

Process Header

Process Header

Document ID: Bbl Brkt XP100	Remington Arms Company
Part Name: Barrel Bracket XP100	
Product Line: C/F Rifle	Effective Date: 07-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 05-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
05-Oct-1992	Retype Entire Process from 290120 - Replaces Old Paper Copy	GLC 293087

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15475	1	Barrel Bracket (Steel) - XP100
15487	1	Blank

Document Number: Bbl Brkt XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1

OF 7

Process Routing

Dept	Oper	Operation Description	Part Numbers
8158	2	Drill and Buttmill (2) Holes	15475
8158	3	Flat File to Remove Burr (One Side Only)	15475
8551	5	Neutral Salt Harden, Oil Quench, Wash and Dry	15475
8551	10	Nitre Draw, Water Quench, Wash and Dry	15475
9257	11	Inspect for Rockwell Hardness	15475
8502	14	Wash Brfore Grind	15475
8502	15	Grind Both Sides	15475
8579	20	Supersheen Tumble	15475
8579	25	Wax	15475
		To MRP Crib# 06	15475

Operation Step Detail

Operation: 2

Step

Operation / Step Description

Drill and Buttmill (2) Holes

Document Number: Bbl Brkt XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 2

OF 7

Operation Tool Detail

Operation: 2

Tool Number	Tooling Description
Std	(2) Spindle Drill Press
A-47401	Step Drill
D-85139	Drill Jig
	Gages:
***** SKETCH NEEDED*****	
B-80268-D	Plug Gage - .1315/.1275 - Drilled Hole Dia.
B-80118-G	Plug Gage - .190/.186 - C'Bore Dia. - .105/.095 - C'Bore Depth
C-85141	Pinning Gage - .821/.817 - Distance of Centerline of Large Hole to Centerline of (2) Small Holes - .3765/.3735 - Distance of Centerline of Large Hole to Centerline of Each of the (2) Small Holes - .753/.747 - Distance from Centerline to Centerline of the (2) Small Holes

Operation Procedure Notes

Operation: 2

Description

NOTE: Locate Parts with "X" Stamp Facing Up (To Orient C'Bore with Locating Surface)

Operation Step Detail

Operation: 3

Step

Operation / Step Description

Flat File to Remove Burr (One Side Only)

Operation Tool Detail

Operation: 3

Tool Number	Tooling Description
Std	File

Document Number: Bbl Brkt XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 3

OF 7

Operation Step Detail

Operation: 5

Step

Operation / Step Description

Neutral Salt Harden, Oil Quench, Wash and Dry

Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

Std

Neutral Salt Furnace

Operation Procedure Notes

Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 8630 - 4130

TEMPERATURE: 1550 Degrees F

MAXIMUM LOAD:

TIME: 20 Min. @ Temp.

QUENCH: Oil

REMARKS: Wash and Dry

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 10

Step

Operation / Step Description

Nitro Draw, Water Quench, Wash and Dry

Document Number: Bbl Brkt XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 4

OF 7

Operation Tool Detail

Operation: 10

Tool Number

Tooling Description

Std

Nitre Furnace

Operation Procedure Notes

Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 8630 - 4130

TEMPERATURE: 900 - 950 Degrees F

MAXIMUM LOAD:

TIME: 30 Min. @ Temp

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 202

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 11

Step

Operation / Step Description

Inspect for Rockwell Hardness

Operation Tool Detail

Operation: 11

Tool Number

Tooling Description

Std

Rockwell Hardness Tester

Document Number: Bbl Brkt XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 5

OF 7

Operation Procedure Notes

Operation: 11

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 8630 - 8640

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS: RC 33-38

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 14

Step

Operation / Step Description

Wash Brfore Grind

Operation Step Detail

Operation: 15

Step

Operation / Step Description

Grind Both Sides

Operation Tool Detail

Operation: 15

Tool Number

Tooling Description

X-7137

Mics. - .187/.185

Document Number: Bbl Brkt XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 6

OF 7