Part: [illegible]

Part No.: 17945

Dwg. No.:

Returned COMPLETE FEB 5 1947

MATERIAL PROCUREMENT - RAW MATERIAL Date: 2/5/47

Detailed Description

Pieces Required Per Assembly:

Material Specification No. : [illegible]

Material :

Size : [illegible]

Condition : Cold

Weight Per 100 : Calculated: 3.1 Measured:

Additional Uses of Material :

Uses of Part :

Identification of Material : Routing Ticket to be marked Mat. Spec. #1411E.

Remarks:

Edge [illegible]

TPR-19

PART: SAFETY CAM | PART No. 17945

Returned OBSOLETE FEB 18 1947

MATERIAL PROCUREMENT - RAW MATERIAL Date: 2/5/47

REV. No.	DATE

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI C-1022 or substitute 1029

Size : *.064" 3/32" +.002 -.002 x 5/8" +.008 -.008 x 10 to 12' lengths

Condition : Cold Finished Strip

Temper : Half Hard

Edge : #3

Finish : #2

Weight Per 100 : Calculated 3.1 Measured

Additional Uses of Material :

Uses of Part : M/721 Safety Cam

Identification of Material : Routing Ticket to be marked Mat. Spec. # 101B

Remarks: * Finished [illegible] to 1½" [illegible] to the [illegible] of .060" - .052"

COMPILED BY: R.H.Grace 2/5/47 | APPROVAL & DATE: [illegible] 2/5/47

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

H. H. SULLIVAN, INC.

PART: SAFETY CAM	PART No. 17945

MATERIAL PROCUREMENT - RAW MATERIAL Date 2/5/47

REV. No.	DATE
1	2/18/47

OBSOLETE 2-7-47

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI C-1022 or substitute 1029

Size : .084" $^{+.002}_{-.002}$* X 5/8" $^{+.008}_{-.008}$ X 10 to 12' lengths

Condition : Cold Finished Strip

Temper : Half Hard

Edge : #3

Finish : #2

Weight Per 100 : Calculated 3.1 Measured

Additional Uses of Material :

Uses of Part : M/721 Safety Cam

Identification of Material : Routing Ticket to be marked Mat. Spec. No. 101B

Remarks:

*To facilitate procurement material up to 1/8" thickness can be used but will have to be ground to .086" - .082" before machining.

COMPILED BY: R.H.Grace 2/5/47	APPROVAL & DATE: WM

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

H. H. SULLIVAN, INC.

OBSOLETE

1. The OBSOLETE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced with a colored tissue dividing shee

2. Each operation may have several OBSOLETE SHEETS. Where this i true they have been put in ord according to the date when the were OBSOLETED, the latest dat being on top.

3. All sketch sheets placed thei

Part: Sear

Model:
Part No.:
Dwg. No.:

OBSOLETE
Returned
FEB 5 1947

MATERIAL PROCUREMENT - BAR MATERIAL Date: 2/5/47

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. :

Material :

Size : 3½" [illegible] x 7/16" ±.005 x [illegible] 12' Lengths

Condition : Cold [illegible]

Weight Per 100 : Calculated: 2.1 Measured:

Additional Uses of Material :

Uses of Part :

Identification of Material : Routing Ticket to be marked Mat. Spec. # 1115

Remarks:

TPR-19

PART: SEAR | PART No. 17946

OBSOLETE

MATERIAL PROCUREMENT - RAW MATERIAL Date: 2/5/47

REV. No.	DATE

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI-C-1022 or substitute C-1029

Size : .064 3/32" +.002 -.002 x 7/16" +.008 -.008 x 10 to 12 ' lengths

Condition : Cold Finished Strip

Temper : Half Hard

Edge : #3

Finish : #2

Weight Per 100 : Calculated 2.1 Measured

Additional Uses of Material :

Uses of Part : M/721 Sear

Identification of Material : Routing Ticket to be marked Mat. Spec. # 101B

Remarks:

* To facilitate [illegible] thickness can be [illegible] T.C.C. [illegible]

COMPILED BY: R.H.Grace 2/5/47 | APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

TPR-19

PART: SEAR | PART No. 17946

MATERIAL PROCUREMENT - RAW MATERIAL Date 2/5/47

OBSOLETE

REV. No.	DATE
1	2/18/47

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI-C-1022 or substitute C-1029

Size : .084 $^{+.002*}_{-.002}$ X 7/16" $^{+.008}_{-.008}$ X 10 to 12' lengths

Condition : Cold Finished Strip

Temper : Half Hard

Edge : #3

Finish : #2

Weight per 100 : Calculated 2.1 Measured _____

Additional Uses of Material :

Uses of Part : M/721 Sear

Identification of Material : Routing Ticket to be marked Mat. Spec. No. 101B

Remarks:

*To facilitate procurement material up to 1/8" thickness can be used but will have to be ground to .086" - .082" before machining.

COMPILED BY: R.H.Grace 2/5/47 | APPROVAL & DATE:

REMINGTON ARMS COMPANY. INC.. ILION. N. Y.

H. H. SULLIVAN, INC.

17255-Y OBSOLETE Bolt Final Assembly

1. The OBSOLETE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced wi a colored tissue dividing she
2. Each operation may have sever OBSOLETE SHEETS. Where this true they have been put in or according to the date when th were OBSOLETED, the latest da being on top.
3. All sketch sheets preceed the operation sheets and are sep-

[redacted]

TPR-19

PART: FINAL BOLT ASSEMBLY	PART No. 17255-Y

PROCESS RECORD-ASSEMBLY

STEP	TOOLS & GAGES TYPE	NO.	REMARKS
1) Insert ejector Sprg. 17019 and ejector 17017	Fixture	C51730	
2) Insert ejector pin 17018	Hammer Fixture	C51730	
3) Insert extractor 17020-W-V			Claw must be opposite ejector hole.
4) Screw Firing Pin Assembly 17223-YW-YV into Bolt Body Assembly 17005-W-V and remove "U" spacer-B-52037 & measure Firing Pin Protrusion	Flush Pin Gage 0.075-0.045	B-52089	

Recycled 7-11

COMPILED BY:	APPROVAL & DATE:

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

PART No. 17255-Y

PROCESS RECORD-ASSEMBLY

STEP	TOOLS & GAGES TYPE	NO.	REMARKS
1) Insert ejector Sprg. 17019 and ejector 17017	Fixture	C51730	
2) Insert ejector pin 17018	[redacted] Fixture	C51730	
3) Insert extractor 17020-W-V			Claw must be opposite ejector hole.
4) Screw Firing Pin Assembly 17223-YW-YV into Bolt Body Assembly 17005-W-V and remove "U" spacer-B-52037 & measure Firing Pin Protrusion	Flush Pin Gage 0.075-0.045	B-52089	

Relapped 7-11

OBSOLETE

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. BIO

REVISED JUL 15 1949

PART: Bolt Final Assembly	PART No. 17255Y

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
7-25-46	Changed name from Final Bolt Assembly to Bolt Final Assembly

OBSOLETE

Retyped 7-27

COMPILED BY:	APPROVAL & DATE:

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

IPR-17

PART: BOLT FINAL ASSEMBLY	PART No. 17255Y

REGISTER OF ALL PROCESS RECORD REVISIONS

OBSOLETE

JAN 27 19[illegible]

DATE	DESCRIPTION OF CHANGE
1-25-46	Changed name from Final Bolt Assembly to Bolt Final Assembly

COMPILED BY:	APPROVAL & DATE: MWH 8/20/46

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

TPR-1

PROCESS RECORD

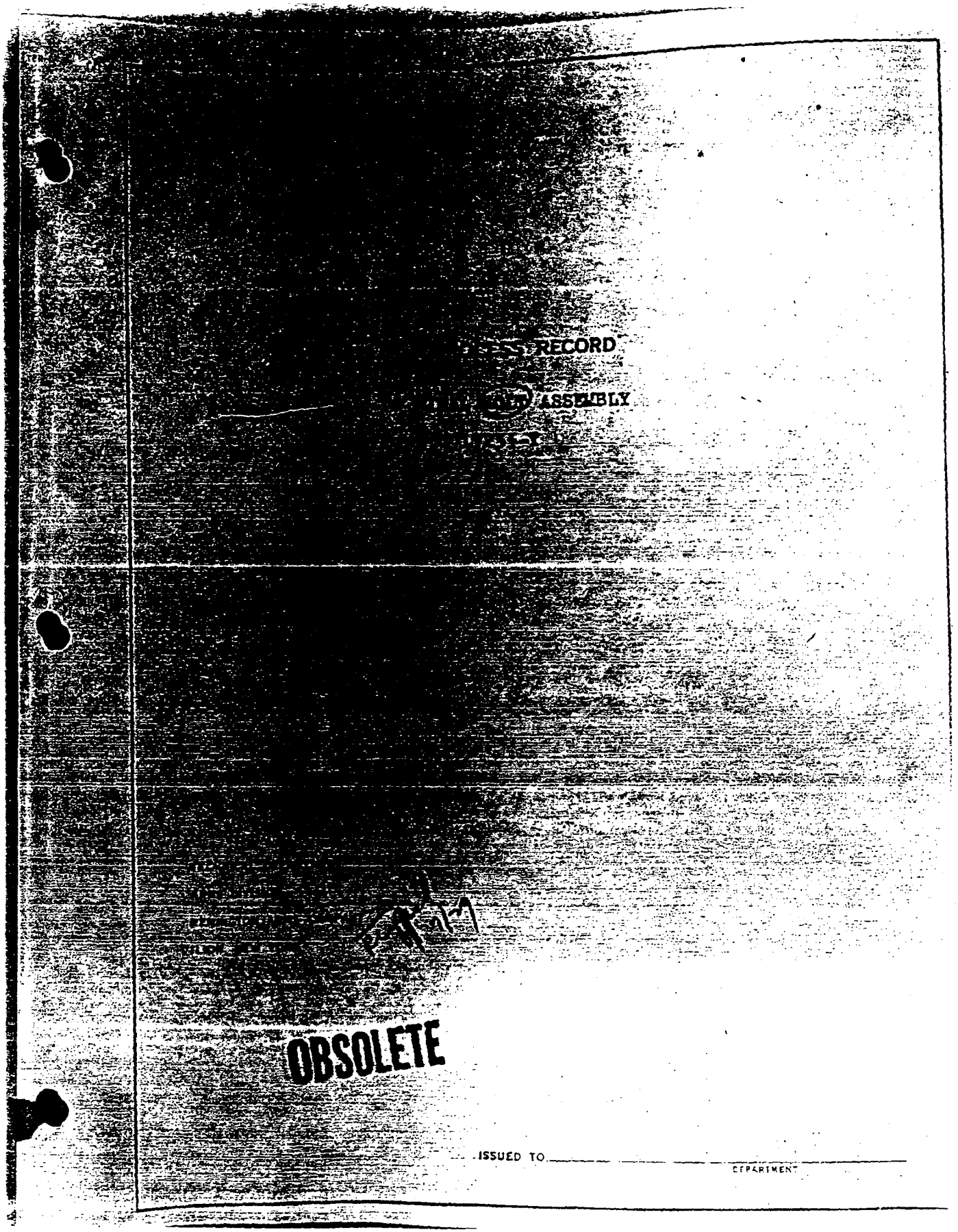
FINAL BOLT ASSEMBLY

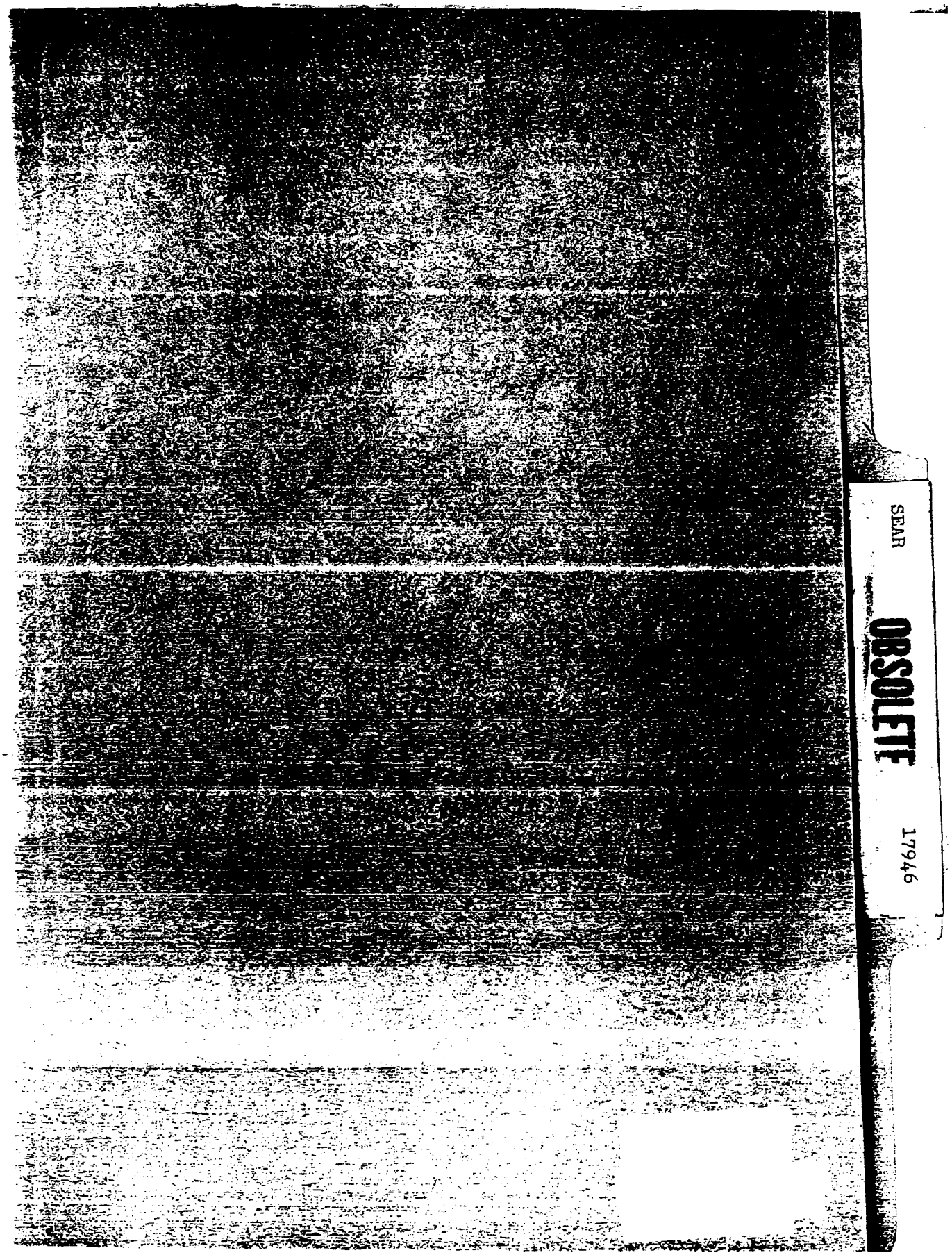
17255-Y

ISSUED BY:
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

OBSOLETE

ISSUED TO: _____
DEPARTMENT


RECORD
ASSEMBLY
OBSOLETE
ISSUED TO
DEPARTMENT



TPR-12

Obsolete
Revised 12-30-63

PART: 4444147	PART No.
OPERATION:	OPER. No.:

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
		Def. Pins used on oper 20 for typing		

SKETCH

COMPILED BY:	APPROVAL & DATE:

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

TPR-14

Obsolete 4/4/47 Revised 1/16/47

PART: ~~Striker~~ Firing Pin Rear Lug 17946 Firing Pin Rear 17945 and Cam Pin 17955 | PART No. ~~17043~~

OPERATION: High Temperature Cyanide Harden, Oil Quench, Wash, Dry and Oil for Storage | OPER. No.: ~~15~~ 29

HEAT TREAT Spec. No. 2387

EQUIPMENT: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep

DETAILED DESCRIPTION

MATERIAL SPECIFICATION No.:

MATERIAL: : C-1019

TEMPERATURE: 1575/1600°F.

CONTAINER: Basket - 7-1/2" dia. x 6" deep

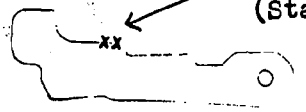
MAXIMUM LOAD: 400 pieces = approximately 2" depth in basket

TIME: 20 minutes at temperature

QUENCH: Oil

STANDARD PRACTICE: #198

REMARKS: Maximum Load-Wash 400 pieces



HEAT TREATMENT INSPECTION Op. No.: 17

Operation: Inspect for Rockwell Hardness

Standard Practice : 164 except Superficial Rockwell Machine, Plane Anvil

Hardness Limits : R_{15N} 86/92

Appearance of Part : Steel grey color, clean, free of salt, well oiled for storage. Next Op. No. Part Stores

COMPILED BY: J. F. Bowling 1/16/47 | APPROVAL & DATE: 1/16/47

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

TPR-9

PART: Obsolete 4/4/47 Revised to 1 Hole

PART No. 17246

OPERATION: Finish Barr

OPER. No.: 20

PROCESS RECORD

EQUIPMENT:

SPEED: Low Safety Cam ope 22 for 6 pcs

FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.

