-15-83 NEW - WAS OP 6 IN F.A. - RLS

DESCRIPTIVE INFORMATION



(1) NOTE: For Australian use only:
Substitute Trigger Engagement Screw, #91117; Followed by Trigger Engagement Screw Lock screw, #91127.

(2) NOTE: For Australian use only:
Substitute Trigger Screw Front, #91118; Followed by Trigger Screw Lock Screw Front, #91127.

25

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~6~~

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE

Form R. D. 6466

R2535797

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised, Changed Op. #WW - 277413~~
~~10/9/79 - Added clean element - WAW - 278187~~
6-15-83 NEW-WAS OP 6 IN F.A.-RLS

DESCRIPTIVE INFORMATION

1. Inspect Trigger Housing:
   - Black Color
   - No Bleedout (White Material).
   - Check inside Housing - No Burrs at Sear Pin Holes.
   - Clean and free of excess oil and foreign material.
2. Position Trigger in Housing and install Trigger Pin:
   - Pin Must be flush to housing on right side.
   - Grip Trigger and rotate housing around Trigger pin - Trigger must rotate freely in housing without bind.

EQUIPMENT-TOOLS & GAGES

Pin Holder Drive Punch
A - 35645

OPERATION DESCRIPTION	OCC. No.						
Assemble Trigger Sub-Assembly.	STD. HRS/C						
	STD. No.						
Stage One.	EFF. DATE						
	PART No.						
	GA.						

25

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 6
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4
MACHINE

R2535798

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised Changed Op # 277413 WW~~
6-15-83 NEW - WAS OP 6 IN F.A. - RLS

DESCRIPTIVE INFORMATION

3. Install:

- Same Connector as fitted to Trigger (Op. #4)
- Trigger Stop Screw - One full turn (Thread) above flush with hole.
- Trigger Spring
- Trigger Adjusting Screw - Flush with hole or below. (There must be Spring Force on connector while adjusting Trigger Engagement Screw).
- Trigger Engagement Screw - Flush with hole

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Assemble Trigger Sub-Assembly. Stage One.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~6~~ 25
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4
MACHINE

R2535799

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

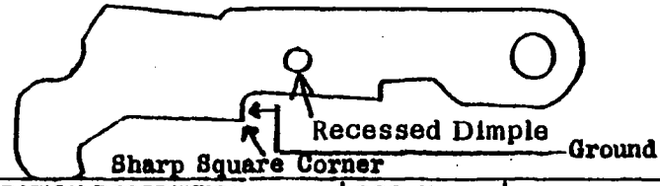
DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised - Changed Op. # WW - 277413~~
~~10/9/79 Added width WW - 278107~~
6-15-83 NEW - WAS OP 6 IN F.A. - RLS

DESCRIPTIVE INFORMATION

4. Install Sear Spring and *Sear using two dummy pins

- Sear must be flat - not bowed. Check 100% thru width gauge.
  (WIDTH CHECK)
- Sear must have dimple
- Sear must be ground at vertical contact surface with Connector.
- Sharp square corner at contact surface.

* Sear - Part #91470 Has a Recessed Dimple.
Do not Substitute



EQUIPMENT—TOOLS & GAGES

Dummy Pins - A-51468

Width Gage - C-44522

OPERATION DESCRIPTION	OCC. No.						
Assemble Trigger Sub-Assembly.	STD. HRS/C						
	STD. No.						
Stage One.	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~6~~ 25
TYPE MACH. HRS DEPT. No. 61 PAGE 4 OF 4
MACHINE

Form R D 4434

R2535800

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised - Changed Op. #WW-277413~~
6-15-83 NEW - WAS OP 7 IN F.A. - RLS

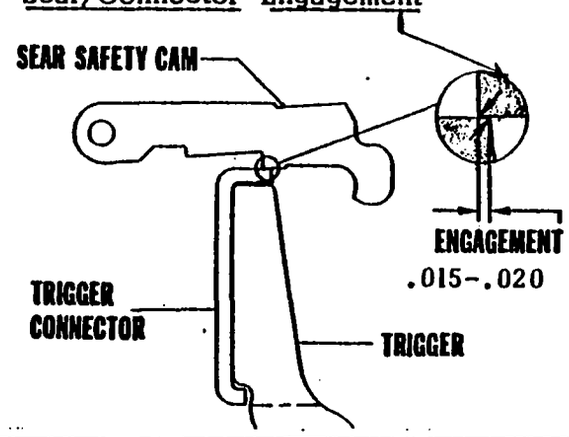
DESCRIPTIVE INFORMATION

1. Pick Trigger Sub-Assembly. Position in Comparator Fixture and Clamp.
   - Housing must properly contact all locators.
   - Top of Housing must be flat on Fixture.
   - Push with thumb on rear of Trigger (toward left) This seats Trigger firmly against end of Trigger Adjusting Screw.
2. Adjust fixture to locate Sear on "Set" line of comparator screen.

EQUIPMENT--TOOLS & GAGES

Comparator Fixture - E-42271
Comparator Screen - A-600-CL25

Sear/Connector Engagement



OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator, 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

30

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 7

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE Jones & Lamson Comparator TC-10

Form R D 6466

R2535801

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS & ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised Changed Op. # WW-277413~~
~~10/9/79 - Chg. weight - WAW - 29016~~
6-15-83 NEW - WAS OP 7 IN F.A.-RLS

DESCRIPTIVE INFORMATION

3. Adjust Sear/Connector Engagement (.015 - .020), to correct Comparator Screen line, by turning Trigger Engagement Screw slowly clockwise. (To reduce Engagement).

After correctly adjusting Sear/Connector Engagement

4. Hang Dead Weight Assembly to end of Trigger.

5. Adjust Trigger Pull by turning Trigger adjusting screw slowly counter-clockwise until Sear just disengages (Fires).

EQUIPMENT—TOOLS & GAGES

Comparator Fixture dead weight - 2.9 lbs. (M/600 only)

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Pivot~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 7 30
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4
MACHINE Jones & Lamson Comparator TC-10

R2535802

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS & ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised, Changed OP. #WW-277413~~
~~10/9/79 - Added page to note - WAW - 278187~~
6-15-83 NEW - WAS ~~OP~~ OP 7 IN F.A. - RLS

DESCRIPTIVE INFORMATION

9. Remove Trigger Sub-Assembly from Comparator Fixture.

10. Seal all three screws with "Duco" Cement.

EQUIPMENT - TOOLS & GAGES

NOTE: Adjust Comparator Projection System, as required, to maintain sharp clear image of Fixture hole around entire Perimeter, Refer to page #7 of J & L Operating Manual.

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

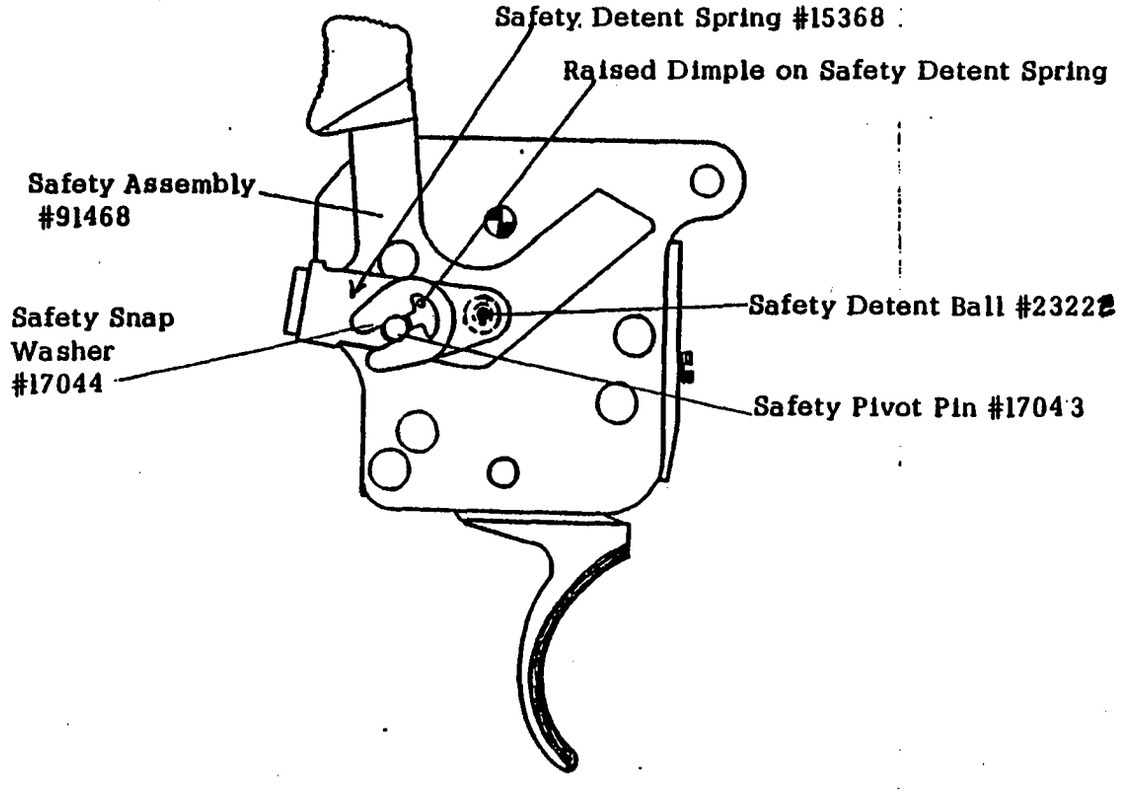
PART NAME ~~Final~~ TRIGGER Assemly
TYPE
COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 130
MACH. HRS. DEPT. No. 61 PAGE 4 OF 4
MACHINE Jones & Lamson Comparator TC-10

R2535803

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised Changed Op. # WW 277413~~
6-15-83 NEW - Was Op 9 In F.A. -RLS

DESCRIPTIVE INFORMATION



PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~35~~ 9
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 3
MACHINE

Form R. D. 6466

R2535804

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS (EMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 Revised and Changed Op. # WW 277413~~
~~10/9/79 Add sketch & description WAW - 278187~~
6-15-83 NEW - WAS OP 9 IN F.A. - RLS

DESCRIPTIVE INFORMATION

1. Pick Correctly adjusted Trigger Sub-Assembly.

2. Assemble:

   Safety Assembly

   Safety Detent Ball

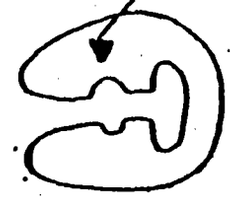
   Safety Detent Spring - Visually Check for correct size Dimple.

   Safety Pivot Pin

   Safety Snap Washer - Curved Side to be away from Safety Detent Spring // Side with deeper notch (For safety Pivot Pin) must be on top.

EQUIPMENT - TOOLS & GAGES

Deep Notch Must be on top.



OPERATION DESCRIPTION							
Assemble Trigger Assembly, Stage Two.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER Final Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~9~~ 35
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 3
MACHINE

R2535805

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - Revised, Changed Op. # WW-277413~~
6-15-83 NEW - WAS OP 9 IN F.A. - RLS

DESCRIPTIVE INFORMATION

- Safety Snap Washer Must be Completely contained within Pivot Pin Groove.
- The raised end of Dimple on Safety Detent Spring Must be at the left end of the opening at the closed end of Safety Snap Washer. (Refer to Illustration)

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
A.ssemble Trigger Assembly.	OCC. No.						
	STD. HRS/C						
Stage Two.	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 8 35
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 3
MACHINE

R2535806

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS & ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW - 277413~~
6-15-83 NEW - WAS OP 11 IN F.A. - RLS

DESCRIPTIVE INFORMATION

1. Pick Trigger Assembly

2. Apply Small amount of "Molykote" Powder to Sear/Connector Engagement Surfaces thru Engagement view hole.

EQUIPMENT - TOOLS & GAGES

Dry Type "Z" Molykote" Powder.

Squeeze container
(eyedropper)

OPERATION DESCRIPTION							
Lubricate Connector and Sear with "Molykote" Dry Powder.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 40
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1
MACHINE

R2535807

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW - 27413~~
6-15-83 NEW - WAS OP 12 IN F.A. - RLS

DESCRIPTIVE INFORMATION

NOTE: All Elements 100%

1. Put Safety in "OFF SAFE" Position.
   Check For:

   Trigger Retraction
   - Pull Trigger and Release
   - Trigger and Connector must return freely to original position with Spring Force.

   Sear Freedom
   - Pull Trigger and Hold.
   - Depress Sear Fully and Release.
   - Sear must move freely in Housing without Binding. The Sear must return fully upward under Sear Spring Force.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION							
Function check completed Trigger Assembly. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 12 45
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 3
MACHINE

R2535808

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW-277413~~
6-15-83 NEW - WAS OP # 12 IN F.A-RLS

DESCRIPTIVE INFORMATION

2. Operation of Safe

- Push Safety thumb piece fully forward beyond detent position.
- Safety must Spring return rearward to detent position.
- Push Safety thumb piece fully rearward beyond detent position.
- Safety must Spring return forward to detent position.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check completed Trigger Assembly. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. ~~12~~ 45
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 3
MACHINE

R2535809

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS . 3EMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW-27743~~
6-15-83 NEW - WAS OP # 12 IN F.A. - RLS

DESCRIPTIVE INFORMATION

Move Safety from "On Safe" to "Off Safe" position and back. Twice.

- Safety must Spring forward into "Off Safe" position when pushed.
- There must be no hang-up or hesitation between detent positions.
- The Bolt Lock Arm of Safety Assembly must work freely on housing.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Function check Complete Trigger Assembly. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 45 12
TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 3
MACHINE

R2535810

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ..SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 - NEW - WW-27743~~
6-15-83 NEW-WAS OP 13 IN F.A. -RLS

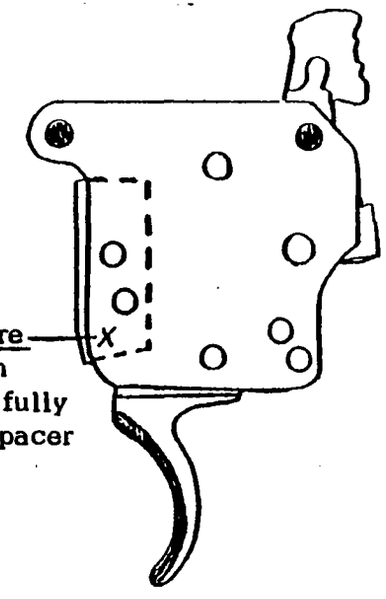
DESCRIPTIVE INFORMATION

1. Locate Trigger Assembly on Stamping Fixture.

2. Stamp Lower Left Front Corner (as shown) with correct Assembler identification.

   - Use 1/16" size character

EQUIPMENT—TOOLS & GAGES



Mark must be on Housing where fully supported by Spacer Block

OPERATION DESCRIPTION							
	OCC. No.						
ADJUSTED	STD. HRS/C						
Mark correctly assembled and checked Trigger Assembly with Assembler's identification.	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. X-50

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535811

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/9/78 - NEW - WW - 277413~~
~~10/9/79 - Added to note - WAW - 278197~~
6-15-83 NEW - WAS OP 14 IN F.A. - RLS

DESCRIPTIVE INFORMATION

Inspect Sear Lift 100%

Procedure:

1. Push Slave Pins in Trigger Assembly Part Way Out, Toward Right Side of Trigger Assembly.

2. Raise Locating Pins in Gage half way, by pulling lever toward body.

3. Place Trigger Assembly over locating pins and clamp down. Make sure Assembly is Flat to the Gage Locating Surfaces.

EQUIPMENT—TOOLS & GAGES

Dial Base Gage #D-42614

NOTE: Clamps on Base Gage must be adjusted as required to locate Trigger Assembly flat to Gage while testing. Clamp pad must miss rivets.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for sufficient Sear Lift.	EFF. DATE						
100%							
	PART No.						
	GA.						55

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~14~~

TYPE MACH. HRS. DEPT. No. 16/61 PAGE 1 OF 6

MACHINE

Form R. D. 6465

R2535812

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 — NEW — WW 277413~~
~~10/9/79 - Added to element #6 WAW - 278197~~
6-15-83 NEW — WAS OPR IN F.A. -RLS

DESCRIPTIVE INFORMATION

4. Hold Trigger Assembly in position with Finger, and raise Locating Pins to full upward position.

5. Move Safety Lever to "OFF SAFE" Position.

6. Draw Dial Indicator into position with adjustment knob, until Dial Indicator READS ZERO ("O"). On both scales.

7. Move Safety Lever to "ON SAFE" Detented Position. READ Dial Indicator.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for Sufficient Sear Lift. 100%	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Trigger Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~14~~ 55
TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 6
MACHINE

Form R. D. 6465

R2535813

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 NEW WW 277413~~
6-15-83 NEW-WAS OP 14 IN F.A.-RLS

DESCRIPTIVE INFORMATION

MUST BE .008 TO .018 SEAR LIFT

- Reject if less that .008.
- Reject if more than .018.

(If Reading is within limits, continue:)

8. Push Safety lever to "OFF SAFE" Detented Position.

9. Re-Zero Dial (if necessary) using Adjustment Knob.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect For Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~14~~ 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 6

MACHINE

Form R. D. 6465

R2535814

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 NEW WW 277413~~
6-16-83 NEW - WAS OP 14 IN F.A.-RLS

DESCRIPTIVE INFORMATION

10. Move Safety Lever from "OFF SAFE" Position toward "ON SAFE" Position TO LOCATE AND STOP Safety Lever at the *Forward most Null location.

* FORWARD MOST NULL LOCATION - is that "Just Stable" place between "On" and "Off" Safe - closest to "Off Safe" - where the Safety Lever will not spring forward to the "Off Safe" Position when released.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~14~~ 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 6

MACHINE

Form R. D. 6465

R2535815

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 - NEW - WW 277413~~
~~10/9/79 - Added removal - WAW - 270107~~
6-16-83 NEW - WAS OP 18 IN F.A. - RLS

DESCRIPTIVE INFORMATION

- If the Null Location is overshot (where the Safety Lever was moved too far toward "On Safe"); then return to "Off Safe" and again approach Null Location from the "Off Safe" side.

Remove Trigger Assembly from Dial Base Gage.

11. Separate Trigger Assemblies, into labeled containers, according to Dial Readings at that "Forward Most Null Location".

- Less that .007 - Repair

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. A 55
TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 6
MACHINE

Form R. D. 6468

R2535816

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 NEW - WW-27413~~
6-16-83 NEW - WAS OP 14 IN F.A. - RLS

DESCRIPTIVE INFORMATION

- .007 to .008 - Retest (Operation #16.5)
- Over .008 - Good (Continue to Op. #16)
- Over .018 - Repair

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~14~~ 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 6 OF 6

MACHINE

Form R. D. 6465

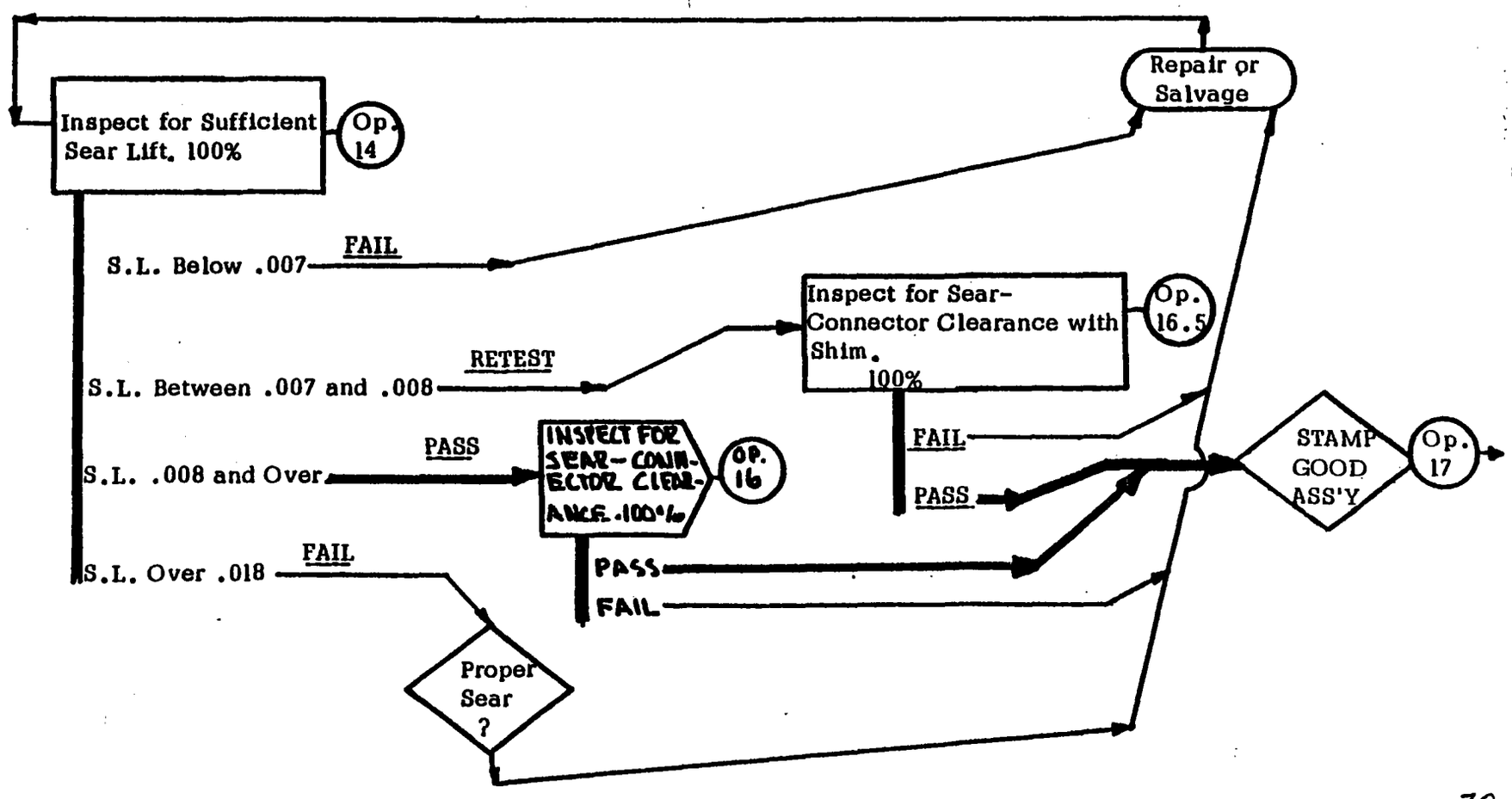
R2535817

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS ~~11/16/78 - NEW - WW 277413~~
6-15-83 NEW - WAS OP [redacted] 14-17 IN E.A. - RLS

DESCRIPTIVE INFORMATION

FLOW CHART - TRIGGER ASSEMBLY TEST SEQUENCE



55 TO 70

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~14 TO 17~~
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1
MACHINE

Form R. D. 6466

R2535818

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 11/2/78 - New - JAA - 277320
6-16-83 CHG READING - RLS

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
SPEED / FEED		
Gage - Functional	C-85288	
"A" (Process Dim.)		
Approx. .025		
OPERATION DESCRIPTION	PART NO.	91468
Adjust Lock Arm ~~to Gage~~ ON SAFETY TO GAGE		

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. XP-100 600 OPER. No. 21
TYPE MACHINE DEPT. No. 79 PAGE 1 OF 1

R2535819

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

17

MATERIAL AND SPECIFICATION C - 1020

STD. PRACTICE No.

TEMPERATURE 350° F

MAXIMUM LOAD

TIME 1/2 Hour at Temperature

QUENCH

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS R 15N 88-92

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS ~~1/6/78 - Made process regular - SB - 276520~~ 6-16-83 NEW - RLS
Lindgerg draw ~~and Inspect~~	APPROVAL AND DATES

GA. OR CAL.						
PART No.	91468					
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD.						

PART NAME Safety Assembly EQUIPMENT MODEL No. Moh 600 OPER 50 ~~& 55~~

DEPT. No. 51 PAGE 1 OF 1

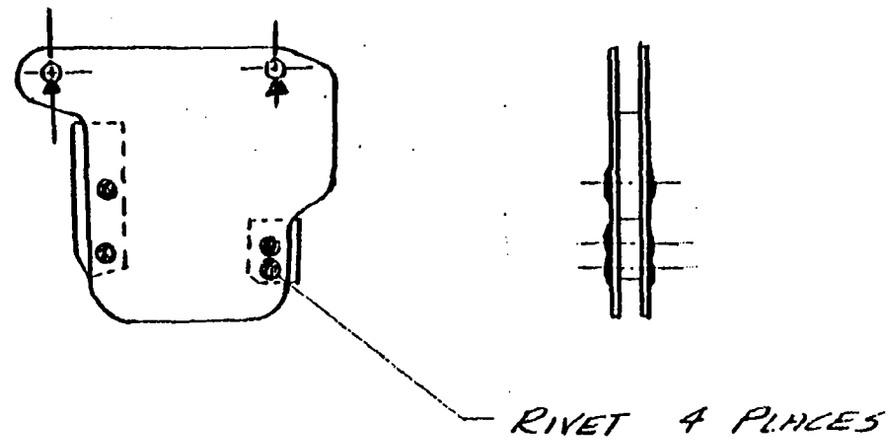
RD-8404

R2535820

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 5-1-70-NEN-AJH 26238 6-5-70-REVISED-AJH 268536
11/5/70 - Remove "A" - Urtz - 269172 11-11-71 Added M-700 L.H. RH
11/11/70 - Chg. dept. # - Urtz - 269187 - 5/17/82 - Add Seven LW - CAK - 281453
2/5/71 - Make regular - 269420 - AJU - Chg. dept.# - 6-16-83 ADD MOH 600-RLS
11/3/80 - Revised for MRP - RLJ - 279424

DESCRIPTIVE INFORMATION



MOH 600
Seven LW
PART NAME TRIGGER HOUSING ASSEMBLY SET UP MODEL No. 700 RH 700 L.H. OPER. No. 50
TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE DEALSON PRESS

Form R. D. 6466

R2535821

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES RECORDS

DATES AND REASONS FOR REVISIONS 5/17/82 - Add Seven LW - CAK - 281453
6/10/82 - Corrected number of gage for trigger hole - RBW - 281531
6-16-83 ADD MOH 600 - RLS

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	700			700 L.H.		
SPEED / FEED		Seven LW MOH 600					
Fixture 2⅓ ton		D-36361			D-39937		
Alignment Plug		B-80154-J	(Sear holes) (2)		B-80154-J		
Flush Pin Gage		B-36352			B-36352		
Alignment Plug		B80219-D	(Trigger hole)		B-80219-D		
Flat Plug Ga. "Go" - .173 No "Go" - .178		B-88986	(Sear & Safety Cam opening)		B-88986		
OPERATION DESCRIPTION	PART NO.	26655			32905		
Assemble side plates, spacers, rivets and rivet.					MOH 600		

APPROVAL AND DATES

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700, 700L.H., Seven LW OPER. No. 50

TYPE MACHINE Denison Press DEPT No. 8579 PAGE 1 OF 1

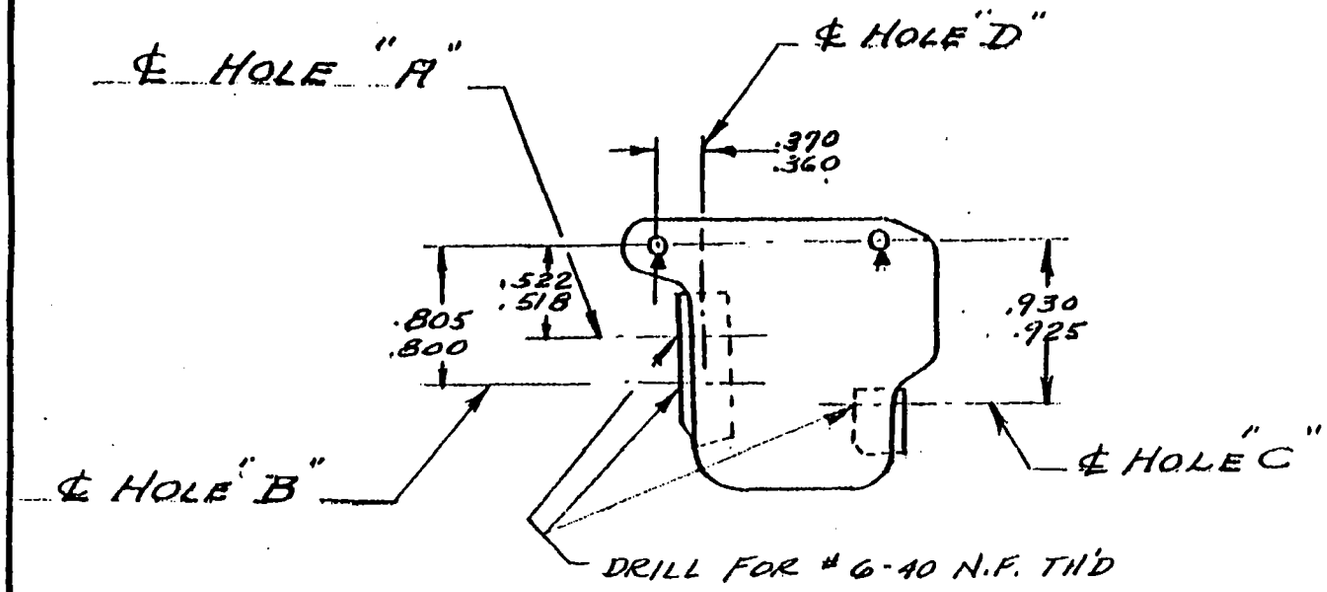
RD-8461

R2535822

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 5-1-70-NEW-AJU 26[illegible]238 6-5-70-REVISED-AJU 268836
11/5/70 - Remove "A" - Urtz - 269172 4/20/72 - Added 700 LH - Marley - 270639
11/11/70 - Chg. dept/# - Urtz - 269187 11/3/80 Revised for MRP - RLJ - 279424
2/5/71 - Make regular - AJU - 269420 - Chg. dept/# - 5/17/82 - Add Seven LW - CAK - 281453
6-16-83 ADD MOH 600 - RLS

DESCRIPTIVE INFORMATION



PART NAME TRIGGER HOUSING ASSEM. COOLANT SET UP TIME MODEL No. MOH 600 Seven LW 700 RH-700 LH OPER. No. 55
TYPE 4 SPDLE DRILL PRESS MACH. HRS. MACHINE DEPT. No. 8579 PAGE 1 OF 1

Form M. D. 6466

R2535823

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

17

MATERIAL AND SPECIFICATION C - 1020

STD. PRACTICE No.

TEMPERATURE 350° F

MAXIMUM LOAD

TIME 1/2 Hour at Temperature

QUENCH

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS R 15N 88-92

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS ~~1/6/78 - Made process regular - SB - 276520~~ 6-16-83 NEW - RLS	APPROVAL AND DATES				
~~Inductory Draw out~~ Inspect	GA. OR CAL.					
	PART No.	91468				
	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE OF STD. OF STD.					

