

TITLE: Rear Receiver Screw XP100

Process Header

Process Header

Document ID: Rear Rec Scr XP100	Remington Arms Company
Part Name: Rear Receiver Screw XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 30-Oct-1992

Process Revision Reasons

Date: Reason For Revision: Eng Log #:

30-Oct-1992	Retype Entire Process from 283475 - Replaces Old Paper Process - Revise Heat Treat Process Changes Op.#5	GLC 293278
	Description - Add 97759	

Process Approval List

Approved By: Badge #: Date: Designation:

Jacksora			
----------	--	--	--

Process General Notes

Notes:

Process Material

Part Number Qty Description

15450	1	Rear Receiver Screw - XP100
16503	1	Blank
97759	1	Rear Receiver Screw - XP100
97762	1	Blank

Document Number: Rear Rec Scr XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1

OF 5

TITLE: Rear Receiver Screw XP100

Process Routing

Opt	Oper	Operation Description	Part Numbers
8551	5	Degrease, Carbo-Nitride (MicroCarb) Harden Oil Quench, Degrease	15450, 97759
8551	10	Nitre Black, Water Quench, Wash, Dry and Oil	15450, 97759
9257	15	Inspect for Oil and Color	15450, 97759
		To MRP Crib #29	15450, 97759

Operation Step Detail

Operation: 5

Step

Operation / Step Description

	Degrease, Carbo-Nitride (MicroCarb) Harden Oil Quench, Degrease
--	---

Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

Std	Micro-Carb Furnace
Std	Basket - 12"x20"x2" Deep

Document Number: Rear Rec Scr XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 2

OF 5

TITLE: Rear Receiver Screw XP100

Operation Procedure Notes Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: .75 Carbon Potetial - 1600 Degrees F

MAXIMUM LOAD: 3000 Pcs - 2 Baskets 1500 Pcs per Basket

TIME: 1.5 Hrs. @ Temp.

QUENCH: Oil

REMARKS: Degreased

INSPECT FOR: File Hard to Insure Proper Quench

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail Operation: 10

Step Operation / Step Description

Nitre Black, Water Quench, Wash, Dry and Oil

Operation Tool Detail Operation: 10

Tool Number Tooling Description

Std Nitre Black Bath

Std Basket - 12"x20"x3" Deep with Handle

Document Number: Rear Rec Scr XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 3

OF 5

TITLE: Rear Receiver Screw XP100

Operation Procedure Notes Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: 925 - 950 Degrees F

MAXIMUM LOAD: 3000 Pcs per Basket

TIME: 15 - 20 Min. @ Temp.

QUENCH: Water

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free from Salts Well Oiled

Operation Step Detail Operation: 15

Step Operation / Step Description

Inspect for Oil and Color

Document Number: Rear Rec Scr XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 4

OF 5

TITLE: Rear Receiver Screw XP100

Operation Procedure Notes Operation: 15

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free from Salts, Well Oiled

Document Number: Rear Rec Scr XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 5 OF 5