SKETCH

COMPILED BY:

APPROVAL & DATE:

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

PART: 14/14 Lever

PART No. 17776

OPERATION: Grind Firing Pin - Hd surface

OPER. No.: 18

Rework

PROCESS RECORD

EQUIPMENT: #2 B+S Surface Grinder

SPEED:

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
"X" Dial Lead Dogs	Std C-53239	Fixture	C-53245

SKETCH

Dec reamer stock + operation on safety cam - 9° 20

COMPILED BY:

APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

TPR-9

Obsolete 4/4/47 Sear
Revised Feb

PART:	PART No. 17946
OPERATION: Grind Trigger Connector surface	OPER. No.: 16

PROCESS RECORD

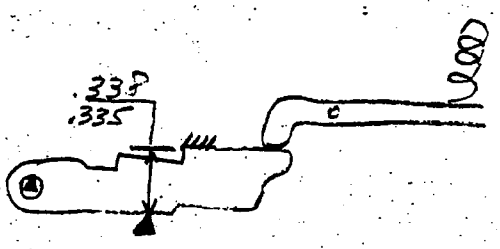
EQUIPMENT: #2 B+S Surface Grinder

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS. JIGS & FIXTURES	
TYPE	No.	TYPE	No.
"K" Vibrel Dial Gage	Std C-53239	Fixture	B-53245

SKETCH



COMPILED BY: APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

PART: Upper	PART No. 17946
OPERATION: C'Sink to Remove Burr	OPER. No.: 12

PROCESS RECORD

EQUIPMENT: #1 Leland Gifford Drill Press

SPEED: 1800 FEED: Hand

MAX. PROD. PER HOUR: COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Drill - 3/16" ? 90° Pt. - ~~B-90144W~~	~~B-90144W~~ B-90144W	Held in hand to hover both sides Slight C'Sink is desirable	

SKETCH

COMPILED BY: [illegible] APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

TPR-1

Broke 4/9/41 Lear
received at Ilion
4/11/41

PART:	PART No. 17946
OPERATION: Ream Pin Hole	OPER. No.: 10

PROCESS RECORD

EQUIPMENT: Leland Gifford Drill Press

SPEED: 600 FEED: Hand

MAX. PROD. PER HOUR: COOLANT: Emcool or Soluble oil

TOOLS & GAUGES		TOOL HOLDERS. JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Reamer	B-90794	Jig	B-53234
Plug Gage .1267-.1259	B-[illegible]		

SKETCH

COMPILED BY: APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

TPR-12

Obsolete Revised 4/4/47 Hwb.

PART: SEAR

PART No 1B-17946

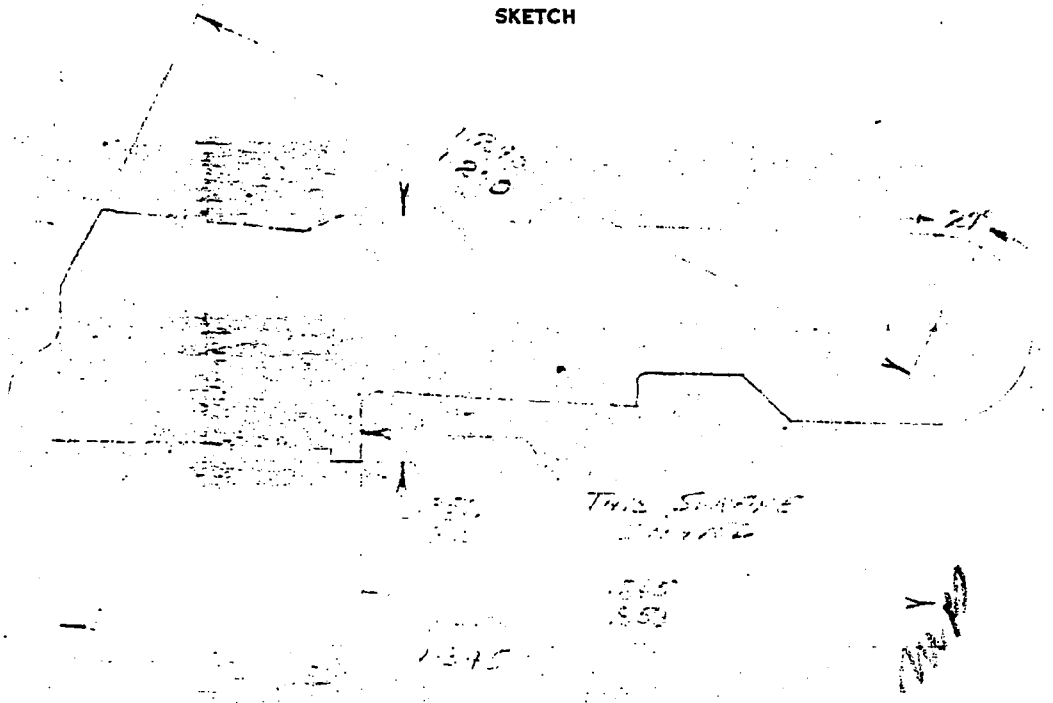
OPERATION: PURCHASED PART INSPECTION

OPER. No.: 6

PROCESS RECORD — INSPECTION

GAUGES		USE	AOQL	LIMITS	
TYPE	No.			MAX	MIN.
J & L Comparator					
Compar. Fixt.	C-53230	Check Dim. as shown below	7%		
~~Compar. Stage~~					
Compar. Screen	C-53232				
Plug Gage ~~.120~~ .120-.123	B-60106-N	Check Pierced Hole	7%	.123	.120

SKETCH



COMPILED BY J.F. Bowling 2/21/47

APPROVAL & DATE

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

H. H. SULLIVAN, INC.

Obsolete 1/14/47 Rev'd N.M.

PART: Rear	PART No. 17946
OPERATION: Grind Stock to Thickness (Temp)	OPER. No.: 4

PROCESS RECORD

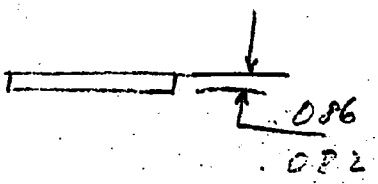
EQUIPMENT: 12" X 48" MATTISON SURFACE GRINDER

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT: Cimcool or Sol. Oil

TOOLS & GAUGES		TOOL HOLDERS. JIGS & FIXTURES	
TYPE	No.	TYPE	No.
ADJ. SNAP GA. R.U. .086-.082	B-80138-W		

SKETCH



COMPILED BY: Bowling APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

TPR-26

PART: SEAR | PART No. 1B-17946

MATERIAL PROCUREMENT — SEMI-FINISHED COMPONENT

REV. No.	DATE
1	3/10/47

OBSOLETE APR 3 '47
REVI

REMINGTON PLANNING

Pieces Required Per Assembly: 1

Uses of Part : M/721 & 722

VENDOR

Material : AISI C-1022 or Substitutes *1
[redacted], 1020, 1025, [redacted], C-1019
Packing slip to show material used for each shipment of parts.

Heat Treatment : None

Final Appearance : Commercial Stamping, Sheared Edge

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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 on the Process Record Inspection Page.

Remarks:

COMPILED BY: J.F. Bowling | APPROVAL & DATE:
DATE: 2/20/47

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

H. H. SULLIVAN, INC.

TPR-10

PART: SEAR	PART NO. 17946

MATERIAL PROCUREMENT - RAW MATERIAL — Date: 2/5/47

OBSOLETE REVISED APR 3 1947

REV. No.	DATE
1	2/18/47
2	2/20/47
3	3/10/47

Detailed Description

Pieces Required Per Assembly: 1

Material Specification : 101B

Material : AISI-C-1022 or substitutes ~~C-1008~~, C-1020, C-1025, ~~A-3003~~, C-1019 *3

Size : .084 $^{+.002}_{-.002}$ * X 1-3/4" $^{+.008}_{-.008}$ X 10 to 12' lengths.

Condition : Cold Finished Strip

Temper : Half Hard

Edge : #3

Finishe : #2

Weight Per 100 : Calculated 2.1 Measured

Additional Uses of Material :

Uses of Part : M/721 Sear

Identification of Material : Routing Ticket to be marked Mat. Spec. No. 101B

Remarks:

1. This material is for shipment to stamping vendor

*2. To facilitate procurement material up to 1/8" thickness can be used but will have to have operations 2 & 4 performed before shipment to vendor.

COMPILED BY: R.H.Grace 2/5/47	APPROVAL & DATE

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

Lear

PART No. 17996

SEQUENCE OF OPERATIONS

Peters Hdle.

OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp)	
2	Cut to 9' Length (Temp)	
4	Grind to Thickness (Temp)	
	Ship Stock to Vendor	
6	Purchased Part Inspection	
8	Mask	
10	Reams Pin Hole	
12	Drill Hole & Remove Burr	
14	Mask	
16	Grind Trigger Connector Surface	
18	Grind F.P. Hd. Surfaces	
20	Finish Burr	
22	Heat Treatment (Cyanide)	
24	" " Inspection	
26	Inspect	
	Transfer to Tool Crib	

COMPILED BY: Brothers

APPROVAL & DATE:

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

SULLIVAN, INC.

FPR-2 REV

OBSOLETE REVISED APR 23 1947

PART: --SEAR | PART No. 17946

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp.)	
2	Cut to 4' Length (Temp.)	
4	Grind to Thickness (Temp.)	
	Ship Stock to Vendor	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'Sink. Hole to Remove Burrs	
14	Wash	
16	Grind Trigger Connector Surface	
18	Grind F. P. Hd. Surface	
20	Finish Burr	
22	Heat Treatment (Cyanide)	
24	" " Inspection	
26	Inspect	
	Transfer to Part Stores	

COMPILED BY: J. F. Bowling | APPROVAL & DATE: 7/15

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

H. H. SULLIVAN, INC.

OBSOLETE

PART No. 17946

DEPT.

...NUDE HARDEN — OIL QUENCH

...HARDNESS

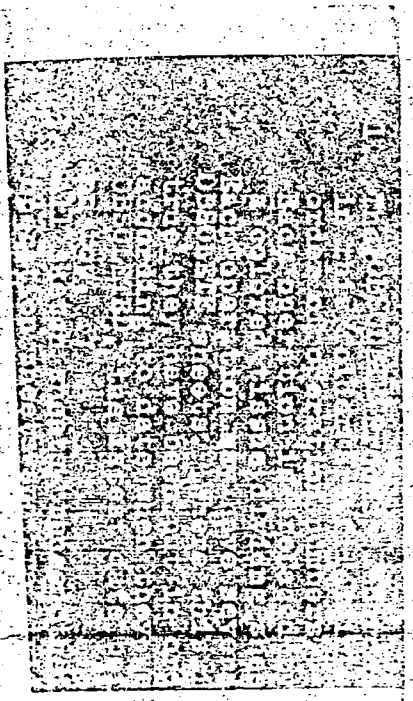
...NCH, AIR COOL, WASH & DRY, OIL FOR STORA...

...HARDNESS, COLOR & OIL

...TORES:

APPROVAL & DATE:

...INGTON ARMS COMPANY, INC., ILION, N. Y.



OBSOLETE
DEC 11 1963

PROCESS RECORD

SEAR

PART NO. [illegible]

(PURCHASE PART)

(TEMPORARY)

ISSUED TO:
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

ISSUED TO _____ DEPARTMENT

OBSOLETE

PROCESS RECORD

SEAR

PART NO. 1702-5

ISSUED BY
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

ISSUED TO: _____ DEPARTMENT

OBSOLETE

PROCESS RECORD

SEAR BLANK

PART NO. N758

(PURCHASE PART)

ISSUED BY

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO _____ DEPARTMENT _____

TPR-1

OBSOLETE

PROCESS RECORD

SEAR

PART NO. 17045

NO. 1

ISSUED BY:
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

ISSUED TO: _____
DEPARTMENT

TPR-2 REV

PART [redacted] PART No. 17045

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	OBSOLETE JAN 1 1947	
1	Material Procurement	
2	Cut to Length	
3	Mill Top and Bottom & Burr	
4	Remove Cutter Mismatch (Temporary)	
5	Grind to Thickness (Temporary)	
6	Tumble	
7	Spot, Drill & Ream Pin Hole	
8	Burr Hole	
8a	Harden (Case)	
8b	Inspect Hardness	
9	Grind Trigger Connector Surface	
11	Grind Safety Surface	
13	Harden (Case)	
14	Inspect Hardness	
	TO PART STORES	

COMPILED BY: J. G. Bowling 11/29/46 | APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

ER-2 REV

PART NAME: SEAR

PART NO. 17045

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	Material Procurement	
1	OBSOLETE Cut to Length	
2	Rough Cut Profile	
5	Grind to Thickness (Temporary)	
3	Mill Top and Bottom & Burr	
4	Remove Cutter Mismatch (Temporary)	
6	Tumble to remove Burrs	
7	Spot, Drill & Ream Pin Hole	
8	C'Sink to Remove Burrs	
9	Grind Trigger Connector Surface	
11	Grind Safety Surface	
12	Finish Burr Sides, Trigger Connector Surface and Safety Surface	
13	Inspect	
15	Harden (Case)	
17	Inspect Hardness	
	TO PART STORES	

obsolete

COMPILED BY: J. F. Bowling 1/9/47

APPROVAL & DATE: 1/8/47

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

H. H. SULLIVAN, INC.

SEQUENCE OF OPERATIONS

	OPERATION	DEPT.
	Material Procurement	
	Forging	
	Mill Top & Bottom	
	Rough & Finish Thickness	
	Spot, Drill & Ream Pin Hole	
	Rough Mill Outer Contour Surface	
	Rough Mill Body Surface	
	Inspect	
	Broach (Case)	
	Inspect	
	Heat Treat	

FINAL TECHNICAL PROCESS RECORD
DATE JAN 4 1947

COMPILED BY: Bob Ling 11/29/46 | APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

SEAR [illegible] PART No. 1705

SEQUENCE OF OPERATIONS

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1		Material Procurement	
2	1	Cut-to length Purchase Inspection of Sear Blank	
3	3	Mill Top & Bottom	
4	5	Grind to Thickness	
5	7	Spot, Drill & Ream Pin Hole	
6	9	Grind Trigger Connector Surface	
7	11	Grind Safety Surface	
8	13	Inspect	
9	15	Harden (Case)	
10	17	Inspect	
11		TO PART STORES	

COMPILED BY: J. F. Bowling 11/29/46 | APPROVAL & DATE:

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

PART: SEAR (TEMPORARY) | PART No. 17045

REGISTER OF ALL PROCESS RECORD REVISIONS

OBSOLETE DEC 11 1946

	DESCRIPTION OF CHANGE
9-24-46	Add temporary procurement page & process for precision cast Sear.

COMPILED BY: R. W. Selwood 9/30/46 | APPROVAL & DATE:

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

TFR-17

PART: SEAR (TEMPORARY)

PART No. 17045

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
9-24-46	Part No. 17045 of Sear Blank Material Procurement (raw material for Sear) changed to Part No. 17758. See Le. 9/17/46 in obsolete file for reference.
	add temporary procurement page & prices for precision cast sear.

COMPILED BY: R.W.Selwood 9/30/46

APPROVAL & DATE: W.H.

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

TPR-17

PART: [illegible] BLANK

PART No. [illegible]

Retained
OBSOLETE
10/16

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE

COMPILED BY: R.W.Selwood 9/30/46

APPROVAL & DATE:

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

OBSOLETE

PART Firer

PART NO. 1-7095

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE

COMPILED BY:

APPROVAL & DATE:

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

TPR-19

PART No. 17045

...RAW MATERIAL Date: 5/23/46

REV. NO.	DATE
1	11/7/46
2	11/18/46

...ed Description

...C-1022 or substitute AISI C-1118
or AISI C-1019

...+.000" x 9/16" +.000" x 12'
-.003 -.003 lengths

Condition: Cold Rolled Flat Bar Stock

Weight Per 100: Calculated: 5.6 lbs. Measured:

...tional Uses of Material:

Uses of Part: M/721 - All Calibers
M/722 - " "

Identification of Material: Routing Ticket to be marked Mat. Spec. #101-K.