PART NAME Safety Assembly EQUIPMENT MODEL No. Moh 600 OPER. ~~50~~ 55

DEPT. No. ~~92575~~ 51 PAGE 1 OF 1

RD-6464

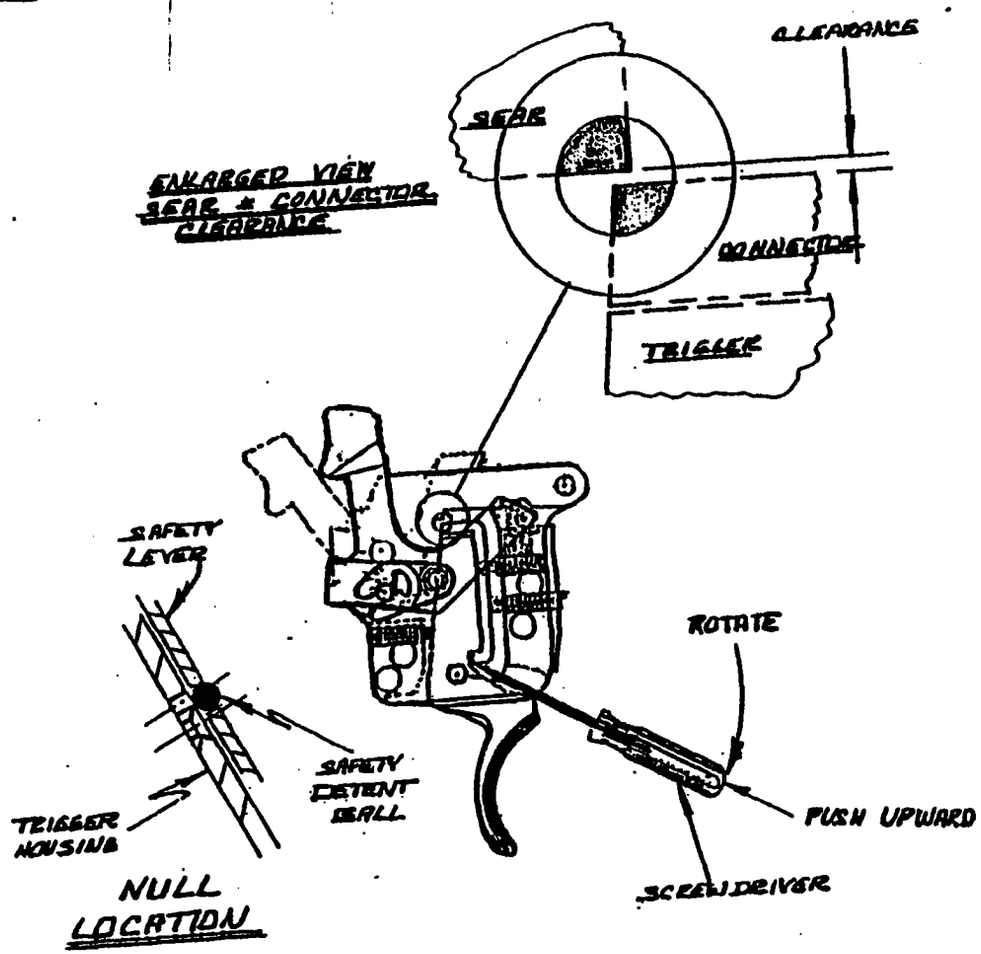
R2535824

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES | REASONS FOR REVISIONS ~~11/3/78 NEW WW 177413~~

6-16-83 NEW - WAS OP16 IN F.A. - RLS

DESCRIPTIVE INFORMATION



PART NAME ~~Trigger Final~~ Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16~~ 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE

Form R. D. 6466

R2535825

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 = NEW = WW=27741~~
6-16-83 NEW - WAS OP 16 IN F.A. - RLS

DESCRIPTIVE INFORMATION

Inspect Sear-Connector Clearance.100%

Procedure:

1. With Safety Lever in "Null Location," (previously defined in Operator #14, Page #4), insert small screwdriver blade in housing, just ahead of Trigger.

   • Push connector upward toward Sear.

CAUTION: Be sure to push on connector and not on spacer block.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear Connector Clearance. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME TRIGGER ~~Final~~ Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~10~~ 60

TYPE MACH. HRS. MACHINE DEPT. No. 61 PAGE 2 OF 4

Form R. D. 6469

R2535826

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS A_ EMBLY SHEETS

DATES AND REASONS FOR REVISIONS	~~11/3/78 — NEW — WW — 277413~~
	6-16-83 NEW — WAS OP 16 IN F.A. — RLS

DESCRIPTIVE INFORMATION	EQUIPMENT — TOOLS & GAGES
2. While looking thru inspection hole on left side of Trigger Assembly, Push downward on Sear with thumb or finger. Use the Screw Driver to pivot the Trigger, front to Rear. • Clearance Must be observed between Sear and Connector. (See illustration. Page #1) • Connector Must freely return under Sear when Trigger is released.	

OPERATION DESCRIPTION							
Inspect Sear-Connector clearance. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 16 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE

Form R. D. 6461

R2535827

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/3/78 - NEW WW-277413~~
6-16-83 NEW - WAS OP 16 IN F.A. - RLS

DESCRIPTIVE INFORMATION

2. (CONTINUED)

- REJECT IF:

No clearance is visible

or

Connector catches on Sear.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear - Connector Clearance. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 500 OPER. No. 16 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

MACHINE

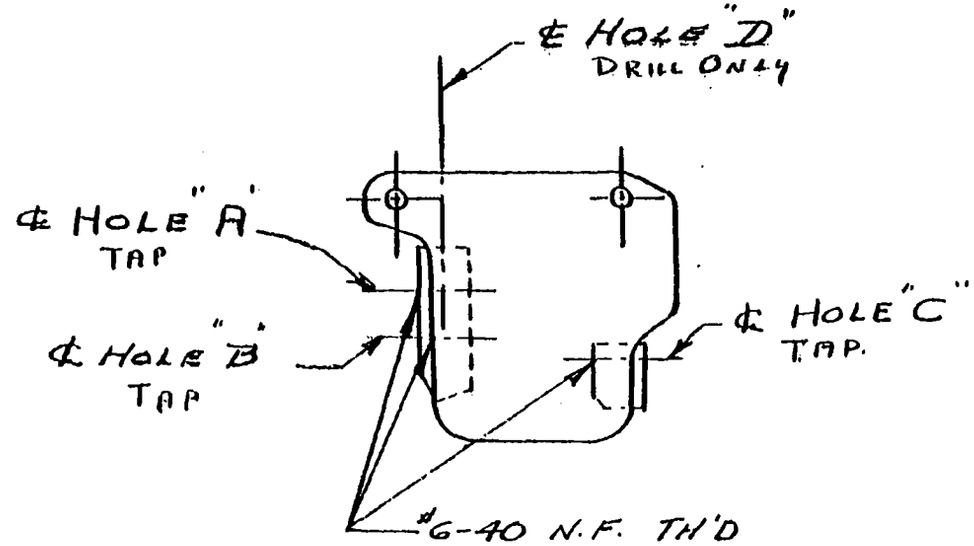
Form R. D. 6465

R2535828

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 5-1-70-NEW-AJU 268738 — 6-5-70-REVISED-AJU 268836
11/5/70 - Remove "A" - Urtz - 269172
11/11/70 - Chg. dept/# - Urtz - 269187
2/5/71 - Make regular - AJU - 269420 - Chg. dept/# -
5/17/82 - Add Seven LW - CAK - 281453
4/20/72 - Added 700 L.H. - Marley - 270639
11/3/80 - Revised for MRP - RLJ - 279424
6-16-83 ADD MOH 600 - RLS

DESCRIPTIVE INFORMATION



MOH 600
Seven LW
PART NAME TRIGGER HOUSING ASSEM. COOLANT SET UP TIME MODEL No. 700 R.H.=700 L.H. OPER. No. 60
TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE

Form R. D. 6466

R2535829

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

24

DATES AND REASONS FOR REVISIONS 7/14/70 - Retyped from 6/5/70 - 268830 6-16-83 ADD MOH 600-RLS
11/5/70 - Remove "A" - chg. part # - Urtz - 269172 4/20/72 - Added 700 LH - Marley - 270639
11/11/70 - Chg. dept/# - Urtz - 269187 11/3/80 - Revised for MRP - RLJ - 279424
2/5/71 - Make regular - AJU - 269420 - Chg. dept. # 4/7/81 Add RPM - JAA - 280264
6/8/71 - Removed temp. no. - JM - 269775 5/17/82 - Add APPROVAL AND DATES Seven LW - CAK - 281453

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	MOH 600 700 R.H. Seven LW	700 LH	
		Holding Fixture		C-36318	C-36318	
1350 RPM		Tap #6 - 40 NF-2		A-88021	A-88021	
		Th'd Plug Ga.		B-80223-W	B-80223-W	
		Plug Gage .118 Go		B-80179EE	B-80179-EE	Trigger Spring hole B-
		NOTE: Use #780 Oil				

OPERATION DESCRIPTION	PART NO.			
		26655	32905	
Tap Adjusting Screw holes (3)				

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. MOH 600 Seven LW 700 R.H. - 700 LH OPER. No. 60
TYPE MACHINE Haskins Tapper DEPT No 8579 PAGE 1 OF 1

BD-6461

R2535830

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS ~~9/21/81 - New - KRT - 280753~~
6-16-83 NEW - RLS

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.						
SPEED / FEED							
	Refer to Std. Practice #301 for Details.						
	Lot Size - 2000						

OPERATION DESCRIPTION	PART NO.						
Vacuum Wash	~~26585~~ ~~32900~~ ~~(700 LH)~~	91868					

PART NAME Safety Assembly COOLANT SET UP TIME MODEL No. ~~700, 40XB, 700LH~~ MOHAWK 600 OPER. No. ~~35~~ 63

TYPE MACHINE DEPT. No. 79 PAGE 1 OF 1

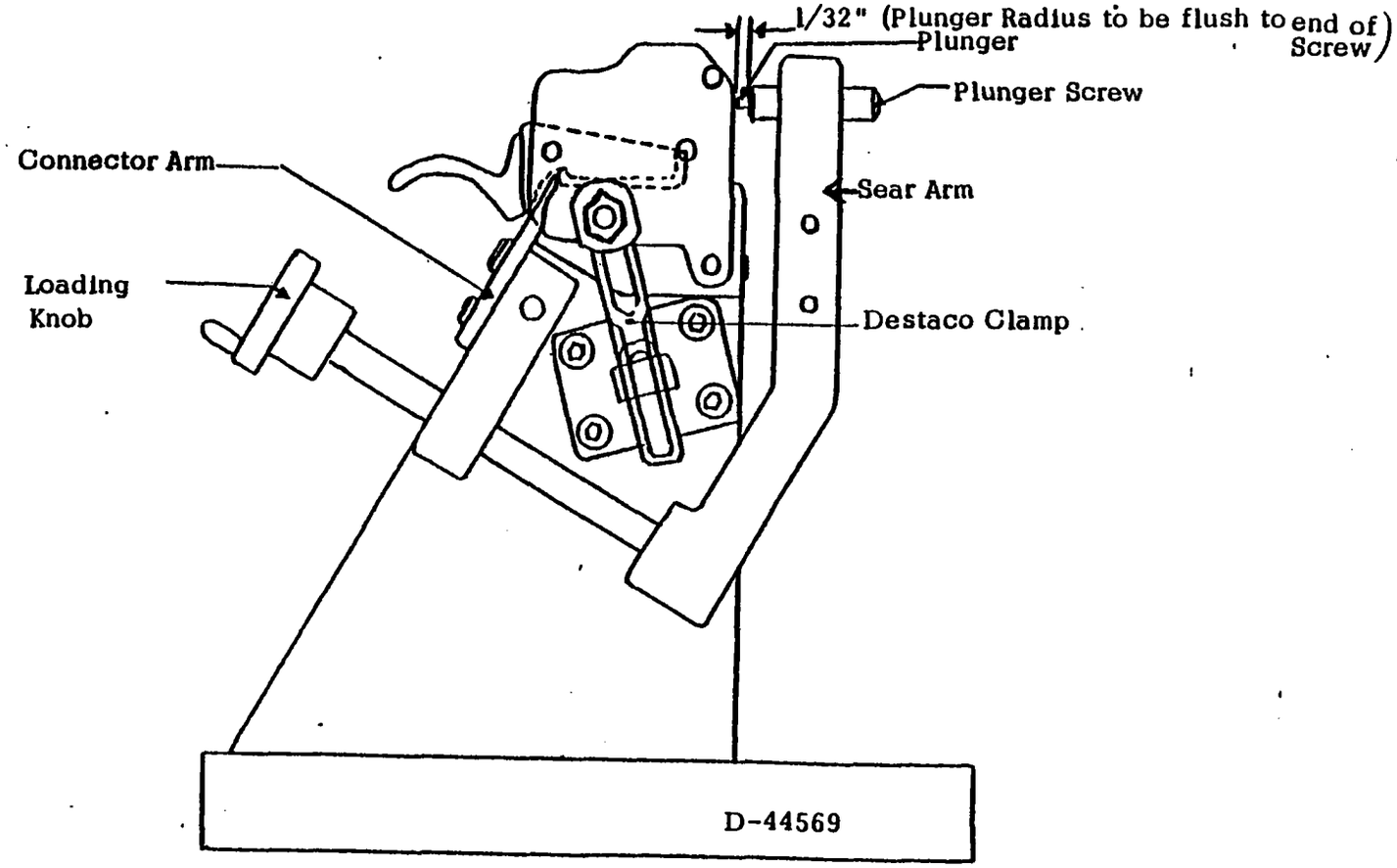
R2535831

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES | REASONS FOR REVISIONS ~~11/30/78 NEW - W/~~ 17413

6-16-83 NEW - WAS OP16.5 IN F.A. - RLS

DESCRIPTIVE INFORMATION



65

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 8

MACHINE

Form R. D. 6466

R2535832

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/70 - NEW - WW - 277413~~
~~10/9/79 - Add pad note - WAW - 278107~~
6-16-83 NEW - WAS OP 16.5 IN F.A. -RLS

DESCRIPTIVE INFORMATION

NOTE: Only Trigger Assemblies segregated at Operation #14, for Sear Lift between .007 and .008, are to be tested in this operation.

PROCEDURE:

1. Place Trigger Assembly over Connector Arm and Seat on Locators.
   - Housing must be flush to fixture.
2. Tighten (Destaco) clamp.
   - Clamp must hold Trigger Assembly firmly.

EQUIPMENT—TOOLS & GAGES

Inspection Gage - D-44569

.0025 Shim Stock, as required

NOTE: Worn or burred or damaged shim will bind and give a false REJECT Reading. Replace Shim as required. Shim must be narrow enough to pass thru view hole in housing.

NOTE: Contact pad of clamp must not interfere with Safe Arm.

OPERATION DESCRIPTION	OCC. No.						
(ONLY WHEN NECESSARY) Retest for sufficient Sear—Connector clearance with Shim.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Pivot~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~ 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 8

MACHINE

Form R. D. 6461

R2535833

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/78 - NEW - WW-277413~~
~~10/9/79 - Added "Move Safety" - WAW - 276107~~
6-16-83 NEW - WAS OP 16.5 IN F.A. - RLS

DESCRIPTIVE INFORMATION

Move Safety to "Off Safe" position.

3. Rotate loading knob clockwise until plunger end is within 1/32" of Screw. The Plunger radius is to be flush with end of Plunger Screw.

   • Do not bottom on Sear.

4. Put Safety Lever to "On Safe" position.

   • Safety snap washer must be correctly positioned.

5. Insert Shim fully into view hole.

   • It must be BETWEEN Sear and Connector

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
Retest for sufficient Sear Connector clearance with shim.	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						65

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 8

MACHINE

Form R. D. 6469

R2535834

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/76 NEW - WW 277413~~
6-16-83 NEW - WAS OP 16.5 IN F.A. - RLS

DESCRIPTIVE INFORMATION

6. Move Safety to "OFF SAFE" Position.
   Lightly pull on Shim with thumb and finger.

   - Shim must REMAIN TRAPPED between the Connector and Sear.
   - If Shim is free - Repeat Test.

7. Move Safety Lever from "OFF SAFE" position toward "ON SAFE" TO LOCATE AND STOP Safety Lever at the forward most Null Location.
   (Previously defined in Op. #14, Page #4.)

   This is easiest while thumb is located on top of Sear Arm.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Retest for sufficient Sear-Connector clearance with Shim.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final Assembly~~ TRIGGER COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~ 65
TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 8
MACHINE

Form R. D. 6465

R2535835

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD[illegible] SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/78 - NEW - WW 277413~~

6-16-83 NEW - WAS OP 16.5 IN E.A. - RLS

DESCRIPTIVE INFORMATION

7. (CONTINUED).

- If Null Location is passed (too far toward "ON SAFE") then return to "OFF SAFE" Position and approach Null Location from "OFF SAFE" side again.

8. With the Safety Lever in the forward most Null Location, lightly pull on Shim with thumb and finger.

- If Shim binds or hangs up between Sear and Connector, then REJECT TRIGGER ASSEMBLY. END OF TEST.

EQUIPMENT - TOOLS & GAGES

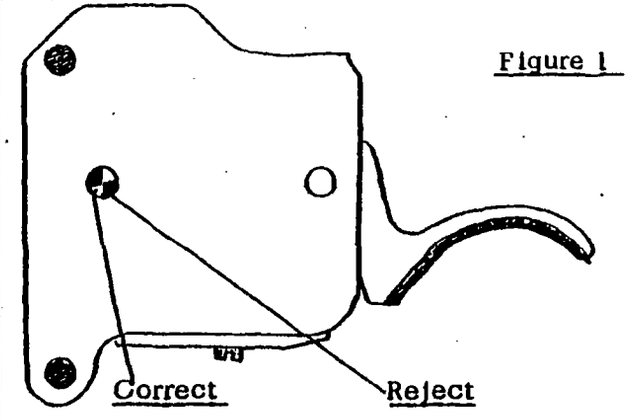


Figure 1

Connector Under Sear

Connector Trapped Forward of Sear

OPERATION DESCRIPTION							
Retest for Sufficient Sear Connector clearance with Shim.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						65

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~

TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 8

MACHINE

R2535836

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/78 - NEW - WW-277413~~
6-16-83 NEW - WAS OP. 16.5 IN F.A. - RLS

DESCRIPTIVE INFORMATION

- If Shim removes freely, Sear Connector clearance is correct.

CONTINUE:

9. Pull Trigger and Relea se:

- Connector must fully return under Sear. Check visually.

- If Connector is trapped forward of Sear,

REJECT TRIGGER ASSEMBLY END OF TEST.

(See Figure 1)

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Retest for Sufficient Sear Connector clearance with Shim.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~ 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 6 OF 8

MACHINE

Form R. D. 6465

R2535837

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ..SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/78 NEW WW 277413~~
6-16-83 NEW - WAS 16.5 IN F.A. - RLS

DESCRIPTIVE INFORMATION

10. Move Safety Lever to "OFF SAFE" Position.

- Sear must not drop.
- If Sear drops (Fires),

  REJECT TRIGGER ASSEMBLY

- If Sear does not drop,

  TRIGGER ASSEMBLY IS GOOD

11. Loosen thumb screw

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Retest for sufficient Sear Connector clearance with Shim.	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65 ~~16.5~~

TYPE MACH. HRS. DEPT. No. 61 PAGE 7 OF 8

MACHINE

Form R. D. 6465

R2535838

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~11/30/78 = NEW = WW-877413~~
6-16-83 NEW - WAS 16.5 IN F.A. - RLS

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
12, Release Clamp. 13. Remove Trigger Assembly. Re-seat front Dummy Sear Pin flush to Housing. 14. Add Trigger Assembly into labeled container, according to test results.	

OPERATION DESCRIPTION							
Retest for sufficient Sear Connector clearance with Shim.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. ~~16.5~~ 65
TYPE MACH. HRS. DEPT. No. 61 PAGE 8 OF 8
MACHINE

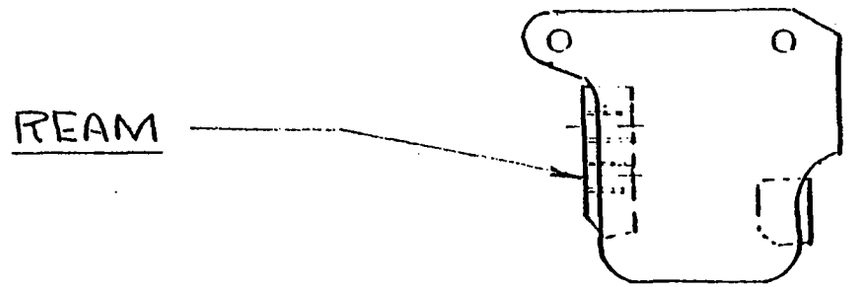
Form R. D. 6469

R2535839

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/7/79 - New - JAA - 277856
11/3/80 - Revised for MRP - RLJ - 279424 -
5/17/82 - Add Seven LW - CAK - 281453
6-16-83 ADD MOH 600 - RLS

DESCRIPTIVE INFORMATION



MOH 600

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700, Seven LW OPER. No. 65
TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE

Form R. D. 6466

R2535840

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 6/7/79 - New - JAA - 277856
11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
6-16-83 ADD MOH 600

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
		Reamer - .1195 Dia.	Std.	
		Plug Gage .119 - .121	B-80202-JJ	

OPERATION DESCRIPTION	PART NO.	APPROVAL AND DATES
Ream Trigger Spring Hole	26655 32905	

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700, Seven LW MOH 600 OPER. No. 65
TYPE MACHINE Drill Press DEPT No. 8579 PAGE 1 OF 1

RD-6461

R2535841

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

23

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 2/5/71 - New operation - Urtz - 269420 - Chg. dept/#
6/8/71 - Removed temp. no. - Marley - 269775 6-16-83 ADD MOH 600 - RLS
4/20/72 - Added 700 L.H. - Marley - 270639
11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	700 RH	700 LH	APPROVAL AND DATES			
SPEED / FEED		Seven LW					
		MOH 600					
	File						

OPERATION DESCRIPTION	PART NO.						
		26655	32905				
Deburr Holes							
					MOH 600 Seven LW		

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700 R.H.-700 LH OPER. No. 70
TYPE MACHINE DEPT. No. 8579 PAGE 1 OF 1

RD-6461

R2535842

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS ~~10/31/78 NEW WW 277413~~
6-16-83 NEW - WAS OP 17 IN E.A. - RLS

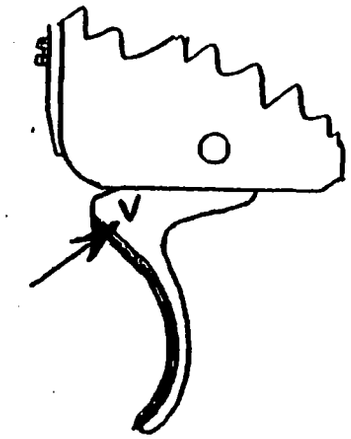
DESCRIPTIVE INFORMATION

1. Locate Trigger Assembly on Stamping Fixture.

2. Stamp "V" on Trigger; left side, just below Housing ONLY on Trigger Assemblies which have passed Operation #14 and Operation #16 or 16.5.

3. Use a standard 1/16" size character "V".

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION							
Stamp passed Trigger Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME ~~Final~~ TRIGGER Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 70 ~~17~~

TYPE MACH. HRS DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535843

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

09

DATES AND REASONS FOR REVISIONS

7/14/70 - Retyped from 6/5/70 - 268830
11/5/70 - Remove "A" - chg. part # - Urtz - 269172
2/5/71 - Make regular - Urtz - 269420
6/8/71 - Removed temp. no. - Marley - 269775
4/20/72 - Added M/700 LH - Marley - 270639
11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
6-16-83 ADD MOH 600 - RLS

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES					
SPEED / FEED		700 R.H. Seven LW MOH 600	700 LH				
	Color						
OPERATION DESCRIPTION	PART NO.						
Black Oxide color		26655	32905				

MOH 600 Seven LW

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700R.H. - 700 LH OPER. No. 75

TYPE MACHINE DEPT No. 8579 PAGE 1 OF 1

BD-6461

R2535844

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS . SSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
6-16-83 ADD MOH 600 - RLS

DESCRIPTIVE INFORMATION

This operation removes and excess "Steelgard" and/or foreign material just prior to Assembly operation.

Clean First tank : "Freon" vapor degreaser. Basket Dip. Then immediately transfer to :

Preserve Second tank: Water based rust inhibiting bath. Basket dip. Then air dry.

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
Clean Trigger Housing Assembly and apply Rust Preventative.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
		MOH 600					
	PART No.	26655	32905				
	GA.	700RH, Seven LW	LH				

PART NAME Trigger Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. MOH 600 700, Seven LW OPER. No. 80

TYPE _____ MACH. HRS. _____ DEPT. No. 8761 PAGE 1 OF 1

MACHINE

Form R. D. 6463

R2535845

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

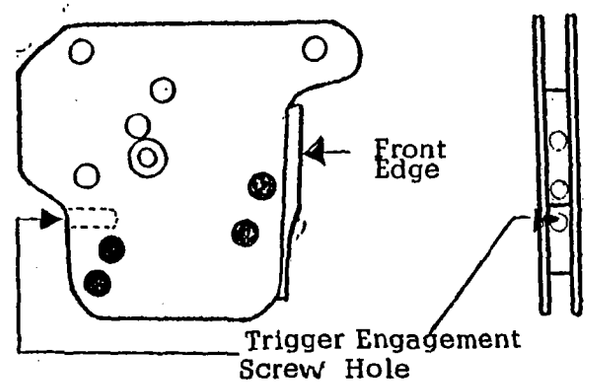
PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 2 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

1. Position Trigger Housing Assembly on its front edge.
2. Clean (using compressed air hose) housing and Trigger Engagement Screw Hole.
3. Spray Trigger Engagement Screw Hole with "Locquic Primer T" (Aerosol Can).
   - NOTE: Housings must Air Dry (Do Not Use Compressed Air Hose) at least Five (5) minutes after spraying with primer.
4. To Trigger Sub-Assembly.

- NOTE: Use Red Plastic Valve - Finger Piece and Plastic Tube from can of "Inhibisol" on can of "Locquic"



OPERATION DESCRIPTION	OCC. No.						
Clean and Prime Trigger Engagement Screw Hole.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 5

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535846

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 3.1 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

NOTE: Do All Elements 100%.

1. Inspect long inside connector surface, and inside surface of long (top) leg for flatness.

Hold Connector against flatness block with light finger pressure.

- If no light shows between inside surfaces of back and long leg of connector, and block surface; connector is good. (continue) (See Figure #1, Page #4).

EQUIPMENT-TOOLS & GAGES

Flatness Block - C-44524

OPERATION DESCRIPTION							
Inspect connectors 100%.	OCC. No.						
	STD. HRS/C						
Scrap all defects	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 10

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE

R2535847

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 3.1 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

- If light gap shows, measure gap with a .006 shim. If gap accepts shim without moving connector - Reject connector. (See Figure #2, Page #4.)
- If connector rocks on flatness block - reject connector. (See Figure #3, Page 4).
- Front edge of long (top) leg, must be square with shoulder of flatness block.

  (See Figure #4, Page #4).

EQUIPMENT-TOOLS & GAGES

.006 Shim - Make new shim as required.

OPERATION DESCRIPTION							
Inspect Connectors 100%.	OCC. No.						
	STD. HRS/C						
Scrap all Defects	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 10

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE

R2535848

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 3.1 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

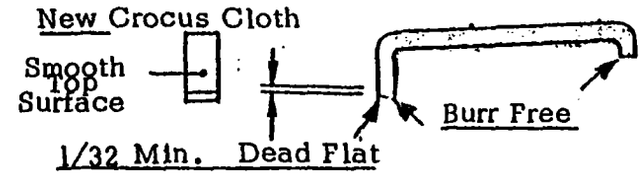
3. Smooth top surface of long leg of Connector. Use Crocus Cloth.

Surface must be:

- Smooth
- Burr -Free at top and bottom corner
- Dead flat within 1/32" minimum of end.

Check for burrs and smoothness with finger tip.

EQUIPMENT—TOOLS & GAGES



(This is the same as the Wire Diameter of a Paperclip)

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect Connectors, 100%	EFF. DATE						
Scrap all Defects							
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 10

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE

R2535849

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 3.1 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

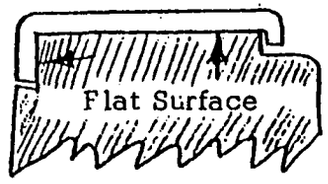


Fig. #1
Good

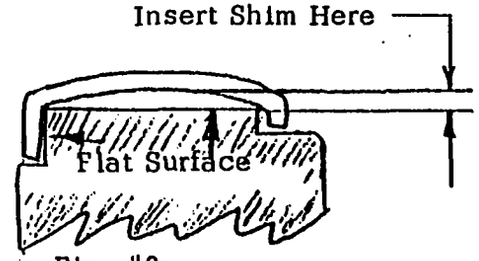


Fig. #2
Test Light Gap
With Shim

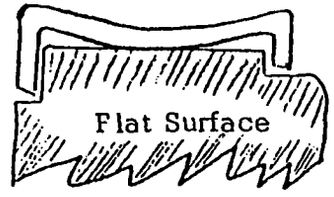


Fig. #3
Reject

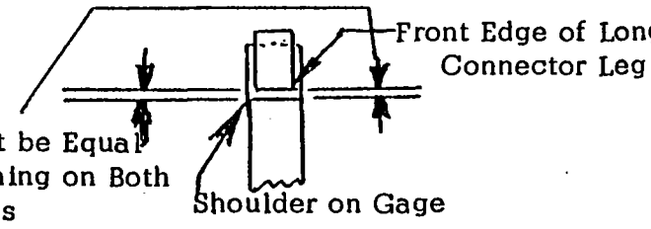


Figure #4

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 10

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

MACHINE

Form N. D. 6466

R2535850

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 3.3 in F.A. - RLS - 283007

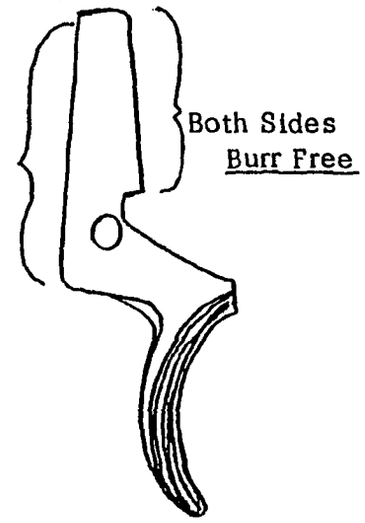
DESCRIPTIVE INFORMATION

1. Inspect Trigger.

   Trigger Must Have:

   - Good Black Color
   - No Bleed Out (White Material on Surface)
   - No Burrs on Sides
   - No cracks or damage @ pivot hole.

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Inspect Trigger.							
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 15

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R253851

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was Op. 4 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

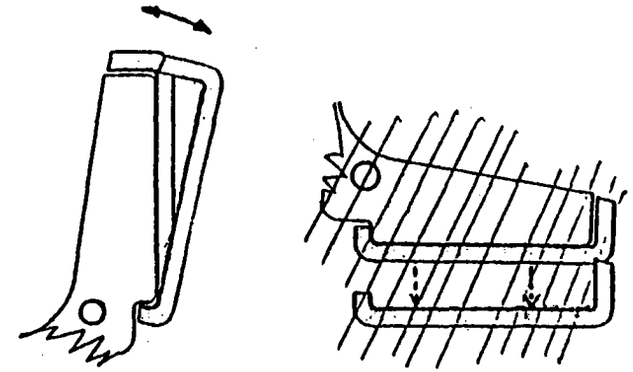
1. Fit passed Connector to passed Trigger and check for Min. working clearance (slip fit).

   - Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.

   - Connector must fall off Trigger when Trigger is held horizontally.

   - If Binding occurs, file bottom notch on Trigger to remove bind. Filed surface must be flat and square with sides of Trigger. **Use filing fixture only, not freehand.**

EQUIPMENT—TOOLS & GAGES



SLIP FIT MIN.

Filing Fixture - D-44521

OPERATION DESCRIPTION							
Check Connector to Trigger Fit. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 20

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 2

MACHINE

Form R. D. 6461

R2535852

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 4 in F.A. - RLS - 283007

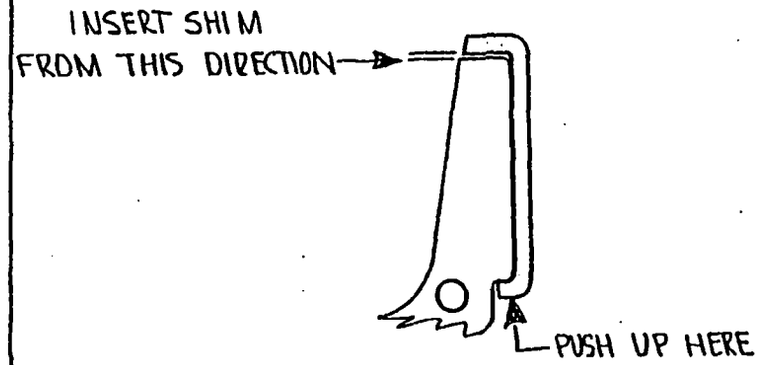
DESCRIPTIVE INFORMATION

2. With the Same Trigger and Connector, Check for Max.Working Clearance.

- Push Connector tight to Trigger at bottom and hold it parallel to sides of Trigger.
- Insert Shim Stock in clearance from front to back
  - .006 Shim Must Not Go.
- If Shim Enters without moving Connector, Scrap Trigger.

