

TITLE: SEAR SAFETY CAM

Process Header

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Document ID: SEAR SAFETY CAM XP100	Remington Arms Company
Part Name: SEAR SAFETY CAM	
Product Line: C/F RIFLE	Effective Date: 09-NOV-1992-09:00:00
Engineering Group: RIFLE	Origination Date: 31-OCT-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
17-OCT-1992	RETYPE PROCESS FROM 290373 - REPLACES OLD PAPER COPY	ERF 293175
06-Nov-1992	Chg. Description Op.#59	GLC 293323

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JACKSORA			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
14269	1	SEAR SAFETY CAM - XP100
91919	1	POWDER METAL BLANK

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1 OF 9

TITLE: SEAR SAFETY CAM

Process Routing

pt	Oper	Operation Description	Part Numbers
8575	35	MILL SPRING SEAT	14269
8575	40	DEBURR	14269
8575	42	MILL RADIUS	14269
8575	43	DEBURR	14269
8551	45	MICROCARB HARDEN	14269
8551	50	LINDBERG DRAW	14269
9257	55	INSPECT FOR ROCKWELL HARDNESS	14269
9279	56	SAND TUMBLE	14269
8574	58	SURFACE GRIND CONNECTOR SURFACE AND LABEL PAN WITH RED TAG MARKED "READY FOR PLATE"	14269
	59	TO MRP CRIB 11 - TO BE SENT TO VENDOR FOR CHROME PLATE - INSPECT UPON RETURN	14269
8567	61	INSPECT FOR FLATNESS	14269
8567	62	GRIND CONECTOR SURFACE (DIP IN STEELGARD)	14269
8567	63	DEMAGNETIZE	14269
		TO MRP CRIB #14	

Operation Step Detail

Operation: 35

Step

Operation / Step Description

MILL SPRING SEAT

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 2

OF 9

TITLE: SEAR SAFETY CAM

Operation Tool Detail

Operation: 35

Tool Number	Tooling Description
B-85029	WISE JAWS
STD.	3" VISE
STD.	ARBOR 1" DIA.
A-85361	FORM CUTTER
C-85031	DIAL BASE GAGE "A" = .235/.225
A-85032	TEMPLATE "B" = .945/.935

Operation Procedure Notes

Operation: 35

Description

*****SKETCH NEEDED*****

Operation Step Detail

Operation: 40

Step

Operation / Step Description

BURR

Operation Tool Detail

Operation: 40

Tool Number	Tooling Description
STD.	FILE

Operation Step Detail

Operation: 42

Step

Operation / Step Description

MILL RADIUS

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 3

OF 9

TITLE: SEAR SAFETY CAM

Operation Tool Detail

Operation: 42

Tool Number

Tooling Description

B-45453

WISE JAWS

A-45462

ARBOR CUTTER

C-XP100-CL-35

COMPARATOR SCREEN

Operation Step Detail

Operation: 43

Step

Operation / Step Description

BURR

Operation Tool Detail

Operation: 43

Tool Number

Tooling Description

STD.

FILE

Operation Step Detail

Operation: 45

Step

Operation / Step Description

MICROCARE HARDEN

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 4

OF 9

TITLE: SEAR SAFETY CAM

Operation Procedure Notes Operation: 45

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: HD2020

TEMPERATURE: 1650 deg. 3 1/2 HRS. .90C POTENTIAL

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail Operation: 50

Step Operation / Step Description

LINDBERG DRAW

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 5

OF 9

TITLE: SEAR SAFETY CAM

Operation Procedure Notes Operation: 50

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: HD2020
 TEMPERATURE: 350 deg. F
 MAXIMUM LOAD:
 TIME:
 QUENCH:
 REMARKS:

INSPECT FOR:
 HEAT TREAT INSPECTION:
 STANDARD PRACTICE NO:
 HARDNESS LIMITS:
 APPEARANCE OF PARTS:

Operation Step Detail Operation: 55

Step Operation / Step Description

INSPECT FOR ROCKWELL HARDNESS

Operation Tool Detail Operation: 55

Tool Number Tooling Description

STD. ROCKWELL HARDNESS TESTER

Document Number: SEAR SAFETY CAM XP100 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 6 OF 9

TITLE: SEAR SAFETY CAM

Operation Procedure Notes Operation: 55

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: HD2020

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: ROCKWELL HARDNESS

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS: FILE HARD RC50 MIN

APPEARANCE OF PARTS:

Operation Step Detail Operation: 56

Step Operation / Step Description

SAND TUMBLE

Operation Tool Detail Operation: 56

Tool Number Tooling Description

STD. BAIRD BARREL
(TIME 1 hr.)
(PCS: 1000)

Document Number: SEAR SAFETY CAM XP100 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 7 OF 9

TITLE: SEAR SAFETY CAM

Operation Step Detail

Operation: 58

Step

Operation / Step Description

SURFACE GRIND CONNECTOR SURFACE AND LABEL PAN WITH RED TAG MARKED-
(READY FOR PLATE)

Operation Tool Detail

Operation: 58

Tool Number

Tooling Description

STD. GRINDING WHEEL

STD. 1" MICROMETERS
(.346 / .341)

Operation Procedure Notes

Operation: 58

Description

*****SKETCH NEEDED*****

Operation Step Detail

Operation: 61

Step

Operation / Step Description

INSPECT FOR FLATNESS 100%

Operation Tool Detail

Operation: 61

Tool Number

Tooling Description

C-44522 WIDTH GAGE - PASS SEAR SAFETY CAM THRU 100%

Operation Procedure Notes

Operation: 61

Description

REJECT ALL COMPONENTS WHICH DO NOT PASS GAGE

Operation Step Detail

Operation: 62

Step

Operation / Step Description

GRIND CONNECTOR SURFACE (DIP IN STEELGARD)

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 8

OF 9

TITLE: SEAR SAFETY CAM

Operation Tool Detail

Operation: 62

Tool Number

Tooling Description

B-41453

GRINDING FIXTURE

STD.

NORTON WHEEL (WHITE SAUCER)

6" X 7/16" X 1 1/4"

38A100 M8VBE

Operation Procedure Notes

Operation: 62

Description

*****SKETCH NEEDED*****

NOTE: USE HORIZONTAL DRESSER TO GRIND AT 6 deg. ANGLE

USE A MIXTURE OF STEELGARD & STODDARD SOLVENT (1:10 RATIO)

DIP A LOAD OF SEAR SAFETY CAMS AFTER GRINDING CONNECTOR SURFACE TO PRVENT RUSTING.

DRAIN THE EXCESS OIL

Operation Step Detail

Operation: 63

Step

Operation / Step Description

DEMAGNETIZE

Document Number: SEAR SAFETY CAM XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 9

OF 9