Remarks:

COMPILED BY: B. C. Andrews

APPROVAL & DATE: ...R. N. Grace 11/14/46

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

H. H. SULLIVAN, INC.

DON'T SAY IT—WRITE IT

DATE Bench Rest

TO

FROM Dear Material

Ref: Materials

Specification AISI C-1019

PART: SEAR

PART No. 17025

OBSOLETE 1-21

MATERIAL PROCUREMENT - RAW MATERIAL

REV. NO.	DATE

DETAILED DESCRIPTION

Pieces Required Per Assembly: (1) One

Material Specification :

Material : AISI C-1019 to 1022

Size : 11/64 x 9/16 Bar - Stock Lengths Approx. 12'

Condition : Cold Drawn

Weight Per 100 : Calculated 4.5 Measured ____
One year supply 25,000 guns = 1120#

Additional Uses of Material :

Uses of Part : 721 All Calibers
722 All Calibers

Identification of Material : Routing Ticket to be marked Mat. Spec. No. ____

Remarks:

Approved as obsolete
Gee
11/16/46

COMPILED BY: T.V. Withington 11-7-46 APPROVAL & DATE:

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

H. SULLIVAN, INC.

PART NO. 21702

MATERIAL PROCUREMENT - RAW MATERIAL

OBSOLETE

REV. NO.	DATE

DETAILED DESCRIPTION

Pieces Required Per Assembly: (1) One

Material Specification :

Material : AISI C-1019 to 1022

Size : 11/64 x 9/16 Bar - Stock Lengths Approx. 12'

Condition : Cold Drawn

Weight Per 100 : Calculated 4.5 Measured _____
One year supply 25,000 guns = 1120#

Additional Uses of Material :

Uses of Part : 721 All Calibers
722 All Calibers

Identification of Material : Routing Ticket to be marked Mat. Spec. No. _____

Remarks:

COMPILED BY: T. V. Withington 11-7-46 | APPROVAL & DATE:

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

H. SULLIVAN, INC.

CTPR-19

PART: SEARIBLANK (PURCHASE READY FOR DRILLING) (RAW MATERIAL FOR SEAR - 17025) (TEMPORARY) | PART No. 17758

MATERIAL PROCUREMENT - FINISHED COMPONENT 8/30/46

Revised OBSOLETE 1/1/

REV. NO.	DATE

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor:

Material : Haynes Stellite #410 Stainless Steel

Heat Treatment : None (will be heat treated at Remington)

Final Appearance

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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 following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection

Gage No.	Type	Use	AOQL
	Visual	Defects	5%
B-80031M	Adj. Snap	Check Thickness	5%
	Radius Gage	Radius on Rear End	5%

Part to have a workmen-like sand blasted finish with no visible parting lines, and no burrs at cut off point. Parts to be clean, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).

COMPILED BY: B.C. Andrews | APPROVAL & DATE: [illegible] 8/30/46

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

H. H. SULLIVAN, INC.

PART [illegible] Blank (Purchase) ready for Drilling)
[illegible] Material for Sears 1045) (Temporary)
PART No. [illegible]

OBSOLETE

MATERIAL PROCUREMENT - FINISHED COMPONENT Date: 8/30/46

REV. No.	DATE

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor

Material : Haynes Stellite #410 Stainless Steel

Heat Treatment : None

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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 following gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Inspection:

Gage No.	Type	Use	% AOQL
	Visual	Defects	5%
B-80031M	Adj. Snap	Check Thickness	5%
	Radius Gage	Radius on Rear End	5%

COMPILED BY: B. C. Andrews | APPROVAL & DATE: mfs RH Grace 8/30/46

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

H. H. SULLIVAN, INC.

TPR-19

PART SEAR BLANK (PURCHASE READY FOR DRILLING)
(SEAR MATERIAL FOR SEAR - 17045) (TEMPORARY)

PART No. 17758

OBSOLETE DEC 11 1946

MATERIAL PROCUREMENT - FINISHED COMPONENT 8/30/46

REV. No.	DATE

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor

Material : Haynes Stellite #410 Stainless Steel

Heat Treatment : None (Will be heat treated at Remington)

Final Appearance : Parts to have a workman-like sand blasted finish with no visible parting line, and no burrs at cutoff point. Parts to be clean, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on staistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AOQL
	Visual	Defects	5%
B-80031M	Adj. Snap Gage	Check Thickness	5%
	Radius Gage	Radius on Rear End	5%

COMPILED BY: B. C. Andrews

APPROVAL & DATE: MWL 12/2/46 AHGrace 12/5/46.

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

TPR-19

PART: Sear (Purchase ready for Assembly) | PART No. 17045

Date: 5-23-46

OBSOLETE

MATERIAL PROCUREMENT — FINISHED COMPONENT

REV. No.	DATE

Detail Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers
M/722 - All Calibers

Vendor:

Material : Powdered Metal Products Corp. Alloy #Z-10 Powdered Iron (Hardened)

Heat Treatment : Harden and Temper

Hardness : Rockwell C-40-45.

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing :

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the "Average Outgoing Quality Limit" listed.

Inspection:

Gage No.	Type	Use	AOQL
1.		Hardness	5%
2.	Visual	Defects	5%
3. B-80015-M	Adj. Snap	Mat'l. Thickness	5%
4. B-80002-S	Plug	Hole Dia.	5%
5.	Comparator	Contour	5%
D-50325	Fixture		
B-50156	Stage		
B-50352	Master		
C-50353	Screen		
6. Standard Finish Blocks	Visual	Surface Finish	7%

COMPILED BY: B.D.Andrews

APPROVAL & DATE: M Hunt 5/27/46

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

TPR-10

(Purchase ready for Assembly) PART No. 17045

Furnished Component

OBSOLETE MATERIAL PROCUREMENT #807 (Replaces #807)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : Powdered Metal Products Corp. Alloy #Z-10, Powdered Iron (Hardened).

Surface Finish : ~~63 microinch or finer surface required as indicated in sketch. All other areas as molded or as satisfactory.~~

Heat Treatment : Harden and Temper.

Hardness : Rockwell C40-45

Packaging : Purchase Order Number and quantity by pieces to be shown on each container, the gross weight of which 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. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the "Average Outgoing Quality Limit" listed.

INSPECTION:

	GAGE No.	TYPE	USE	AOQL
1.				
2.			HARDNESS	3%
3.	B-80013-M	VISUAL ADJ. SNAP.	DEFECTS	3
4.	B-80002-S	PLUG	[illegible]	5
5.		COMPARATOR	[illegible]	3
	D-50337	FIXTURE		5
	B-50157	STRAIGHT		
	B-50332	MASTER		
	G-50333	SCREEN		
	Screen B-50333			

~~Received 3/25/46 [illegible]~~

COMPILED BY: B. C. Andrews | APPROVAL & DATE: R.H. Brace 3/18/46

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

Part [illegible] (Purchase ready for Assembly) | PART No. 17045

MATERIAL PROCUREMENT #869 (Replaces #849);

OBSOLETE

Detailed Description

Remington Planning

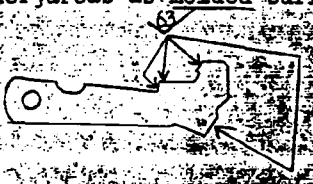
Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : Powdered Metal Products Corp. Alloy #Z-10.
Powdered Iron (Hardened).

Surface Finish : 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory



Heat Treatment : Harden and Temper

Hardness : Rockwell C40-45.

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the "Average Outgoing Quality Limit" listed.

Inspection Type or Gage	AOQL %
1. Hardness	3
2. Surface Finish will be checked against Standard Finished manufactured by Baird Associates, Cambridge, Mass.	3
3. Visual inspect for Defects	3
4. Gage B-80013M	5
5. Gage B-80002S	3
6. Comparator —	5
Fixture D-50325	
*Stage B-50156	
*Master B-50332	
Screen C-50333	

*Revised 3/25/46 RWR.

COMPILED BY: B. C. Andrews | APPROVAL & DATE: R.H. Grace 3/15/46

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

TPR-19

PART No. 17045

PROCUREMENT #849 (Replaces #643)

Description

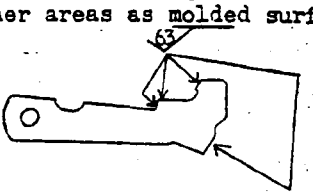
Preliminary

Pieces Required For Assembly: 1
Use of Part: M/721 - All Calibers; M/722 - All Calibers

Vendor:

Material: Powdered Metal Products Corp. Alloy #Z-10. Powdered Iron (Hardened).

Surface Finish: 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory



Heat Treatment: Harden and Temper

Hardness: Rockwell C40-45.

Packaging: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the "Average Outgoing Quality Limit" listed.

Inspection Type or Gage	AOQL %
1. Hardness	3
2. Surface Finish will be checked against Standard Finished manufactured by Baird Associates, Cambridge, Mass.	3
3. Visual inspect for Defects	3
4. Gage B-80013M	5
5. Gage B-80002S	3
6. Comparator —	5
Fixture D-50325	
Stage B-50156	
Master B-50332	
Screen C-50333	

*Revised 3/26/46

COMPILED BY: B. C. Andrews

APPROVAL & DATE: W. J. Lee 3/18/46

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

TPR-18

(Bronze Ready for Assembly) PART NO. 17045

OBSOLETE

849 643

MATERIAL PROCUREMENT [illegible] (Replaces [illegible])

Detailed Description

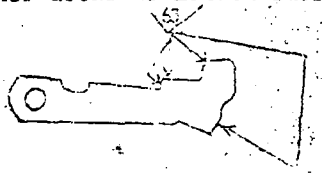
Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material : Powdered Metal Products Corp. Alloy # Z-10. Powdered Iron (Hardened).

Surface Finish : 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory.



Heat Treatment* : Harden and Temper

Hardness* : Rockwell "C" 40/45.

Packaging : ~~Ship in containers of 5,000 to 6,000 pieces.~~ Inspection will be based on Statistical Sampling accepted by Ilion Quality Control Department which is in accordance with the following

Acceptance Testing:* A random sample of 145 pieces will be selected from each container for inspection. If the allowable number of defects shown in the table below is not exceeded, the lot will be accepted.

	Inspection Type or Gage	Allowable Defects in Sample (Pieces)	AOQL %
1.	Hardness	7	3
2.	Surface Finish (visual check)	7	3 1/2
3.	Visual Check for Defects	15	5
4.	Gage B-8001M	15	5
5.	Gage B-8002-B	7	3
6.	Comparator Finish D-50325 Edge D-50156	15	5

~~(1) Visual check~~ against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent.
Master D-50332
Screen C-50353

*Changed ~~2/8/46~~ 3/14/46

COMPILED BY B. C. Andrews | APPROVAL & DATE

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

Bar (Purchase ready for Assembly) | PART NO. 17045

OBSOLETE

MATERIAL PROCUREMENT #643* (Replaces #366)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material* : Powdered Metal Products Corp. Alloy # Z-10. Powdered Iron (Hardened).

Surface Finish* : 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory.

Heat Treatment* : Harden and Temper

Hardness* : Rockwell "C" 40/45.

2/13/46

Packaging : Ship in containers of 5,000 to 8,000 pieces.

Acceptance Testing:*

A random sample of 145 pieces will be selected from each container for inspection. If the allowable number of defects shown in the table below is not exceeded, the lot will be accepted.

	Inspection Type or Gage	Allowable Defects in Sample (Pieces)	AOQL %
1.	Hardness	7	3
2.	Surface Finish(1)	7	3
3.	Visual	18	7
4.	Gage B-80013M	15	5
5.	Gage B-8002-S	7	3
6.	Comparator	15	5

(1) Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent.

*Changed 2/8/46

COMPILED BY B. C. Andrews | APPROVAL & DATE

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

TPR 18

PART Sear (Purchase ready for Assembly) | PART NO. 17045

OBSOLETE

MATERIAL PROCUREMENT #643* (Replaces #366) obsolete

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material* : Powdered Metal Products Corp. Alloy # Z-10
Powdered Iron (Hardened)

Surface Finish* : 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory.

Heat Treatment* : Harden and Temper

Hardness* : Rockwell "C" 40/45

Packaging : Ship in containers of 5,000 to 8,000 pieces.

Acceptance Testing:*

A random sample of 145 pieces will be selected from each container for inspection. If the allowable number of defects shown in the table below is not exceeded, the lot will be accepted.

	Inspection Type or Gage	Allowable Defects in Sample (Pieces)	AOQL %
1.	Hardness	7	3
2.	Surface Finish(1)	7	3
3.	Visual	18	7
4.	Gage B-8001-M	15	5
5.	Gage B-8002-S	7	3
6.	Comparator	15	5

(1) Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent.

*Changed 2/8/46

COMPILED BY B. C. Andrews | APPROVAL & DATE R.H. Grace 2/10/46

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

TPR - 18

Bear (Purchase ready for Assembly) | PART NO. 17045-1

OBSOLETE

MATERIAL PROCUREMENT #366

Detailed Description

Remington Planning

Pieces Required Per Assembly : 1
Uses of Part : M/721 - All Calibers; M/722 - All Cabliers.

Vendor

Material : AISI C-1020 or C-1022

Surface Finish : Flat Surface - Cold Finished Surface (Commercial) Cross Section - All shear marks to be removed from areas indicated in sketch. 63 microinch finish. Other areas as sheared surface satisfactory.

Heat Treatment : Case Harden

Case Depth : .005 to .008"

Hardness : Superficial Rockwell 30N*

Final Color : Parts to be bright, free of rust, oiled for rust protection with light (SAE-20 or equiv.) oil.

Packaging : Ship in containers of 5,000 to 8,000 pieces.

Acceptance Gages:

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each shipment of parts.

Hardness* -

Finish - Visual check against Standard Finishes manufactured by Baird Assoc., Cambridge, Mass. or equiv. will be used.

Gaging -

*To be determined after initial lot is received.

COMPILED BY B. C. Andrews | APPROVAL & DATE R. H. Grace 11/15/45

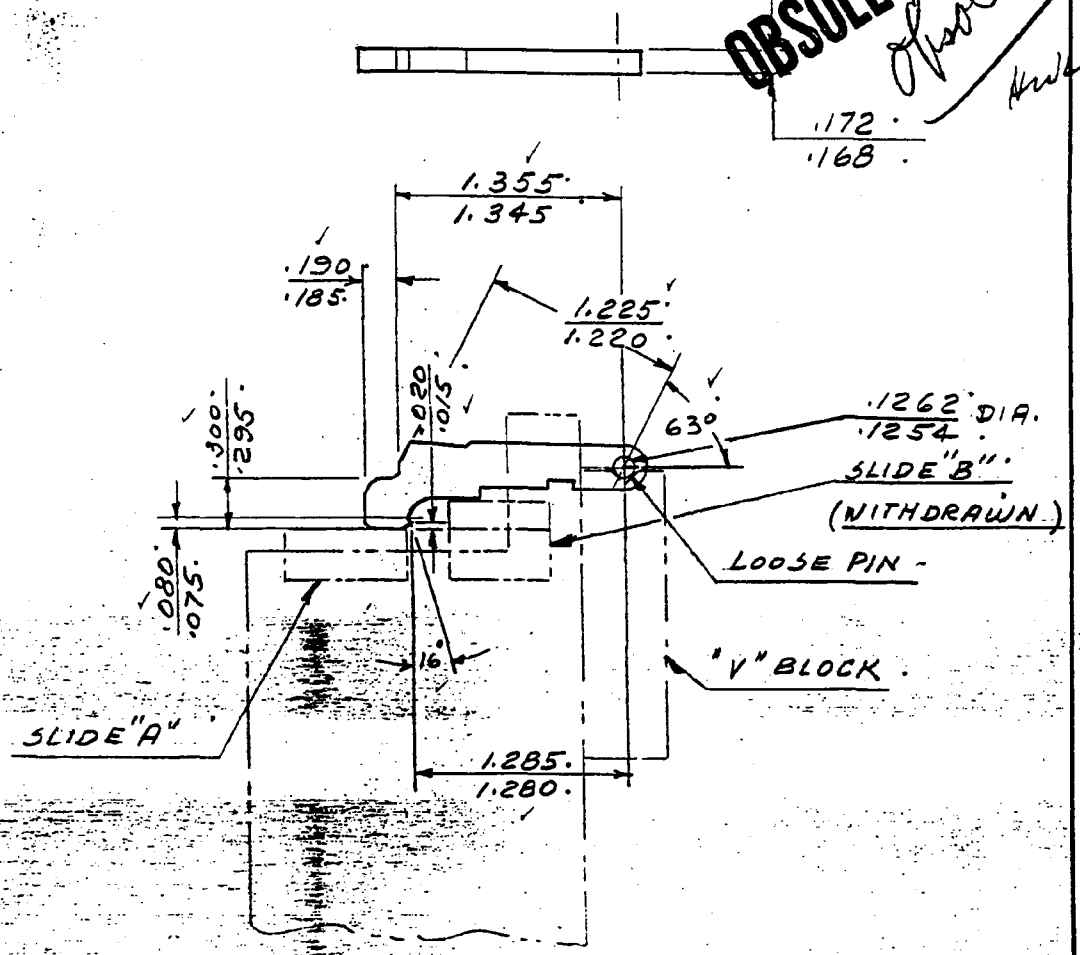
REMINGTON ARMS COMPANY, INC., ILION, N. Y.

TPR-7

PART: [redacted]SEAR	PART No. 17045
OPERATION: FINAL	OPER. No.: 1

PROCESS RECORD — ILLUSTRATION SKETCH

OBSOLETE 8/2 Obsolete



SUPERSEDED
BY SKETCH OF 7-31-46.