EQUIPMENT—TOOLS & GAGES

.006 Shim Stock. Make new shim as required.



OPERATION DESCRIPTION							
Check Connector To Trigger Fit. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 20

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 2

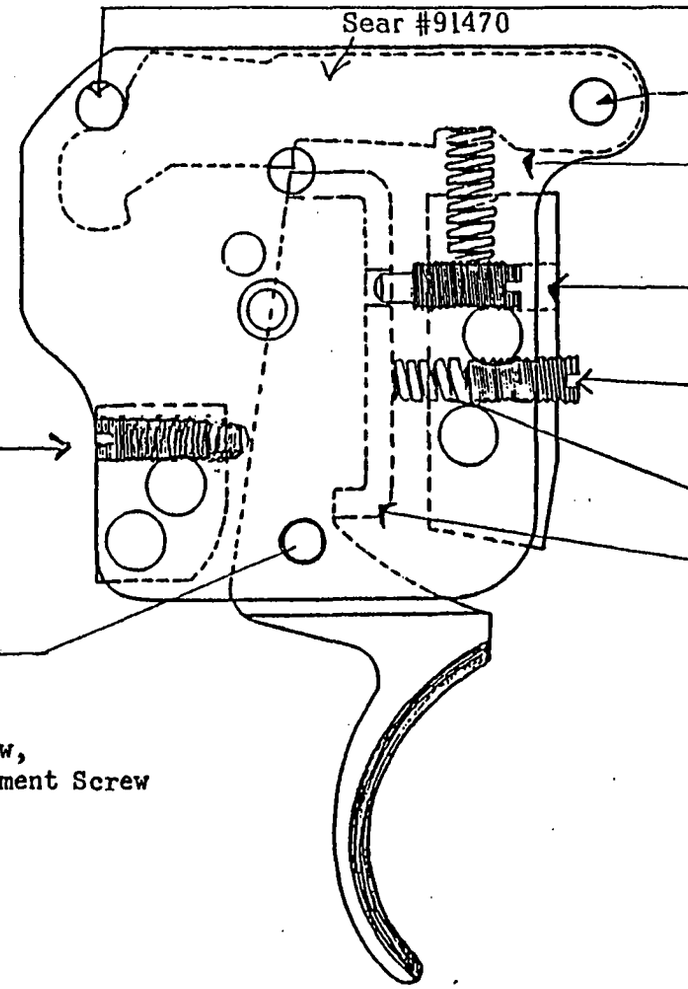
MACHINE

R2535853

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 6 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION



(1) NOTE: For Australian use only:
Substitute Trigger Engagement Screw, #91117; Followed by Trigger Engagement Screw Lock screw, #91127.

(2) NOTE: For Australian use only:
Substitute Trigger Screw Front, #91118; Followed by Trigger Screw Lock Screw Front, #91127.

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 25

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE

Form R. D. 6466

R2535854

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 6 in F,A, - RLS - 283007

DESCRIPTIVE INFORMATION

1. Inspect Trigger Housing:
   - Black Color
   - No Bleedout (White Material).
   - Check inside Housing - No Burrs at Sear Pin Holes.
   - Clean and free of excess oil and foreign material.
2. Position Trigger in Housing and install Trigger Pin:
   - Pin Must be flush to housing on right side.
   - Grip Trigger and rotate housing around Trigger pin - Trigger must rotate freely in housing without bind.

EQUIPMENT--TOOLS & GAGES

Pin Holder Drive Punch
A - 35645

OPERATION DESCRIPTION	OCC. No.						
Assemble Trigger Sub-Assembly.	STD. HRS/C						
	STD. No.						
Stage One.	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 25

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE

R2535855

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 6 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

3. Install:

- Same Connector as fitted to Trigger (Op. #4)
- Trigger Stop Screw - One full turn (Thread) above flush with hole.
- Trigger Spring
- Trigger Adjusting Screw - Flush with hole or below. (There must be Spring Force on connector while adjusting Trigger Engagement Screw).
- Trigger Engagement Screw - Flush with hole

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Assemble Trigger Sub-Assembly. Stage One.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 25

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE

R2535856

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

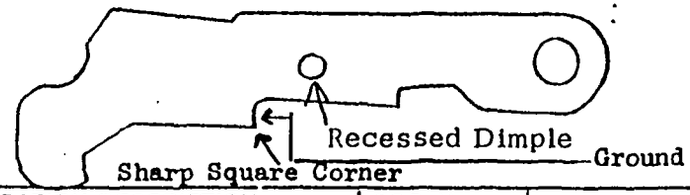
DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 6 ij F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

4. Install Sear Spring and *Sear using two dummy pins

- Sear must be flat - not bowed. Check 100% thru width gauge. (Inspection Check)
- Sear must have dimple
- Sear must be ground at vertical contact surface with Connector.
- Sharp square corner at contact surface.

* Sear - Part #91470 Has a Recessed Dimple.
Do not Substitute



EQUIPMENT—TOOLS & GAGES

Dummy Pins - A-51468

Width Gage - C-44522

OPERATION DESCRIPTION							
Assemble Trigger Sub-Assembly. Stage One.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 25

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

MACHINE

R2535857

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

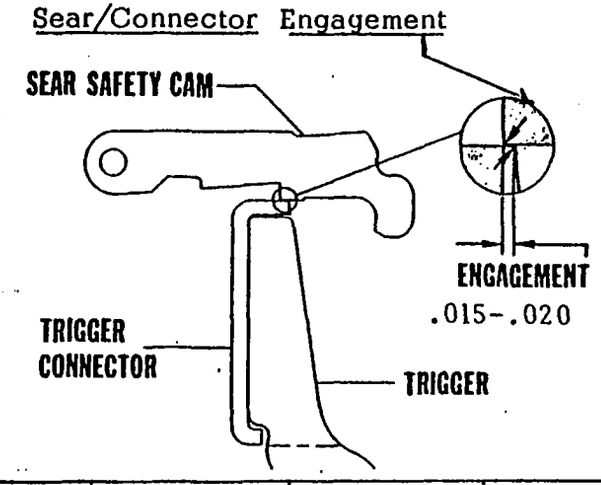
DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op! 7 in F.A. - RES - 283007

DESCRIPTIVE INFORMATION

1. Pick Trigger Sub-Assembly. Position in Comparator Fixture and Clamp.
   - Housing must properly contact all locators.
   - Top of Housing must be flat on Fixture.
   - Push with thumb on rear of Trigger (toward left) This seats Trigger firmly against end of Trigger Adjusting Screw.
2. Adjust fixture to locate Sear on "Set" line of comparator screen.

EQUIPMENT—TOOLS & GAGES

Comparator Fixture - E-42271
Comparator Screen - A-600-CL25



OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 30
TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4
MACHINE Jones & Lamson Comparator TC-10

Form B D 6461

R2535858

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 7 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

3. Adjust Sear/Connector Engagement (.015 - .020), to correct Comparator Screen line, by turning Trigger Engagement Screw slowly clockwise. (To reduce Engagement).

After correctly adjusting Sear/Connector Engagement

4. Hang Dead Weight Assembly to end of Trigger.

5. Adjust Trigger Pull by turning Trigger adjusting screw slowly counter-clockwise until Sear just disengages (Fires).

EQUIPMENT—TOOLS & GAGES

Comparator Fixture dead weight - 2.9 lbs. (M/600 only)

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Trigger Sub-Assembly on Comparator.							
100%							
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 30

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE Jones & Lamson Comparator TC-10

R2535859

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 7 in F,A, - RLS - 283007

DESCRIPTIVE INFORMATION

6. Re-adjust Fixture to locate Sear on "Set" Line of Comparator Screen.

7. Remove Dead Weight Assembly from Trigger.

8. Hold Trigger in fired position firmly with finger, and:

   - Set Over-Travel by turning Trigger stop Screw slowly clockwise, until Trigger Connector touches correct line on Comparator Screen.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator.	OCC. No.						
	STD. HRS/C						
100%	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 30

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE Jones & Lamson Comparator TC-10

R2535860

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 7 in F,A, - RLS - 283007

DESCRIPTIVE INFORMATION

9. Remove Trigger Sub-Assembly from Comparator Fixture.

10. Seal all three screws with "Duco" Cement.

EQUIPMENT—TOOLS & GAGES

NOTE: Adjust Comparator Projection System, as required, to maintain sharp clear image of Fixture hole around entire Perimeter. Refer to page #7 of J & L Operating Manual.

OPERATION DESCRIPTION							
Adjust Trigger Sub-Assembly on Comparator. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 30

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

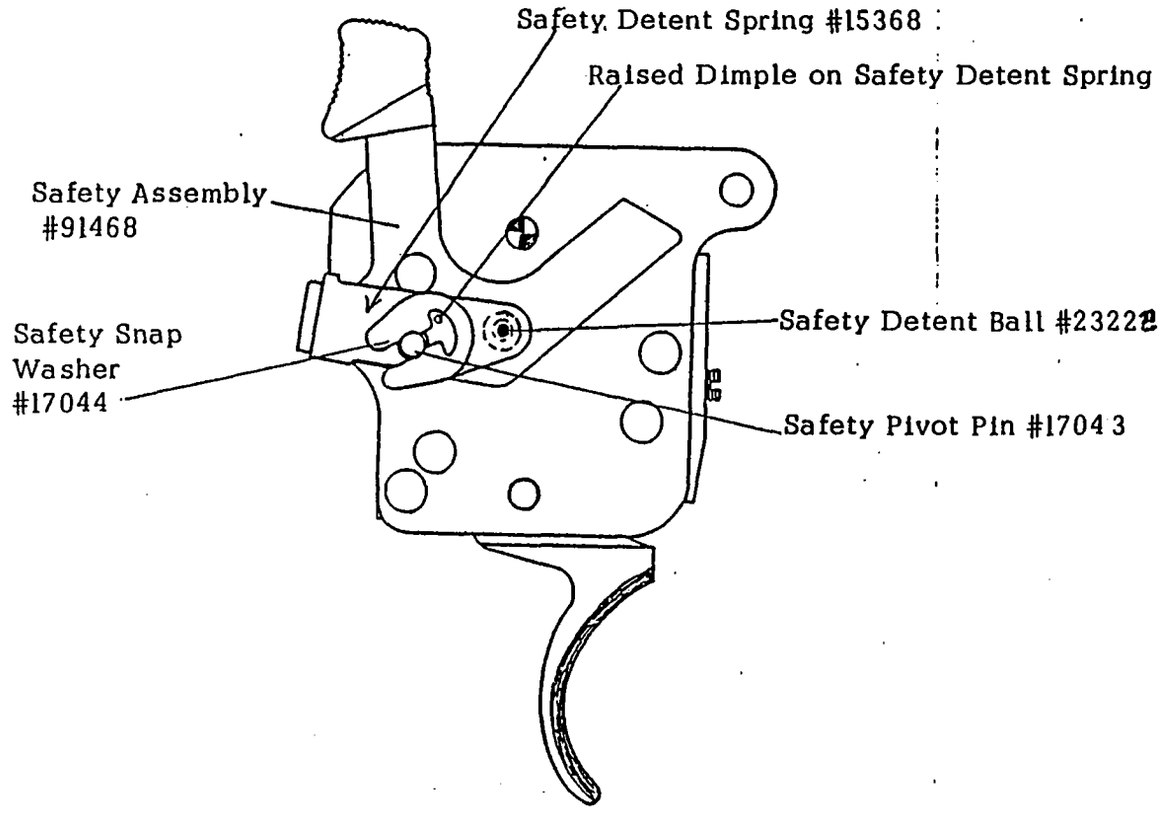
MACHINE Jones & Lamson Comparator TC-10

R2535861

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 9 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION



PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 35

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 3

MACHINE

Form R. D. 6466

R2535862

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 9 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

1. Pick Correctly adjusted Trigger Sub-Assembly.

2. Assemble:

   Safety Assembly

   Safety Detent Ball

   Safety Detent Spring -Visually Check for correct size Dimple.

   Safety Pivot Pin

   Safety Snap Washer -

   Side with deeper notch (For safety Pivot Pin) must be on top.

EQUIPMENT—TOOLS & GAGES

Deep Notch Must be on top.

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Assemble Trigger Assembly,	EFF. DATE						
Stage Two.							
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 35

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 3

MACHINE

R2535863

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 9 in E.A. - RLS - 283007

DESCRIPTIVE INFORMATION

- Safety Snap Washer Must be Completely contained within Pivot Pin Groove.
- The raised end of Dimple on Safety Detent Spring Must be at the left end of the opening at the closed end of Safety Snap Washer. (Refer to Illustration)

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
A.ssemble Trigger Assembly.	OCC. No.						
	STD. HRS/C						
Stage Two.	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 35

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 3

MACHINE

R2535864

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 11 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
1. Pick Trigger Assembly	
2. Apply Small amount of "Molykote" Powder to Sear/Connector Engagement Surfaces thru Engagement view hole.	Dry Type "Z" Molykote" Powder. Squeeze container (eyedropper)

OPERATION DESCRIPTION							
Lubricate Connector and Sear with "Molykote" Dry Powder.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 40

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535865

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 12 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

NOTE: All Elements 100%

1. Put Safety in "OFF SAFE" Position.
   Check For:

   Trigger Retraction
   - Pull Trigger and Release
   - Trigger and Connector must return freely to original position with Spring Force.

   Sear Freedom
   - Pull Trigger and Hold.
   - Depress Sear Fully and Release.
   - Sear must move freely in Housing without Binding. The Sear must return fully upward under Sear Spring Force.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check completed Trigger Assembly.	OCC. No.						
	STD. HRS/C						
100%	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 45

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 3

MACHINE

R2535866

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 12 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

2. Operation of Safe

- Push Safety thumb piece fully forward beyond detent position.
- Safety must Spring return rearward to detent position.
- Push Safety thumb piece fully rearward beyond detent position.
- Safety must Spring return forward to detent position.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check completed Trigger Assembly. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 45

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 3

MACHINE

R2535867

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 12 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

Move Safety from "On Safe" to "Off Safe" position and back. Twice.

- Safety must Spring forward into "Off Safe" position when pushed.
- There must be no hang-up or hesitation between detent positions.
- The Bolt Lock Arm of Safety Assembly must work freely on housing.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Function check Complete Trigger Assembly. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 45

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 3

MACHINE

R253868

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 13 in F.A. - RLS - 283007

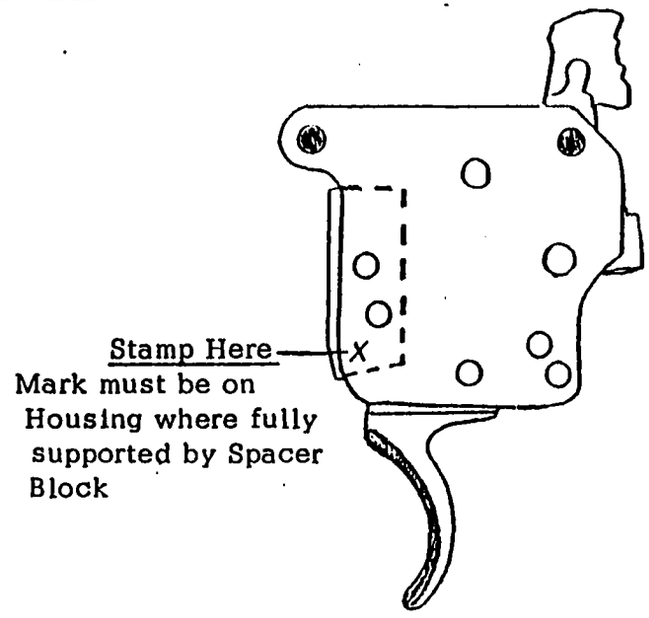
DESCRIPTIVE INFORMATION

1. Locate Trigger Assembly on Stamping Fixture.

2. Stamp Lower Left Front Corner (as shown) with correct Assembler identification.

   - Use 1/16" size character

EQUIPMENT-TOOLS & GAGES



Mark must be on Housing where fully supported by Spacer Block

OPERATION DESCRIPTION								
Mark correctly assembled, Adjusted and checked Trigger Assembly with Assembler's identification.	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.	91469						
	GA.							

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 50

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535869

DATES AND REASONS FOR REVISIONS 5-1-70-NEN-AJU 268238 6-5-70-REVISED-AJU 268836

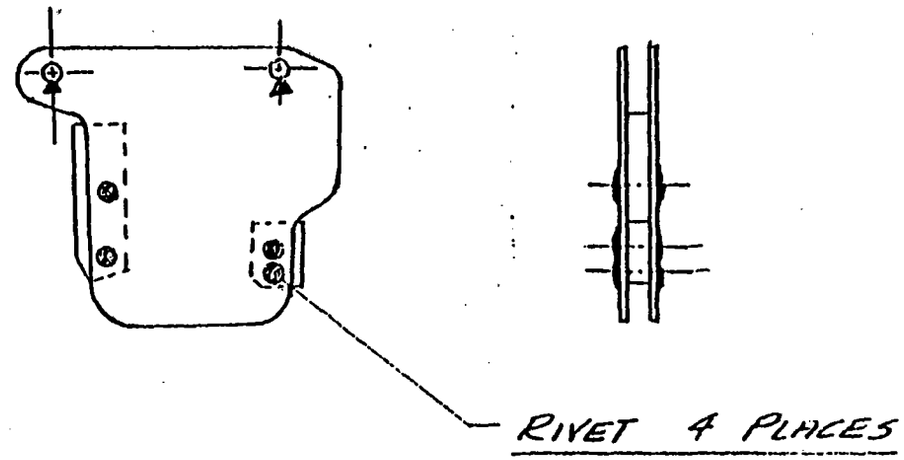
11/5/70 - Remove "A" - Urtz - 269172 11-11-71 Nobed M-700 L.H. M

11/11/70 - Chg. dept. # - Urtz - 269187 - 5/17/82 - Add Seven LW - CAK - 281453

2/5/71 - Make regular - 269420 - AJU - Chg. dept.# - 7/8/83 - Add Moh. 600 - RLS - 283008

11/3/80 - Revised for MRP - RLJ - 279424

DESCRIPTIVE INFORMATION



PART NAME TRIGGER HOUSING ASSEMBLY COOLANT SET UP TIME MODEL No. 700-RH 700-L.H. Moh.600Seven LW OPER. No. 50

TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1

MACHINE DENISON PRESS

Form R. D. 6466

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCES RECORDS

DATES REASONS FOR REVISIONS 5/17/82 - Add Seven LW - CAK - 281453
6/10/82 - Corrected number of gage for trigger hole - RBW - 281531
6/23/83 - Add note on spacers - CFC - 282948 2/24/86-Add width ga.-CFC-286381
7/8/83 - Add Moh 600 - RLS - 283008

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES 700 Seven LW Moh. 600			700 L.H.		
		Fixture 2½ ton		D-36361			D-39937		
		Alignment Plug		B-80154-J	(Sear holes) (2)		B-80154-J		
		Flush Pin Gage		B-36352			B-36352		
		Alignment Plug		B80219-D	(Trigger hole)		B-80219-D		
		Flat Plug Ga. "Go" - .173 No "Go" - .178		B-88986	(Trigger Opening)		B-88986		
				NOTE:	If spacers are not ground all over, measure at .174 on unground area. If .174 or greater pass, If less than .174 scrap.				
		Overall width at Top-Outside .305 Max.		B-802015					

OPERATION DESCRIPTION	PART NO.						
Assemble side plates, spacers, rivets and rivet.		26655			32905		

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700, 700L.H., Moh. 600, Seven LW OPER. No. 50
TYPE MACHINE Denison Press DEPT. No. 8579 PAGE 1 OF 1

RD-6461

R2535871

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 14 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

Inspect Sear Lift 100%

Procedure:

1. Push Slave Pins in Trigger Assembly Part Way Out, Toward Right Side of Trigger Assembly.

2. Raise Locating Pins in Gage half way, by pulling lever toward body.

3. Place Trigger Assembly over locating pins and clamp down. Make sure Assembly is Flat to the Gage Locating Surfaces.

EQUIPMENT—TOOLS & GAGES

Dial Base Gage #D-42614

NOTE: Clamps on Base Gage must be adjusted as required to locate Trigger Assembly flat to Gage while testing. Clamp pad must miss rivets.

OPERATION DESCRIPTION							
Inspect for sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 6

MACHINE

Form R. D. 6465

R2535872

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 14 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

4. Hold Trigger Assembly in position with Finger, and raise Locating Pins to full upward position.

5. Move Safety Lever to "OFF SAFE" Position.

6. Draw Dial Indicator into position with adjustment knob, until Dial Indicator READS ZERO ("O"). On both scales.

7. Move Safety Lever to "ON SAFE" Detented Position. READ Dial Indicator.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 6

MACHINE

Form R. D. 6469

R2535873

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 14 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

MUST BE .008 TO .018 SEAR LIFT

- Reject if less that .008.
- Reject if more than .018.

(If Reading is within limits, continue:)

8. Push Safety lever to "OFF SAFE" Detented Position.

9. Re-Zero Dial (if necessary) using Adjustment Knob.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect For Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 6

MACHINE

Form R. D. 6465

R2535874

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op 14 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

10. Move Safety Lever from "OFF SAFE" Position toward "ON SAFE" Position TO LOCATE AND STOP Safety Lever at the *Forward most Null location.

* FORWARD MOST NULL LOCATION - is that "Just Stable" place between "On" and "Off" Safe - closest to "Off Safe" - where the Safety Lever will not spring forward to the "Off Safe" Position when released.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 6

MACHINE

Form R. D. 6465

R2535875

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 14 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

- If the Null Location is overshot (where the Safety Lever was moved too far toward "On Safe"); then return to "Off Safe" and again approach Null Location from the "Off Safe" side.

Remove Trigger Assembly from Dial Base Gage.

11. Separate Trigger Assemblies, into labeled containers, according to Dial Readings at that "Forward Most Null Location".

- Less that .007 - Repair

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
Inspect for Sufficient Sear Lift.	EFF. DATE						
100%							
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 6

MACHINE

Form R. D. 6465

R2535876

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op 14 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

- .007 to .008 - Retest (Operation #16.5)
- Over .008 - Good (Continue to Op. #16)
- Over .018 - Repair

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect for Sufficient Sear Lift. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55

TYPE MACH. HRS. DEPT. No. 61 PAGE 6 OF 6

MACHINE

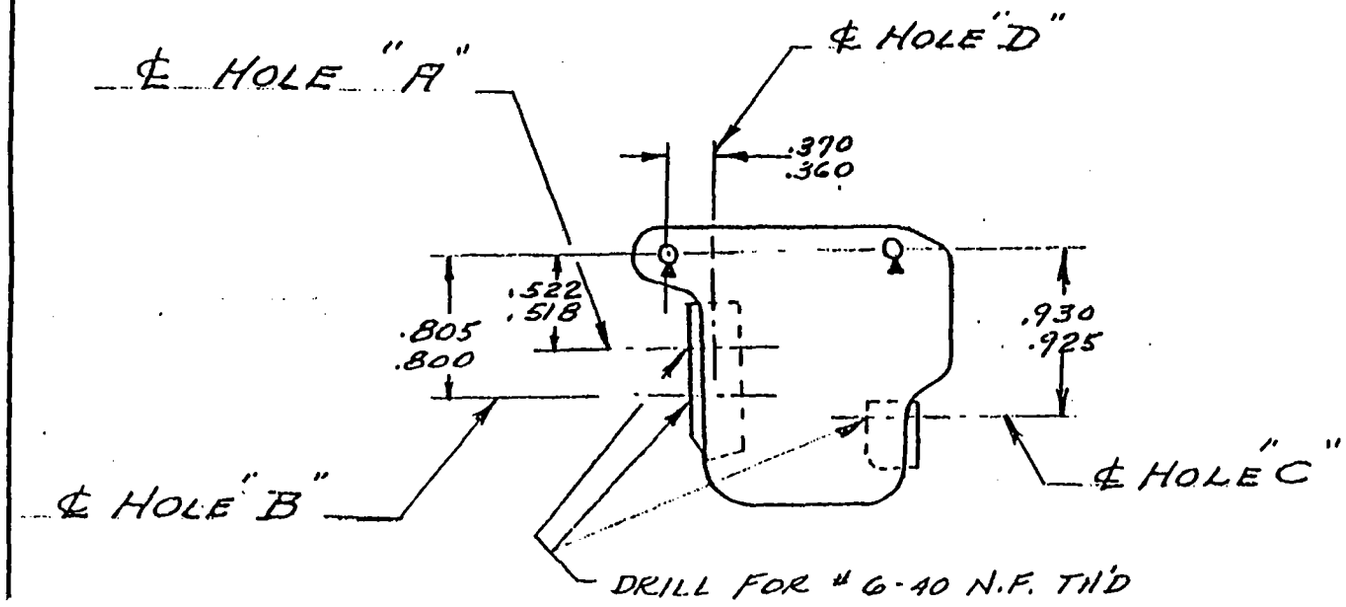
Form R. D. 6465

R2535877

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 5-1-70-NEW-AJU 268738 6-5-70-REVISED-AJU 268836
11/5/70 - Remove "A" - Urtz - 269172
4/20/72 - Added 700 LH - Marley - 270639
11/11/70 - Chg. dept/# - Urtz - 269187
11/3/80 Revised for MRP - RLJ - 279424
2/5/71 - Make regular - AJU - 269420 - Chg. dept/# -
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008

DESCRIPTIVE INFORMATION



PART NAME TRIGGER HOUSING ASSEM. COOLANT SET UP TIME MODEL No. Moh. 600, Seven LW 700 RH-700 LH OPER. No. 55
TYPE 4 SPDLE DRILL PRESS MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE

Form R. D. 6466

R2535878

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 9/26/79 - Retyped & filed with process no. - 278165 - EB
9/26/79 - Chg. depth .240 to .242 & add plug ga. number - JAA - 278165 7/8/83 - Add Moh. 600 - RLS - 283008
11/3/80 - Revised for MRP - RLJ - 279424
12/30/80 - Chg. A,B&C to #33 Drill - JAA - 280034
5/17/82 - Add Seven LW - CAK - 281453

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	Moh. 600 700 R.H.	700 L.H.	APPROVAL AND DATES		
SPEED / FEED		Seven LW				
	Drill Jig	C-36326				
	Drill #33 (.113 Dia) A,B&C	Std.				
	Plug Ga. .112 - .114	B-80202BB				
	Drill - #24 (.152) - "D"	A-44979				
	Plug Ga. - .151 - .155 dia.	B-80121-U				
	Depth - .242 - .300					

OPERATION DESCRIPTION	PART NO.					
		26655	32905			
Drill Adjusting Screw holes (3) and Sear Spring hole.						

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. Moh. 600, Seven LW 700R.H.-700 L.H. OPER. No. 55
TYPE MACHINE 4 Spindle Drill Press DEPT. No. 8579 PAGE 1 OF 1

RD-6461

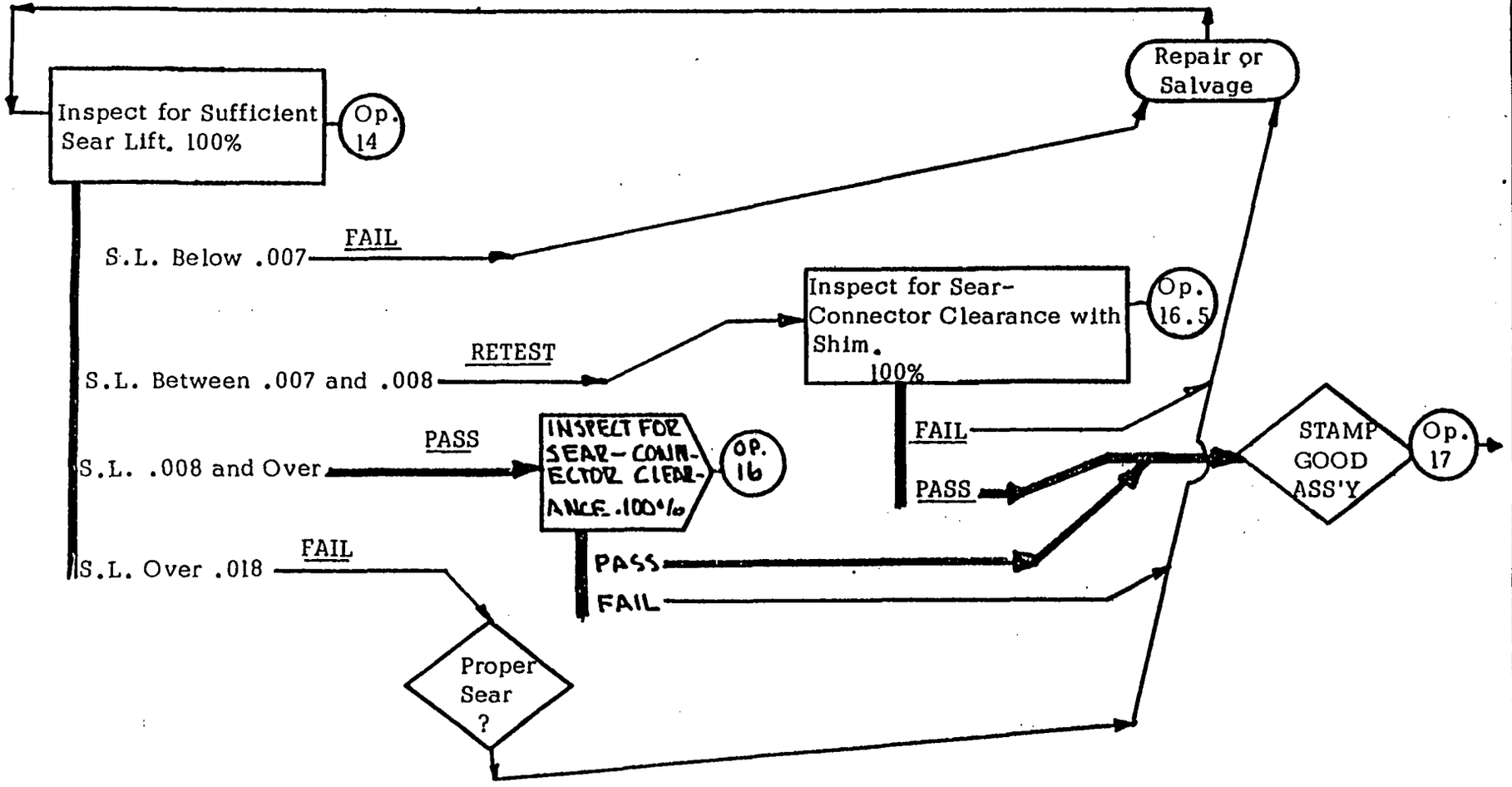
R2535879

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 14 - 17 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

FLOW CHART - TRIGGER ASSEMBLY TEST SEQUENCE



PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 55 - 70

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

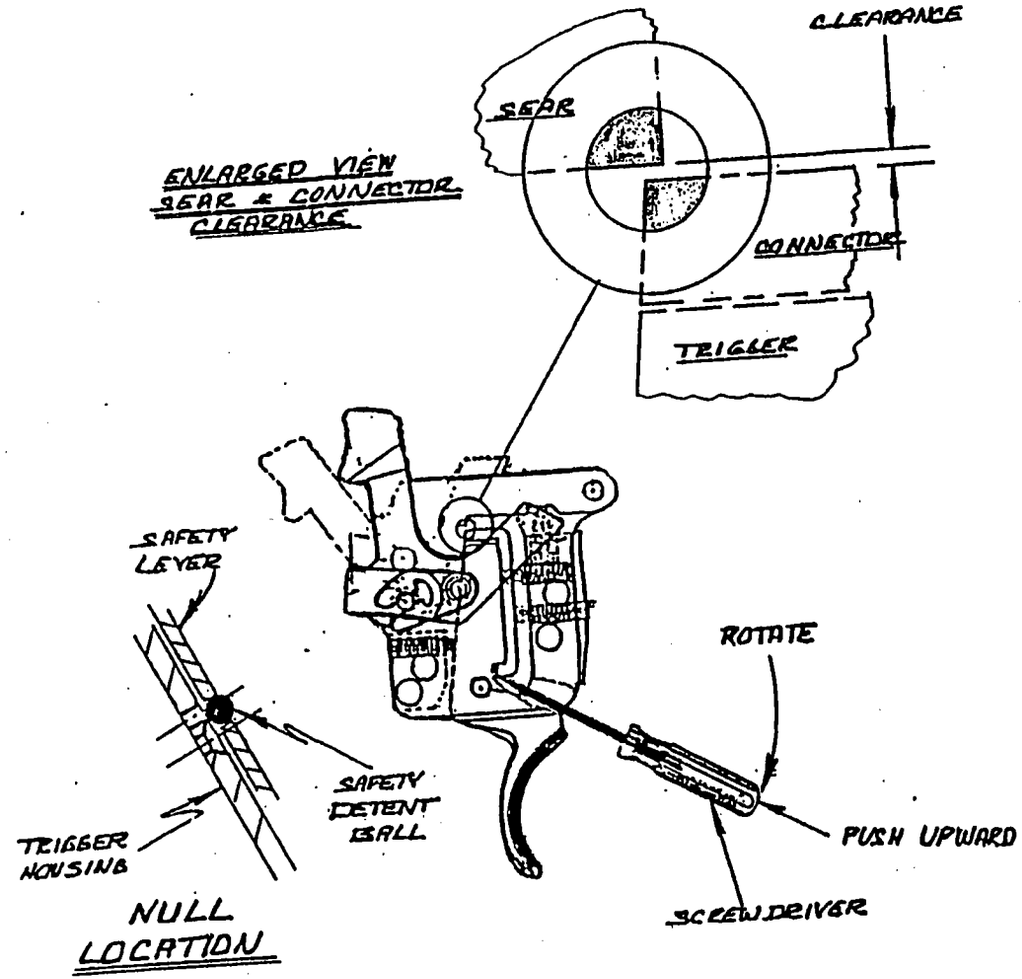
Form R. D. 6466

R2535880

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op 16 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION



PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 4

MACHINE

Form R. D. 6466

R2535881

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op, 16 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

Inspect Sear-Connector Clearance.100%

Procedure:

1. With Safety Lever in "Null Location," (previously defined in Operator #14, Page #4), insert small screwdriver blade in housing, just ahead of Trigger.

