

1-30-08

To: Jim Doolittle
From: Glen Sietsema

Re: Black XMP Trigger and Trigger Housing.

Jim,

Per the request form Iron Brigade Armory below are my recommendations to make a black M/700 XMP Trigger Housing and Trigger.

Trigger Housing: PN 306380

The trigger housing complete is plated with 0.0002 – 0.0004” high phosphorous electroless nickel plating.

To make this part black it can be:

- Plated with a flash (0.000005 – 0.00015”) of cosmetic Black Nickel or Black Cr.
- Coated with a black PVD

Recommended Supplier:

Plating:

National Metal Finishing - Springfield, MA 01104

PVD:

Richter Precision - East Petersburg, PA 17520

IonBond – Greensboro, NC 27409

Vergason Technology - Van Etten, NY 14889

Trigger: PN 300688

The trigger is plated with 0.0002 – 0.0004” High Phosphorus Electroless Nickel Plate Under 0.00005 – 0.00015” medium Phosphorus Electroless Nickel co deposited with PTFE (Teflon).

To make the trigger black a finished trigger will need:

- The ENi with Teflon will need to be stripped,
- A new base coat of 0.0002- 0.0003” of High Phos. ENi re plated to bring the holes to sized,
- A top coat of PVD or Black Ni or Black Cr added as described above.

Alternately Remington could provide a trigger ready for plate to Iron Brigade and they could do the finishing from a bright part, skipping the strip sequence.

The same suppliers could do the coating of the trigger as are listed above.

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