Superseded by new sketch 7-31-46 fc

COMPILED BY: ES&M	APPROVAL & DATE:

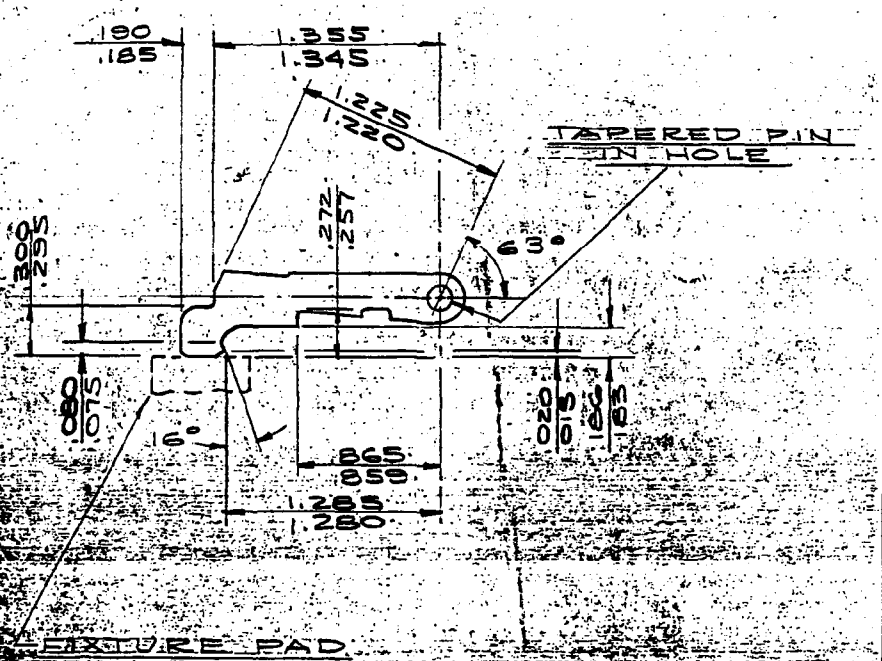
REMINGTON ARMS COMPANY, INC., ILION, N. Y.

F-121

TPR-7

PART: SEAR	PART No. 17045
OPE OBSOLETE PHASE INSPECTION	OPER. No.: 1

PROCESS RECORD — ILLUSTRATION SKETCH



COMPILED BY:	APPROVAL & DATE: F.C. 7-31-46 MKD 8/22/46

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

TPR-7

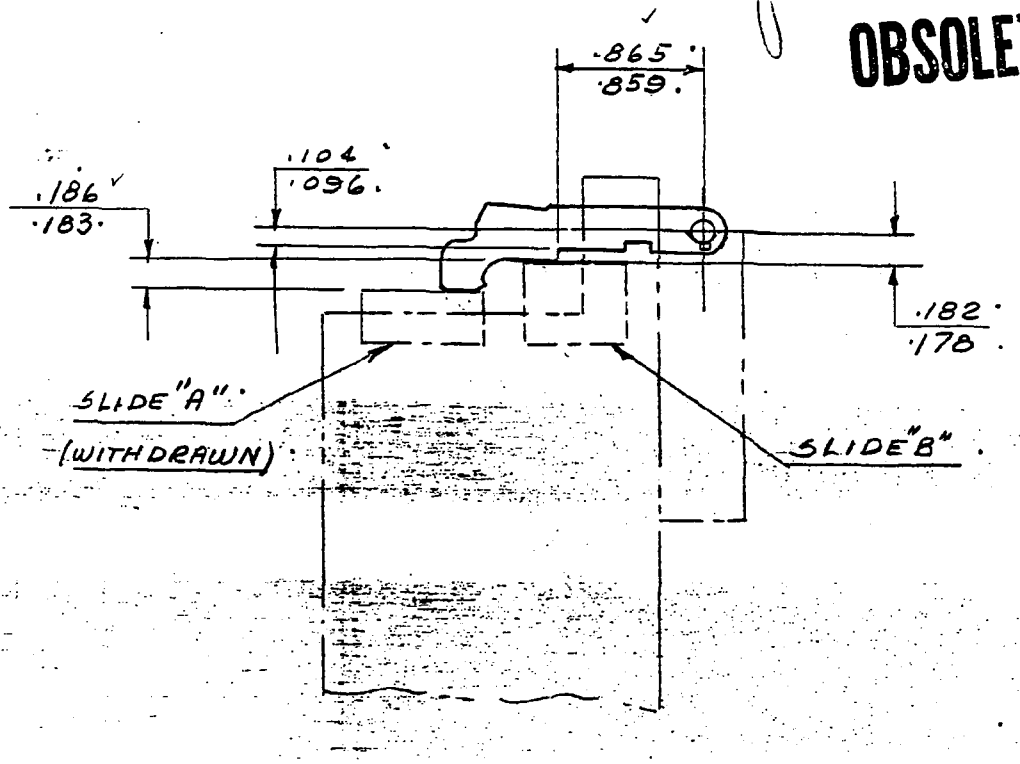
PART: SEAR	PART No. 17045
OPERATION: FINAL	OPER. No.:

4-9

PROCESS RECORD — ILLUSTRATION SKETCH

Obsolete 9/2 14w L

OBSOLETE



SUPERSEDED
BY SKETCH OF 7-31-46

Superseded by new sketch 7-31-46 Re

COMPILED BY: ES&M	APPROVAL & DATE:

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

F-1.91

TPR 11

115

OBSOLETE

PART NO. 17045

OPERATION: PURCHASE INSPECTION

OPER. No.: 1

PROCESS RECORD — INSPECTION

	GAUGES		USE	LIMITS	
	Type	No.		Max.	Min.
1.			Visual Inspect For Defects		
2.	Adj. Snap Gage	B-80013M	Check Thickness	.172	.168
3.	Plug Gage	B-80002S	Check Hole	.1262	.1254
4.	Comparator		a) Set To Master		
	Fixture	D-50325	b) Place Part in Comparator		
	Stage	B-51056	Fixture with Taper Pin in		
	Master	B-50332	Hole and Part Resting on Pad.		
	Screen	C-50333			
			Check the following Dimensions:		
			1.280-1.285		
			16° Angle		
			.015-.020		
			.075-.080		
			.295-.300		
			63° Angle		
			1.220-1.225		
			1.345-1.355		
			.185-.190		
			.183-.186		
			.859-.865		
			.272-.257		

COMPILED BY:

APPROVAL & DATE: MH 8/22/46

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

PART No. 17045

[redacted] Pitchless Inspection

OPER. No.: 1

OBSOLETE

Retyped

PROCESS RECORD — INSPECTION

	GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
1.			Visual Inspect For Defects		
2.	Adj. Snap Gage	B-80013-M	Check Thickness	.172	.168
3.	Plug Gage	B-80002-S	Check Hole	.1262	.125
4.	Comparator Fixture Stage Master Screen	D-50325 B-50156 B-50332 C-50333	(a) Set to Master (b) Place Part In Comparator Fixture With Taper Pin in Hole and Part Resting on ~~Slide "B"~~ PAD.		
			~~Note: Slide "B" is withdrawn and not in contact with part.~~		
			Check the Following Dimensions: 1.280 - 1.285 16° Angle .015 - .020 .075 - .080 .295 - .300 63° Angle 1.220 - 1.225 1.345 - 1.355 .185 - .190 .183 - .186 .859 - .865 .172 - .254		

~~(Continued)~~

fc 7/31/46

COMPILED BY:

APPROVAL & DATE:

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

TPR-11-

PART: SEAR | PART No. 17045

OPERATION: FINAL | OPER. No.: 1

OBSOLETE

PROCESS RECORD — INSPECTION

	GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
1.			Visual Inspect For Defects		
2.	Adj. Snap Gage	B-80013-M	Check Thickness	.172	.168
3.	Plug Gage	B-80002-S	Check Hole	.1262	.1254
4.	Comparator Fixture State Master Screen	D-50325 B-50156 B-50332 C-50333	(a) Set to Master (b) Place Part In Comparator Fixture With Taper Pin in Hole and Part Resting on Slide "A" Note: Slide "B" is withdrawn and not in contact with part. Check the Following Dimensions: 1.280 - 1.285 16° Angle .015 - .020 .075 - .080 .295 - .300 63° Angle 1.220 - 1.225 1.345 - 1.355 .185 - .190		

(Continued)

COMPILED BY: | APPROVAL & DATE:

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

PART No. 17045

OPERATION: Purchase Inspection

OPER. No.: 1

OBSOLETE

PROCESS RECORD — INSPECTION

	GAUGES		USE	LIMITS	
	TYPE	No.		MAX.	MIN.
4. CONTINUED			(c) Withdraw Slide "A" and Push Slide "B" in position. Part is now resting on Slide "B". Check the following dimensions: .183 - .186 .859 - .865 .178 - .182 .096 - .104		

7/31/46

COMPILED BY: | APPROVAL & DATE:

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

TPR-M

OBSOLETE

PART NAME: SEAR

PART No. 17045

OPERATION: FINAL

OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
4. CONTINUED		(c) Withdraw Slide "A" and Push Slide "B" in position. Part is now resting on Slide "B". Check the following dimensions: .183 - .186 .859 - .865 .178 - .182 .096 - .104		

COMPILED BY:

APPROVAL & DATE:

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

PART No. 17045

OPERATION CUT TO LENGTH | OPER. No. 1

OBSOLETE

PROCESS RECORD

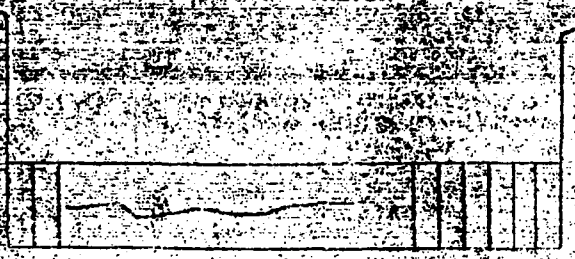
EQUIPMENT: POWER HACK-SAW.

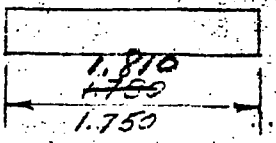
SPEED: | FEED:

MAX. PROD. PER HOUR: | COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Adjustable Snap Ga.-Length	B-80125-N		

SKETCH





COMPILED BY: A. J. Shebby 11/25/46 | APPROVAL & DATE:

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

PART: SEAR BLANK | PART No. 17045

OPERATION: PURCHASE INSPECTION OF SEAR BLANK 17758 | OPER. No.: 1

OBSOLETE DEC 11

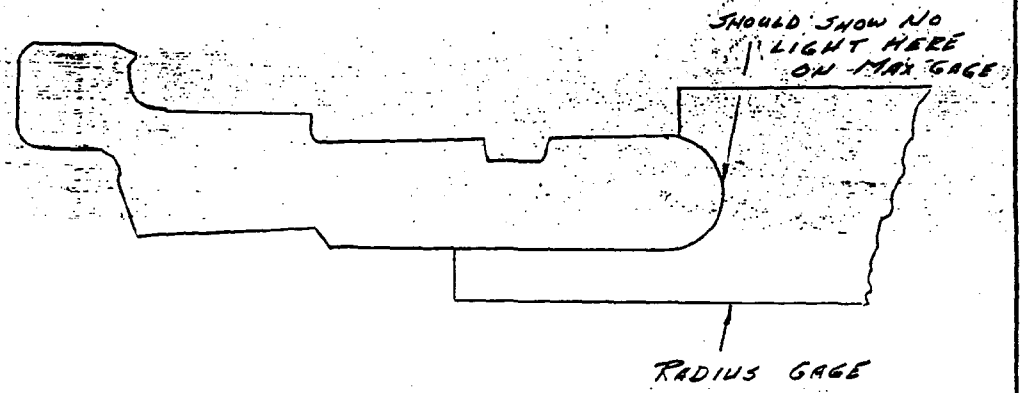
(Temporary)

PROCESS RECORD — INSPECTION

GAUGES		USE	AOQL	LIMITS	
TYPE	No.			MAX.	MIN.
1. Visual		For Defects	5%		
2. Adjustable Snap Gage	B-80013M	Check Thickness	5%	.172	.168
3. Radius Gage Min. & Max.		To Check Radius on Hole End of Part	5%	.150	.147

SKETCH

(5)



COMPILED BY: R.W.Selwood 9/26/46 | APPROVAL & DATE: MWD

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

ULLIVAN, INC.

TPR-9

PART: SEAR PIN

PART No. 17045

OPERATION: DRILL & REAM PIN HOLE (TEMPORARY)

OPER. No.: 2

OBSOLETE
11/15/46.

PROCESS RECORD

EQUIPMENT: Leland Gifford Drill Press

SPEED: 3600 Drill
2400 Ream

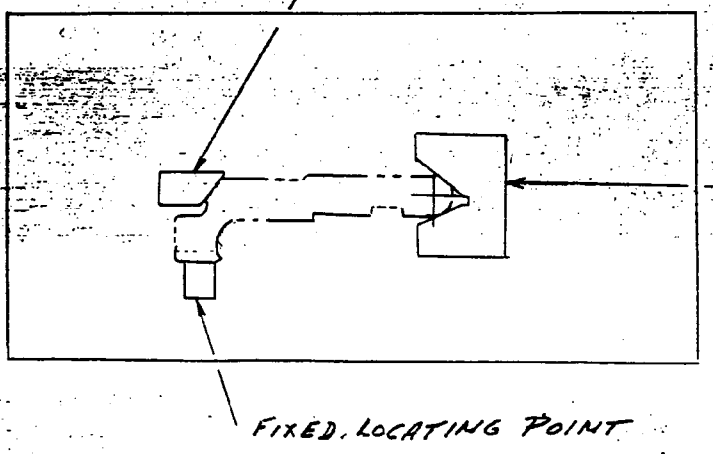
FEED: .003 Drill
.009 Ream

MAX. PROD. PER HOUR: 100

COOLANT: Soluble Oil

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
#31 Drill (.120) .1260 Dia. Reamer Plug Gage Go .125 & No Go .1262		Drill Jig Drill from one side and Ream from the other	

SKETCH



COMPILED BY: R.W.Selwood 9/25/46

APPROVAL & DATE: WPD

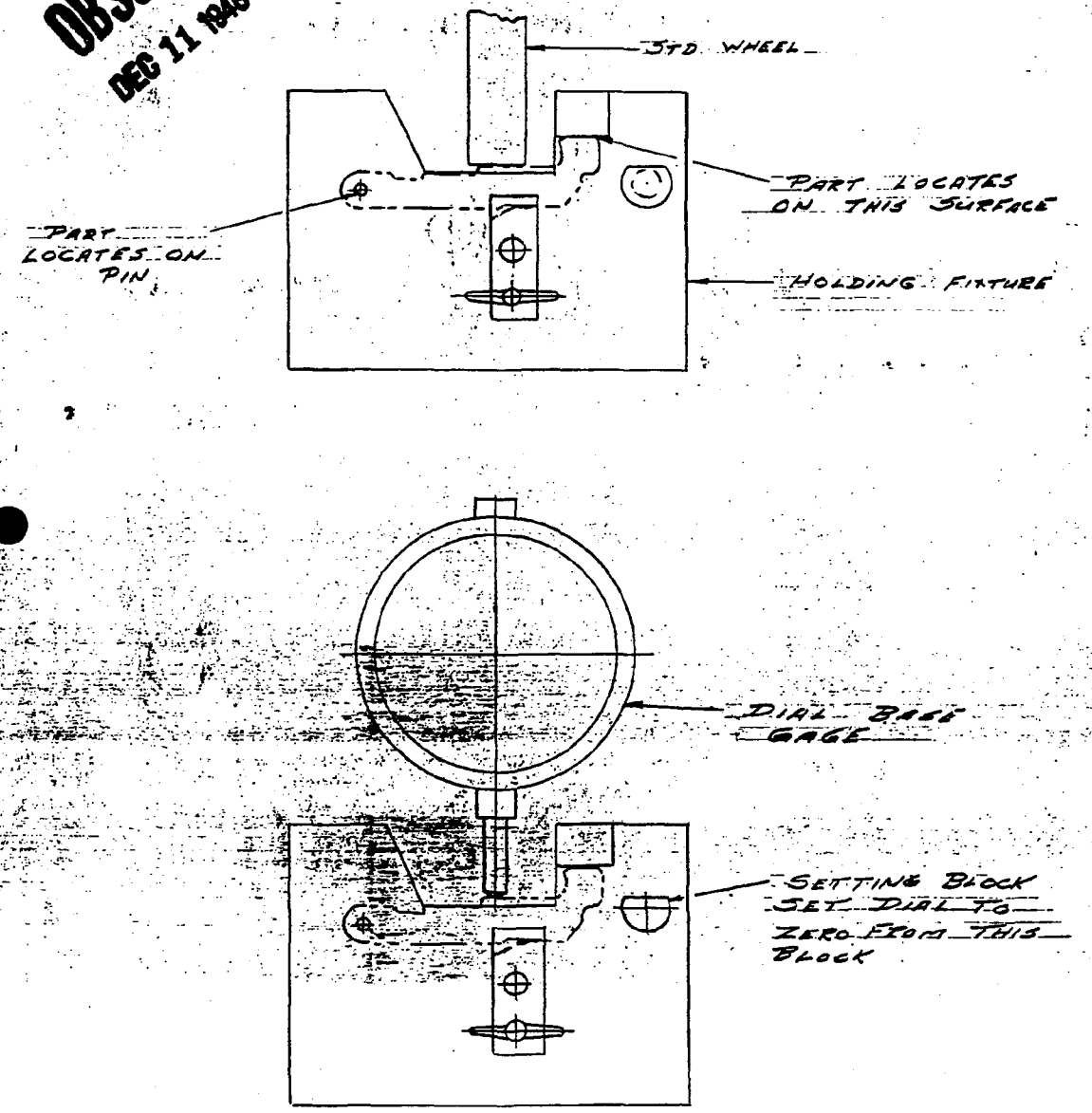
REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: SEAR [illegible] | PART No. 1[illegible]045

OPERATION: GRIND (TEMPORARY) | OPER. No.: 3

PROCESS RECORD — ILLUSTRATION SKETCH

OBSOLETE DEC 11 1946



COMPILED BY: R.W.Selwood 9/26/46 | APPROVAL & DATE: [illegible]

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

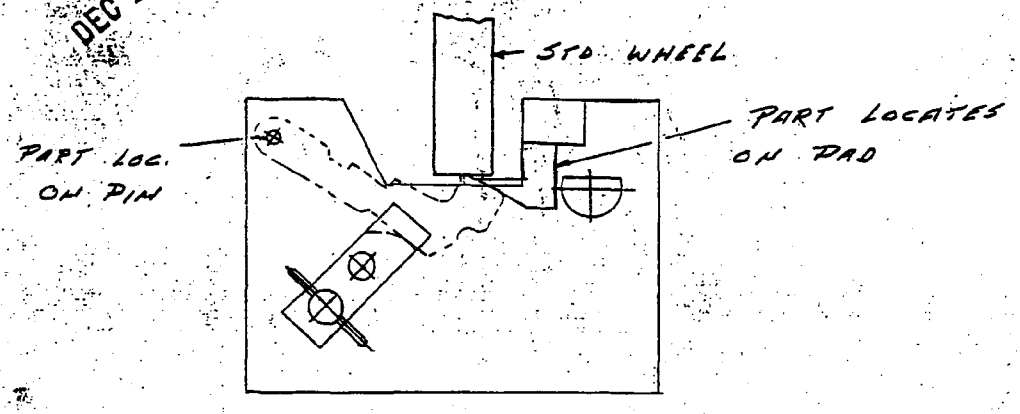
H. H. SULLIVAN, INC.