   • Push connector upward toward Sear.

CAUTION: Be sure to push on connector and not on spacer block.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear Connector Clearance. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 4

MACHINE

Form R. D. 6465

R2535882

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

2. While looking thru inspection hole on left side of Trigger Assembly, Push downward on Sear with thumb or finger. Use the Screw Driver to pivot the Trigger, front to Rear.

   - Clearance Must be observed between Sear and Connector. (See illustration. Page #1)
   - Connector Must freely return under Sear when Trigger is released.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear-Connector clearance. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 4

MACHINE

Form R. D. 6465

R2535883

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

2. (CONTINUED)

- REJECT IF:

No clearance is visible

or

Connector catches on Sear.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear - Connector Clearance. 100%	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 500 OPER. No. 60

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 4

MACHINE

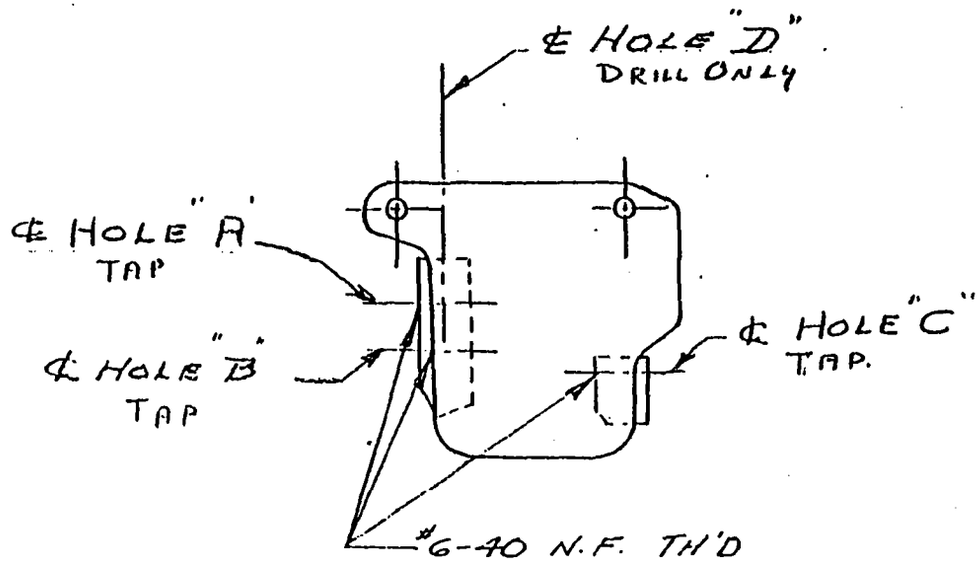
Form R. D. 6465

R2535884

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 5-1-70-NEW-AJU 268738 - 6-5-70-REVISED-AJU 268836
11/5/70 - Remove "A" - Urtz - 269172
11/11/70 - Chg. dept/# - Urtz - 269187
2/5/71 - Make regular - AJU - 269420 - Chg. dept/# -
5/17/82 - Add Seven LW - CAK - 281453
4/20/72 - Added 700 L.H. - Marley - 270639
11/3/80 - Revised for MRP - RLJ - 279424
7/8/83 - Add Moh. 600 - RLS - 283008

DESCRIPTIVE INFORMATION



PART NAME TRIGGER HOUSING ASSEM. COOLANT SET UP TIME MODEL No. Moh. 600 Seven LW 760 R.H. - 700 L.H. OPER. No. 60
TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE

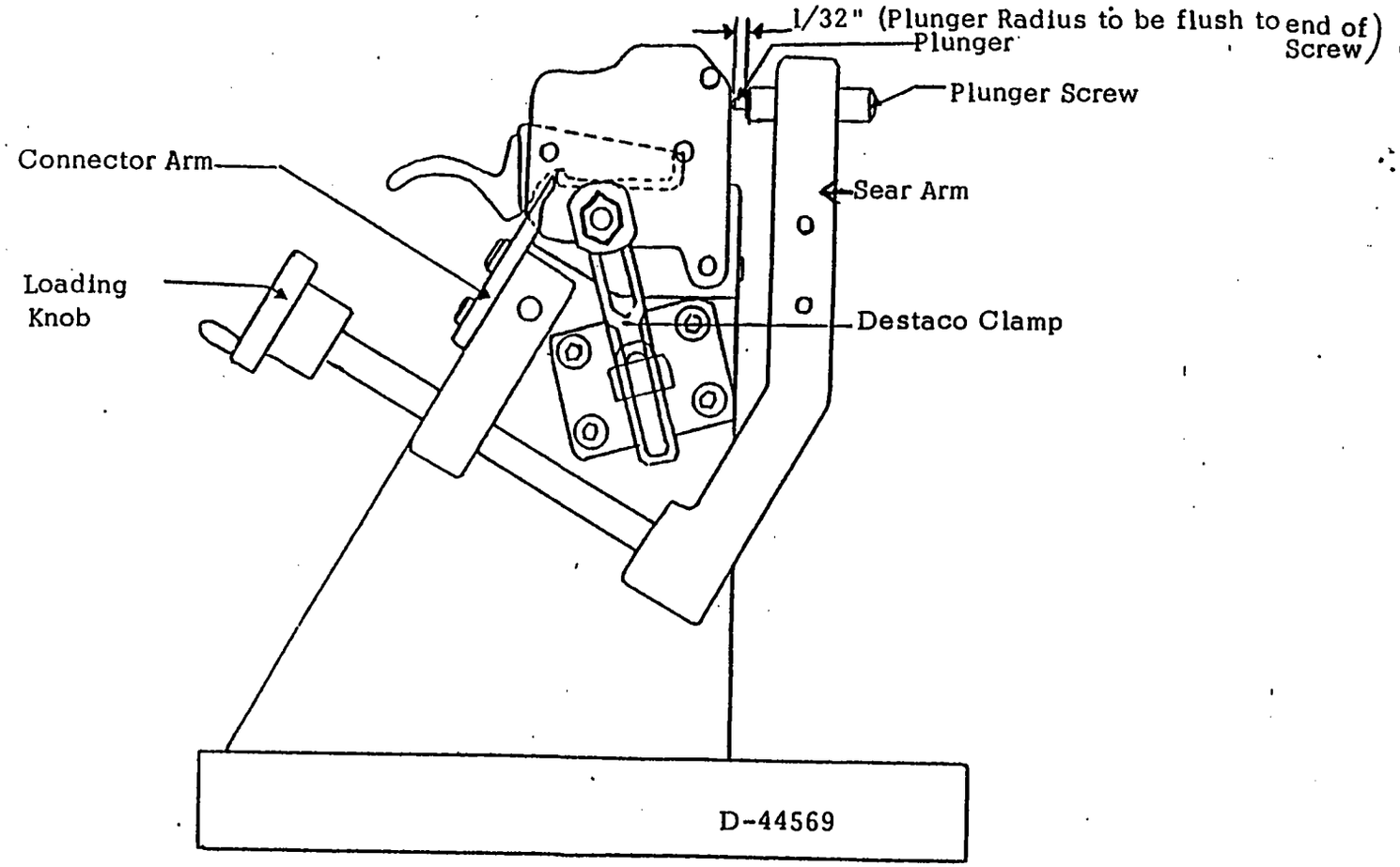
Form R. D. 6466

R2535885

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 C.A. - RLS - 283007

DESCRIPTIVE INFORMATION



PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 8

MACHINE

Form R. D. 6466

R2535886

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

NOTE: Only Trigger Assemblies segregated at Operation #14, for Sear Lift between .007 and .008, are to be tested in this operation.

PROCEDURE:

1. Place Trigger Assembly over Connector Arm and Seat on Locators.
   - Housing must be flush to fixture.
2. Tighten (Destaco) clamp.
   - Clamp must hold Trigger Assembly firmly.

EQUIPMENT—TOOLS & GAGES

Inspection Gage - D-44569

.0025 Shim Stock, as required

NOTE: Worn or burred or damaged shim will bind and give a false REJECT Reading. Replace Shim as required. Shim must be narrow enough to pass thru view hole in housing.

NOTE: Contact pad of clamp must not interfere with Safe Arm.

OPERATION DESCRIPTION							
Retest (only when necessary) for sufficient Sear-Connector clearance with shim.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 8

MACHINE

Form R. D. 6465

R2535887

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

Move Safety to "Off Safe" position.

3. Rotate loading knob clockwise until plunger end is within 1/32" of Screw. The Plunger radius is to be flush with end of Plunger Screw.

   • Do not bottom on Sear.

4. Put Safety Lever to "On Safe" position.

   • Safety snap washer must be correctly positioned.

5. Insert Shim fully into view hole.

   • It must be BETWEEN Sear and Connector

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 8

MACHINE

Form R. D. 6465

R2535888

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION	EQUIPMENT—TOOLS & GAGES
6. Move Safety to "OFF SAFE" Position. Lightly pull on Shim with thumb and finger. • Shim must REMAIN TRAPPED between the Connector and Sear. • If Shim is free - Repeat Test. 7. Move Safety Lever from "OFF SAFE" position toward "ON SAFE" TO LOCATE AND STOP Safety Lever at the forward most Null Location. (Previously defined in Op. #14, Page #4.) This is easiest while thumb is located on top of Sear Arm.	

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 8

MACHINE

Form R. D. 6465

R2535889

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

7. (CONTINUED).

- If Null Location is passed (too far toward "ON SAFE") then return to "OFF SAFE" Position and approach Null Location from "OFF SAFE" side again.

8. With the Safety Lever in the forward most Null Location, lightly pull on Shim with thumb and finger.

- If Shim binds or hangs up between Sear and Connector, then REJECT TRIGGER ASSEMBLY. END OF TEST.

EQUIPMENT—TOOLS & GAGES

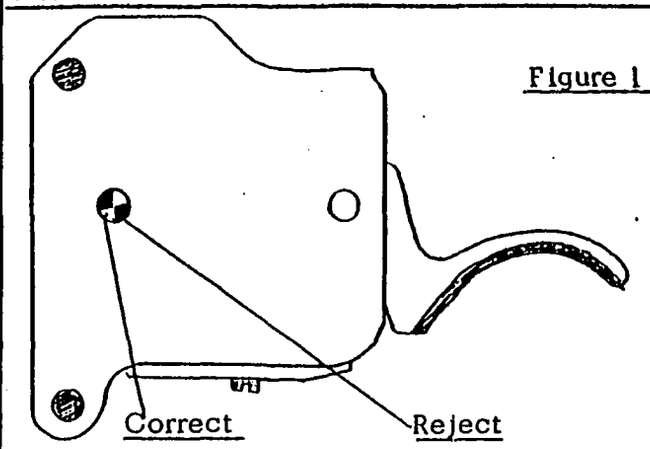


Figure 1

Connector Under Sear

Connector Trapped Forward of Sear

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 8

MACHINE

R2535890

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op 16.5 in F.A.- RLS - 283007

DESCRIPTIVE INFORMATION

- If Shim removes freely, Sear Connector clearance is correct.

CONTINUE:

9. Pull Trigger and Release:

- Connector must fully return under Sear. Check visually.

- If Connector is trapped forward of Sear,

REJECT TRIGGER ASSEMBLY END OF TEST.

(See Figure 1)

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 6 OF 8

MACHINE

Form R. D. 6461

R2535891

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

10. Move Safety Lever to "OFF SAFE" Position.

- Sear must not drop.
- If Sear drops (Fires),

  REJECT TRIGGER ASSEMBLY
- If Sear does not drop,

  TRIGGER ASSEMBLY IS GOOD

11. Loosen thumb screw

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 7 OF 8

MACHINE

Form R. D. 6465

R2535892

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 16.5 in F.A. - RLS - 283007

DESCRIPTIVE INFORMATION

12. Release Clamp.

13. Remove Trigger Assembly. Re-seat front Dummy Sear Pin flush to Housing.

14. Add Trigger Assembly into labeled container, according to test results.

EQUIPMENT--TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 65

TYPE MACH. HRS. DEPT. No. 61 PAGE 8 OF 8

MACHINE

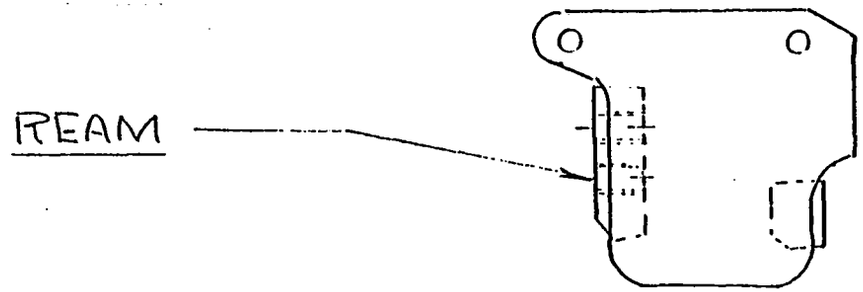
Form R. D. 6465

R2535893

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 6/7/79 - New - JAA - 277856
11/3/80 - Revised for MRP - RLJ - 279424 -
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008

DESCRIPTIVE INFORMATION



PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. Moh. 600, 700, Seven LW OPER. No. 65
TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE

Form R. D. 6466

R2535894

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 7/8/83 - New - Was op. 17 in F.A. - RLS - 283007

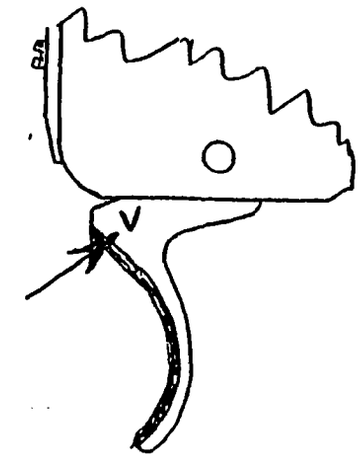
DESCRIPTIVE INFORMATION

1. Locate Trigger Assembly on Stamping Fixture.

2. Stamp "V" on Trigger; left side, just below Housing ONLY on Trigger Assemblies which have passed Operation #14 and Operation #16 or 16.5.

3. Use a standard 1/16" size character "V".

EQUIPMENT—TOOLS & GAGES



OPERATION DESCRIPTION							
Stamp passed Trigger Assembly	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	91469					
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. Mohawk 600 OPER. No. 70

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

R2535895

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 2/5/71 - New operation - Urtz - 269420 - Chg. dept/#
7/8/83 - Add Moh. 600 - RLS - 283008
6/8/71 - Removed temp. no. - Marley - 269775
4/20/72 - Added 700 L.H. - Marley - 270639
11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.	APPROVAL AND DATES					
SPEED	FEED			700 RH	700 LH				
				Seven LW					
				Moh. 600					
		File							

OPERATION DESCRIPTION	PART NO.						
		26655	32905				
Deburr Holes							

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL NO. Seven LW, Moh. 600 700 R.H.-700 LH OPER. NO. 70

TYPE MACHINE DEPT NO. 8579 PAGE 1 OF 1

RD-6461

R2535896

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 7/14/70 - Retyped from 6/5/70 - 268830
11/5/70 - Remove "A" - chg. part # - Urtz - 269172 11/3/80 - Revised for MRP - RLJ. - 279424
2/5/71 - Make regular - Urtz - 269420 5/17/82 - Add Seven LW - CAK - 281453
6/8/71 - Removed temp. no. - Marley - 269775 7/8/83 - Add Moh. 600 - RLS - 283008
4/20/72 - Added M/700 LH - Marley - 270639

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES					
SPEED	FEED		700 R.H.	700 LH				
			Seven LW					
			Moh. 600					
		Color						

OPERATION DESCRIPTION	PART NO.						
Black Oxide color		26655	32905				

PART NAME Trigger Housing Assembly COOLANT SET UP TIME MODEL No. 700R.H. - 700 LH Seven LW Moh. 600 OPER. No. 75

TYPE MACHINE DEPT. No. 8579 PAGE 1 OF 1

RD-8441

R2535897

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD—HEAT TREAT SPECIFICATION

M...RIA ND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE 400° F

MAXIMUM LOAD

TIME 1 hour

QUENCH

REMARKS

Absolute
283184
9/19/83
RLD

INSPECT FOR Rockwell Hardness

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS File Hard R_c 50 Min.

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
Lindberg Draw. Inspect for Rockwell hardness.	APPROVAL AND DATES

GA. OR CAL.						
PART No.						
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE OF STD.	91470					
OF STD.						

PART NAME Sear Safety Cam
Powder Metal

EQUIPMENT

MODEL No. Moh. 600 OPER. 50-55

DEPT. No. 51 PAGE 1 OF 1

RD-6464

R2535898

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 7/8/83 - Add Moh. 600 - RLS - 283008

11/7/83 - Elim. Plug B-80179-EE- CEG- 283536

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL	Moh. 600, 700 R.H. Seven LW	700 LH	APPROVAL AND DATES
		Holding Fixture		C-36318	C-36318	
1350R	M	Tap #6 - 40 NF-2		A-00021	A-00021	
		Th'd Plug Ga.		B-00223-W	B-00223-W	
		NOTE: Use #700 011				

OPERATION DESCRIPTION	PART NO.			
		26655	32905	
Tap Adjusting Screw holes (3)				

PART NAME Trigger Housing Assembly COOLANT SET UP TIME Moh. 600 Seven LW MODEL NO 700 R.H. - 700 LH OPER NO 60

TYPE MACHINE Haskins Tapper DEPT NO 6579 PAGE 1 OF 1

R2535899

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008
12-21-83 CHG DEPT No. - RLS

DESCRIPTIVE INFORMATION

This operation removes and excess "Steelgard" and/or foreign material just prior to Assembly operation.

Clean First tank : "Freon" vapor degreaser. Basket Dip. Then immediately transfer to :

Preserve Second tank: Water based rust inhibiting bath. Basket dip. Then air dry.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION

Clean Trigger Housing Assembly and apply Rust Preventative.

OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
	Moh. 600					
PART No.	26655	32905				
GA.	700RH, Seven	LW LH				

PART NAME Trigger Housing Assembly COOLANT SET UP TIME Moh. 600, MODEL No. 700, Seven LW OPER. No. 80
TYPE MACH. HRS. DEPT. No. ~~8761~~ 8579 PAGE 1 OF 1
MACHINE

Form B D 6441

R2535900

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008
1/9/84-Chg.Dept.#-RLS-283807

DESCRIPTIVE INFORMATION

This operation removes and excess "Steelgard" and/or foreign material just prior to Assembly operation.

Clean First tank : "Freon" vapor degreaser. Basket Dip. Then immediately transfer to :

Preserve Second tank: Water based rust inhibiting bath. Basket dip. Then air dry.

EQUIPMENT—TOOLS & GAGES

Obsolete
283919
RLS
2/13/84

OPERATION DESCRIPTION

Clean Trigger Housing Assembly and apply Rust Preventative.

OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
	Moh. 600					
PART No.	26655	32905				
GA.	700RH,Seven	LW LH				

PART NAME Trigger Housing Assembly COOLANT _____ SET UP TIME _____ MODEL No. Moh. 600, 700,Seven LW OPER. No. 80

TYPE _____ MACH. HRS. _____ DEPT. No. 8579 PAGE 1 OF 1

MACHINE

Form R. D. 6465

R2535901

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ... SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008
1/9/84-Chg.Dept.#-RLS-283807

DESCRIPTIVE INFORMATION

This operation removes and excess "Steelgard" and/or foreign material just prior to Assembly operation.

Clean First tank : "Freon" vapor degreaser. Basket Dip. Then immediately transfer to :

Preserve Second tank: Water based rust inhibiting bath. Basket dip. Then air dry.

EQUIPMENT—TOOLS & GAGES

OBSOLETE

OPERATION DESCRIPTION							
Clean Trigger Housing Assembly and apply Rust Preventative.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
		Moh. 600					
	PART No.	26655	32905				
	GA.	700RH,Seven LW	LH				

PART NAME Trigger Housing Assembly COOLANT SET UP TIME Moh. 600, MODEL No. 700,Seven LW OPER. No. 80
TYPE MACH. HRS. DEPT. No. 8579 PAGE 1 OF 1
MACHINE

Form R. D. 6469

R2535902

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ...SEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: ~~11/3/80 - Revised for MRP - RLJ - 279424~~
~~5/17/82 - Add Seven LW - CAK - 281453~~
~~7/8/83 - Add Mch. 600 - RLS - 283008~~
~~1/9/84 Chg. Dept. # RLS-283807~~
1-30-84 NEW - WAS OP 80 IN T.H. Assy - RLS

DESCRIPTIVE INFORMATION

This operation removes and excess "Steelgard" and/or foreign material just prior to Assembly operation.

Clean First tank : "Freon" vapor degreaser. Basket Dip. Then immediately transfer to :

Preserve Second tank: Water based rust inhibiting bath. Basket dip. Then air dry.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION							
Clean Trigger Housing Assembly and apply Rust Preventative.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
		91469					
		~~Mch. 600~~					
	PART No.	~~26655~~	~~32905~~				
	GA.	~~700RH,Seven LW~~	~~LH~~				

PART NAME ~~Trigger Housing Assembly~~ TRIGGER ASSEMBLY COOLANT _____ SET UP TIME ~~Mch. 600,~~ MODEL No. ~~700,Seven LW~~ Mch. 600 OPER. No. ~~80~~ 3

TYPE _____ MACH. HRS. _____ DEPT. No. ~~6579~~ 61 PAGE 1 OF 1

MACHINE

Form R. D. 6465

R2535903

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 2/13/84-NEW-(was Op.#80 in T.H.Ass'y)-RLS-283922

DESCRIPTIVE INFORMATION

This operation removes and excess "Steelguard" and/or foreign material just prior to Assembly operation.

CLEAN First Tank: "Freon" vapor degreaser. Basket Dip. Then immediately transfer to:

PRESERVE Second Tank: Water based rust inhibiting bath. Basket dip. Then air dry.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
CLEAN TRIGGER HOUSING	EFF. DATE						
ASSEMBLY AND APPLY RUST							
PREVENTATIVE							
	PART No.	91469					
	GA.						

PART NAME TRIGGER ASSEMBLY COOLANT SET UP TIME MODEL No. MOH. 600 OPER. No. 3

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

Form R. D. 6461

R2535904

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATE: REASONS FOR REVISIONS 6/7/79 - New - JAA - 21056
11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008
3/22/84 - Add Holding Fixture - CFC

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	APPROVAL AND DATES
		Holding Fixture	D-46651	
		Reamer - .1195 Dia.	Std.	
		Plug Gage .119 - .121	B-80202-JJ	

OPERATION DESCRIPTION	PART NO.
Ream Trigger Spring Hole	26655 32905

PART NAME Trigger Housing Assembly COOLANT SET UP TIME Moh. 600 MODEL No. 700, Seven LW OPER. No. 65
TYPE MACHINE Drill Press DEPT No. 8579 PAGE 1 OF 1

RD-6461

R2535905

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 6/7/79 - New - JAA - 277856
11/3/80 - Revised for MRP - RLJ - 279424
5/17/82 - Add Seven LW - CAK - 281453
7/8/83 - Add Moh. 600 - RLS - 283008
4/16/84-Add Holding Fix.-CFC-284157

APPROVAL AND DATES

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.
		Holding Fixture	D-46651
		Reamer - .1195 Dia.	Std.
		Plug Gage .119 - .121	B-80202-JJ

OPERATION DESCRIPTION	PART NO.
Ream Trigger Spring Hole	26655 32905

PART NAME Trigger Housing Assembly COOLANT SET UP TIME Moh. 600 MODEL No. 700, Seven LW OPER. No. 65

TYPE MACHINE Drill Press DEPT No. 8579 PAGE 1 OF 1

RD-6461

R2535906

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 11/19/82 - Make regular - ZJK - 282052 11/4/87-Add 925955-GEB-287704
10/17/83 - ADD SPORTSMAN 78 - RLJ - 283406
10/29/84-ADD 926158 & 926160-RLJ-284726
10/7/85-Add 578-223-RLJ-286050
10/9/86-Add Kit Guns-RLJ-286956

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Check reject guns for proof stamp and obstruction in barrel.	Kit	243	308	270	30-06	7 MM	
		925670	925680	925672	925674	925676	
	SPORTSMAN	30/06	270	243	308	223	
	78	926164	926162	926158	926160	926172	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	925769	925771
	PART No.	30-06	308	7MM Mag.	30-06		
	GA.	925773	925775	925777	925955		

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 ADL '83 OPER. No. 605R
TYPE MACH. HRS. DEPT. No. 8085 PAGE 1 OF 1
MACHINE

R2535907

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/22/85-New-RLJ-285430
10/7/85-Add 578-223-RLJ-286050
2/5/87- Add ADL RAMACS-RLJ-287105
11/4/87-Add 925955-GEB-287704

DESCRIPTIVE INFORMATION

For Information see Op. 614

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.	30-06	926164				
	STD. HRS/C	270	926162				
	STD. No.	308	926160				
	EFF. DATE	243	926158				
Test-		223	926172				
Shoulder							
	Kit	243	308	270	30-06	7MM	
		925670	925680	925672	925674	925676	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	925769	925771
	PART No.	30-06	308	7MM Mag.	30-06		
	GA.	925773	925775	925777	925955		

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. S-78 OPER. No. 614B
TYPE MACH. HRS. DEPT. No. 8085 PAGE 1 OF 1
MACHINE

R2535908

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/22/85-New-RLJ- 285430
10/7/85-Add 578-223-RLJ-286050
2/5/87-Add ADL Ramacs-RLJ-287105
11/4/87-Add 925955-GEB-287704

DESCRIPTIVE INFORMATION

For Information See OP. 614

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
	OCC. No.	30-06	926164				
	STD. HRS/C	270	926162				
	STD. No.	308	926160				
Test-	EFF. DATE	243	926158				
		223	926172				
Rejected guns							
	KIT	243	308	270	30-06	7MM	
		925670	925680	925672	925674	925676	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	~~925769~~	~~925771~~
	PART No.	30-06	308	7MM Mag.	30-06		
	GA.	925773	925775	925777	925955		

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. S-78 OPER. No. 614J
TYPE MACH. HRS. DEPT. No. 8085 PAGE 1 OF 1
MACHINE

R2535909

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/22/85-New-RLJ-285430
10/7/85-Add 578-223-RLJ-286050
2/5/87-Add ADL Ramacs-RLJ-287105
11/4/87-Add 925955-GEB-287704

DESCRIPTIVE INFORMATION

1. See Gallery procedure

EQUIPMENT—TOOLS & GAGES

R.S. Windage Gage-A-82384

F.S. Gage-A-82421

Bending Tool-B-82825

Line O Sighter for new Rear Sight D 36871
R.S.Windage gage for new rear sight A-41114
Locating Block R/H C-41111-A
Locating Block L.H. C-41111-B

OPERATION DESCRIPTION							
TARGET	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE	243	308	270	30-06	7MM	
	Kit	925670	925680	925672	925674	925676	
	Sportsman 78	30/06 926164	270 926162	243 926158	308 926160	223 926172	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	925769	925771
	PART No.	30-06	308	7MM Mag.	30-06		
	GA.	925773	925775	925777	925955		

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE MACH. HRS. DEPT. No. PAGE 1 OF 16
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R2535910

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/22/85-New-RLJ-285430
10/7/85-Add 578-223-RLJ-286050
2/5/87-Add ADL Ramacs-RLJ-287105

DESCRIPTIVE INFORMATION

1. See Gallery procedure

EQUIPMENT—TOOLS & GAGES

R.S. Windage Gage-A-82384

F.S. Gage-A-82421

Bending Tool-B-82825

Line O Sighter for new Rear Sight D 36871
R.S.Windage gage for new rear sight A-41114
Locating Block R/H C-41111-A
Locating Block L.H. C-41111-B

OPERATION DESCRIPTION							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE	243	308	270	30-06	7MM	
	Kit	925670	925680	925672	925674	925676	
						223	
	Sportsman 78	30/06 926164	270 926162	243 926158	308 926160	926172	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	925769	925771
	PART No.	30-06	308	7MM Mag.			
	GA.	925773	925775	925777			

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE MACH. HRS. DEPT. No. PAGE 1 OF 16
MACHINE

R2535911

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/22/85-retyped from 282652-285430

DESCRIPTIVE INFORMATION

Safety Before Test: All plant rules, gallery rules and job safety key points are to be observed at all times.

I Guns Targeted

A. Three (3) rifles are to be targeted after test, regardless of truck size. First gun from truck is to be tested and targeted simultaneously. The remaining 2 are to be randomly selected, not in succession. At least one gun must be taken from each side of truck. (See item XII)

B. Reocrd results of targeting on forms provided. (See Gallery Fpreman for instructions).

II Target Objectives

A. Accuracy: Tocheck the ability of each gun sampled to satisfactorily meet specifications for point of impact and/or group size.

1. To detect and repaidly respond to poor accuracy or accuracy related trends.

III Shooting Range

A. Use accuracy device provided for this model.

1. Adjust and set device with master gun for each caliber and bullet weight used, as necessary.

PART NAME _____ COOLANT _____ SET UP TIME _____ MODEL No. Sportsman 78 _____ OPER. No. 618

TYPE Procedure and Specifications _____ MACH. HRS. _____ DEPT. No. 8085 PAGE 2 OF 16

MACHINE

Form R. D. 6466

R2535912

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND ASONS FOR REVISIONS Retyped from 282652-RLJ-2854

DESCRIPTIVE INFORMATION

III. Shooting Range- (Contd.)

B. Use centerfire targeting range-100 yards (300 Ft.)

1. Use grid type targeting paper.

2. Use line-o-sighter and spotting scope as outlined in Item V "Description of Test/Target"

C. Setting of Master Guns

1. All set to zero by authorized personnel.

2. Use heavy grain bullet where two are specified.

IV. Specifications

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DATES AND REASONS FOR REVISIONS ~~3/22/85-Retyped from 282652-A-1-285430~~

DESCRIPTIVE INFORMATION

IV. Specifications-(Contd.)

Notes

1. Where two bullet types are specified, use the heavy grain bullet type on one truck and use the light grain bullet type on the next truck. Alternate bullet-type from truck to truck.
   a. Do not mix bullet types in the same truck.

A. Open Sights

- Normal Appearances on 3 gun sample per truck

1. Front Sight Ramp and Sight

   a. Ramp must be central on Barrel and straight with line of sight.

   b. Must conform to barrel-good fit-no excessive opening at sides or ends-screwed tight to barrel.

R2535914

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/19/82 - Make regular - ZJK - 282052
4/20/83 - Chg. page # - RAJ - 282652 3/22/85-chg. page # & Model #-RLJ-285430

DESCRIPTIVE INFORMATION

IV. Specifications - (Contd.)

- Normal Appearances - (Contd.)

1. Front Sight Ramp and Sight

c. Front sight must be reasonably central on ramp - tight in dovetail - not bent, twisted, tipped or deformed Do not adjust for centrality.

2. Rear Sight Ramp and Sight

a. Ramp must be central in Barrel and straight with line of sight - level crosswise with front sight ramp.

b. Must conform to barrel - good fit, no excessive opening at sides or ends, screwed tight to barrel.

c. Rear sight and eyepiece must be level crosswise with line of sight as viewed from rear - not tipped, twisted or bent.

d. Mark on elevating piece set to coincide with fourth mark form rear on rear sight ramp. (Except 788 style)

e. Rear sight eyepiece good fit on dovetail of elevating slide - no excessive opening.

f. Rear sight eyepiece positioned central crosswise with windage screw.

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 8085 PAGE 5 OF 16
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R2535915

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DESCRIPTIVE INFORMATION

IV. Specifications - (Contd.)

B. Acceptance limits for sight line - (No point of impact)

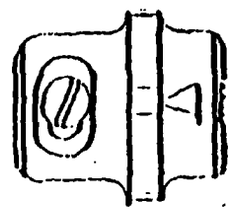
Caliber	Elevation		Windage	
	High	Low	Left	Right
All	2"	8"	9"	9"

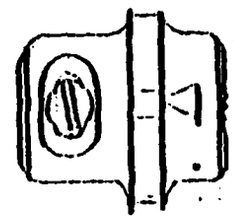
NOTE: 1. Acceptance limits only apply when sights are positioned on the gun as described in Item IV - B. Sights must be capable of adjustment to 0" X 0". With point of impact within the sight limits described in Item IV-D, below:

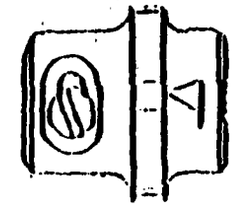
C. Rear Sight

1. Elevation - Mark on elevating slide may be adjusted to any position on the ramp between the second line from the rear to the third line from the front of the ramp.

2. Windage - Eyepiece may be adjusted crosswise on elevating piece to any position with windage screw within the length of the adjusting slot. Must show full width of screw retaining shoulder - minimum - at side of screw after adjustment.







Form H. D. 6400

R2535916

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 11/19/82 - Make regular - ZJK - 282052
4/20/83 - Chg. page # - RAJ - 282652 - 3/22/85-Changed Model, Page# and OP.#. - RLJ-285430

DESCRIPTIVE INFORMATION

IV. Specifications - (Contd.)

. Point of Impact

1. Definition - Using line-o-sighter, the mean average position of all shots fired in the group from point of aim should be within the limits set in Item IV-C, above.

. Group Size - Definitions

1. Center to Center - Maximum extreme spread from center to center of holes farthest apart.

2. Inside to Inside - Maximum extreme spread from inside edges of holes fartheat apart.

V. Description of Test/Target - Each gun as received, bolt in open position - Safe in "OFF" position.

NOTE: The first rifle tested and targeted is to be left off of truck so there will be an open space between targeted and untargeted guns. Place first gun back on truck when the entire laod has been sampled. Sample three(3) rifles from truck.

A. Test/Target Description

1. Remove tickets from three(3) guns and place on top of truck.

2. Pick up gun from truck and inspect for;

a. Safety - Inspect chamber and Magazine - both must be empty.

b. Caliber - To verify for shooters personal safety in selecting ammunition for test.

PART NAME Gallery Test and Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 8085 PAGE 7 OF 16
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R2535917

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/22/85-Retyped from 28[illegible]7-RLJ-285430

DESCRIPTIVE INFORMATION

V. Description of Target-(Contd.)

A. Target Description-(Contd.)

2. Pick up gun from truck and inspect for:

c. Proof mark on barrel (REP) must be present, right rear side of Barrel ahead of magnaflux stamp.

d. Proof mark on bolt-(') Prick punch mark must be present at bottom of bolt handle.

e. Test stamp on Barrel- test stamp must be present forward of the proof stamp.

f. Visual defects-If not within specifications for items a-d, reject gun at this point.

g. Normal sight alignment-as described IV-B.

Note: Visually check the first gun from the truck for marring by jack or device- Before and After it is targeted.

PART NAME Gallery Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618

TYPE Procedure and Specifications MACH. HRS. MACHINE DEPT. No. 8085 PAGE 8 OF 16

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R2535918

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS New-Retyped from 282652[illegible]-2854305 chg. model # & Page #'OP.#

DESCRIPTIVE INFORMATION

V. Description of Target-(Contd.)

A. Target - Description

3. With action open, position gun in divice and clamp.

4. Lower line-o-sights and adjust device to point gun on target paper. if necessary.

5. Remove line-o-sighter.

6. Load magazine to capacity-see table #1 and #2, item IX-for magazine capacity by caliber.

PART NAME Gallery Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618

TYPE Procedure and Specifications MACH. HRS. DEPT. No. 8085 PAGE 9 OF 16

MACHINE

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R2535919

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISION 3/22/85-Changed Page #,OP.# & Model #-RLJ-285430

DESCRIPTIVE INFORMATION

V. Descriaption of Test and Target - (Contd.)

A. Test/Target - Description

7. Assemble firing pin trip pin in device.

8. Close guard.

9. Close bolt to feed shell into chamber and lock - to start test.

10. Fire gun by pushing (2) two buttons on device simultaneously.

11 Check each shot with spotting scope for gun "seating in" and position of shots on paper.

a. Adjust device if shots off paper or group too close to edge.

12. Operated action full cycle to extract, eject, and feed each shot.

13. Fire all rounds required for regular seating and targeting.

a. If additional rounds beyond magazine capacity are required to meet accuracy specifications, single load and fire additional rounds.

b. If last shell in magazine is not needed to satisfy accuracy specifications, feed shell into chamber, and extract and eject unfired round.

R2535920

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DATES AND REASONS FOR REVISIONS: 3/22/85-Changed OP#, Page# & Model #

DESCRIPTIVE INFORMATION

V. Description of Target-Contd.

A. Target - Description

14. Open guard.

15. Lower line-o-sighter onto sights and check point of impact and group size.

a. Cross hairs in scope must line up with average position of shot pattern within point of impact specifications.

b, Spread of holes must be within group size specifications.

16. Remove line-o-sights.

17. Unclamp and remove gun from device.

18. Inspect chamber and magazine for live ammunition.

a. Chamber must be empty.

b. Follower must be visibel.

19. Place gun back on truck.

20. Repeat target on two (2) additional rifles.

21. Replace gun tickets to barrels of guns.

R2535921

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DATES AND REASONS FOR REVISIO: 3/22/85-Changed Page #, OP. # & Model#-RLJ-285430

DESCRIPTIVE INFORMATION

V. Description of Target-(contd.)

B. Target Stamping - (Acceptable Product Only)

1. When three (3) guns have been targeted, move entire load to stamping bench.

2. Place stamp, right rear side of barrel, ahead of the test stamp.

a. Rejected guns are not to be stamped. guns not to be stamped.
b. Place color dot on bottom of stock near fore-tip. (3 passed guns-only)

3. Replace gun to truck.

VI. Retest - None, unless ammunition, man, or method are questioned.

VII. Interpretation of Target (See section XII Also)

A. Pass Gun

1. Within specifications for:

a. Visual items and,

b, Point of impact within specified number of shots and,

c, Group size (on required guns) within specified number of shots and,

d, Within limits on eyepiece and front sight acceptance limits.

PART NAME Gallery Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 8085 PAGE 12 OF 16
MACHINE

Form R. D. 4460

R2535922

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/22/85-Chg. Model #, OP# & Page #-RLJ-285430

DESCRIPTIVE INFORMATION

VII. Interpretation of Target (See section XII also)

B. Reject Gun

1. Not within specifications;

a. For any one (1) or more of the items listed under A-1 above.

b. Record all malfunctions on target and on reject ticket which is attached to gun.

1. Reject ticket to be written and attached to gun before next gun is

VIII. Safety After Target

A. Open bolt

1. Move bolt to open position before removing gun from accuracy device.

B. Inspect Chamber and Magazine for live ammunition

1. Gun must be empty,
2. Follower must be visible.
3. Switch safety to "S" position.

NOTE: Perform "A" & "B" above on each individual gun immediately after shooting test, Repeat "B" for all guns on truck on completion of test.

C. Visual inspect for marring by device or port.

1. Take first gun from each after test, and check for any possible damage damage to gun from the test.

PART NAME Gallery COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
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R2535923

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/22/85-Retyped from 2820 2-RLJ-285430

DESCRIPTIVE INFORMATION

IX. Safety After Test-(Contd.)

D. All guns are moved to ammunition area

1. See Job Safety Key Points for proper ammunition procedure.

X. Ammunition Specifications and Rounds Required

A. Table 1-Field Grade Rifles Standard Barrel-(Front and rear sights assembled)

Caliber	POI	Group Size
3006	3 Yds	3 to 5 Yds.

PART NAME Gallery Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 8085 PAGE 14 OF 16
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KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/22/85-Retyped from 282[illegible]-RJL 285430

DESCRIPTIVE INFORMATION

XI. Group Size Specifications

A. Table 1-Field Grade Rifles Standard Barrel- (Front and Rear Sights Assembled)

Calibers	Ammo Type	Maximum Group Center to Center 3 Shots	4 Shots	5Shots	Maximum Group Inside To Inside 3 Shots	4 Shots	5 Shots
270	150gr.-130gr.	1.7	2.2	2.7	1.5	210	215
3006	180gr.-150gr.	2.5	3.0	3.5	2.2	2.7	3.2

1-All figures in inches.

PART NAME Gallery Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618
TYPE ~~Procedure and Specifications~~ MACH. HRS. DEPT. No. 8085 PAGE 15 OF 16
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 3/22/85-Retyped from 2[illegible]52-RLJ- 285430

DESCRIPTIVE INFORMATION

Notes: (These notes pertain to Tables IX, A-C and X, A-C)

Field Grade Guns-Standard Barrel-(Front and Rear Sights Assembled)

1. Target three(3) rifles per truck
2. Inspect same three (3) rifles for group size.

XII Summary of target results and appropriate actions to be taken.

A. The sample size would be 3 per load, regardless of lead size.

B. If no devects are found, stamp 3 targeted rifles and pass the load.

C. Put color dot on the rifles that were targeted.

D. If one or more defects are found, target entire load.

E. If two or more identical defects on the same load, hold the load and contact the Process Engineer. Sample target the next load.

F.

F. If 2 defects are found in the first 3, contact Engineer before testing remainder of load.

1. During 2nd shift or other times when engineering personnel are not available, target entire load but hold load for engineering examination. Continue with next and succeeding loads.

PART NAME Gallery Target COOLANT SET UP TIME MODEL No. Sportsman 78 OPER. No. 618

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R2535926

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS
3/22/85- New RLJ-285400
10/7/85-Add 578-223-RLJ-286050
2/5/87- Add ADL Ramacs-RLJ-287105
11/4/87-Add 925955-GEB-287704

DESCRIPTIVE INFORMATION

For Information See OP. 618

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Target- Shoulder	OCC. No.	30-06	926164				
	STD. HRS/C	270	926162				
	STD. No.	308	926160				
	EFF. DATE	243	926158				
		223	926172				
	Kit	243 925670	308 925680	270 925672	30-06 925674	7MM 925676	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	925769	925771
	PART No.	30-06	308	7MM Mag.	30-06		
	GA.	925773	925775	925777	925955		

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. S-78 OPER. No. 618B
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R2535927

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/22/85-New-RLJ-285430
~~10/7/85-Add 578-223-RLJ-286050~~
~~2/5/87-Add ADL Ramacs-RLJ-287105~~
11/4/87-Add 925955-GEB-287704

DESCRIPTIVE INFORMATION

For Information See OP. 618

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Target-	OCC. No.	30-06	926164				
	STD. HRS/C	270	926162				
	STD. No.	308	926160				
Rejected Guns	EFF. DATE	243	926158				
		223	926172				
	Kit	243	308	270	30-06	7MM	
		925670	925680	925672	925674	925676	
		222	22-250	6MM	243	25-06	270
		925761	925763	925765	925767	925769	925771
		30-06	308	7MM Mag.	30-06		
	PART No.	925773	925775	925777	925955		
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. S-78 OPER. No. 618J
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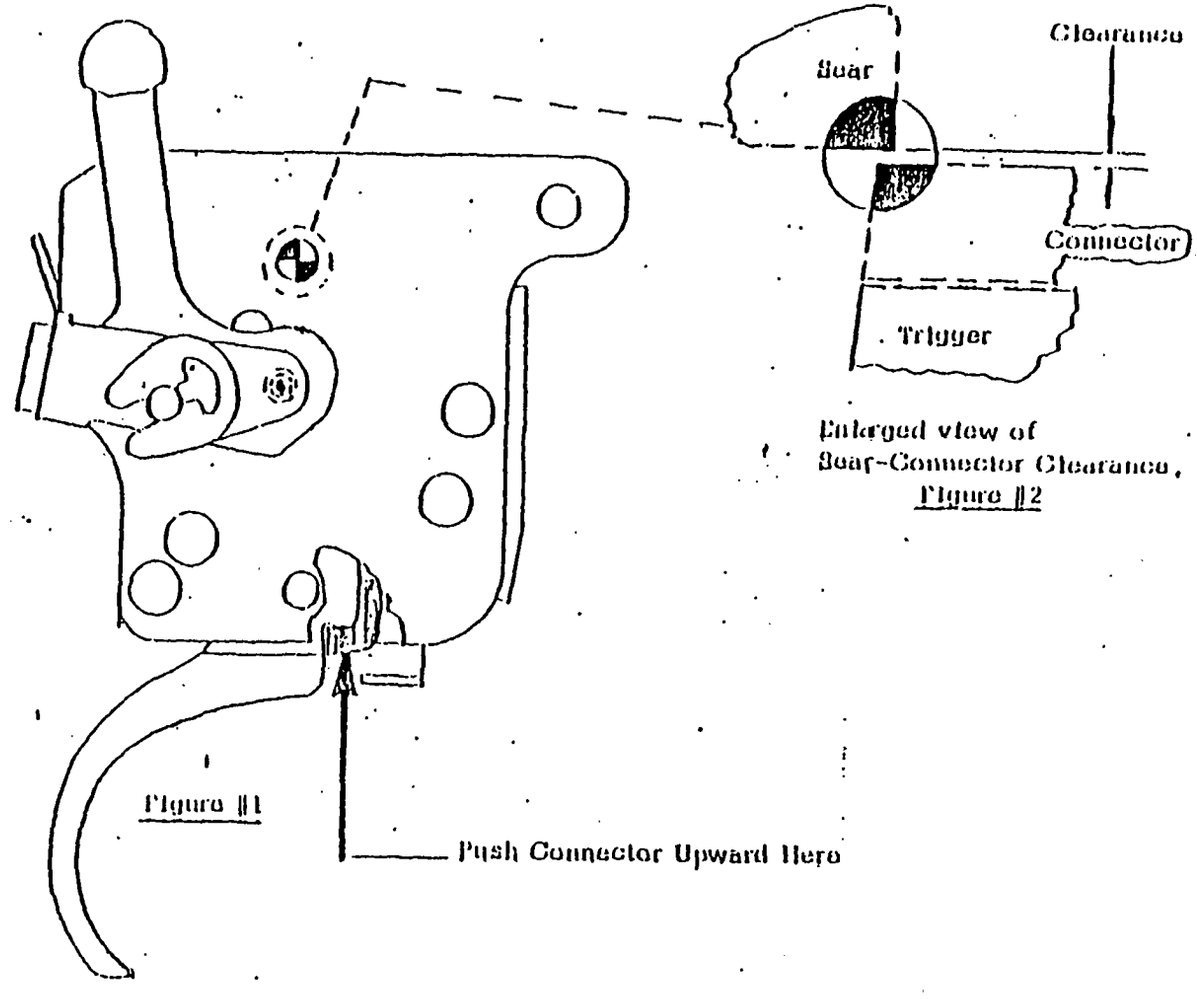
R2535928

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION



Enlarged view of Gear-Connector Clearance, Figure #2

Figure #1

FOR INFO ONLY

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

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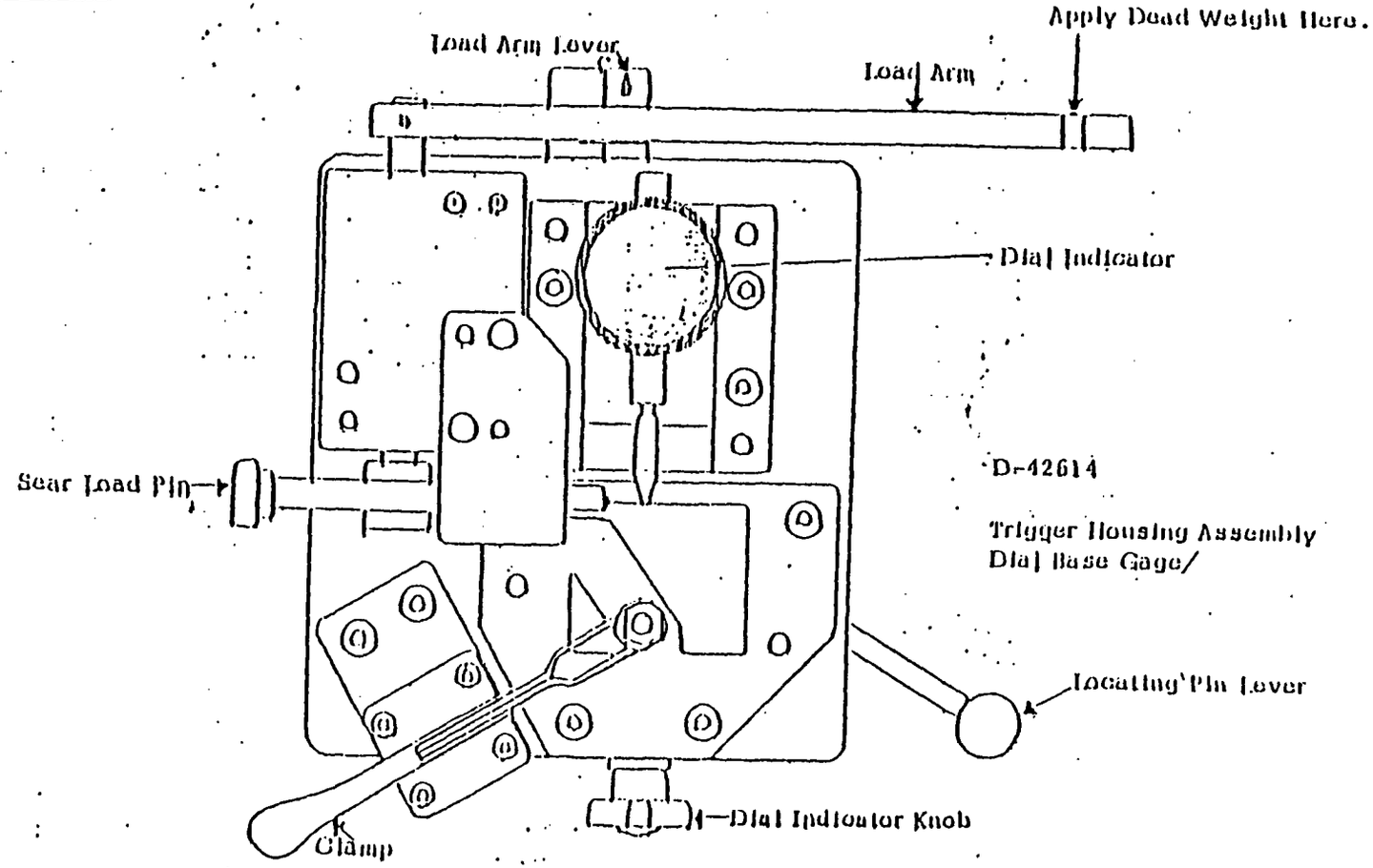
*Form R. D. 6466

R2535929

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION



PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 1

MACHINE

Form R. D. 6466

R2535930

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECOR ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION

NOTE: For Customer Repair Only

1. Rotate Gage **Load Arm** Lever to left:
2. Rasie Gage Locating Pins half way, by pulling locating pin lever toward body.
3. Place Trigger Assembly over locating pins and clamp down. Make sure Assembly is flat to the gage locating surfaces.

EQUIPMENT--TOOLS & GAGES

Dial Base Gage #D-42614 with 2 lbs. dead weight.

NOTE:
Clamps on base gage must be asdjusted as required to locate Trigger Assembly flat to gage while testing

NOTE: Inspect Trigger Assy's for prick punch mark on left side of Trigger per Photo Sample. If mark is not present or out of position, Reject Ass'y.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Inspect Sear Lift 100% For Customer repair only.							
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 1 OF 8

MACHINE

R2535931

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KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88 NEW-GEBJ287810

DESCRIPTIVE INFORMATION

4. Hold Trigger Assembly in position with finger, and raise Locating pins to full upward position.
5. Move Safety Lever to "OFF SAFE" position.
6. Rotate Load Arm Lever to right (this loads Sear Safety Cam.)
7. Draw Dial Indicator into position with Dial Indicator Knob until Dial Indicator first READS ZERO ("0")

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear Lift 100%. For Customer Repair only.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 2 OF 8

MACHINE

R2535932

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION

8. Move Safety Lever to "ON SAFE" detented position. Read Dial Indicator:

   MUST BE .006 TO .018 SEAR LIFT

   - Reject if less than .006
   - Reject if more than .018.

   If reading is within limits, continue:

9. Push Safety Lever to "OFF SAFE" detented position.

10. Re-Zero Dial (if necessary) using Dial Indicator Knob.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 3 OF 8

MACHINE

Form R. D. 6465

R2535933

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION

11. Move Safety Lever from "OFF SAFE" position toward "ON SAFE" position TO LOCATE AND STOP Safety Lever at the *Forward most Null location.

* FORWARD MOST NULL LOCATION is that "Just Stable" place between "ON" and "OFF" Safe, closest to "OFF Safe", where the Safety Lever will not spring forward to the "Off Safe" position when released.

- If the Null Location is overshot (where the Safety Lever was moved too far toward "ON SAFE"); then return to "OFF SAFE" and again approach Null location from the "OFF SAFE" side.

EQUIPMENT – TOOLS & GAGES

OPERATION DESCRIPTION							
Inspect Sear Lift 100%. For Customer Repair only.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 4 OF 8

MACHINE

Form R. D. 6461

R2535934

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PROCESS RECORDS / ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION

12. Separate Trigger Assemblies, into labeled containers, according to dial readings at that "Forward Most Null Location".

- Less than .006 : Repair.
- .006thru .018: Good. Continue to Op. #23 (Leave Trigger Assembly in place on fixture for next operation).
- Over .018: Repair

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION

Inspect Sear Lift 100%.
For customer repair only.

OCC. No.							
STD. HRS/C							
STD. No.							
EFF. DATE							
PART No.	920014	920052					
GA.							

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 5 OF 8

MACHINE

Form R. D. 6465

R2535935

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB: 287810

DESCRIPTIVE INFORMATION

NOTE: For Customer Repair Units Passing Searleft

NOTE: Leave Trigger Assembly in fixture D-42614

1. With Safety Lever in the forward most Null location, (Previously defined in , insert suitable tool between Trigger and Bolt Stop Release (Refer to Fig. #1).

   Push Connector firmly upward (toward Sear) and hold.

   CAUTION: Be sure to push on Connector only and not on housing.

EQUIPMENT—TOOLS & GAGES

Dial Base Gage: D-42614
with 2 pound dead weight.

OPERATION DESCRIPTION							
Inspect Sear - Connector Clearance 100%. For Customer Repair Only.	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS DEPT. No. 61 PAGE 5 OF 8

MACHINE

Form R. D. 6465

R2535936

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION

2. Pull Trigger fully to Rear and Release slowly:

   - Connector must freely and completely return under Sear when Trigger is released (refer to Fig. 2).

   Reject if Connector is trapped forward of Sear.

3. Push Safety Lever to "Off Safe" position:

   - If Sear Safety Cam drops off behind Connector (Fired Position), Reject Trigger Assembly.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 7 OF 8

MACHINE

Form R. D. 6165

R2535937

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/19/88-NEW-GEB-287810

DESCRIPTIVE INFORMATION

4. Move Load Arm Lever to left slightly.
   To remove Sear Load Pin force from Sear Safety Cam:
   - If "click" is heard, or Trigger moves, reject Trigger Assembly.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Inspect Sear - Connector clearance 100%. For Customer Repair Only.							
	PART No.	920014	920052				
	GA.						

PART NAME Trigger Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 172

TYPE MACH. HRS. DEPT. No. 61 PAGE 8 OF 8

MACHINE

R2535938

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PROCESS RECORD—INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free of burrs		
		Chamfer both ends .010 X 45°		
Mic's	Std.	Over-All Length	.505	.495
Mic's	Std.	Diameter	.125	.1248

Final Aupearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 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 gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS 9/19/88-New-ELB-288557
10/17/88-Add Substiture Material-ELB-288592

MATERIAL: AISI C-1095 or 52100
HEAT TREATMENT AT: REMINGTON
COMPONENT CONDITION: FINISHED: SEMI-FIN. X
MODEL NO. XP-100
PART NO. 24483
BLANK DRAWING NO. C-24475
PART NAME TRIGGER PIN
DEPT. NO. 9291 PAGE 1 OF 1

RP-4491-1 REMINGTON ARMS CO., INC., ILION, N.Y.

R2535939

TITLE: Trigger Assy

Process Header

Process Header

Document ID: Trigger Assy 700 7 Lwt	Remington Arms Company
Part Name: Trigger Assy	
Product Line: Rifle	Effective Date: 05-Apr-1991-08:00:00
Engineering Group: Rifle Group	Origination Date: 26-Jun-1990

Process History

Status	Date/Time	Status Set	Responsible User
Submitted	28-MAR-1991	10:29:57.06	Shirley Willoughby
Comment:	"Process verified by GEB"		
Fully Approved	1-APR-1991	09:49:21.84	R.A.Jackson
Comment:			
Normal Release	5-APR-1991	08:00:31.37	"CART"
Comment:			

Process Revision Reasons

Date:	Reason For Revision:		Eng Log #:
26-Jun-1990	Retyped entire process from 283920 - Replaces old paper process.	SJK	290349
18-Jul-1990	Added Model 700 Trigger Assembly To Process; Changed Name From "Trigger Assembly 7 LWT" to present	JAR	290448
28-Mar-1991	This process has been varified and also added Oper.140	GEB	291237

Process Approval List

Approved By:	Badge #:	Date:	Designation:
R.A.Jackson +	00000	1-APR-1991	Technical Supervisor

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KINZER V. REMINGTON

R2535940

TITLE: Trigger Assy

Process Material

Part Number	Qnty	Description
92458		Trigger Assembly 7 LWT
91828	1	Bolt Stop Release
91853	1	Safety Assembly
23222	1	Safety Detent Ball
15368	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
15666	1	Sear Safety Cam
17047	1	Sear Spring
15280	1	Trigger
17053	1	Trigger Screw Front
19461	1	Trigger Connector
91128	1	Trigger Engagement Screw
26655	1	Trigger Housing Assembly
24477	1	Trigger Pin
15400	1	Trigger Spring
15481	1	Trigger Stop Screw
26345		TRIGGER ASSEMBLY 700 R.H.
15478	1	Bolt Stop Release
92297	1	Safety Assembly
23222	1	Safety Detent Ball
15368	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
15666	1	Sear Safety Cam
17047	1	Sear Spring
15280	1	Trigger
17053	1	Trigger Screw Front
19461	1	Trigger Connector
91128	1	Trigger Engagement Screw
26655	1	Trigger Housing Assembly
24477	1	Trigger Pin
15400	1	Trigger Spring
15481	1	Trigger Stop Screw
32895		TRIGGER ASSEMBLY 700 L.H.
90555	1	Bolt Stop Release
92296	1	Safety Assenbly
23222	1	Safety Detent Ball
92546	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
15666	1	Sear Safety Cam
17047	1	Sear Spring
15280	1	Trigger
17053	1	Trigger Screw Front
19461	1	Trigger Connector
91128	1	Trigger Engagement Screw
32905	1	Trigger Housing Assembly
24477	1	Trigger Pin
15400	1	Trigger Spring
15481	1	Trigger Stop Screw

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R2535941

Continued ...

Process Material

Part Number	Qnty	Description
26345		TRIGGER ASSEMBLY 700 R.H. AUSTRAILIAN
15478	1	Bolt Stop Release
92297	1	Safety Assembly
23222	1	Safety Detent Ball
15368	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
15666	1	Sear Safety Cam
17047	1	Sear Spring
15280	1	Trigger
17053	1	Trigger Screw Front
19461	1	Trigger Connector
91117	1	Trigger Engagement Screw
26655	1	Trigger Housing Assembly
24477	1	Trigger Pin
15400	1	Trigger Spring
91127	1	Trigger Stop Screw

Process Routing

Dept	Oper	Operation Description	Part Numbers
8761	140	Demagnetize Springs	92458 26345 32895
8761	145	Clean Trigger Housing Assembly and apply Rust Preventative.	92458 26345 32895
8761	151	Assemble Trigger Assembly - Stage One. Inspect Connector 100%, inspect Trigger 100% and check Connector to Trigger Fit 100%.	92458 26345 32895
8761	154	Assemble Trigger Assembly - Stage Two.	92458 26345 32895
8761	155	Adjust Trigger Assembly on Comparator 100%.	92458 26345 32895
8761	160	Assemble Trigger Assembly - Stage Three.	92458 26345 32895
8761	165	Function Check complete Trigger Assembly 100%.	92458 26345 32895
8761	170	Mark correctly assembled, adjusted and checked Trigger Assembly with Assemblers Identification. To Final Assy - Crib 29	92458 26345 32895
8761	175R	Repair rejected Trigger Assemblies.	92458 26345 32895

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KINZER V. REMINGTON

R2535942

Operation Step Detail Operation: 140

Step	Operation / Step Description
	Demagnatize Springs Procedure: 1. Place Sear Springs and Trigger Springs separately in a pan. The amount should be based on daily requirements. 2. Turn demagnetizer "ON". 3. Pass pan across the effective area located between the handles. Start the pan over the right handle and pass to the left handle and remove. 4. Turn switch to "OFF". Do not turn switch off with pan in contact with demagnetizer, this may magnetize parts.

Operation Tool Detail Operation: 140

Tool Number	Tooling Description
	Machine-Electr-Matic Type A13

Operation Step Detail Operation: 145

Step	Operation / Step Description
	**********SKETCH NEEDED********** Clean Trigger Housing Assembly and apply Rust Preventative This operation removes any excess "Steelguard" and /or foreign material just prior to Assembly operation. CLEAN First Tank: 1.1.1 Trichlorethane Basket Dip. Then immediately transfer to: PRESERVE Second Tank: Water based rust inhibiting bath. Basket dip. Then air dry.

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KINZER V. REMINGTON

R2535943

Step Operation / Step Description

*** See Sketches (4) ***

Assemble Trigger Assembly - Stage One
Inspect Connector 100%, inspect Trigger 100% and check Connector to Trigger fit 100%.

NOTE: Do all elements 100%

1. Inspect long inside Connector surface, and inside surface of long (top) leg for flatness.

   Hold Connector against flatness block with light finger pressure.

   * If no light shows between inside surfaces of back and long leg of Connector and block surface, Connector is good.