PART: [redacted] PART No. 17025 12-5

OPERATION: GRIND (TEMPORARY) OPER. No.: 3

OBSOLETE DEC 11 1946

PROCESS RECORD — ILLUSTRATION SKETCH



COMPILED BY: R.W.Selwood 9/26/45

APPROVAL & DATE: [illegible]

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

TPR-6

PART: SEAR PLATE

PART No. 1713045

OPERATION: GRIND (TEMPORARY)

OPER. No.: 3

OBSOLETE DEC 11 1948

PROCESS RECORD

EQUIPMENT: Brown & Sharpe Surface Grinder

SPEED:

FEED:

MAX. PROD. PER HOUR:

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Dial Base Gage		Holding Fixture for Grinding 2 surfaces Same fixture - use to grind both surfaces.	

COMPILED BY: R.W.Selwood 9/18/46

APPROVAL & DATE:

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

H. H. SULLIVAN INC.

PART NO. 1570V45

OPERATION TURN TOP & BOTTOM & BURR — OPER. NO. 9

OBSOLETE

PROCESS RECORD

EQUIPMENT 1-18 Chcl. Plain Miller

SPEED 75 RPM — FEED 21"/Min./Tbl.

MACH. MOD. NO. 1-171 — COOLANT Soluble Oil or Sheil Geria 28C

Climb Mill

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
NAME	NO.	NAME	NO.
Form Cutter (Bottom)	C-52706	Fixture	D-52597
Form Cutter (Top)	C-52707	Fixed Jaw (Bottom)	
Arbor (#40-1¼-B-1¼-3)	B-900370	Set to Jaw	D-527 07
Adj. Snap Ga.-Height	B-801250	Movable Jaw	D-52729
Adj. Snap Ga.-Height	B-801251	Fixed Jaw (Top)	
Set-up Comparator		Set to Jaw	D-527 30
Screen for Form Cutter		Movable Jaw	D-52728
Screen for Form Cutter			
Set-up Comparator		Burning Fixture	B-52937
Fixture	C-52727		
Locating Bits	C-52724A		
Gage	B-801256		
Screen	C-52726		

SKETCH

COMPILED BY — DATE 11/23/46 — APPROVAL & DATE

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

Rev

OBSOL

PART NO. B-70[illegible]

[illegible] TOP & BOTTOM Pin Slot — OPER. No. 3

PROCESS RECORD

EQUIPMENT: #1-18 Cinci. Plain Miller

SPEED: 19 RPM — FEED: 2 3/16" /Min.

MAX. PROD. PER HOUR: ~~171 Pieces / Hr.~~ — COOLANT: Soluble Oil. or Shell-Sarna PG

CLAMP-MILL

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	NO.	TYPE	NO.
Form Cutter (Bottom)	C-52706	Fixture	D-52597
Form Cutter (Top)	C-52707	Vise Jaws. (Bottom)	
Arbor (#40-1¼-B-1½-3)	B-90057U	Solid Jaw	D-52730W
Adj. Snap Ga.-Height	B-80125Q	Movable Jaw	D-52729W
~~Adj. Snap Ga.-Height~~	~~B-80125P~~	Vise Jaws. (Top)	
J & L Comparator		Solid Jaw	D-52730V
Screen for Form Cutter (Bottom)		Movable Jaw	D-52729W
Screen for Form Cutter (Top)			
J & L Comparator		BURRING FIXTURE	B-52937
Fixture	C-52724		
Locating Blk.	C-52724W		
Stage	B-50156		
Screen	C-52726		

SKETCH

Vise Jaws
Mill Bottom

FINAL TECHNICAL PROCESS RECORD
DATE
Vise Jaws
Mill Top

.597
.537

PIECE TO BE BURRED AFTER EACH CUT - ONLY BURR REMOVED AFTER FINISH CUT

COMPILED BY: [illegible] APPROVED BY: [illegible] DATE: 11/25/46

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

TPR-9

Revised

OBSOLETE

PART NAME: SEAR

PART No. 17045

OPERATION: MILL TOP & BOTTOM

OPER. No.: 3

PROCESS RECORD

EQUIPMENT: #1-18 Cinci. Plain Miller

SPEED: 73 RPM

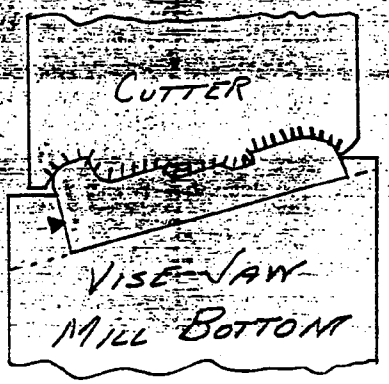
FEED: 2 3/16"/Min.

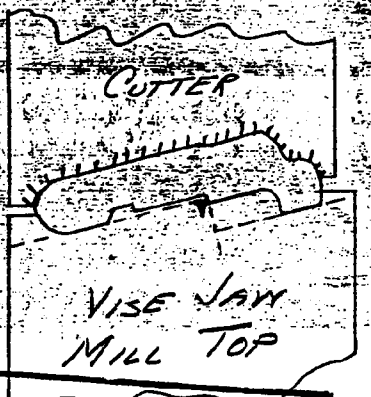
MAX. PROD. PER HOUR: 171 Pieces / Hr.

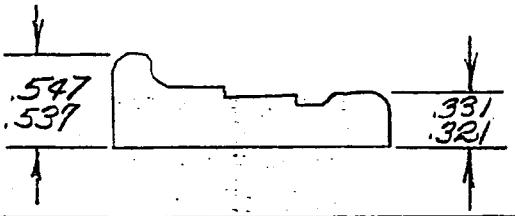
COOLANT: Soluable Oil.

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Form Cutter (Bottom)	C-52706	Fixture	D-52597
Form Cutter (Top)	C-52707	Vise Jaws. (Bottom)	
Arbor (#40-1¼-B-15½-3)	B-90057U	Solid Jaw	D-52730W
Adj. Snap Ga.-Height	B-80125Q	Movable Jaw	D-52729W
Adj. Snap Ga.-Height	B-80125P	Vise Jaws. (Top)	
J & L Comparator		Solid Jaw	D-52730V
Screen for Form Cutter(Bottom)		Movable Jaw	D-52729V
Screen for Form Cutter(Top)			
J & L Comparator			
Fixture	C-52724		
Locating Blk.	C-52724W		
Stage	B-50156		
Screen	C-52726		

SKETCH







FINAL TECHNICAL PROCESS RECORD DATE .....

COMPILED BY: J. J. Webbing 11/25/46

APPROVAL & DATE:

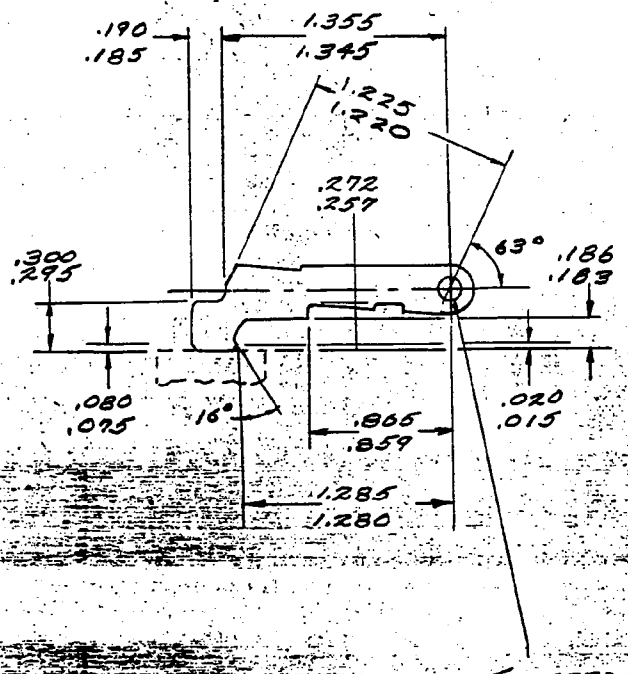
REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: SEAR BLANK L | PART No. 47025

OPERATION: FINAL INSPECTION (TEMPORARY) | OPER. No.: 4

OBSOLETE DEC 11 1946

PROCESS RECORD — ILLUSTRATION SKETCH



COMPILED BY: R.W. Selwood 9/26/46 | APPROVAL & DATE: MWD

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

H. H. SULLIVAN, INC.

PART NAME: GEAR | PART No. 17982

OPERATION: FINAL INSPECTION (TEMPORARY) | OPER. No. 4

OBSOLETE DEC 11 1946

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Comparator Fixture Stage Master Screen	D-50325 B-51056 B-50332 C-50333	a) Set to Master b) Place part in Comparator Fixture with Taper Pin in Hole and Part Resting on pad. Check the following dimensions: 1.280-1.285 16° Angle .015-.020 .075-.080 .295-.300 63° Angle 1.220-1.225 1.345-1.355 .185-.190 .183-.186 .859-.865 .272-.257		

COMPILED BY: R.W.Selwood 9/26/45

APPROVAL & DATE: WKS

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

H. H. SULLIVAN, INC.

TYPE-0

Relyp
OBSOLETE
JAN 1947

PART NO. 17045

PT: Liar

OPERATION: Remove Cutter Mismatch

OPER. NO.: 4

PROCESS RECORD

EQUIPMENT: Porter Cable Sander

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
80 Grit Belt		Hold piece in hand	

SKETCH

Remove Cutter mismatch
Hold piece in

COMPILED BY: J. Bowling

APPROVAL & DATE:

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

PART NO. 14435

OPER. No.: 5

GRIND TO THICKNESS

OBSOLETE

PROCESS RECORD

SPEED:

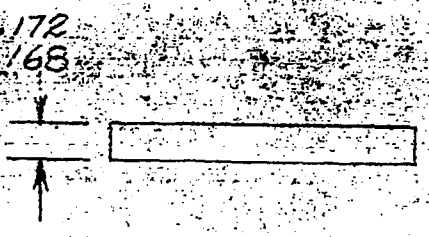
FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
ADJUSTABLE SNAP GA. *Thickness	B-80013-[illegible]		

SKETCH



COMPILED BY: [illegible] 11/25/46

APPROVAL & DATE:

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

R-20

PART BEAR

PART NO. 17045

OPERATION SPOT, DRILL & REAM PIN HOLE

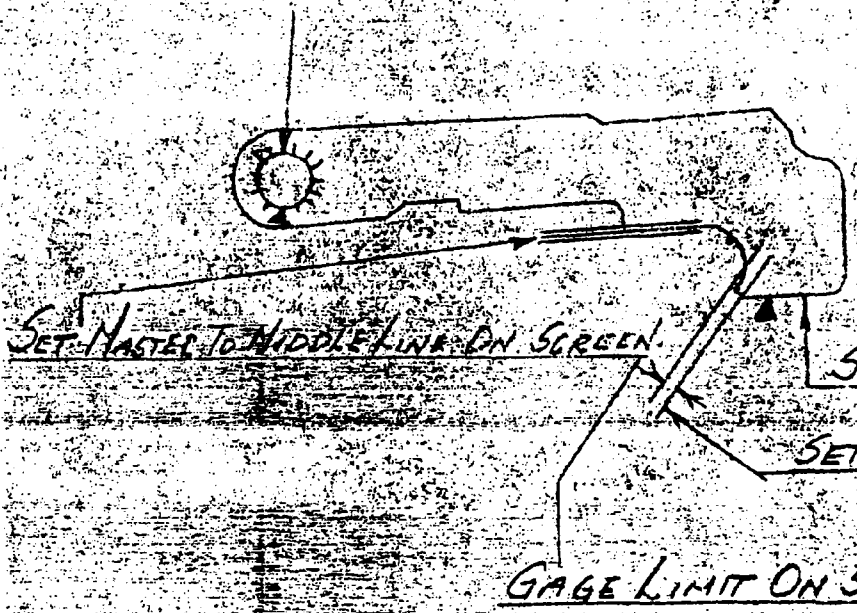
OPER. No. 7

OBSOLETE

INSPECTION RECORD

J. & L. 007 Comparator
Fixture D-50325
Stage B-50156
Screen C-50333
Master B-50332

PLUG GA.-DIA. OF HOLE. (.1262 / .1254) - B - 80002-R



COMPILED BY [redacted] 11/25/56

APPROVAL & DATE:

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

TPR-10

PART: SEAR | PART No. 17045

OPERATION: SPOT, DRILL & REAM PIN HOLE | OPER. No.: 7

PROCESS RECORD

OBSOLETE JAN 1 4 1947

EQUIPMENT: Leland - Gifford 3 Spindle Drill Press

MAJ[illegible] PER HOUR:

COOLANT: Cim Cool or Soluble Oil

OPERATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
1. Spot	1800	Hand	Spot Drill (B-90080-K) .126	3.21 MM	Jig	C-52690
2. Drill	1800	Hand	Drill (B-90054-T) .120	#31	Jig	C-52690
3. Ream	600	Hand	Reamer (.1258)	B-90079-L	Jig	C-52690
			Plug Gage .1262-.1254	B-80002-25		
			See next page for comparator layout			
NOTE: ~~Lift Jig Cover~~ make sure no chips are in hole before reaming.						

COMPILED BY: J. F. Bowling 1/6/47

APPROVAL & DATE:

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

TPR-10

PART: Gear

PART No. 17045

OPERATION: Spot Drill & Ream Pin Hole

OPER. No.: 7

Returned COMPLETE JAN 6 1947

PROCESS RECORD

EQUIPMENT: #1 Leland-Gifford 3 Spindle Drill Press

MAX. PROD. PER HOUR:

COOLANT: Cimcool

	STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
	STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
1.	Spot Drill	1800	HAND	Spot Drill (B-900801) .126	3.2 MM	Jig	C-52690
2	Drill			Drill (B-900547) .120	#31	Jig	C-52690
3.	Ream			Reamer (.1258)	B-900792	Jig	C-52690

NOTE: Lift Jig Cover to make sure no chips are in hole before reaming

COMPILED BY: J. F. Bowlby

APPROVAL & DATE:

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

TPR-9

PART: SEAR — PART No. 17045

OPER. DESC.: SPOT, DRILL & REAM PIN HOLE. — OPER. No. 7

OBSOLETE

PROCESS RECORD

JAN 6 1947

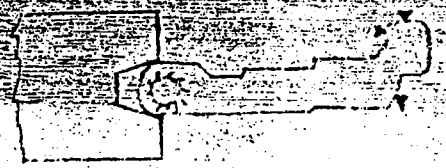
EQUIPMENT:

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Spot Drill (3.2MM-.126)e	B-90080K	Jig	C-52690
Drill (#31-.120)	B-90054T	Spot Drill (3.2MM-.126)	B-90080K
Reamer (.1258)	B-90079L	Drill (#31-.120)	B-90054T
J & T Comparator	B-50156	Reamer (.1258)	B-90079L
Fixture	C-50325		
Stager	B-50156		
Screen	C-50333		
Master	B-50332		
Plug Ga. - Dia. of Hole	B-80002R		

SKETCH



COMPILED BY: [illegible] 11/25/46 — APPROVAL & DATE:

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

TPH-5

PART: SEAR

PART No. 17045

OBSOLETE JAN 4 1947

OPERATION: SPOT, DRILL & REAM PIN HOLE.