   (See Figure #1)

   * If light gap shows, measure gap with a .006 shim. If gap accepts shim without moving Connector - Reject Connector. (See Fig. #2)

   * If Connector rocks on flatness block - reject Connector. (See Fig. #3)

   * Front edge of long (top) leg, must be square with shoulder of flatness block. (See Fig. #4)

   .006 Shim - Make new Shim as required.

2. Smooth top surface of long leg of Connector. Use Crocus cloth.

   Surface must be:
   * Smooth
   * Burr - Free at top and bottom corners and hole.
   * Dead flat within 1/32" (Minimum of end.

   Check for burrs and smoothness with fingertip.

   Separate rejected connector into labeled containers based on reject reason.

3. INSPECT TRIGGER.

   Trigger Must Have:
   * Good black color
   * No bleed out (white material on surface)
   * No burrs
   * No cracks or damage at pivot hole.
   * Floor Plate clearance milled, both sides of finger piece.

4. Fit passed Connector to passed Trigger and check for MIN. WORKING CLEARANCE. (Slip Fit)

   * Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.

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R2535944

Continued ...
Operation Step Detail Operation: 151
Step Operation / Step Description

* If additional clearance is needed, file bottom notch on Trigger. Filed surface must be FLAT and SQUARE with sides of trigger. Use filing fixture only. DO NOT FILE FREE HAND.

5. With the same Trigger and Connector, check for Max. Working clearance:

   * Push Connector tight to Trigger at bottom, and hold it parallel to sides of Trigger.

   * Insert shim stock in clearance from front to back.

     * .006 shim MUST NOT GO

   * If shim enters without moving Connector SCRAP TRIGGER.

   * Keep trigger and connector together in container ready for Stage Two.

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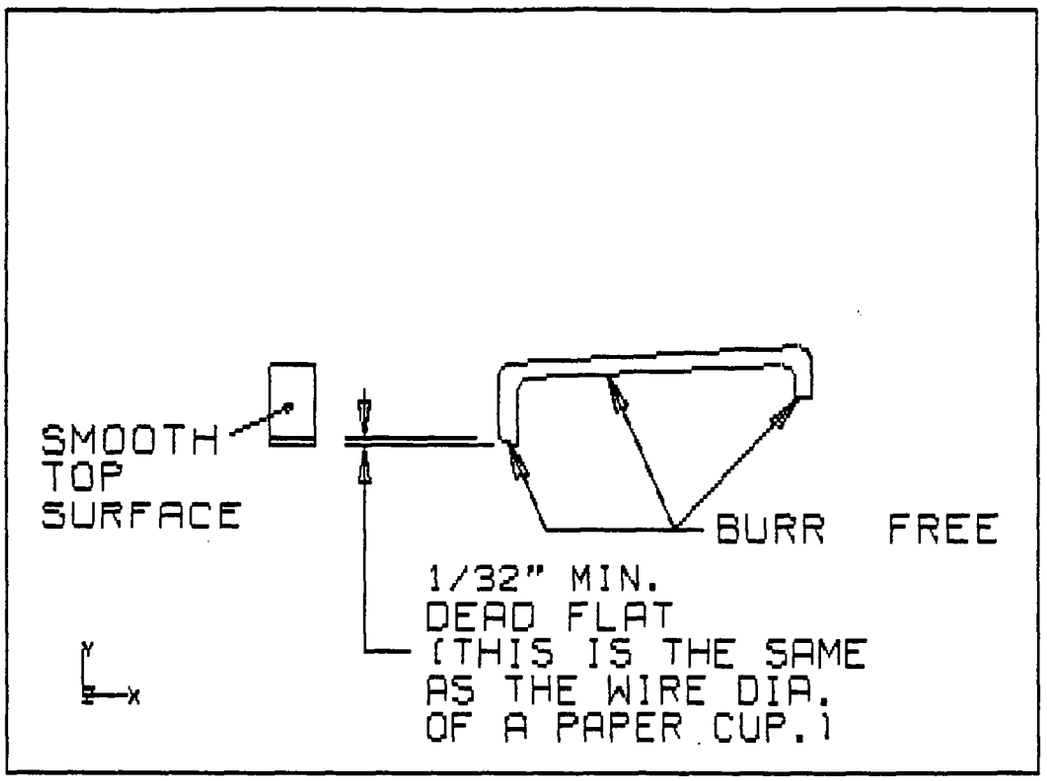
R2535945

TITLE: Trigger Assy

Picture: Sketch 151 **Operation:** 151



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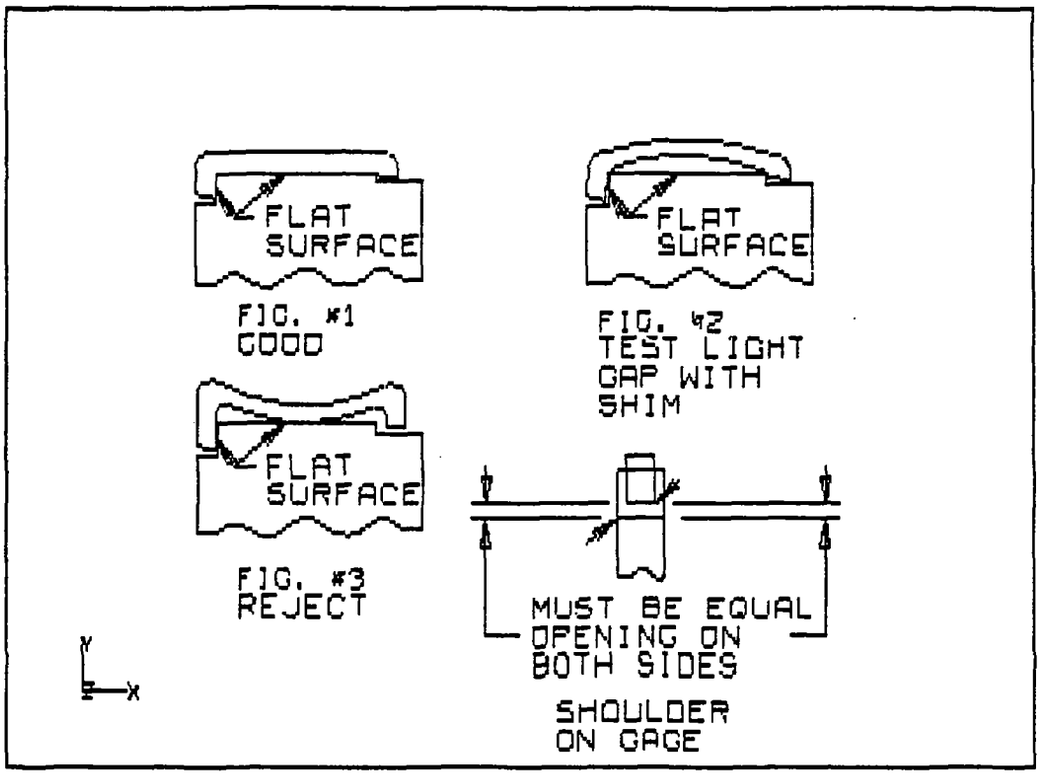
R2535946

TITLE: Trigger Assy

Picture: Sketch 151-1 **Operation:** 151



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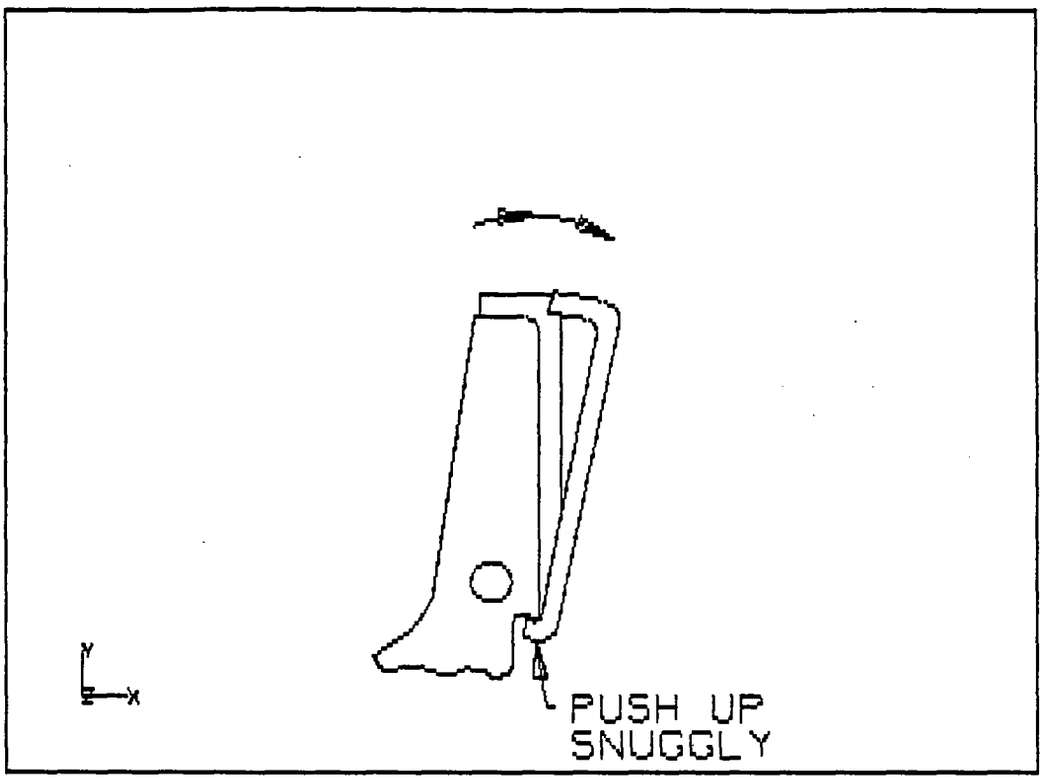
R2535947

TITLE: Trigger Assy

Picture: Sketch 151-2 Operation: 151



Document Number: Trigger Assy 700 7 Lwt **Rev:**

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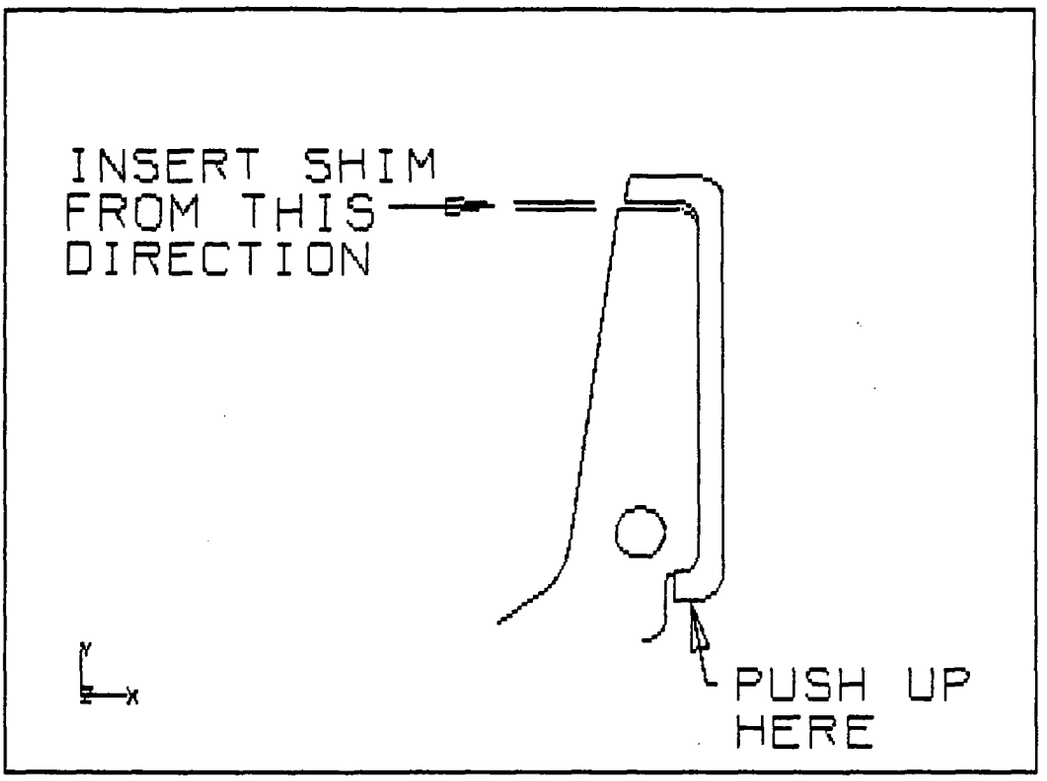
R2535948

TITLE: Trigger Assy

Picture: Sketch 151-3 **Operation:** 151



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R2535949

TITLE: Trigger Assy

Operation Tool Detail Operation: 151

Tool Number	Tooling Description
C-44604	Flatness Block

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R2535950

*** See Sketch ***

Assembly Trigger Assembly - Stage Two

1. Inspect Trigger Housing:

   * Black color
   * No bleedout (White Material)
   * Check inside Housing - No burrs at holes.
   * Clean and free of excess oil and foreign material.

2. Position Trigger in Housing and install Trigger Pin:

   * Pin must be flush to housing on right side, left side for left hand.
   * Grip Trigger and rotate housing around Trigger Pin. Trigger must rotate freely in housing without bind.

3. Install:

   * Same Connector as fitted to Trigger (Op. #151)
   * Trigger Stop Screw - Flush with hole.
   * Trigger Spring
   * Trigger Adjusting Screw - Flush with hole or below. (There must be adequate spring force on Connector while adjusting Trigger Engagement Screw.) (except with Austrailian)
   * Trigger Engagement Screw - flush with hole. (except with Austrailian) - Screw should have been precoated with loctite sealant before assembly - see PROCEDURE.

PROCEDURE FOR COATING TRIGGER ENGAGEMENT SCREW WITH LOCTITE SEALANT:

1. Place approximately 1000 clean, dry screws in a plastic bag.
2. Pour sufficient loctite sealant into bag to evenly coat screws with a thin film of sealant.
3. Agitate bag to coat all screws.
4. If screws are too moist, add more screws and re-agitate. If screws are too dry, add more sealant and re-agitate.

Screws may be used immediately or stored if required.

4. Install Sear Spring and *Sear Safety Cam using Two Dummy Pins.

   * Sear must be flat - not bowed. Check 100% thru width gage.
   * Sear must not have dimple.
   * Sear must be ground at vertical contact surface with Connector and at horizontal contact surface.
   * Sharp Square Corner at Connector Contact Surface.

* Sear Safety Cam - Part #15666 does not have a recessed dimple.

NOTE: Grind at vertical contact surface is done AFTER chrome plate. Grind at horizontal contact surface is done BEFORE

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R2535951

Continued ...
Operation Step Detail Operation: 154
Step Operation / Step Description

	chrome plate.

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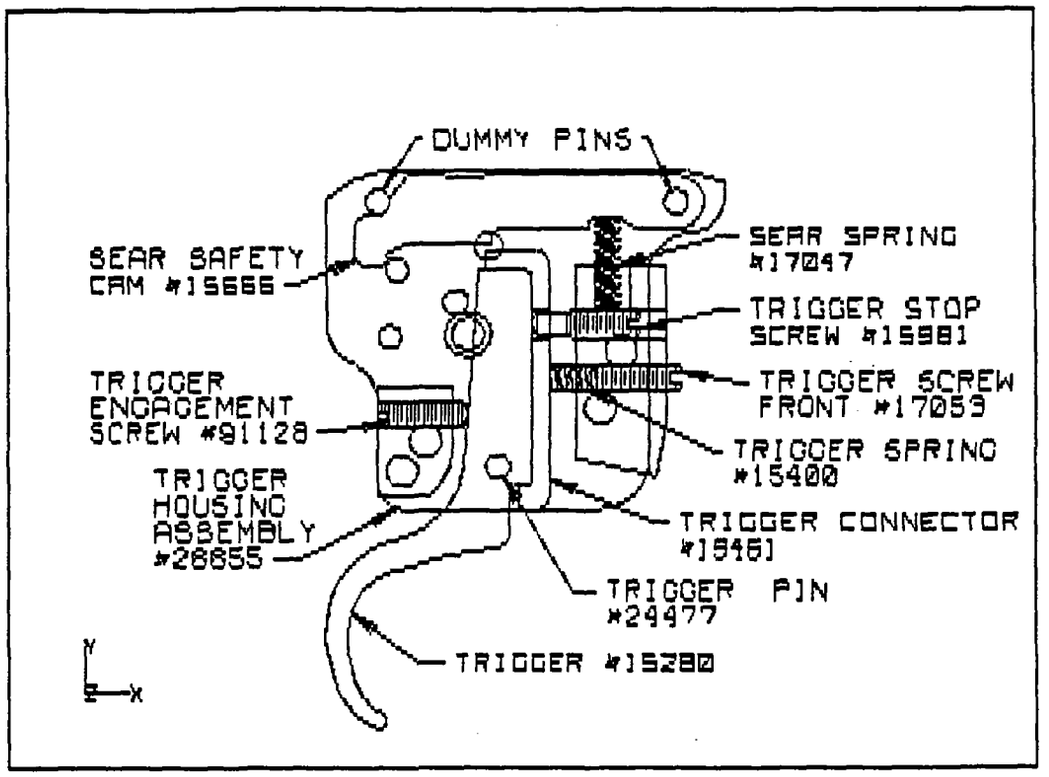
R2535952

TITLE: Trigger Assy

Picture: Sketch 154 **Operation:** 154



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R2535953

TITLE: Trigger Assy

Operation Tool Detail Operation: 154

Tool Number	Tooling Description
A-35645	Pin Holder Drive Punch
A-51468	Dummy Pins
C-44522	Width Gage

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R2535954

TITLE: Trigger Assy

Operation Step Detail Operation: 155

Step	Operation / Step Description

*** See Sketch ***

Adjust Trigger Assembly on Comparator 100%

1. Pick Trigger Sub-Assembly. Position in comparator fixture and clamp:

   * Housing must properly contact all locators.
   * Top of Housing must be flat on fixture.
   * Push with thumb on rear of Trigger (toward left) This seats Trigger firmly against end of Trigger Adjusting Screw.

2. Adjust fixture to locate Sear on "set" line of comparator screen.

3. Adjust Sear/Connector engagement (.015 - .020), to correct comparator screen line by turning Trigger Engagement Screw SLOWLY CLOCKWISE (to reduce engagement.

   AFTER CORRECTLY ADJUSTING SEAR/CONNECTOR ENGAGEMENT

4. Hang dead weight assembly to end of Trigger.

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).

   Comparator fixture dead weight - 4 lbs.

6. Re-adjust fixture to locate Sear on "Set Line" of Comparator Screen.

7. Remove dead weight assembly from Trigger.

8. Hold Trigger in fired position firmly with finger and:

   * Set OVER-TRAVEL by turning Trigger Stop Screw SLOWLY CLOCKWISE, until Trigger Connector touches correct line in comparator screen.

9. Remove Trigger Sub-Assembly from comparator fixture.

10. Seal all three screws with "Duco" Cement, including screw slots.

    NOTE: Realign Lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light Beam from condensing lens to projection lens must be parallel.

    Adjust as required.

    Refer to Page 7 of J&L Operating Manual.

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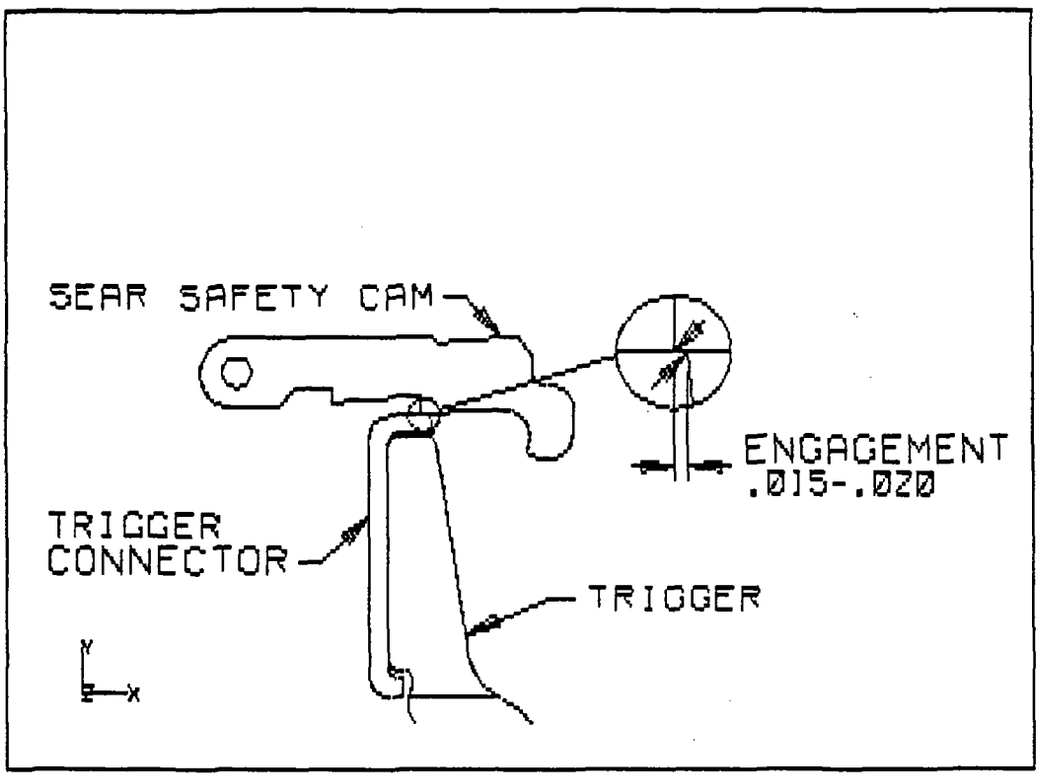
R2535955

TITLE: Trigger Assy

Picture: Sketch 155 **Operation:** 155



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R2535956

TITLE: Trigger Assy

Operation Tool Detail Operation: 155

Tool Number	Tooling Description
Std.	Jones & Lamson Comparator TC-10
E-42271	Comparator Fixture
A-600-CI.25	Comparator Screen

Operation Step Detail Operation: 160

Step	Operation / Step Description

**********SKETCH NEEDED**********

Assembly Trigger Assembly - Stage Three

1. Pick correctly adjusted Trigger Sub-Assembly.

2. Assemble:

   Bolt Stop Release - Do not use twisted or bent parts.
   File inside surface flat if necessary.
   Safety Assembly

   Safety Detent Ball

   Safety Detent Spring - Visually check for correct size dimples.

   Safety Pivot Pin

   Safety Snap Washer

   * Safety Snap Washer MUST be completely contained within Pivot Pin Groove.

   * Both raised dimples on Safety Detent Spring must be within opening of Safety Snap Washer (refer to illustration)

3. Push Bolt Stop Release up and down to ends of Travel several times.

   * Bolt Stop Release must move smoothly and freely without bind.

4. Apply a small amount of Molykote Powder to Sear/Connector engagement surfaces thru engagement view hole, and safety detent area of trigger assembly.

5. Place in pan.

   MOLYKOTE POWDER: Dry Type "Z"
   Squeeze container or eye dropper

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2535957

TITLE: Trigger Assy

Operation Tool Detail Operation: 160

Tool Number	Tooling Description
	.140 Plug Gage

Operation Step Detail Operation: 165

Step	Operation / Step Description
	Function check completed Trigger Assembly 100%
	NOTE: Do All Elements 100%
1.	Put Safety in "OFF SAFE" position.
	Check for:
	TRIGGER RETRACTION Pull Trigger and release:
	* Trigger and Connector must return freely to original position WITH SPRING FORCE.
	SEAR FREEDOM Pull Trigger and hold. Depress Sear FULLY and release:
	* Sear must move freely in housing without binding. The Sear must return upward under Sear Spring force.
2.	Operation of Safe
	Push Safety Thumb Piece fully forward beyond detent position:
	* Safety must spring-return rearward to detent position.
	Push Safety Thumb Piece fully rearward beyond detent position:
	* Safety must spring-return forward to detent position.
	Move Safety for "ON SAFE" to "OFF SAFE" position and back. Do this TWICE:
	* Safety must spring forward into "OFF SAFE" position when pushed.
	* There must be no hang-up or hesitation between detent positions.

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KINZER V. REMINGTON

R2535958

TITLE: Trigger Assy

Operation Step Detail Operation: 170

Step	Operation / Step Description
	*** See Sketch ***
	Mark correctly assembled, adjusted and checked Trigger Assembly, with Assembler's Identification.
	1. Locate trigger assembly on stamping fixture.
	2. Stamp lower left corner (as shown) with correct Assemblers Identification.
	* Use 1/16" size character

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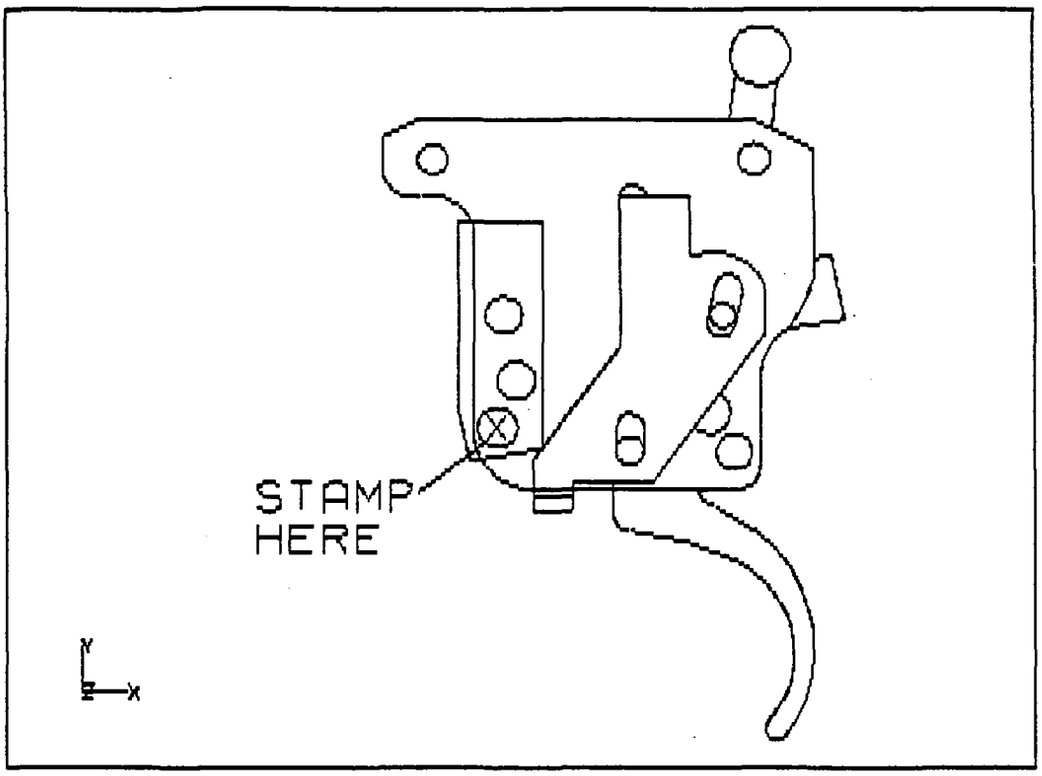
KINZER V. REMINGTON

R2535959

TITLE: Trigger Assy

Picture: Sketch 170 Operation: 170



Document Number: Trigger Assy 700 7 Lwt **Rev:**

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KINZER V. REMINGTON

R2535960

Step	Operation / Step Description
	Repair Rejected Trigger Assemblies
	NOTE: Each repair Trigger Assembly is to go to Assembler who originally built it.
	1. Make corrections as required.
	2. Return Trigger Assembly to process at point where it will again receive all applicable adjustments and function checks.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2535961

TITLE: Trigger Pin

Process Header

PURCHASED PARTS INSPECTION

Material	: AISI C-1095 or 52100
Heat Treatment At	: Remington
Component Condition	: Finished Semi-Fin X
Model	: XP100
Part Number	: 24483
Blank Drawing Number	: C-24475
Part Name	: Trigger Pin
Department	: 9291
A. Q. L.	: 3 %
Origination Date	: 13-Oct-1988
Effective Date	: 06-Aug-1991-08:00:00
Final Appearance	: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent).
Packaging	: The gross weight of any container must not exceed 50 pounds.
Acceptance Testing	: Inspection will be based on statistical sampling according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
02-Aug-1991	Retyped old paper process last Log 288592	SLW 292044

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process Tools

Type	Number	Use	Max	Min
Visual		Free from burrs Chamfer both ends .010 x 45 deg.		
Mics.	Std.	Over-all length	.505	.495
	Std.	Diameter	.125	.1248

Document Number: 24483 **Rev:**

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KINZER V. REMINGTON

R2535962

TITLE: Final Assy 700

Process Header

Process Header

Document ID: Final Assy 700 — Remington Arms Company
Part Name: Final Assy 700
Product Line: Centerfire — Effective Date: 21-Nov-1991-08:00:00
Engineering Group: Centerfire — Origination Date: 19-Oct-1989

Process History

Status	Date/Time	Status Set	Responsible User
Submitted	7-NOV-1989	08:33:32.37	M.D.Keeney
Comment:			
Recalled	8-NOV-1989	11:21:30.50	M.D.Keeney
Comment:			
Submitted	13-DEC-1990	13:18:49.01	M.D.Keeney
Comment:	"RELEASE :18-DEC-1990"		
Recalled	13-DEC-1990	13:19:47.44	M.D.Keeney
Comment:			
Submitted	25-OCT-1991	09:13:42.14	Shirley Willoughby
Comment:	"Made chg. for GEB"		
Recalled	25-OCT-1991	11:54:13.12	Shirley Willoughby
Comment:			

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:	
18-APR-1991	RETYPED VERIFIED FROM OLD PAPER PROCESS CHANGE #290789.	MDK	291565
18-APR-1991	CORRECTED TYPO'S.	MDK	291566
26-SEP-1991	ADDED 25-06 TO MTN. RIFLE, 223, 22-250, 308 VAR. SYN. & 222 CLASSIC	MDK	292214
25-Oct-1991	Changed guard screws part numbers from slotted to allen head cap screws.	MDK	292319
25-Oct-1991	Added 220 Swift for the 1992 Classic	GEB	292330
19-Nov-1991	Removed component #26555 Swivel Assy & Op. 668	GEB	292401
01-APR-1992	Added European (Oiled Stock) M/700 BDL - 243,270,280, 7MM-08,30-06,308,7MM Rem Mag Calibers	GLC	292601
15-May-1992	Corrected Part #'s for Front & Rear Guard Screws for 926100, 925795, 925913, 926098, and 925793 104127 was 22037, 104125 was 22037, 104126 was 26355	GLC	292678

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KINZER V. REMINGTON

R2535963

TITLE: Final Assy 700

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

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KINZER V. REMINGTON

R2535964

TITLE: Final Assy 700

Process Material

Part Number	Qnty	Description					
M/700 BDL RAMAC		17 925801	222 925781	223 925798	22-250 925783	243 925787	6MM 925785
BBl Assy Com.	1	31504	31514	31512	31506	31496	31498
Bolt Stop	1	17013	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224	15224
Firing Pin Assy	1	22041	22041	22041	22041	22041	22041
Frt Guard Screw	1	104127	104127	104127	104127	104127	104127
Front Sight Hood	1	15363	15363	15363	15363	15363	15363
Front Sight Ramp	1	15635	15635	15635	15635	15635	15635
Front Sight	1	15373	15373	15373	15373	15373	15373
Sight Screw	4	28505	28505	28505	28505	28505	28505
Magazine	1	16716	16716	16716	16715	16715	16715
Mag. Follower	1	90951	90951	90951	90982	90982	90982
Magazine Spacer	1	15286	15286	15286			
Magazine Spring	1	91133	91133	91133	15699	17891	17891
Rear Guard Screw	1	104126	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103145	103145	103145
Rec. Plug Screw	4	17034	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476	24476
Stock Assembly	1	103600	103600	103600	103600	103600	103600
Swivel Screw	2	15358	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31490	31490	31490	31490	31490	31490
Flr Plate Latch	1	15291	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452	16452
M/700 BDL RAMAC		257 RBTS 925753	25-06 925789	270 925791	280 925797	7MM-08 925799	7MM R. Mag. 925803
BBl Assy Com.	1	31518	31502	31499	31503	31511	31501
Bolt Stop	1	17013	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224	15224
Firing Pin Assy	1	22040	22040	22040	22040	22041	22040
Frt Guard Screw	1	104125	104125	104125	104125	104127	104125
Front Sight Hood	1	15363	15363	15363	15363	15363	15363
Front Sight Ramp	1	15635	15992	15635	15635	15635	15635
Front Sight	1	15373	15373	15373	15373	15373	14659
Sight Screw	4	28505	28505	28505	28505	28505	28505
Magazine	1	16430	16430	16430	16430	16715	16430
Mag. Follower	1	92218	92218	92218	92218	90982	90952
Magazine Spring	1	15677	15677	15677	15677	17891	15677
Rear Guard Screw	1	104126	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103145	103145	103148
Rec. Plug Screw	4	17034	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476	24476
Stock Assembly	1	103601	103601	103601	103601	103600	103602
Swivel Screw	2	15358	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345	26345

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Process Material

Part Number	Qnty	Description					
T. G. Sub-Assy	1	31491	31491	31491	31491	31490	31491
Flr Plate Latch	1	15291	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452	16452
M/700 BDL		30-06	308	35 WHELEN	300 SAVAGE		
RAMAC		925793	925795	925796	925755		
BBl Assy Com.	1	31500	31497	94213	31519		
Bolt Stop	1	17013	17013	17013	17013		
Bolt Stop Pin	1	24475	24475	24475	24475		
Bolt Stop Spring	1	15224	15224	15224	15224		
Firing Pin Assy	1	22040	22041	22040	22041		
Frt Guard Screw	1	104125	104127	104125	104127		
Front Sight Hood	1	15363	15363	15363	15363		
Front Sight Ramp	1	15635	15635	15635	15635		
Front Sight	1	15373	15373	15373	15373		
Sight Screw	4	28505	28505	28505	28505		
Magazine	1	16430	16715	16430	16715		
Mag. Follower	1	92218	90982	92218	90982		
Magazine Spacer	1		15286				
Magazine Spring	1	15677	17891	15677	17891		
Rear Guard Screw	1	104126	104126	104126	104126		
Rear Sight Assy	1	103145	103145	103145	103145		
Rec. Plug Screw	4	17034	17034	17034	17034		
Sear Pin	1	24476	24476	24476	24476		
Stock Assembly	1	105784	105783	103608	103600		
Swivel Screw	2	15358	15358	15358	15358		
Swvl Scrw Spacer	2	94241	94241	94241	94241		
Trigger Assembly	1	26345	26345	26345	26345		
T. G. Sub-Assy	1	31491	31490	31491	31490		
Flr Plate Latch	1	15291	15291	15291	15291		
Flr Plt Lt Pin	1	16451	16451	16451	16451		
F. P. Lt Spring	1	16452	16452	16452	16452		
M/700 BDL LH		22-250	243	270	7MM MAG	308	30-06
RAMAC		925749	925819	925811	925815	925818	925813
BBl Assy Com.	1	31514	31513	31508	31509	31516	31507
Bolt Stop	1	17013	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224	15224
Firing Pin Assy	1	22041	22041	22040	22040	22041	22040
Frt Guard Screw	1	104127	104127	104125	104125	104127	104125
Front Sight Hood	1	15363	15363	15363	15363	15363	15363
Front Sight Ramp	1	15635	15992	15635	15635	15635	15635
Front Sight	1	15373	15373	15373	14659	15373	14659
Sight Screw	4	28505	28505	28505	28505	28505	28505
Magazine	1	16715	16715	16430	16430	16715	16430
Mag. Follower	1	90982	90982	92218	90952	90982	92218
Magazine Spring	1	15699	17891	15677	15677	17891	15677

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Continued ...

Process Material

Part Number	Qnty	Description					
Rear Guard Screw	1	104126	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103148	103145	103145
Rec. Plug Screw	4	17034	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476	24476
Stock Assembly	1	103603	103603	103604	103605	103603	103604
Swivel Screw	2	15358	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241	94241
Trigger Assembly	1	32895	32895	32895	32895	32895	32895
T. G. Sub-Assy	1	31490	31490	31491	31491	31490	31491
Flr Plate Latch	1	15291	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452	16452
M/700 BDL LH		338 WIN MAG					
RAMAC		925751					
BBl Assy Com.	1	31517					
Bolt Stop	1	17013					
Bolt Stop Pin	1	24475					
Bolt Stop Spring	1	15224					
Firing Pin Assy	1	22040					
Frt Guard Screw	1	104125					
Front Sight Hood	1	15363					
Front Sight Ramp	1	15635					
Front Sight	1	14659					
Sight Screw	4	28505					
Magazine	1	16430					
Mag. Follower	1	90952					
Magazine Spring	1	15677					
Rear Guard Screw	1	104126					
Rear Sight Assy	1	103148					
Rec. Plug Screw	4	17034					
Sear Pin	1	24476					
Stock Assembly	1	103605					
Swivel Screw	2	15358					
Swvl Scrw Spacer	2	94241					
Trigger Assembly	1	32895					
T. G. Sub-Assy	1	31491					
Flr Plate Latch	1	15291					
Flr Plt Lt Pin	1	16451					
F. P. Lt Spring	1	16452					
M/700 VARMINT		222	223	22-250	243	6MM	25-06
RAMAC		925821	925825	925823	925829	925827	925831
BBl Assy Com.	1	31520	31522	31521	31524	51323	31525
Bolt Stop	1	17013	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224	15224
Firing Pin Assy	1	22041	22041	22041	22041	22041	22040
Frt Guard Screw	1	104127	104127	104127	104127	104127	104125

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Process Material

Part Number	Qnty	Description					
Magazine	1	16716	16716	16715	16715	16715	16340
Mag. Follower	1	90951	90951	90982	90982	90982	92218
Mag. Spacer	1	15286	15286				
Magazine Spring	1	91133	91133	15699	15699	15699	15677
Rear Guard Screw	1	104126	104126	104126	104126	104126	104126
Rec. Plug Screw	4	17034	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476	24476
Stock Assembly	1	103606	103606	103606	103606	103606	103607
Swivel Screw	2	15358	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31490	31490	31490	31490	31490	31491
Flr Plate Latch	1	15291	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452	16452
M/700 VARMINT		7MM-08	308				
RAMAC		925835	925833				
BBl Assy Com.	1	31526	31527				
Bolt Stop	1	17013	17013				
Bolt Stop Pin	1	24475	24475				
Bolt Stop Spring	1	15224	15224				
Firing Pin Assy	1	22041	22041				
Frt Guard Screw	1	104127	104127				
Magazine	1	16716	16716				
Mag. Follower	1	90951	90951				
Mag. Spacer	1	15286	15286				
Magazine Spring	1	91133	91133				
Rear Guard Screw	1	104126	104126				
Rec. Plug Screw	4	17034	17034				
Sear Pin	1	24476	24476				
Stock Assembly	1	103606	103606				
Swivel Screw	2	15358	15358				
Swvl Scrw Spacer	2	94241	94241				
Trigger Assembly	1	26345	26345				
T. G. Sub-Assy	1	31490	31490				
Flr Plate Latch	1	15291	15291				
Flr Plt Lt Pin	1	16451	16451				
F. P. Lt Spring	1	16452	16452				
M/700 VAR. SYN.		223	22-250	308			
RAMAC		929702	929700	929704			
BBl Assy Com.	1	104745	104746	104747			
Bolt Stop	1	17013	17013	17013			
Bolt Stop Pin	1	24475	24475	24475			
Bolt Stop Spring	1	15224	15224	15224			
Firing Pin Assy	1	94093	94093	94093			
Frt Guard Screw	1	104133	104133	104133			
Magazine	1	16716	16715	16715			
Mag. Follower	1	90951	90982	90982			
Mag. Spacer	1	15286					

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Continued ...

Process Material

Part Number	Qnty	Description					
Magazine Spring	1	91133	15699	15699			
Rear Guard Screw	1	104134	104134	104134			
Rec. Plug Screw	4	24476	24476	24476			
Sear Pin	1	103606	103606	103606			
Stock Assembly	1	104710	104710	104710			
Trigger Assembly	1	26345	26345	26345			
T. G. Sub-Assy	1	94534	94534	94534			
Flr Plate Latch	1	15291	15291	15291			
Flr Plt Lt Pin	1	16451	16451	16451			
F. P. Lt Spring	1	16452	16452	16452			
M/700 MTN RIFLE		243	270	280	7x57	7MM-08	308
RAMAC		925614	925630	925632	925629	925616	925618
BBl Assy Com.	1	100324	100320	100321	100326	100325	100323
Bolt Stop	1	17013	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224	15224
Firing Pin Assy	1	22041	22040	22040	22040	22041	22041
Frt Guard Screw	1	104127	104125	104125	104125	104127	104127
Magazine	1	16715	16430	16430	16430	16715	16715
Mag. Follower	1	90982	92218	92218	92218	90982	90982
Magazine Spring	1	15699	15677	15677	15677	15699	15699
Rear Guard Screw	1	104126	104126	104126	104126	104126	104126
Rec. Plug Screw	4	17034	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476	24476
Stock Assembly	1	100566	100565	100565	100565	100566	100566
Swivel Screw	2	15358	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31490	31491	31491	31491	31490	31490
Flr Plate Latch	1	15291	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452	16452
M/700 MTN RIFLE		30-06	257 RBTS	7x64 BRNKE	25-06		
RAMAC		925634	925600	925607	925606		
BBl Assy Com.	1	100322	97265	100329	97398		
Bolt Stop	1	17013	17013	17013	17013		
Bolt Stop Pin	1	24475	24475	24475	24475		
Bolt Stop Spring	1	15224	15224	15224	15224		
Firing Pin Assy	1	22040	22041	22040	22040		
Frt Guard Screw	1	104125	104127	104125	104125		
Front Sight Ramp	1			92081			
Front Sight	1			15719			
Sight Screw	4			28505			
Magazine	1	16430	16715	16430	16430		
Mag. Follower	1	92218	90982	92218	92218		
Magazine Spring	1	15677	15699	15677	15677		
Rear Guard Screw	1	104126	104126	104126	104126		

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Continued ...

Process Material

Part Number	Qnty	Description				
Rear Sight Assy	1			103145		
Rec. Plug Screw	4	17034	17034	17034	17034	
Sear Pin	1	24476	24476	24476	24476	
Stock Assembly	1	100565	100566	100565	100565	
Swivel Screw	2	15358	15358	15358	15358	
Swvl Scrw Spacer	2	94241	94241	94241	94241	
Trigger Assembly	1	26345	26345	26345	26345	
T. G. Sub-Assy	1	31491	31490	31491	31491	
Flr Plate Latch	1	15291	15291	15291	15291	
Flr Plt Lt Pin	1	16451	16451	16451	16451	
F. P. Lt Spring	1	16452	16452	16452	16452	

M/700 CLASSIC RAMAC		22-250 925854	243 925860	6MM 925858	250 SAVAGE 925754	257 ROBERTS 925850
BBl Assy Com.	1	31506	31496	31536	31544	31542
Bolt Stop	1	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224
Firing Pin Assy	1	22041	22041	22041	22041	22041
Frt Guard Screw	1	104127	104127	104127	104127	104127
Front Sight Hood	1	15363	15363	15363	15363	15363
Front Sight Ramp	1	15635	15992	15635	15635	15635
Front Sight	1	15373	15373	15373	14659	15373
Sight Screw	4	28505	28505	28505	28505	28505
Magazine	1	16715	16715	16715	16715	16715
Mag. Follower	1	90982	90982	90982	90982	90982
Magazine Spring	1	15699	15699	15699	15699	15699
Rear Guard Screw	1	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103148	103145
Rec. Plug Screw	4	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476
Stock Assembly	1	34590	34590	34590	34590	34590
Swivel Screw	2	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31490	31490	31490	31490	31490
Flr Plate Latch	1	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452

M/700 CLASSIC RAMAC		25-06 925907	264 WIN 925898	270 925864	7MM MAG 925872	30-06 925866	300 H&H 925846
BBl Assy Com.	1	94655	93465	31539	31540	31538	31543
Bolt Stop	1	17013	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224	15224
Firing Pin Assy	1	22040	22040	22040	22040	22040	22040
Frt Guard Screw	1	104125	104125	104125	104125	104125	104125
Front Sight Hood	1	15363	15363	15363	15363	15363	15363

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Process Material

Part Number	Qnty	Description					
Front Sight Ramp	1	15635	15992	15635	15635	15635	15635
Front Sight	1	15373	15373	15373	14659	15373	14659
Sight Screw	4	28505	28505	28505	28505	28505	28505
Magazine	1	16430	16430	16430	16430	16430	16430
Mag. Follower	1	92218	92218	92218	90952	92218	90952
Magazine Spring	1	15677	15677	15677	15677	15677	15677
Rear Guard Screw	1	104126	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103148	103145	103145
Rec. Plug Screw	4	17034	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476	24476
Stock Assembly	1	34591	34591	34591	34592	34591	34592
Swivel Screw	2	15358	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31491	31491	31491	31491	31491	31491
Flr Plate Latch	1	15291	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452	16452

M/700 CLASSIC RAMAC		300 WBY MG 925903	338 WIN MG 925899	350 MAG 925756	35 WLN 925901	7MM WBY MG 925909
BBl Assy Com.	1	94388	31515	93184	94213	94790
Bolt Stop	1	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224
Firing Pin Assy	1	22040	22040	22041	22040	22040
Frt Guard Screw	1	104125	104125	104127	104125	104125
Front Sight Hood	1	15363	15363	15363	15363	
Front Sight Ramp	1	15635	15992	15635	15635	
Front Sight	1	15373	15373	15373	14659	
Sight Screw	4	28505	28505	28505	28505	
Magazine	1	16430	16430	14756	16430	16430
Mag. Follower	1	90952	90952	90982	92218	90952
Magazine Spring	1	15677	15677	15699	15677	15677
Rear Guard Screw	1	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103148	
Rec. Plug Screw	4	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476
Stock Assembly	1	34592	34592	34590	34594	34592
Swivel Screw	2	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31491	31491	31490	31491	31491
Flr Plate Latch	1	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452

M/700 CLASSIC RAMAC		220 SWIFT 925913
BBl Assy Com.	1	97533

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Process Material

Part Number	Qnty	Description
Bolt Stop	1	17013
Bolt Stop Pin	1	24475
Bolt Stop Spring	1	15224
Firing Pin Assy	1	22041
Frt Guard Screw	1	104127
Magazine	1	16715
Mag. Follower	1	90982
Magazine Spring	1	15699
Rear Guard Screw	1	104126
Rec. Plug Screw	4	17034
Sear Pin	1	24476
Stock Assembly	1	34590
Swivel Screw	2	15358
Swvl Scrw Spacer	2	94241
Trigger Assembly	1	26345
T. G. Sub-Assy	1	31490
Flr Plate Latch	1	15291
Flr Plt Lt Pin	1	16451
F. P. Lt Spring	1	16452

		WOOD		SYNTHETIC	
M/700 POLICE		223	308	223	308
RAMAC		925743	925744	925745	925746
BBl Assy Com.	1	31528	31529	31528	31529
Bolt Stop	1	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224
Firing Pin Assy	1	22041	22041	22041	22041
Frt Guard Screw	1	104127	104127	104127	104127
Magazine	1	16716	16715	16716	16715
Mag. Follower	1	93353	93120	93353	93120
Magazine Spring	1	91133	15699	91133	15699
Rear Guard Screw	1	104126	104126	104126	104126
Rec. Plug Screw	4	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476
Stock Assembly	1	102821	102821	94519	94519
Swivel Screw	2	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345
T. G. Sub-Assy	1	93830	93830	93830	93830
Flr Plate Latch	1	93829	93829	93829	93829
Flr Plt Lt Pin	1	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452

M/700 EUROPEAN (OILED STOCK)		243	270	280	7MM-08	7MM REM MAG
RAMAC		926084	926088	926092	926094	926104
BBl Assy Com.	1	31496	31499	31503	31511	31501

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Process Material

Part Number	Qnty	Description				
Bolt Stop	1	17013	17013	17013	17013	17013
Bolt Stop Pin	1	24475	24475	24475	24475	24475
Bolt Stop Spring	1	15224	15224	15224	15224	15224
Firing Pin Assy	1	22041	22040	22040	22041	22040
Frt Guard Screw	1	104127	104125	104125	104127	104125
Front Sight Hood	1	15363	15363	15363	15363	15363
Front Sight Ramp	1	15635	15635	15635	15635	15635
Front Sight	1	15373	15373	15373	15373	14659
Sight Screw	4	28505	28505	28505	28505	28505
Magazine	1	16715	16430	16430	16715	16430
Mag. Follower	1	90982	92218	92218	90982	90952
Magazine Spring	1	17891	15677	15677	17891	15677
Rear Guard Screw	1	104126	104126	104126	104126	104126
Rear Sight Assy	1	103145	103145	103145	103145	103148
Rec. Plug Screw	4	17034	17034	17034	17034	17034
Sear Pin	1	24476	24476	24476	24476	24476
Stock Assembly	1	105783	105784	105784	105783	105785
Swivel Screw	2	15358	15358	15358	15358	15358
Swvl Scrw Spacer	2	94241	94241	94241	94241	94241
Trigger Assembly	1	26345	26345	26345	26345	26345
T. G. Sub-Assy	1	31490	31491	31491	31490	31491
Flr Plate Latch	1	15291	15291	15291	15291	15291
Flr Plt Lt Pin	1	16451	16451	16451	16451	16451
F. P. Lt Spring	1	16452	16452	16452	16452	16452
M/700 EUROPEAN (OILED STOCK)		30-06	308			
RAMAC		926098	926100			
BBl Assy Com.	1	31500	31497			
Bolt Stop	1	17013	17013			
Bolt Stop Pin	1	24475	24475			
Bolt Stop Spring	1	15224	15224			
Firing Pin Assy	1	22040	22041			
Frt Guard Screw	1	104125	104127			
Front Sight Hood	1	15363	15363			
Front Sight Ramp	1	15635	15635			
Front Sight	1	15373	15373			
Sight Screw	4	28505	28505			
Magazine	1	16430	16715			
Mag. Follower	1	92218	90982			
Magazine Spring	1	15677	17891			
Rear Guard Screw	1	104126	104126			
Rear Sight Assy	1	103145	103145			
Rec. Plug Screw	4	17034	17034			
Sear Pin	1	24476	24476			
Stock Assembly	1	105784	105783			
Swivel Screw	2	15358	15358			
Swvl Scrw Spacer	2	94241	94241			
Trigger Assembly	1	26345	26345			
T. G. Sub-Assy	1	31491	31490			
Flr Plate Latch	1	15291	15291			
Flr Plt Lt Pin	1	16451	16451			
F. P. Lt Spring	1	16452	16452			

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Process Material

Part Number	Qnty	Description

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TITLE: Final Assy 700

Process Routing

Dept	Oper	Operation Description	Part Numbers
8761	570	Assemble Rear Sight Assembly, Front Sight Ramp and Front Sight to Barrel Assembly Complete	ALL EXCEPT FOR: 925821 925825 925823 925829 925827 925831 925835 925833 925614 925600 925630 925632 925629 925616 925618 925634 925607 925743 925744 925745 925746 925913 929702 929700 929704 925606
8761	575	Assemble four (4) Receiver plug screws.	ALL
8761	580	Assemble Action	ALL
8761	583	Assemble Spacer to Magazine	925798 925801 925781 925821 925825 925743 925745 925913 929702
8761	585	Assemble Stock to Action	ALL
8785	600	Proof Test	ALL
8785	605R	Check repaired guns returning to gallery for proof stamp, prick punch and obstruction in barrel	ALL
8785	606	Test (100%) and Target (10% Std. Models, 100% Police)	ALL
8785	620	Inspect for live ammunition	ALL
8786	625	Print box end label	ALL
8786	625A	Print box end label off line	ALL
8786	630	Match label to gun and place label in plastic envelope	ALL
8761	640	Final Inspection	ALL
8761	660	Assemble Hood to Front Sight Ramp (R.S.)	ALL
8786	667	Pack instruction folder, Ten Commandments, Gunsmith list and wire	ALL
8786	676	Pack Rifle	ALL
8786	676C	Pack Hardware with gun (ALTERNATE TO OP. 676)	ALL
8786	677C	Pack authorized gunsmiths folder (ALTERNATE TO OP. 676)	ALL
8786	678C	Position wax paper around barrel, oil,	ALL

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Process Routing

Dept	Oper	Operation Description	Part Numbers
		place price tag on Trigger Guard and pack rifle. (ALTERNATE TO OP. 676)	
8786	690R	Unpack gun.	ALL
8786	695R	Repack gun.	ALL
8761	700R	Repair max headers	ALL
8761	705R	Recrown Barrel - Target Rejects.	ALL
8761	710R	Make all necessary stock repairs.	ALL
8761	715R	Repair target rejects.	ALL
8761	716R	Diassemble Target Rejects	ALL
8761	717R	Reassemble Target Rejects.	ALL
8761	718R	Repair for loose Front Sight.	ALL
8761	720R	Reburnish Chamber - "Extracts hard" rejects.	ALL
8761	740R	Mark Label when necessary.	ALL
		To Warehouse	

Operation Step Detail Operation: 570

Step	Operation / Step Description
	Assemble Rear Sight Assembly, Front Sight Ramp and Front Sight to Barrel Assembly. 1. Select Barrel Assembly from truck & place in vise. 2. Select, inspect, and assemble Front Sight Ramp with (2) screws. 3. Select, inspect, and assemble Rear Sight Assembly with (2) screws. 4. Remove Barrel Assembly from vise and step to Front Sight Assembly Fixture. 5. Place Barrel Assembly in fixture. 6. Select, inspect, and assemble Front Sight to Barrel Assembly. 7. Remove Barrel Asembly from fixture, inspect sight alignment. Set Barrel Assy Complete aside in Barrel Truck.

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TITLE: Final Assy 700

Operation Tool Detail Operation: 570

Tool Number	Tooling Description
E-82757	Front Sight Fixture Vise Air Screwdriver-Ingersoll Rand Model SPA 102 RM60 1100 RPM Bench

Operation Step Detail Operation: 575

Step	Operation / Step Description
	Assemble receiver plug screws. 1. Select Barrel Assembly from truck and place in holding vise on bench. 2. Select four plug screws and install in scope mounting holes located in receiver. Use ratchet screw driver.

Operation Tool Detail Operation: 575

Tool Number	Tooling Description
Std.	Ratchet screw driver.

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Step	Operation / Step Description
	Assemble Action
	1. Pick Firing Pin Assembly, inspect for: point not marred, Bolt Plug color O.K., no rust or miscuts.
	2. Lubricate entire threads of Bolt Plug, rear of Bolt lugs and Cocking Cam on Bolt Body with thin film of Molykote GN paste or powder. APPLY WITH LUBE BRUSH
	3. Assemble to Bolt Body Assy. Use Bolt Assy. Tool
	4. Check Firing Pin protrusion. NOTE: Verify that the Serial Numbers on the receiver and bolt match.
	5. Insert Bolt into Action, operate bolt three (3) times to verify proper fit. Remove bolt and place on bench.
	6. Select Trigger Assembly.
	7. Insert Trigger Assembly in Receiver (Must fit freely) (File slot if necessary)
	8. Select Sear Pin and start in sear pin hole. (Drive in flush with inside of Bolt Stop cut.)
	9. Select Bolt Stop-Position in Receiver (Must fit freely) (File slot if necessary)
	10. Select Bolt Stop Spring - Position in Receiver.
	11. Position Trigger Assembly - Select Bolt Stop Pin and assemble to Receiver.
	12. Stake Sear Pin and Bolt Stop Pin.
	13. Hold Trigger & press down on Sear - Sear must NOT bind.
	NOTE: Pins tight-Tester B-80652 Only correct components of good color, not broke or deformed should be used.
	14. Try Safety. a. Must be clearance between Sear and Trigger Connector with Safety on. b. With Bolt open, place safety in "S" or "on" position. Close bolt, firing pin must not follow down.
	15. Check Vertical Sear engagement, at least .015" visual. a. Check for jar off by applying steady pressure on end of Firing Pin Head, while rifle is cocked and the Safety is in the "F" or "off" position. Rifle should not fire. b. Place safety in the "F" or "off" position, insert Tool #C-47741 (Solid Bolt), apply steady pressure of 6-8 lbs. at rear of Bolt Tool. Vertical Sear engagement must not change, the Firing Pin Head must not move forward and the Tool

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Operation Step Detail Operation: 580

Step	Operation / Step Description
	must remain engaged with Sear in.
	16. Verify that the firing pin head will release from the cocking notch by squeezing and holding Trigger while closing bolt slowly. Slight Trigger play may be detectable after firing.
	17. Inspect safety function: a. Place safety in "S" or "ON" position, apply heavy pressure to trigger, rifle must not fire. Release trigger, trigger must retract. Place Safety halfway between "S" and "F", pull Trigger, rifle must not fire. Place Safety in "F" or "OFF position, Firing Pin must not follow down. Perform check three times.
	18. Weigh Trigger pull (3 to 5 lbs.) a. Must be short & crisp, no creep over overdraw. Try 3 times.
	19. Place Safety in "S" or "ON" position.
	20. Close the Action.
	21. Try .006 feeler between Sear and Connector. a. Must enter with no bind.
	22. If clearance is less than .006, replace Safety.
	NOTE: Avoid marring guns! Do not load gun trucks beyond their intended capacity.

Operation Tool Detail Operation: 580

Tool Number	Tooling Description
B-70697	Trigger Pull Scales
	.006 Feeler Gage or suitable shim.
D-48553	Bolt Disassembly Tool
C-47741	Sear Engagement Gage
B-52089	Firing Protrusion Gage

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TITLE: Final Assy 700

Operation Step Detail Operation: 583

Step	Operation / Step Description
	Assemble Magazine Spacer to Magazine.

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Step	Operation / Step Description

Assemble Stock Action.

1. Select correct stock.
   a. Inspect for marrs and finish.

2. Pick correct Magazine Inspect for color, no rust

3. Assemble Magazine to Receiver

4. Select Trigger Guard Assy. and place in Stock. Assemble Trigger guard and stock to action with front and rear Trigger Guard Screws.
   a. Check for Trigger clearance in Guard, .010 shim must go, both sides. Disassemble & replace Trigger Guard Assy.
   b. Check for clearance between end of trigger and inside of guard bow, .030" shim must pass between trigger and guard bow with trigger in full rearward position.

5. Assemble Magazine Spring to Magazine Follower. Install in Floor Plate. Adjust Floor Plate to Latch properly. (See Sample)

6. Inspect margin at ejection port and Receiver tang, per .030 sample. Opening between Stock & Receiver should be uniform, no chipped or scratched finish. Vertical squeeze-no movement. Guard Screws tight-See sample for Max. opening between Stock & Floor Plate. Reasonable gap between Floor Plate and stock is acceptable, if uniform. Reject if edge is jagged. Gas hole in Receiver 50% visible above Stock, Bbl. to be free floating, .005 min. clearance. (Mountain Rifle Only)

7. Check Safety-no bind-clears stock.
   a. Safety lever must have noticeable overtravel; forward beyond "F" detent and rearward beyond "S" detent before stopping or comming into contact with Stock cuts.

8. Check Bolt-no bind-clears stock.

9. Check trigger pull (3 to 5 lbs.)

10. Use dummy cartridges to check feeding, extraction and ejection adjust if necessary. (Single load and full magazine)

11. Stamp assemblers number on left side of Barrel at rear.

12. Pick correct ticket and fill in rifle number, etc.

13. Make all necessary repairs from test.

NOTE: Bolt insert rod in chamber end. Rod must have sufficient flannel to clean bore. WIPING ROD #43447
VISUAL INSPECTION-STOCK

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Operation Step Detail Operation: 585

Step	Operation / Step Description
	1. Inspect for visual damage. a. Reject for visual damage.

Operation Tool Detail Operation: 585

Tool Number	Tooling Description
B-70697	Trigger Pull Scale
Std.	Ball Ratchet Screw Driver

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1. DESCRIPTION AND SEQUENCE OF PROOF TEST

A. Preliminary Inspection-Each gun prior to proof:
   1. No more than two different calibers per truck load.
   2. Inspect all centerfire bores for obstruction with rod.

B. PROOF TEST

NOTE: The first rifle proofed is to be left off of the truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

1. Pick up first gun from truck and inspect for:
   a. Ammunition-Inspect chamber and magazine-both must be empty.
   b. Caliber-To verify for shooting safety.
      1. If the load has two different calibers on it, place a red tag on the barrel of one gun on the truck to alert the testers and targerters of this condition.
   c. Magnaflux Stamp-Must be present right rear side of Barrel.
   d. Firing Pin Protrusion or Foreign material at Face of Bolt:
      1. Firing Pin must be retracted in the Bolt.
      2. Bolt Face and Shroud must be free from any foreign material.

NOTE: Visually check the first gun from each side of the truck for obvious visual defects before and after proof test.

2. With action open, place assembled gun in proofing jack - muzzle in port.

3. Load one (1) proof round into chamber of barrel, place safe in "F" or "off" position.

4. Close protective steel doors of proofing device.
   a. Closing of left hand door must activitate air cylinder which clamps stock into fixture.
   b. The stops on both doors must contact both relays to activate firing mechanism.

5. PULL large knob on side of proofing device and hold (to position triggering mechanism in fixture).

6. Pull firing button on side of proofing device (to operate triggering mechanism).

7. If gun fails to fire, repeat procedure 5 & 6 listed above. If gun fails to fire second time, wait one (1) minute before opening steel doors to remove shell.
   a. Inspect unfired shell for firing pin indent. If indent appears sufficient to fire round, load another proof round and repeat procedures 3,4,5 & 6.

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b. If gun fails to fire, wait one (1) minute before removing shell.
c. Place safe in "S" or "on" position, remove gun from proof jack and enter gun information and reject in computer.

8. After firing, open doors to proofing device and retrieve fired case.

9. Check fired case for:

a. Primer indent-must be sufficient to fire round.
b. Possible ruptures-must not be ruptured or swelled.
c. Rings or roughness-slight rings are permissable-use fingernail test to determine if serious enough to reject.

NOTE: If primer blows or is pierced complete sequence 10 and 11 (below) and then check receiver of gun for primer or the piece of the pierced primer. If primer can be found, pass gun. If primer or piece of primer can't be found, enter gun information and reject code in computer, place reject ticket in envelope and place the gun on truck.

10. Move Safety to "S" or "on" position before removing gun from proofing device.

11. Inspect chamber and magazine for live ammunition before removing gun from port.

a. Chamber must be empty.
b. Follower must be visible.

12. Remove gun from device and place on bench.

13. Stamp proof mark (REP), right rear side of Barrel ON ACCEPTABLE PRODUCTS ONLY.

a. Bolt action rifles only-stamp prick punch on the underside of the bolt handle, in addition to the proof mark on the Barrel.

14. If gun fails proof test - enter gun information and reject code into computer. Attach reject ticket to gun.

15. Place gun back on truck.

16. Repeat test on next and succeeding guns.

2. INTERPRETATION OF PROOF TEST

A. PASS GUN

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1. If there is no failure at proof.
   a. Gun must be free of defects. (Not broken, cracked, split, chipped, deformed or show stress marks)

2. If fired case is within visual specifications as outlined in Item 1-B9 (above)

3. If there are no serious visual defects found on wood or metal surfaces of the gun.

B. REJECT GUN

1. If gun fails to withstand proof round pressure.

2. If fired case fails to meet visual specifications.

3. If any serious visual defects are found before or after test.

3. SAFETY AFTER PROOF TEST

A. SAFETY

1. Move Safe to "S" or "ON" position before removing gun from shooting device.

2. Place the first gun proofed back onto the truck after complete load has been proofed.

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

1. Chamber must be empty.

2. Follower must be visible.

3. Repeat item B 1 and 2 (above) on all guns upon completion of proof test.

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

1. Take first (1st) gun from each side of the truck, after proof test, and carefully check gun for possible damage from the jack or port.
   a. If any damage is found, stop testing and have the cause of damage corrected.
   b. Resume testing only after correction has been made.

D. MOVE ENTIRE LOAD TO NEXT OPERATION

1. The Model 700 rejects will stay on the original truck when moved to the next operation (Test and Target).

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TITLE: Final Assy 700

Operation Procedure Notes Operation: 600

Description

SAFETY BEFORE TEST-All Plant rules, Gallery rules and Job Safety keypoints are bo be observed at all times.