OPER. No.: 7

PROCESS RECORD

EQUIPMENT:

SPEED:

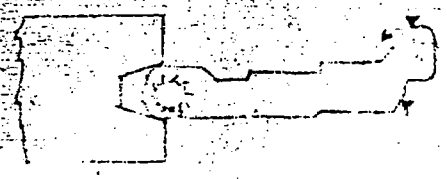
FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Plug Ga. - Dia. Of Hole	B-80002R	Jig	C-52690
J & L Comparator		Spot Drill (3.2MM-.126)	B-90080K
Fixture	B-50325	Drill (#31-.120)	B-90054T
Stage	B-50156	Reamer (.1258)	B-90079T
Screen	C-50333		
Master	B-50332		

SKETCH



COMPILED BY: A. J. Tabbing 11/25/46

APPROVAL & DATE:

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

TPR-9

PART: SEAR | PART No. 17045

OPERATION: SPOT, DRILL & REAM PIN HOLE. | OPER. No.: 7

OBSOLETE 1947

PROCESS RECORD

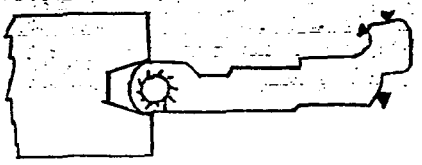
EQUIPMENT:

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Plug Ga. - Dia. Of Hole	B-80002R	Jig	C-52690
J & L Comparator		Spot Drill (3.2MM-.126)	B-90080K
Fixture	B-50325	Drill (#31-.120)	B-90054T
Stage	B-50156	Reamer (.1258)	B-90079L
Screen	C-50333		
Master	B-50332		

SKETCH



COMPILED BY: ~~A. O. Webbing~~ 11/25/46 | APPROVAL & DATE:

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

TPR-9

Returned KINZEE JAN 8 1947

Lever	PART No. 17045
OPERATION: Burr Hole	OPER. No.: 8

PROCESS RECORD

EQUIPMENT: #1 Leland-Gifford Drill Press

SPEED: 1800 FEED: Hand

MAX. PROD. PER HOUR: — COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Drill - 3/16" 90° pt.	B-90144-M	Hold in Hand to burr both sides. Slight C'Sink is desirable	

SKETCH

COMPILED BY: J. Bourhi APPROVAL & DATE:

REMINGTON ARMS COMPANY INC ILION N Y

PART No. 17045

OPERATION: GRIND TRIGGER CONNECTOR SURFACE — OPER. No.: 9

OBSOLETE JAN 4 1947

PROCESS RECORD

EQUIPMENT:

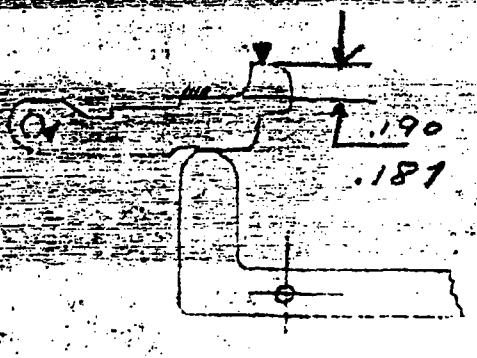
SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES			TOOL HOLDERS, JIGS & FIXTURES	
TYPE		No.	TYPE	No.
Dial Gage		C-52894	Fixture	C-52735

FINAL TECHNICAL PROCESS RECORD DATE JAN 4 1947

SKETCH



COMPILED: 11-25-46

APPROVAL & DATE: M.F.2 12/20/46

REVISED DEC 30 1946

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

PART NO. 17045

...BEYOND SAFETY SURFACE — OPER. NO. 11

OBSOLETE

PROCESS RECORD

EQUIPMENT:

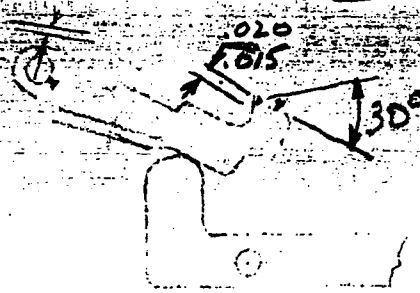
SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Dial Gage	C-52894	Fixture	C-52813

SKETCH

FINAL TECHNICAL PROCESS RECORD DATE JAN 4 1947



COMPILED BY: J. J. Webb 11/25/46

APPROVAL & DATE:

REMINGTON ARMS COMPANY, ILION, N.Y. REVISED DEC 20 1946

TPR-20

PART: SEAR | PART No. 17045

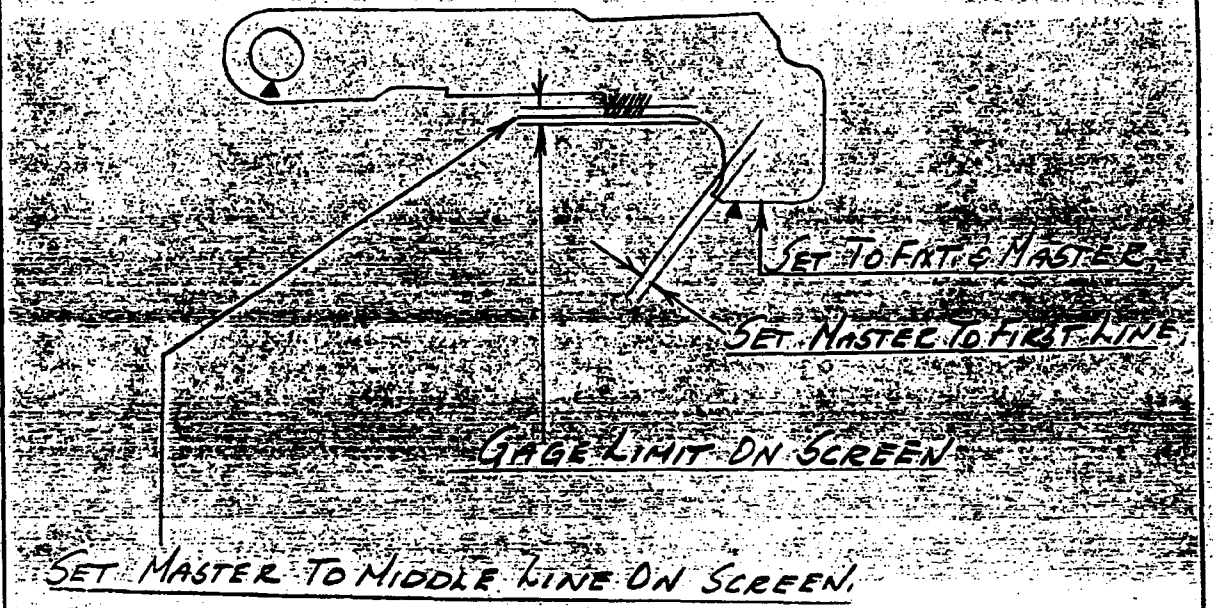
OPERATION: GRIND TRIGGER CONNECTOR SURFACE | OPER. No. 9

OBSOLETE
DEC 19 [illegible]

INSPECTION RECORD

J & L Comparator

Fixture D-50325
Stage B-50156
Screen C-50333
Master B-50332



COMPILED BY: J. J. Rowling / Webb 11/25/46 | APPROVAL & DATE:

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

PART NO. 17045

OPERATION GRIND TRIGGER CONNECTOR SURFACE

OPER. NO. 79

OBSOLETE DEC 19 1946

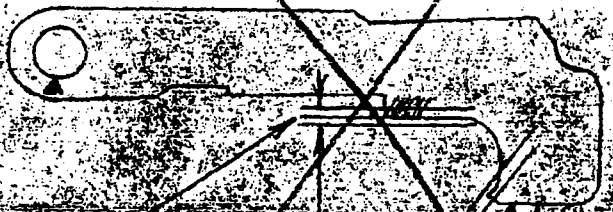
INSPECTION RECORD

J & L Comparator

~~Fixture - B-50225~~
~~Stage - B-50196~~
~~Screen - C-50333~~
~~Master - B-50332~~

Indicator Gage C-52894
12/7/46 JP

Cancel



SET TO FIXED GAGE LINE

SET MASTER TO FIRST LINE

GAGE LIMIT ON SCREEN

SET MASTER TO MIDDLE LINE ON SCREEN

COMPILED BY [illegible] 12/25/46

APPROVAL & DATE:

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

PPR-9

OBSOLETE 12-1-46

PART: SEAR | PART No. 17045

OPERATION: GRIND TRIGGER CONNECTOR SURFACE | OPER. No.: 9

PROCESS RECORD

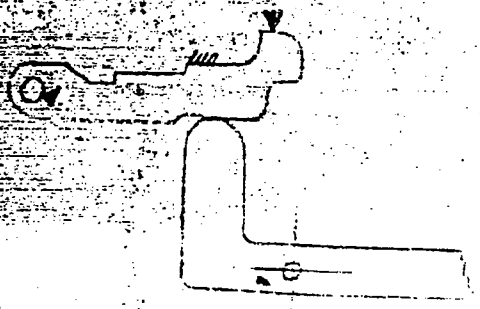
EQUIPMENT:

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator Fixture ~~Stage~~ ~~Screen~~ ~~Master~~ Dial Indicator Gage 12/17/46 JGS	~~D-50325~~ ~~B-50156~~ ~~C-50333~~ ~~B-50332~~ C-52894	Fixture	C-52735

SKETCH



WMR 12/19/46

COMPILED: H. A. J. Hobbing 11/25/46 | APPROVAL & DATE:

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

TYP-9

PART: SEAR | PART No. 17045

OPERATION: GRIND TRIGGER CONNECTOR SURFACE | OPER. No.: 9

Originally OBSOLETE DEC 19 1946

PROCESS RECORD

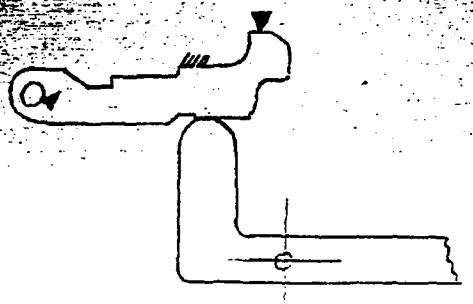
EQUIPMENT:

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator		Fixture	C-52735
Fixture	D-50325		
Stage	B-50156		
Screen	C-50333		
Master	B-50332		

SKETCH



COMPILED BY: A. J. Webbing 11/25/46 | APPROVAL & DATE:

REMINGTON ARMS COMPANY INC ILION N Y

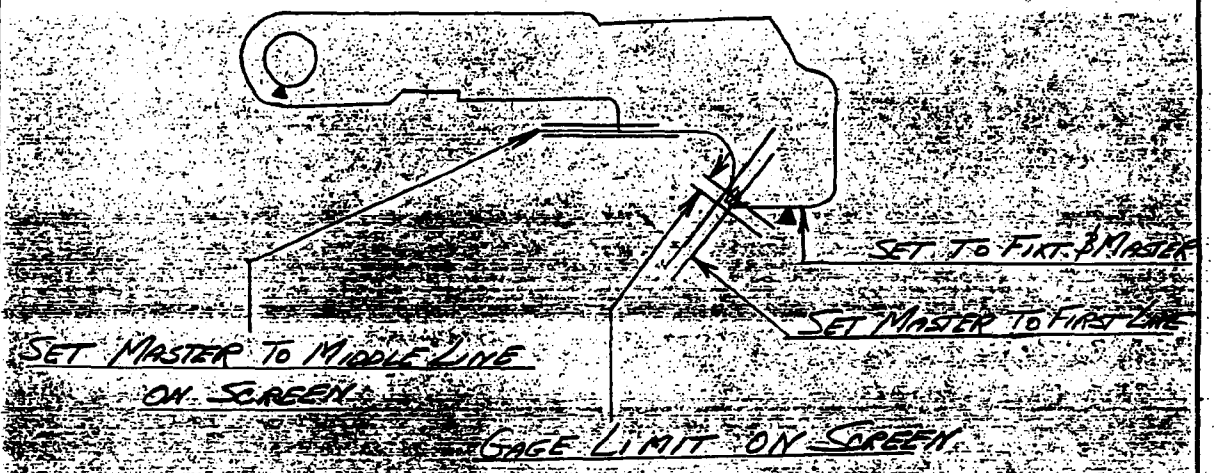
TPR-20

PART: SEAR	PART No. 17045
OPERATION: GRIND SAFETY SURFACE	OPER. No.: 11

OBSOLETE DEC 19 1946

INSPECTION RECORD

J & L Comparator
Fixture D-50325
Stage B-50156
Screen C-50333
Master B-50332



COMPILED BY: A. J. Webbing 11/25/46	APPROVAL & DATE:

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

TPR-30

PART NO. 12025

OBSOLETE

GRIND SAFETY SURFACE

OPER. No. 11

INSPECTION RECORD

Comparator

Plug - B-50325

Ring - B-50326

Setting - C-50329

Master - B-50330

Indicator Gage - C-52894

(4/1/46)PP

Cancel

SET MASTER TO FIRST LINE

SET MASTER TO WHOLE LINE

GAGE LIMIT ON SAFETY

COMPILED

APPROVAL & DATE:

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

PART: SEAR

PART No. 17045

OPERATION: GRIND SAFETY SURFACE

OPER. No. 11

Rail ISSUED Dec 19 01

PROCESS RECORD

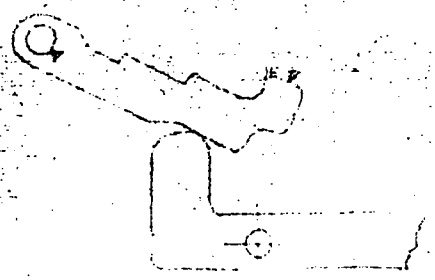
EQUIPMENT:

SPEED: FEED:

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
~~J & L Comparator~~		Fixture	C-52813
~~Fixture~~	~~D 50325~~		
~~Stage~~	~~B 50156~~		
~~Screen~~	~~C 50333~~		
~~Master~~	~~B 50332~~		
~~Index~~ For Gage	C-52894		
Kid	12/17/46 GJP		

SKETCH



WWH 12/19/46

COMPILED BY: J. J. Webbing 11/25/46

APPROVAL & DATE:

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

TPR-9

PART: SEAR

PART No. 17045

OPERATION: GRIND SAFETY SURFACE

OPER. No.: 11

OBSOLETE DEC 19 1946

PROCESS RECORD

EQUIPMENT:

SPEED:

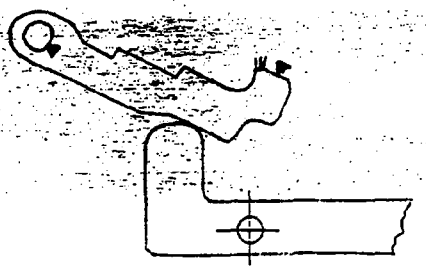
FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator		Fixture	C-52813
Fixture	D-50325		
Stage	B-50156		
Screen	C-60333		
Master	B-50332		

SKETCH



COMPILED BY: A. J. Webbing 11/25/46

APPROVAL & DATE:

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

PART: GEAR

PART No. 17045

OPER. No.:

OBSOLETE JAN 14 1947

PROCESS RECORD

EQUIPMENT: BLANCHARD ROTARY SURFACE GRINDER

SPEED:

FEED:

MAX. PROD. PER HOUR:

COOLANT: CIM COOL

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
ADJUSTABLE SNAP GA.-Thickness	B-80013-M	Load Table Full	

SKETCH

COMPILED BY:

APPROVAL & DATE:

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

TPR-9

PART: [redacted] PART No. 178755

OPERATION: OPER. No.:

PROCESS RECORD

EQUIPMENT: Blanchard Rotary Surface Grinder

SPEED: FEED:

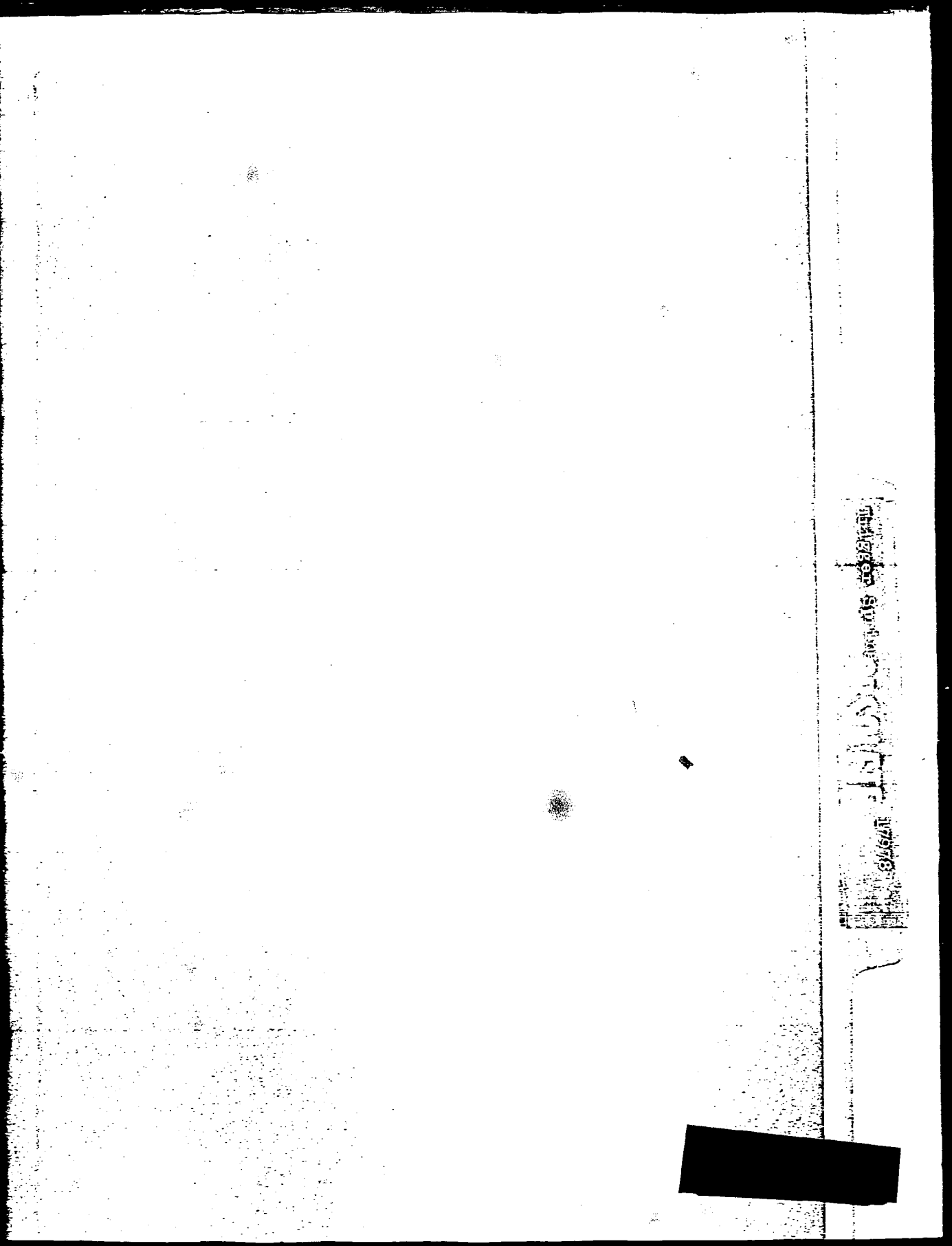
MAX. PROD. PER HOUR: COOLANT: Cim Cool

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
		Load Table Full	

SKETCH

COMPILED BY: APPROVAL & DATE:

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



Form KT-1018

PROCESS RECORDS TURNED OVER TO PLANT

Code [redacted]

Component Name [redacted]

Component No. [redacted]

Operation Preliminary Purification

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

APR 7 1947

Date

[redacted]
Process Engineer

PART: ~~GEAR SPRING~~ TRIGGER SPRING

OPERATION: PURCHASE INSPECTION

FINAL INSPECTION
PROCESS RECORD
DATE

Revised

OBSOLETE

MAR 20 19[illegible]

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
1. Rod Collar	B-51364W B-51365W	Set Sample 24 hours.		
2. Coates Elasticometer		Set up Elasticometer		
Pin	~~B-51361~~	a. Place Bushing in platen		
Ring	~~B-51003~~	b. Snap pin in anvil		
Bushing	B-50127T	c. Load beam with mean load ~~7# 9 oz.~~ 6 [illegible] 11 oz.		
	B-53123-S	d. Set markers on scale * (Includes 1" constant)	[illegible]	1 5/32 [illegible] 19/32
3.		a. Slip spring on pin. Must fit freely.		.108
		b. Check "Free Length" with pin length. Must be finish or longer.		.220 .160
4.		a. Place ring on platen. Raise platen to "Solid Height". Lock platen. Check with ring. Ring if [illegible] Solid Height.		.140 [illegible]
		b. Raise and lower ring over spring to check "Free Length hole" at solid height		[illegible]
5.		a. Lower platen until balance arm is on zero. Move lever arm up and down several times to get true reading. Pointer on platen must fall between tolerance markers on scale.		
6. Visual		a. Check ends Check wind		
		Note: ~~One sample~~ ALL springs are to be set before assembly		

COMPILED BY E.K.Wheat

APPROVAL & DATE 11/1/46

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

PART ~~Sear Spring~~ (Purchase ready for Setting)
Trigger Spring

MAR 30 1949

OBSOLETE

MATERIAL PROCUREMENT - FINISHED COMPONENT

Detailed Description

DWG. No.	D.

Remington Planning

Pieces Required Per Assembly: 1 (~~1 Sear Spring~~)
Uses of Parts : M/721 - All Calibers;
M/722 - All Calibers;

Vendor

Material : Music Wire. Packing slip to show material used for each shipment of parts.

Heat Treatment : Stress Relieve (See footnote)

Set : Vendor need not remove set but parts must comply with drawing when set has been removed by holding fully compressed for 24 hrs.

Final Color : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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 following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Set Sample for inspection by holding fully compressed for 24 hrs., Rod Dwg. B-51564W, Collar B51565W. Balance of lot must be set before parts are ready for assembly.

Inspection: **

Gage No.	Type	Use	AOQL
1. Coats	"Elasticometer" with	(Free Length	7%
B-53 123-5 ~~B-51561T~~	- Pin	(Solid Height	7%
B-53 122-5 ~~B-51000T~~	- Ring	(I.D. of Spring	7%
B-50127T	- Bushing	(O.D. of Spring	7%
		(Load at 80% Deflection	7%
2. Visual		Wind R.H.	7%
		Ends Squared and Ground	7%
		Seams, etc.	7%

** See Process Record - Inspection for Procedure.

Note: As a matter of information only this part has been heat treated satisfactorily at Remington as follows:
Stress Relief; duPont Salt #1; 380 - 400°F; 10 minutes; water quench.

COMPILED BY: C.B.Buonassisi | APPROVAL & DATE: 5/27/46

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

PART: ~~SEAR SPRING~~ TRIGGER SPRING

SEQUENCE OF OPERATIONS

Revised OBSOLETE MAR 30 1947

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1		Material Procurement	
2		Purchase Inspection	
3		Transfer to Part Stores	

FINAL TECHNICAL PROCESS RECORD
DATE

COMPILED BY: M.H.S. 7/1/46 | APPROVAL & DATE 7/11/46

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

Revised
OBSOLETE
MAR 20 1949

PROCESS RECORD

~~GEAR SPRING~~

TRIGGER SPRING

PART NO. ~~17047~~ 17978

ISSUED
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

ISSUED TO: _____ DEPARTMENT

[redacted]

Form RT-118

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Name Trigger Spring

Component No. 17778

Operation Tool Sheet, Sequence of operations

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

March 26, 1947

Process Engineer

[redacted]

PROCESS RECORDS TURNED OVER TO PLANT

Model 22A

Component Name Trigger Spring

Component No. 17978

Operation 1 - Punch Inspection

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

March 26, 1947
Date

Process Engineer

Form RT-118

PROCESS RECORDS TURNED OVER TO PLANT

Model 22A

Component Name Trigger Spring

Component No. 17978

Operation Mat. Proc. - Finished

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

March 26, 1947
Date

Process Engineer

17036 OBSOLETE Trigger Assem.

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3. All sketch sheets precede their operation sheets and are divid-

TPR-19

PART: TRIGGER ASSEMBLY | PART No. 17036Y

PROCESS RECORD-ASSEMBLY

STEP	TOOLS & GAGES TYPE	TOOLS & GAGES NO.	REMARKS
1- Insert trigger- 17048-in Housing-17039-and install Trigger Pin.-17037			Pin must be flush on Safety Side
2- Assemble following: a-Bolt Stop Release-17038 b-Safety Pivot Pin-17043 c-Safety-17040 d-Safety Detent Ball-17041 e-Safety Detent Spring-17042 f-Safety Snap Washer-17044			
3- Install Trigger Adjusting Screw-17049-Butt End.			
4- Insert Trigger Connector 17050			
5- Insert Trigger Stop Screw-17053			
6- Install Trigger Adjusting Screw-17049-and Trigger Spring 17047.			
7- Install Sear-17045-Sear Sprgs. 17047-and Dummy Pins.	Dummy Pins	A-51468	
8- Adjust Butt End Trigger Adjustment Screw-17049			Apply pressure on Sear and tighten screw until Sear falls then back up screw $\frac{1}{2}$ turn.
9- Adjust Trigger Stop Screw-17053			Tighten op Trigger Stop Screw until Tirgger will not disengage Sear. Then apply pressure on top of Sear and Trigger and back Trigger Stop Screw until Sear falls.

* USE NORMAL COMPLEMENT OF ASSEMBLING TOOLS TO PERFORM ABOVE ASSEMBLY.

COMPILED BY: | APPROVAL & DATE: MHS 7/19/46

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

TPR-18

PART: TRIGGER ASSEMBLY

PART No. 17036-Y

OBSOLETE

PROCESS RECORD ASSEMBLY

STEP	TOOLS & GAGES TYPE	NO.	REMARKS
1- Insert trigger-17048-in housing-17039-and install trigger pin. 17037	Hammer		Pin must be flush on safety side.
2- Assemble following: a-Bolt Stop Release-17038 b-Safety Pivot Pin-17043 c-Safety-17040 d-Safety Detent Ball-17041 e-Safety Detent Sprg.-17042 f-Safety Snap Washer-17044	Hammer		
3- Install trigger adjustment screw-17049-butt end.	1/8" Blade Screw Driver		
4- Insert Connector-17050			
5- Insert Trigger Stop Screw-17053	1/8" Blade Screw Driver		
6-Install Trigger Adjusting Screw-17049-and Spring 17047.	1/8" Blade Screw Driver		
7- Install sear-17045-Sear Sprgs.-17047-and Dummy Pins.	Dummy Pins	A-51468	
8-Adjust Butt end Trigger Adjustment Screw-17049	1/8" Blade Screw Driver		Apply pressure on sear and tighten screw until sear falls then back up screw ½ turn.
9- Adjust Trigger Stop Screw-17053	Bench Vise		Tighten up trigger stop screw until trigger will not disengage sear. Then apply pressure on top of sear and trigger and back trigger stop screw until sear falls.

COMPILED BY:

APPROVAL & DATE: MWH 7/19/46

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

NAME TRIGGER ASSEMBLY — PART No. 17036-Y

Revised 8/22/46 OBSOLETE

Chk Rec'd

PROCESS RECORD-ASSEMBLY

STEP	TOOLS & GAGES TYPE	NO.	REMARKS
1- Insert trigger-17048-in Housing-17039-and install Trigger pin. 17045	~~Hammer~~ Type		Pin must be flush on safety side.
2- Assemble following: a-Bolt Stop Release-17038 b-Safety Pivot Pin-17043 c-Safety-17040 d-Safety Detent Ball-17041 e-Safety Detent Sprg.-17042 f-Safety Snap Washer-17044	~~Hammer~~		
3- Install Trigger Adjustment Screw-17049-butt end.	ADJUSTING ~~Adjustment~~ ~~1/8" Blade Screw Driver~~		
4- Insert Connector-17050	TRIGGER		
5- Insert Trigger Stop Screw-17053	~~1/8" Blade Screw Driver~~		
6-Install Trigger Adjusting Screw-17049-and Spring 17047.	~~1/8" Blade Screw Driver~~ Type		
7- Install Sear-17045-Sear Sprg.-17047-and Dummy Pins.	Dummy Pins	A-51468	
8-Adjust Butt end Trigger Adjustment Screw-17049	~~1/8" Blade Screw Driver~~		Apply pressure on sear and tighten screw until sear falls then back up screw ½ turn.
9- Adjust Trigger Stop Screw-17053	~~Bench Vise~~		Tighten up trigger stop screw until trigger will not disengage sear. Then apply pressure on top of sear and trigger and back trigger stop screw until sear falls.

* USE NORMAL COMPLEMENT OF ASSEMBLING TOOLS TO PERFORM ABOVE ASSEMBLY.

COMPILED BY:

APPROVAL & DATE: 7/12/46

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

REVISED JUL 23 1946

TPR-17

PART: Trigger Assembly

PART No. 17036 Y

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
7/19/46	Typed Process Record

COMPILED BY:

APPROVAL & DATE:

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

OBSOLETE

Ret'd Checked 8/21/68

PROCESS RECORD

TRIGGER ASSEMBLY

PART NO. 17036 Y

THIS ASSEMBLY CONSISTS OF:

TRIGGER	17048
HOUSING	17039
TRIGGER PIN	17037
BOLT STOP RELEASE	17038
SAFETY RIVET PIN	17043
SAFETY	17040
SAFETY DETENT BALL	17041
SAFETY DETENT SPRING	17042
SAFETY SNAP WASHER	17044 (2)
TRIGGER ADJUSTING SCREW	17049
TRIGGER CONNECTOR	17050
TRIGGER STOP SCREW	17053
TRIGGER SPRING	17047
SEAR	17045
SEAR SPRING	17047

ISSUED BY
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

ISSUED TO: _____
DEPARTMENT

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3. All sketch sheets precede the operation sheets and are divided

TPR-19

PART: Final Assembly

PART No. 81

OBSOLETE

Final Inspection

Component	Check	Key Points
Function	Finish of bolt	Good - mars and burrs slight
	Wire brush and wipe bore	Visual for no rust or other defects.
Assemble	Insert bolt	No bind by bolt stop
	Pull back bolt to test	Bolt is locked by bolt stop.
Stamp	Final Inspection	On left side rear of barrel.
	Date code mark	" " " " " "
	Send to Warehouse	

COMPILED BY: J H Faust

APPROVAL & DATE:

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

TPR-19

PART: Final Assembly

PART No. 81

OBSOLETE

Final Inspection

Component	Check	Key Points
Stock	Finish	No checks, mars and scratches slight per sample
	All screws	Tight in stock, mars and burrs slight and no bad projections.
	Barrel must seat	
Butt Plate	Fit at face Margin - wood or steel	Max. 0.005 opening Max. 0.020
	Finish	Color uniform - edges not rough - edge chamfered.
Function	Max. Heading Plug	Insert in chamber, close action - Bolt should not lock and safe should not go on. Accept if very snug.
	Operate bolt 3 times and fire	No bind - bolt handle raises & lowers easily.
	Follow down test - open bolt full stroke and close forcibly 3 times	Must not fire until trigger is pulled.
	Safe, Push on (to rear)	No bind
	Push on rear of firing pin head while pulling trigger	Must not fire - notches not click.
	Bolt Handle	Locks down
	Push Safe off with thumb	No bind - must not fire until trigger is pulled.
	Trigger Pull	Min. - 4#, Max 5# No creep or bind Trigger must retract after firing
	Depress bolt stop release & remove bolt	No bind

COMPILED BY: [signature] | APPROVAL & DATE:

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

TPR-19

PART: Final Assembly

PART No.

Final Inspection

Component	Check	Key Points
Assembly	Live Ammunition	Chamber, magazine, and receiver empty, follower visible.
	Stamps:	
	Assembly	On barrel - left side rear
	First Inspection	In bolt handle slot of stock (REP)
	Proof	On rear right side of barrel
	Test	On rear right side of barrel
	Target	" " " " " "
	Tag	Must match with gun
Metal Parts	Finish	Color uniform, good, finish, mars and burrs slight. No seams or red or gray browning.
Barrel	Muzzle Crown Finish	Good finish, no jams at edge of bore.
	Color	Accept 1/16" light ring around bore, otherwise uniform.
Front Sight	Color	Uniform - mars and scratches slight
	~~Bead ball shape~~	~~Blade staked at front of bead.~~
	Blade tight in base	Test with light blow - if sight moves - repair and retarget.
Rear Sight	Tight in Dovetail	Test with light blow - if sight moves - repair and retarget.
	Line-up butt	Both sights aligned & square.

COMPILED BY: J. H. Tuss

APPROVAL & DATE:

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

TPR-19

PART: Final Assembly	PART No.

Target & Test

Test	Method	Key Points
Proof	Fire one proof cartridge	Check for distortion, cracks etc.
Align Sights	Fire sufficient shots to align sights at 100 yards	
Target	Line 5 shots at 100 yards for test to following specification	100% in 3"
	If gun does not meet above standard, fire 5 more shots total must meet specification	100% in 4" 80% in 3"
Live Ammunition	Open bolt and check receiver, chamber and magazine	

OBSOLETE

COMPILED BY:	APPROVAL & DATE:

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

TPR-1

81.

OBSOLETE

PROCESS RECORD

FIRST INSPECTION

TARGET & TEST

FINAL INSPECTION

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

No longer req'd
HWH 7/30/46

ISSUED TO: _____
DEPARTMENT

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3. All sketch sheets preceed the operation sheets and are divid

[redacted]

PROCESS RECORD

Final Assembly

ISSUED BY:
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

OBSOLETE
Stripped
8/1/46

ISSUED TO: _____
DEPARTMENT

TPR-1

PROCESS RECORD

Final Assembly

ISSUED BY:
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
ILION, NEW YORK

OBSOLETE

Recycle 8/1

ISSUED TO: _____ DEPARTMENT

PART: Final Assembly	PART No. Final Assembly

SEQUENCE OF OPERATIONS

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1	Engrave Serial Number	
2	2	Assemble Trigger Assembly, Bolt stop, ~~[illegible]~~, & receiver	
3	3	Final Chamber Reaming ~~& Chamber Heading~~	
4	4	Assemble Sights	
6	5	Final Assembly	
4	6	Mark Serial Number on Bolt ~~Number Bolt~~	
7	10	First Inspection	
8	11	Target and Test	
9	12	Check for Live Ammunition	
10	13	Final Inspection	

OBSOLETE
R 7/7

COMPILED BY. | APPROVAL & DATE:

MINGTON ARMS COMPANY, INC., ILION, N. Y.