1. GUNS TO BE PROOFED
   a. All guns are to be proofed 100% after final assembly and prior to function testing.
      1. Use special remote operated steel covered proofing device and approved booths only. (DO NOT PROOF RIFLES IN SHOTGUN PROOF BOOTHS)

2. PROOFING OBJECTIVE

   a. To test each guns ability to withstand the proof round pressure without damage to the gun or distortion of the proof round.

3. SAFETY

   a. Water tanks are to be inspected each shift before shooting is started and inspection sheet is to be signed. (Refer to General Gallery Safety Rules, Section K.)

   b. All assembled guns are to be stored with the action open and the safe in the "S" or "on" position.

   c. If proof round fails to fire when activated:
      1. Pull large knob on side of proofing device and hold (black handle).
      2. Pull firing button on side of proofing device (black button)
      3. If fails to fire second time, wait on (1) minute before opening steel doors to remove shell.

Operation Step Detail Operation: 605R

Step	Operation / Step Description
	Check previously rejected guns for proof stamp, prick punch on bolt handle and obstruction in barrel.

Operation Tool Detail Operation: 605R

Tool Number	Tooling Description

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Operation Procedure Notes Operation: 605R

Description

[redacted]

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Step Operation / Step Description

1. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

NOTE: The first rifle tested and targeted is to be left off of truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

A. Test/Target Description

1. Remove tickets from guns and place on top of truck.

2. Pick up gun from truck and inspect for:

   a. Live Ammo - Inspect chamber and Magazine-both must be empty.

   b. Caliber - To verify for shooter personal safety in selecting ammunition for test.

   c. Proof mark on Barrel - (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.

   d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt Handle.

   e. Visual Defects - Marring of wood or metal finishes.
   f. Normal Sight Alignment-as described below:
      1. Front and Rear Sight ramps must be central on barrel and straight with line of sight.
      2. Must conform to barrel - good fit - no excessive opening at side or ends, also must be screwed tight to barrel.
      3. Front and Rear Sights must be central on ramps - tight in dovetails, not twisted, bent or deformed.
      4. Mark on rear sight to coincide with fourth mark from rear of the rear sight ramp.
      5. Rear Sight Eyepiece must be positioned central to rear sight.

   If not within specifications for items a-f above, reject guns at this point.

3. With safe in "F" or "OFF" position-close Bolt crisply on empty chamber. Gun must be pointed in safe diretion at all times.

   a. Firing pin must not follow down as Bolt cams shut.

   b. Must not fire on closings.

4. With Saftey in "S" or "on" position and the action closed, raise the bolt.

   a. Bolt must raise or open without excessive force.

5. Close Bolt with safe in ""S" or "on" position - pull trigger firmly.

   a. Gun must not fire

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6. With finger off Trigger-move safe to "F" or "OFF" position.

7. Open and close Bolt full stroke to cock firing pin.

8. Move Safe to full rear "S" or "ON" position and then move half way to the "F" or "OFF" position with thumb.

9. If safety stops at half-way position-pull trigger.

   a. Gun must not fire.

   b. Safety must not move to full "OFF" position.

10. If safety stops in halfway position, move safe to "F" or "OFF" position after pulling trigger.

    a. Gun must not fire.

IMPORTANT-Perform Items 3-10 above, a total of three (3) times per gun.

11. With Action open, position gun in device and clamp.

12. For first gun of a new caliber with iron sights, position line-o-sighter on sights and adjust device to point gun on target paper.
    For first gun of a new caliber without iron sights remove the bolt and look through bore to line up device with paper.

13. Remove line-o-sighter.

14. Load Magazine to capacity: (see chart below)
    a. Magazine must accept total rounds specified.
    b. Cartridges must be retained by rails in receiver.

	CALIBER	AMMUNITION TYPE	MAG. CAP
1.	17 Rem.	25 gr. HP	5
2.	222 Rem.	50 gr. PSP	5
3.	22-250	55 gr. HPPL	4
4.	223 Rem	55 gr. PSP	5
5.	6mm Rem.	80 gr. PSP	4
6.	243 Win.	100 gr. PSPCL	4
7.	25-06	120 gr. PSPCL	4
8.	257 Roberts	117 gr. SPCL	4
9.	270 Win.	150 gr. SP-130 gr. BRP	4
10.	280 Rem.	165 gr. SPCL	4
11.	7mm-08 Rem.	140 gr. PSP	4
12.	7mm Mauser (7x57)	140 gr. PSP	4
13.	7mm Rem. Mag.	175 gr. PSPCL	3
14.	7mm Wby. Mag.	175 gr. PSPCL	3
15.	300 Savage	150 gr. PSPCL	4
16.	30-06	180 gr. SP-150 gr. PSP	4
17.	300 WBY. Mag.	220 gr. SP	3
18.	308	180 gr. SP-150 gr. PSP	4
19.	300 Win. Mag.	150 gr. PSPCL	3
20.	35 Whelen	250 gr. PSP	4

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Continued ...
Operation Step Detail Operation: 606
Step Operation / Step Description

21.	338 Win. Mag.	250 gr. PSP	3
22.	220 Swift	55 gr. PSP	5

15. Hold cartridges down in Magazine, start Bolt over Cartridge column and close Bolt on empty chamber.
    a. Bolt must close over full magazine with normal pressure.

16. Open Bolt full stroke to rear position.

17. Assemble Firing Pin Trip Pin in device.

18. Close guard.

19. Close Bolt to feed shell into chamber and lock to start test.
    a. Must feed single (1) shell with each operating stroke of Bolt.
    b. Must not double feed.
    c. Shells must not stem chamber or magazine. (Bind inside receiver or barrel.)
    d. Bolt must not override shell in magazine.
    e. Bolt must feed shell into chamber with normal pressure.
    f. If, using normal force, the Bolt will not close over a live round in the chamber, perform the following test:
       1. Insert the appropriate close hard plug into the chamber while the gun is held in the test device.

       2. Close and operate bolt:
          a. If bolt closes hard over the plug, reject the gun for Close Hard and record the malfunction in the computer and attach the slip to the gun.
          b. If bolt closes with normal pressure, do not reject the gun. This indicates oversize ammunition.

20. Fire gun by pushing (2) two buttons on device simultaneously.

21. For the 10% of standard guns and 100% of Police guns that are targeted, check each shot with spotting scope for gun "seating in" and position of shots on paper.
    a. Adjust device if shots off paper or group too close to edge.

22. Operate action full cycle to extract, eject, and feed each shot.
    a. Bolt should not pull out of receiver.
    b. Case or shell must be retained by extractor until the case is ejected from receiver.
    c. Case must be completely ejected from receiver, should not catch on receiver.
    d. One fired case from each gun must be visually inspected for firing pin indent and chamber marrs reflected on case.

23. Fire all rounds required for Test and Targeting.
    a. For the Test procedure, each gun is to have the first two (2) rounds fired and the remaining rounds cycled through but not fired.
    b. For the Target procedure, all accuracy specifications are

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based on a five shot group, therefore, those guns will typically require extra rounds to be loaded and shot singly.

24. Open guard

25. For the Targeted guns (10% std. & 100% Police) Place Line-o-sighter onto sights (if sights are present) and check point of Impact and group size.
    a. The average position of all shots fired in the group must be within the following specifications in relationship to the position of the crosshairs.

Elevation	Windage
2" High - 8" Low	9" Left - 9" Right

    b. Use spotting scope, for guns that do not have iron sights, to check group size.
    c. Maximum spread of any two holes must be within group size specifications listed below.

GROUP SIZE SPECIFICATIONS

A. Field Grade Rifles - (BDL,ADL,MTN RIFLE,CLASSIC,POLICE)

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER 3 SHOT	4 SHOT	5 SHOT
1. 17 Rem.	25 gr. HP	1.45	1.95	2.2
2. 222 Rem.	50 gr. PSP	1.45	1.95	2.2
3. 22-250	55 gr. HPPL	1.45	1.95	2.2
4. 223 Rem	55 gr. PSP	1.45	1.95	2.2
5. 6mm Rem.	80 gr. PSP	1.45	1.95	2.2
6. 243 Win.	100 gr. PSPCL	1.45	1.95	2.2
7. 25-06	120 gr. PSPCL	1.45	1.95	2.2
8. 257 Roberts	117 gr. SPCL	1.7	2.2	2.7
9. 270 Win.	150 gr. SP-130 gr. BRP	1.7	2.2	2.7
10. 280 Rem.	165 gr. SPCL	1.7	2.2	2.7
11. 7mm-08 Rem.	140 gr. PSP	1.7	2.2	2.7
12. 7mm Mauser (7x57)	140 gr. PSP	1.4	1.9	2.4
13. 7mm Rem. Mag.	175 gr. PSPCL	2.5	3.0	3.5
14. 7mm Wby. Mag.	175 gr. PSPCL	2.5	3.0	3.5
15. 300 Savage	150 gr. PSPCL	2.5	3.0	3.5
16. 30-06	180 gr. SP-150 gr. PSP	1.7	2.2	2.7
17. 300 WBY. Mag.	220 gr. SP	2.5	3.0	3.5
18. 308	180 gr. SP-150 gr. PSP	2.5	3.0	3.5
19. 300 Win. Mag.	150 gr. PSPCL	2.5	3.0	3.5
20. 35 Whelen	250 gr. PSP	2.5	3.0	3.5
21. 338 Win. Mag.	250 gr. PSP	2.5	3.0	3.5
22. 220 Swift	55 gr. PSP	1.45	1.95	2.2

B. All VARMINT:

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER
1. 222 Rem.	50 gr. PSP	1.5
2. 22-250	55 gr. HPPL	1.5

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Operation Step Detail Operation: 606
Step Operation / Step Description

3. 223 Rem	55 gr. PSP		1.5
4. 6mm Rem.	80 gr. PSP		1.5
5. 243 Win.	100 gr. PSPCL		1.5
6. 7mm-08 Rem.	140 gr. PSP		1.5
7. 308	180 gr. SP-150 gr. PSP		2.0

c. Sights must be capable of adjustment to 0"x 0".
d. Rear sight elevating slide may be adjusted to any position between the second line from the rear to the third line from the front of the ramp.
e. The eye piece may be adjusted crosswise on the elevating piece to any position as long as there is full width of the screw retaining shoulder visible.

26. Remove line-o-sights.

27. Unclamp and remove gun from device.

28. Inspect chamber and magazine for live ammunition.
a. Chamber must be empty.
b. Follower must be visible.

29. Pass all guns that meet specifications for:
a. Visual
b. Functional
c. Accuracy, Point of impact and group size
d. If iron sights are present, Within limits of position

30. Reject all guns that do not meet specifications:
a. Enter all malfunctions into the computer and place ticket on gun.
b. If a gun fails to meet the target group size specifications, reject that gun and target all remaining guns on that side of the truck. If another gun fails to meet group specifications, target all guns on next side or half truck load.

29. Place gun back on truck.

30. Repeat Test on next and succeeding gun.
a. Randomly select 10% (Std. Guns) and Target.
b. Target Police 100%

31. Replace gun tickets on Barrels of guns.

B. Test/Target Stamping-(Acceptable Product Only)

1. When all guns have been tested/targeted, move entire load to stamping bench.

2. Place stamp, right rear side of barrel, ahead of the Proof (REP) stamp.
a. Rejected guns are not to be stamped.

2. Saftey After Test

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A. Open Bolt

1. Move Bolt to open position before removing gun from accuracy device.

B. Inspect Chamber and Magazine for live ammunition.

1. Gun must be empty.

2. Follower must be visible.

NOTE: Perform "A" & "B" above on each individual gun immediately after shooting test. Repeat "B" for all guns on truck at completion of test.

C. Visual Inspect for marring by device or port.

1. Take first gun from each side of truck, after test, and check for any possible damage to gun from the test.

3. All guns are moved to Ammunition Inspection Area.

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Operation Tool Detail Operation: 606

Tool Number	Tooling Description

	CALIBER	CLOSE HARD PLUG
1.	17 Rem.	D-48349-A
2.	222 Rem.	D-48349-B
3.	22-250	D-48349-E
4.	223 Rem	D-48349-C
5.	6mm Rem.	D-48349-D
6.	243 Win.	D-48349-D
7.	25-06	D-48349-J
8.	257 Roberts	D-48349-L
9.	270 Win.	D-48349-J
10.	280 Rem.	D-48349-G
11.	7mm-08 Rem.	D-48349-H
12.	7mm Mauser (7x57)	D-48349-F
13.	7mm Rem. Mag.	D-46200-B
14.	7mm Wby. Mag.	C-48336-B
15.	300 Savage	D-48349-K
16.	30-06	D-48349-J
17.	300 WBY. Mag.	C-48336-A
18.	308	D-48349-H
19.	300 Win. Mag.	D-46200-A
20.	35 Whelen	D-48349-J
21.	338 Win. Mag.	D-46200-B

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Operation Procedure Notes Operation: 606

Description

Gallery Test-Procedure and Specifications

Safety before Test: All plant rules, gallery rules and job safety key points are to be observed at all times.

I. GUNS TESTED AND TARGETED

A. All guns (100%) are to be tested after proof.
B. 10% of each load of Std. Models, 100% of Police guns are to be targeted unless target rejects are found.
C. Record results of testing in computer as test and target operations are performed.

II. TEST AND TARGET OBJECTIVES

A. Function: To check the ability of each gun to satisfactorily load, feed, close, lock, fire, unlock, open, extract, eject and for proper operation of the Safety.
B. Accuracy: To check the ability of each gun to satisfactorily meet specifications for point of impact and/or group size.
C. Visual: To check the ability of each gun to satisfactorily meet appearance specifications for front and rear sights and general overall presentability.

III. SHOOTING DEVICE

A. Test in device provided for this model.
   1. Adjust and set device with master gun if the caliber and model to be shot is produced with iron sights.
B. Use Centerfire Targeting Range - 100 yds. (300 ft.)
   1. Use 1" by 1" grid type targeting paper.
C. Setting of Master Guns, use heavy grain bullets where two are specified.

Operation Step Detail Operation: 620

Step	Operation / Step Description
	Inspect for live ammunition Inspect rifle for live ammunition before leaving Gallery. Chamber must be empty and follower visible.

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TITLE: Final Assy 700

Operation Step Detail Operation: 625

Step	Operation / Step Description
	Print box end labels. 1) Log onto printer at start of shift. 2) Push gun truck to coder station. 3) Code guns on truck. 3a) Select gun. 3b) Type in serial number from Receiver. 3c) Type in index number from production tickets. 4) Tear off labels. 5) Place in proper gun pouches. 6) Push gun truck to holding area.

Operation Tool Detail Operation: 625

Tool Number	Tooling Description

Operation Step Detail Operation: 625A

Step	Operation / Step Description
	Print box end labels. 1) Log onto printer at start of shift. 2) Push gun truck to coder station. 3) Code guns on truck. 3a) Left gun. 3b) Type in serial number from Receiver. 3c) Type in index number from production tickets. 4) Tear off labels. 5) Place in proper gun pouches. 6) Push gun truck to holding area.

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Operation Step Detail Operation: 630

Step	Operation / Step Description
	Match label to gun and place label in plastic envelope. See Oper. 580 for Pt. #'s

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Operation Procedure Notes Operation: 640

Description

FINAL ASSEMBLY
OPER. NAME-FINAL INSPECTION
SEQUENCE OF INSPECTION POINTS (See Following)

1. SAFETY
2. STAMPS
3. SPECIFICATIONS
4. GUN GRADES
5. STOCK
6. METAL PARTS, FINISH
7. HEADING
8. SAFE
9. STAMP FINAL INSPECTION AND CODE MARKS

TO WAREHOUSE

Item:
1. SAFETY
Inspect chamber and Magazine NO LIVE AMMUNITION. Must see follower.

2. Stamps on Barrel
Proof (Rep) (Important, Proof, Test and Target Stamps on right side, rear.)

Magnaflux-Triangle with number in center on right side of Breech-Visible above stock.

3. Specifications
Gun matches gun tag.

Receiver Marking:
Remington Model and Serial No., on left side.
Model No. must be recognizable.

Barrel Marking:
Patent & Cal. on left side.
(Cal. per gun tag)

Bolt Marking: (Disassemble Bolt) Check Bolt Release, must be free. Check serial #-Must agree with Receiver #. Check for mars, finish, Brass in Bolt Head, Proof mark on undersize of Bolt Handle. Check for Extractor in position. Only Extractor claw should be visible.

4. Gun Grades:
Camo or Gray

5. Stock-Inspect for Handling Damage. Max allowance for Stock-Rec. Gap at Tang is .030". Trigger Guard & Floor Plate stock opening maybe excessive but must be uniform, not jagged. Inspect floor plate for mars, finish and proper function. Mountain Rifle barrel to be free floating with a minimum of .005 clearance. Trigger Guard Screws tight. Assemble correct Rear Swivel if specified on gun tag.

6. Front Sight Bead not jammed, Sights must be central. Slight mars per Inspection Stds. Crown good finish. Accept 1/16" light ring at bore. Uniform wall.

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7. Min. and Max heading plugs.
 1. Insert Min. plug in chamber, must close with no more than slight drag.
 2. Insert Inspection Max. plug in chamber, Bolt must stop or lock with noticable pressure.

Caliber		Min. Plug	Insp. Max Plug
1. 17 Rem.		B-38336	B-38113
2. 222 Rem.		B-81544	B-82320
3. 22-250		B-87465	B-87468
4. 223 Rem		B-86881	B-86883
5. 6mm Rem.		B-81268	B-82325
6. 243 Win.		B-81229-A	B-81229-C
7. 25-06		B-73438	B-82327
8. 257 Roberts		B-73286	B-82326
9. 270 Win.		B-73438	B-82327
10. 280 Rem.		B-81578	B-82329
11. 7mm-08 Rem.		B-81229-A	B-81229-C
12. 7mm Mauser (7x57)		B-44975-A	B-44975-C
13. 7mm Rem. Mag.		B-85241-A	B-85241-B
	(BELT)	B-83853-A	B-83853-C
14. 7mm Wby. Mag.		B-48583	B-48584
	(BELT)	B-83583-A	B-83853-C
15. 300 Savage		B-70556	B-82333
16. 30-06		B-73438	B-82327
17. 300 WBY. Mag.		B-48096	B-48097
	(BELT)	B-83583-A	B-83853-C
18. 308		B-81229-A	B-81229-C
19. 300 Win. Mag.		B-86567	B-86586
	(BELT)	B-83853-A	B-83853-C
20. 35 Whelen		B-73438	B-82327
21. 338 Win. Mag.		B-85241-A	B-85241-B
	(BELT)	B-83853-A	B-83853-C
22. 220 Swift		B-49143	B-49145

Remove Heading Plug

 3. With Action in fired position, lift Bolt while pressing foreward firmly, release handle, then close handle, Bolt must cock and remain cocked.

 4. Hold Bolt handle down hard, pull Trigger, Firing Pin must fall without drag or movement of Bolt Handle.

8. Action:
 A. Operate Bolt 3 times and fire, no bind, Bolt Handle raises and lowers easily.
 B. Open and close Bolt forcibly 3 times. Firing Pin must not follow down.

 C. Check for jar off by applying steady pressure on end of firing pin head with safety in "F" or "off" position. (use end of hammer handle).

9. Safe, Gun cocked:
 A. Clean sharp single detent.
 TRY THREE TIMES
 WITH SAFETY IN "S" OR "ON" POSITION, CAN'T FIRE WITH HEAVY TRIGGER PRESSURE. TRIGGER MUST RETRACT. PUSH SAFETY HALFWAY TO THE "F" OR "OFF" POSITION, PULL TRIGGER, MUST NOT FIRE. PUSH SAFETY TO "F" OR "OFF" POSITION.

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Operation Procedure Notes Operation: 640

Description

FIRING PIN MUST NOT FOLLOW DOWN, SAFETY MUST RETURN TO OFF POSTION UNDER TENSION.
USE DOWNWARD PRESSURE ON SAFETY.
Bolt handle must unlock with safety ON.
Safety should snap in detent in both "ON" and "OFF" position.

B. Check trigger pull-no creep (3 to 5 lbs. on M/700)

C. With bolt open, pull safety on, close bolt and lock down. Bolt must lock down without catching on safety. Bolt must open with safety on.

*D. Remove Bolt and insert Special Dial Gage into Receiver and measure Safe-ON, Sear Connector clearance. If clearance is less the .006, reject. Remove gage and reinsert Bolt.

10. Stamp Final Inspection and Code Marks on Left rear side of barrel, sign gun tag.

11. Stock Rejects only:
A. Place 3/4" yellow dot with identification stamp and nonconformity code, close to nonconformity on stock rejects.

*Special Dial Gage D-44581, use with 5/64 Balldriver Hex Tool Bondhus Cat. #10604, Series 106, or equivalent.

Operation Step Detail Operation: 660

Step	Operation / Step Description
	Assemble Front Sight Cover to Front Sight Ramp Insert Front Sight Cover into slots in Front Sight Ramp. Press until seated in Detents. Pointed ends forward.

Operation Tool Detail Operation: 660

Tool Number	Tooling Description
	Bench

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Operation Step Detail Operation: 667

Step	Operation / Step Description
	Pack Instruction folder, ten commandments, gunsmith list, and wire brush in envelope and seal. Polyethylene Bag 7"x 10"s .002 Dwg. #A-P-1238 Pt.#1238

Operation Step Detail Operation: 676

Step	Operation / Step Description
	Pack Rifle A. Oil-700 Solution-(10) parts Shell Solvent, wipe bore and metal parts with (1) part steel guard. ROD D-43447 TAG: 700 1. Select correct tag for Model. 2. Attach to Trigger Guard 3. Packaging Box Ass'y Pt.1411 Royal Self Seal Waxed Paper (6" x 6" .002) A-P-1232 1232 White Ethafoam Block (1 1/2" x 2 1/4" x 1" Tape (16" x 1/2' of 3M#898 A-P-1233 1233 Fil Tape A-P-1234 1234 B. Pack document bag. C. Pack authorized gunsmith folder. D. Pack & Seal Rifle. 1. Place swivel baggie into Bolt slot in Barrel insert. Clean, white cloth wipers Use Polyethylene bag Dwg. A_P_1230 Pt.#1239 (2 1/2" x 9" x .002)

Operation Step Detail Operation: 676C

Step	Operation / Step Description
	Pack hardware with gun. Use Polyethylene Bag (2 1/2" x 9 x .002) Dwg. A-P-1230 Part # 1239

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Operation Step Detail **Operation: 677C**

Step	Operation / Step Description
	Pack authorized gunsmith folder.

Operation Step Detail **Operation: 678C**

Step	Operation / Step Description
	Position Wax Paper around Barrel, Oil, place price tag on Trigger Guard and Pack rifle Oil-700 Solution-(10) parts Shell Solvent, wipe bore and metal parts with (1) part steel guard. ROD D-43447 TAG: 700 1. Select correct tag for model. 2. Attach to trigger guard. 3. Use Packaging Box Assy. Pt.#1411 Royal Self Seal Waxed Paper (6" x 6" x .002) A-P1232 1232 White Ethafoam Block (1 1/2" x 2 1/2" x 1") Tape (16" x 1/2" of 3M #898 A-P-1233 1233 Fil Tape A-P-1234 1234

Operation Step Detail **Operation: 690R**

Step	Operation / Step Description
	Unpack Gun

Operation Step Detail **Operation: 695R**

Step	Operation / Step Description
	Re-Pack Gun. To be used for guns taken from Warehouse for Re-work

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TITLE: Final Assy 700

Operation Step Detail Operation: 700R

Step	Operation / Step Description
	Repair Max. headers 1. Fit and head new Bolt. 2. Assemble Extractor and Ejector to Bolt. 3. Return to final assembler whose stamp appears on the barrel. a.Insert Firing Pin. b.Check protrusion. c.Check function of Extractor & Ejector by using appropriate number of dummies. 4. Send to proof and test.

Operation Step Detail Operation: 705R

Step	Operation / Step Description
	Recrown Barrel Target Rejects

Operation Tool Detail Operation: 705R

Tool Number	Tooling Description
	Recrown Barrel
B-87684	Hand Chamfer, Tool
B-51634	Pilot Bushing (See Tabulation for Cal.)
B-51633	Pilot

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Operation Step Detail Operation: 710R

Step	Operation / Step Description
	Make all necessary stock repairs (not performed on 100% of Product) Make all necessary stock repairs. 1. Rough area to be repaired with carbide burring tool. 2. Mix and apply the "Everglass" filler first. 3. Cure and rough sand repaired area. 4. Mix and apply in small portions the "Polyester" putty to fill the porosity. 5. Cure and sand to the stock contour. 6. Apply paint in large amounts with the air brush, smaller amounts with a cotton swab. a. Paint mixture 2 parts Paint, 1 part Acetone Dremel Moto Tool 1/8" Carbide Burr 1/4" Carbide Burr Air Brush "Mirror Glaxze" Release wax "Everglass" Fiberglass Reinforced Filler "Polyester Glazing Putty" "Creme Hardner" Paint supplied by Brown Precision Acetone

Operation Step Detail Operation: 715R

Step	Operation / Step Description
	Repair Target Rejects 1. For high shooters, change to next higher Front Sight. 2. For low shooters, change to next lower Front Sight. 3. For right or left shooters: a. Remove Front Sight, and Front Sight Ramp. b. Select appropriate Front Sight Ramp and assemble to Barrel. c. Reassemble Front Sight.

Operation Step Detail Operation: 716R

Step	Operation / Step Description
	Disassemble Target Rejects.

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Operation Step Detail Operation: 717R

Step	Operation / Step Description
	Reassemble Target Rejects

Operation Step Detail Operation: 718R

Step	Operation / Step Description
	Repair for loose Front Sights Tighten Sights if Possible. Replace if necessary.

Operation Step Detail Operation: 720R

Step	Operation / Step Description
	Reburnish Chamber-Extracts Hard Rejects. Reburnish Chamber

Operation Tool Detail Operation: 720R

Tool Number	Tooling Description
B-86064	Burnishing Tool

Operation Step Detail Operation: 740R

Step	Operation / Step Description
	Mark label when necessary.

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PROCESS RECORD—HEAT TREAT SPECIFICATION

MATERIAL AND SPECIFICATION

STD. PRACTICE No.

TEMPERATURE

MAXIMUM LOAD

TIME

QUENCH

REMARKS

INSPECT FOR

HEAT TREAT INSPECTION

STANDARD PRACTICE No.

HARDNESS LIMITS

APPEARANCE OF PARTS

OPERATION DESCRIPTION	DATES AND REASONS FOR REVISIONS
BLACK OXIDE	

APPROVAL AND DATES

GA. OR CAL.						
PART No.						
OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
OF STD. OF STD.						

PART NAME TRIGGER EQUIPMENT MODEL No. 600 OPER. 44

DEPT. No. 79 PAGE 1 OF 1

RD-8464

R2536006

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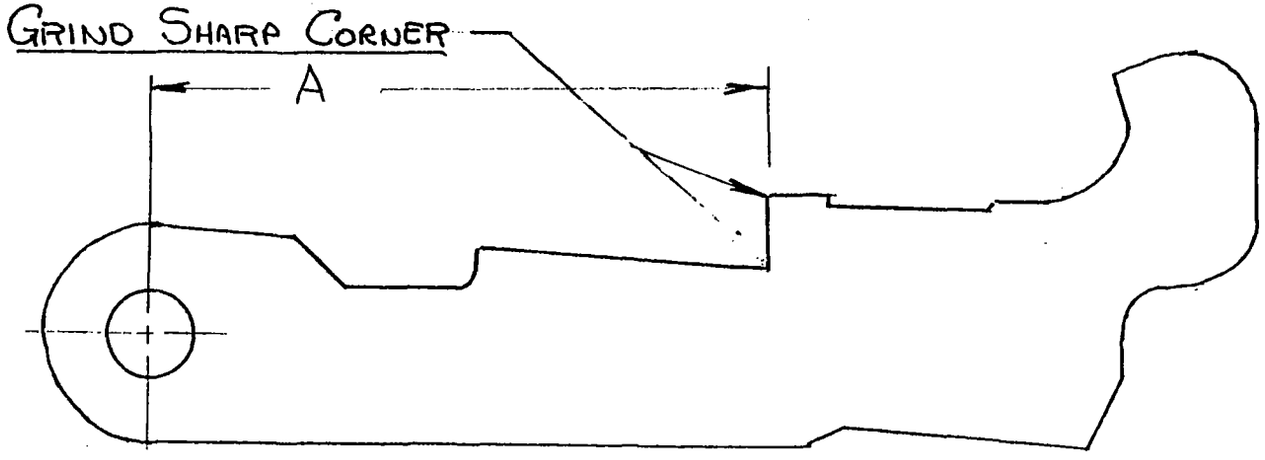
DATE	ID	REASONS FOR REVISIONS
10/61		New Job

DESCRIPTIVE INFORMATION



PART NAME Seat Safety Cam COOLANT SET UP TIME MODEL No. 700, 600 OPER. No. 62

TYPE MACH. HRS. DEPT. No. 67 PAGE 1 OF 1

MACHINE

Form R. D. 6466

R2536007

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DATES AND REASONS FOR REVISIONS 5/18/73 - Added oper. - CP - 272054
5/8/75 - Chg. S to T - chg. expiration dat - CP - 272054
10/.. Mfg permit 1)66

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	APPROVAL AND DATES					
SPEED	FEED							
		Grinding Fixture	B-41453					
		Norton Wheel (White Saucer) 6" x 7/16" x 1¼" #38A100 M8VBE	Std.					
		Staging Fixutre	D-89606					
		Comparator Chart	B-40X-CL-38					
		Gage (ID # 789) A= .855 .859						

OPERATION DESCRIPTION	PART NO.	15666
Grind Connector surface 600 & 700) (Expires ~~9/9/75~~)		

PART NAME Sear Safety Cam COOLANT SET UP TIME MODEL No. 600, 700 OPER. No. ~~59-T~~ 62
TYPE MACHINE DEPT. No. 75 PAGE 1 OF 1

RD-6461

R2536008

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Match label to gun and place label in plastic envelope	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 600 OPER. No. 306-1

TYPE MACHINE . HRS. DEPT. No. 55 PAGE 1 1

R2536009

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: New Operation MH

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION								
Match label to gun and place label in plastic envelope	OCC. No.							
	STD. HRS/C							
	STD. No.							
	EFF. DATE							
	PART No.							
	GA.							

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 OPER. No. 309-1

TYPE MACHINE M . HRS. DEPT. No. 55 PAGE 1 1

Form R. D. 6461

R2536010

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS New Operation AH

DESCRIPTIVE INFORMATION

Same as Operation # 310 plus the following:

1. Inspect Floor Plate for mars and finish.
2. Inspect Floor Plate fit to stock.
3. Try Floor Plate for proper function.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Inspection (BDL Regulars)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 (BDL Regulars) OPER. No. 310-1

TYPE N . HRS. DEPT. No. 55 PAGE 1 1

MACHINE

Form P. D. 6469

R2536011

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: New Operation

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Inspect (Wood Rejects Only)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME: Final Assembly COOLANT: SET UP TIME: MODEL No.: 700 & 600 OPER. No.: 311-J

TYPE: N . HRS.: DEPT. No.: 55 PAGE: 1 1

MACHINE

Form R. D. 6463

R2536012

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS New Operation

DESCRIPTIVE INFORMATION

Same as Operation #312 plus the following:

1. Inspect Floor Plate for mars and finish.
2. Inspect Floor Plate fit to stock.
3. Try Floor Plate for proper function.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION

Final Inspection
(BDL Magnums)

OCC. No.						
STD. HRS/C						
STD. No.						
EFF. DATE						
PART No.						
GA.						

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 700 (BDL Magnums) OPER. No. 312-1

TYPE M HRS. DEPT. No. 55 PAGE 1 1

MACHINE

Form R. D. 6461

R2536013

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS: New Operation

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION							
Final Inspect (Rejects from Final Inspect except wood)	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME: Final Assembly COOLANT: SET UP TIME: MODEL No.: 700 + 600 OPER. No.: 313-J

TYPE: M HRS: DEPT. No.: 55 PAGE: 1 of 1

MACHINE

Form R. D. 6465

R2536014