TPR-2

PART: Final Assembly

PART No. Final Assembly

SEQUENCE OF OPERATIONS

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
	1	Engrave Serial Number	
	2	Assemble Trigger Subassembly, Bolt stop, Spring, & receiver	
	3	Machine Chamber	
	4	Assemble Sights	
	5	Final Assembly	
	6	Number Bolt	

COMPILED BY:

APPROVAL & DATE:

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

Page 1

PART: Firef Housing 6½	PART No. Firef Housing 6½

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
4/4/46	Op #1 - Added operation and fixture to be designed. Op #2 - Added special work and fixture to be designed.
7-25-46	Added Colmonoy application per Reamer B-51592 to Op #3
7-25-46	Added Reamer Tubes B-90098 W, B-90098 U, B-90098 V to Op #3.
7-25-46	Added following gages to Op #3: B-52086 W, V; B-51994 W, V; B-51995 W, V; B-52084 W, V; B-52085 W, V C-52093; C-52094; C-52095; C-52096; C-52097 C-52095 W; C-52093 W; C-52094 W; C-52097 W
7-25-46	Added Forming Guide B-52347 to Op #1
7-25-46	Changed Sequence of Operations from 1, 2, 3, 4, 5, 6 to 1, 2, 3, 5, 6, 4.
7-25-46	Changed Name of Op. #3 from Machine Chamber to Final Chamber Reaming.
7-25-46	Changed Step Gage to Flush Pin Gage B-52089 on Op #10

OBSOLETE per Ryan V

COMPILED BY:	APPROVAL & DATE:

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

[redacted]

FR-17

PART:	PART No.
Final Assembly	Final Assembly

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
4/4/46	OP. #1 - Added operation and fixture to be designed. OP. #2 - Added special machine and tooling to be designed.

OBSOLETE

COMPILED BY:	APPROVAL & DATE:

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

TPR-17

PART: Final assembly	PART No. Final assembly

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE
7-29-46	assigned Op #10 to First Inspection " Op. #11 to Target & Test " 12 to Check for live Ammunition " 13 to Final Inspection

key prob 8/2
OBSOLETE

COMPILED BY:	APPROVAL & DATE:

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

TPR-9

PART: FINAL ASSEMBLY	PART No. FINAL ASSEMBLY
OPERATION: ENGRAVE SERIAL NUMBER	OPER. No.: 17

OBSOLETE

PROCESS RECORD

EQUIPMENT: Gorton 3U Engraver

SPEED:

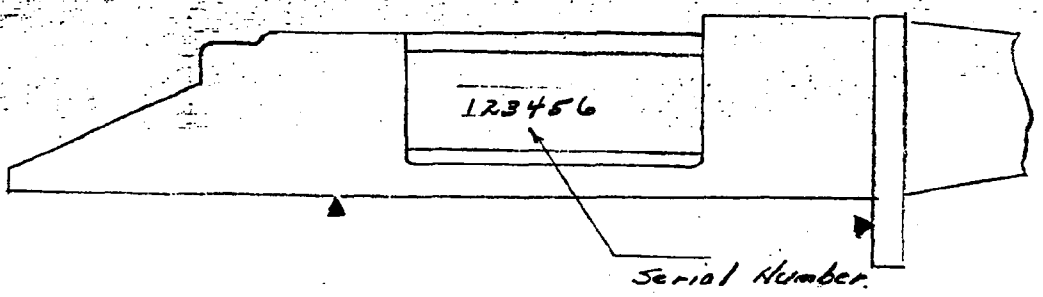
FEED: Hand

MAX. PROD. PER HOUR: 50

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture to locate on O.D. and barrel bracket	D-52322
		1-Forming Guide	A-52347

SKETCH



COMPILED BY:	APPROVAL & DATE: TWR 8/20/46

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

TPR-9

PART: Final Assembly

PART No. M1721 4 722 Final Assembly

OPERATION: Engrave Serial Number on Receiver

OPER. No.: 1

retyped OBSOLETE DEC 27 1946

PROCESS RECORD

EQUIPMENT: Gorton 3-U Engraver

SPEED:

FEED: Hand

MAX. PROD. PER HOUR: 50

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1 - Engraving Cutter	A-52926	1-Fixture	D-52915
1 - Collet Bushing (Dwg. No. B-801296)	Gorton #9619-D	1-Forming Guide	A-52347

SKETCH

COMPILED BY:

APPROVAL & DATE:

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

TPR-4

PART: Final Assembly

PART No. Final Assembly

OPERATION: Engrave Serial Number

OPER. No.: 1

Removed/ OBSOLETE

PROCESS RECORD

EQUIPMENT: Gorton 3U Engraver

SPEED:

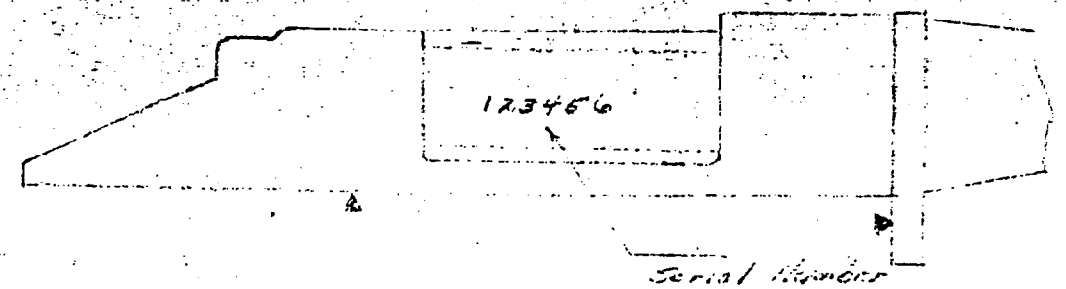
FEED: Hand

MAX. PROD. PER HOUR: 50

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture to locate on OD and barrel chamber	Design D-52322
		1-FORMING GUIDE	A-52347

SKETCH



COMPILED BY:

APPROVAL & DATE:

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

PART: Final Assembly	PART No. Final Assembly
OPERATION: Engrave Serial Number	OPER. No.: 1

PROCESS RECORD

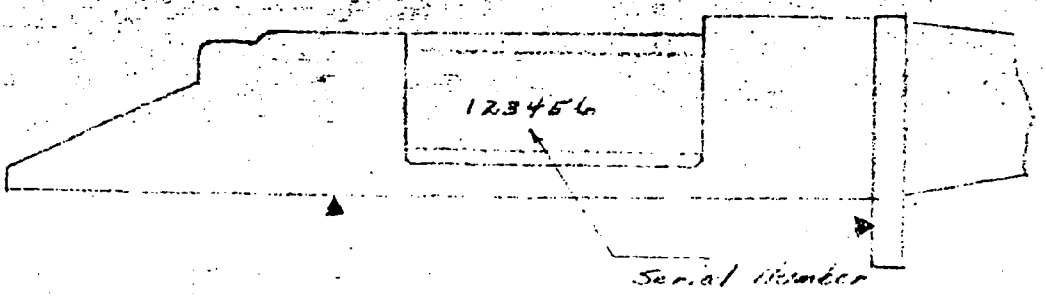
EQUIPMENT: Gorton 3½ Engraver

SPEED: FEED: Hand

MAX. PROD. PER HOUR: 50 COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1- Engraving Cutter	Purchase	1- Fixture to locate on O.D. and barrel bracket.	Design D-52332
		FORMING GUIDE. 7-24-46.	A-52347

SKETCH



COMPILED BY:	APPROVAL & DATE:

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

PART: Final Assembly	PART NO. Final Assembly
OPERATION: Assemble Trigger Assembly, Bolt Stop & Receiver	OPER. NO.: 2

OBSOLETE

PROCESS RECORD - ASSEMBLY

Step	Tools *	Remarks
1. Insert Trigger Assembly, 17036-Y		
2. Start Bolt Stop Pin, 17037-W, and Sear Pin, 17037-V, from right side.	~~1 Hammer~~	
3. Insert Bolt Stop Spring, 17018, and Bolt Stop, 17013		
4. Drive out dummy Pins with Bolt Stop Pin and Sear Pin	~~1 Hammer~~ ~~1 Drift Punch~~	
5. Insert bolt and push safely on.		There must be clearance between Sear and trigger.

* Use normal complement of Hand Tools To Assemble as required

COMPILED BY: | APPROVAL & DATE:

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

TPR-20 A

PART: Final Assembly	PART NO. Final Assembly
OPERATION: Assemble Trigger Assembly, Bolt Stop & Receiver	OPER. No.: 2

Revised 8/2

OBSOLETE

PROCESS RECORD - ASSEMBLY

Step	Tools	Remarks
1. Insert Trigger Assembly, 17036-Y		
2. Start Bolt Stop Pin, 17037-W, and Sear Pin, 17037-V, from right side.	1-Hammer	
3. Insert Bolt Stop Spring, 17013, and bolt stop, 17013		
4. Drive out dummy Pins with Bolt Stop Pin and Sear Pin	1-Hammer 1-Drift Punch	
5. Insert bolt and push safely on.		There must be clearance between gear and trigger. Sear

COMPILED BY:	APPROVAL & DATE:

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

PART: Final Assembly

PART No. Final Assembly

OPERATION: FINAL CHAMBER REAMING ~~Boring~~ Reaming

OPER. No.: 3

PROCESS RECORD

Del Sidem for Shur

EQUIPMENT: Special Chambering Machine

SPEED:

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Special Reamers for Showing Calibers	[redacted]	1 Min. Reaming Fixt.	Available
.300 SAVAGE	C-51889		
.257 Roberts	C-51886		
.270 WINCHESTER	C-51887	1 Mat Reaming Fixt.	Available
.300 H.H. MAGNUM	C-51888		
.30-06	C-51591		
COLMONOY APPLICATION FOR REAMERS	B-51592		

SKETCH	
REAMER TUBE FOR .30-06, .300 SAV. & .300 MAG.	B-90098W
REAMER TUBE FOR .270 WINCHESTER	B-90098V
REAMER TUBE FOR .257 ROBERTS	B-90098U

See next page

Pierpont 81

COMPILED BY:

APPROVAL & DATE:

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

PART: Final Assembly	PART No. Final Assembly
OPERATION: Final Chamber Reaming	OPER. No.: 3

PROCESS RECORD

EQUIPMENT: Special Chambering Machine

SPEED: FEED: Hand

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Special Reamer for following Calibers 300 Sav. 257 Roberts 270 Win. 300 Mag. 30-06	Design	1- Min. Heading Plug 1- Mod Heading Plug	Available Available

SKETCH

COMPILED BY: APPROVAL & DATE:

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

OBSOLETE as new Rev M per 0/14

PART: Final Assembly | PART No. Final Assembly

OPERATION: Machine Chamber Ext | OPER. No.: 3

PROCESS RECORD

EQUIPMENT: Special Chambering Machine

SPEED: | FEED: Hand

MAX. PROD. PER HOUR: | COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Special Reamers for Heading Calibers 300 Sav. .257 Roberts .270 Win. .300 H&H Mag. 30-06	Design	1 Rec. Heading Mtg. FIXTURE.	D-51580
		1 Rec. Heading Mtg.	Gauges

REAMER (30-06) → C-51591
" (.257 ROB.) → C-51886
" (.270 WIN) → C-51887
" (.300 H & H MAG.) → C-51888
" (.300 SAV.) → C-51889

REAMER TUBE (.30-06, .300 H&H MAG., .300 SAV.) → B-90098-W
" " (.270 WIN.) → B-90098-V
" " (.257 ROB.) → B-90098-U

(GO) HEADING DIMM'S (.30-06) (A.U. .270 WIN.) → B-51995-W
(NO GO) " " (.30-06) (A.U. .270 WIN.) → B-51995-V
(GO) " " (.257 ROB.) → B-52086-W
(NO GO) " " (.257 ROB.) → B-52086-V
(GO) " " (.300 SAV.) → B-51994-W
(NO GO) " " (.300 SAV.) → B-51994-V
(GO) " " FOR CDTG. RIM C'BORE (.300 H&H MAG.) → B-52084-W
(NO GO) " " " " " " (.300 H&H MAG.) → B-52084-V
(GO) " " FOR SHOULDER (.300 H&H MAG.) → B-52085-W
(NO GO) " " " " (.300 H&H MAG.) → B-52085-V

COMPILED BY: | APPROVAL & DATE: See Other Side Of Sheet.

[illegible] ARMS COMPANY, INC. [illegible]

TPR-9

PART: Final Assembly

PART No. Final Assembly

OPERATION: Machine Hardening

OPER. No.: 3

OBSOLETE All items used in one shift

PROCESS RECORD

EQUIPMENT: Special Hardening Machine

SPEED:

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS. JIGS & FIXTURES	
TYPE	No.	TYPE	No.
~~Special Hardening Coil~~ ~~Soft Spot~~ ~~Set Screw~~ ~~Hole Cent.~~ ~~Hole Dia.~~ ~~Hole~~	Design	1- Min. Hardening Ring	Available
		1- Max Hardening Ring	Available

SKETCH

RETYPE AS PER SHEETS ATTACHED

OJ 8/5/46

COMPILED BY:

APPROVAL & DATE:

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

TPR-6

PART: FINAL ASSEMBLY	PART No. FINAL ASSEMBLY
OPERATION: FINAL CHAMBER REAMING	OPER. No.: 3

OBSOLETE

PROCESS RECORD

EQUIPMENT: Special Chambering Machine

SPEED: FEED: Hand

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Special Reamer for Following Calibers:		1- Min. Heading Plug	Available
.300 Savage	C-51889		
.257 Roberts	C-51886	1- Max. Heading Plug	Available
.270 Winchester	C-51887		
.300 H. H. Magnum	C-51888		
.30-06	C-51591		
Colmoncy Application for Reamers	B-51592		
Reamer Tube for .30-06, .300 Sav. & .300 Mag.	B-90098W		
Reamer Tube for .270 Winchester	B-90098V		
Reamer Tube for .257 Roberts	B-90098U		
Heading Dummies For:			
.257 Roberts	B-52086W,V		
.300 Savage	B-51994W,V		
.30-06,-.270 Win.	B-51995W,V		
Heading Devices for:Cartridge Rim Counterbore:			
.300 Magnum	B-52084W,V		
Heading Devices for:Shoulder			
.300 Magnum	B-52085W,V		
Chamber Heading Dummy Master:			
.30-06, .270 Win.	C-52093		
.257 Roberts	C-52094		
.300 Savage	C-52095		

COMPILED BY:	APPROVAL & DATE:

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

PR-6

OBSOLETE

PART: FINAL ASSEMBLY	PART No. FINAL ASSEMBLY
OPERATION: FINAL CHAMBER REAMING	OPER. No.: 3

PROCESS RECORD

EQUIPMENT: Special Chambering Machine

SPEED: FEED: Hand

MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Reamer:		Reamer Tube:	
.30-06	C-51591	.30-06, .300 H & H Mag., .300 Sav.	B90098W
.257 Robts.	C-51886		
.270 Win.	C-51887	.270 Win.	B90098X
.300 H & H Mag.	C-51888	.257 Robts.	B90098U
.300 Sav.	C-51889	Fixture	D-5158o
Hand Reamer Assembly .300 H & H Mag. Ctge. Rim Counterbore	C-52431		
Heading Dummy		~~Heading Dummy for Shoulder~~ Shoulder	
.30-06 & Added Use .270 Win. Go	B-51995W	.300 H & H Mag.-Go	B52085W
No Go	B-51995V	.300 H & H Mag.-No Go	B52085V
.257 Robts. Go	B-52086W	Chamber Heading Dummy Master	
No Go	B-52086V	.30-06 & Added Use .270 Win	C52093
		.257 Robts.	C52094
.300 Sav.		.300 Sav.	C-52095
Go	B-51994W	Chamber Heading Dummy Master	
No Go	B-51994V	For Cdg. Rim C'bore .300 H & H Mag.	B-52096
300 H+H Mag. Cdrc Rim C'bore Go	B-52097W		
Taper Test Plug For Master No Go	B-52097V	Chamber Heading Dummy Master For Shoulder	C 52095
.30-06 Added Use .270 Win.	C-52093W	.300 H & H Mag.	B-52096
.257 Robts.	C-52094W		
.300 Sav.	C-52095W	~~Chamber Heading Dummy Master For Shoulder~~	
.300 H & H Mag. For Ctg. Rim Counterbore Shoulder	C-52097W	.300 H & H Mag.	~~B-52096~~

COMPILED BY: AT APPROVAL & DATE:

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

Op # 3
Final assembly

Heading Dummies:

.257 Roberts	B-52086 W, V
.300 Savage	B-51994 W, V
.30-06, .270 WIN.	B-51995 W, V

Heading Dummies for cartridge rim counterbore:

.300 Magnum	B-52084 W, V

Heading Dummies for shoulder

.300 Magnum	B-52085 W, V

Chamber Heading Dummy Master:

.30-06, .270 WIN.	C-52093
.257 Roberts	C-52094
.300 Savage	C-52095

Cartridge Rim Counterbore Heading Dummy Master:

.300 Magnum	C-52096

Shoulder Heading Dummy Master:

.300 Magnum	C-52097

Taper Test Plug for Master:

.300 Savage	C-52095 W
.30-06, .270 WIN.	C-52093 W
.257 Roberts	C-52094 W
.300 Magnum	C-52097 W

Returned B/V

TPR-8

PART: Final Assembly

PART No. Final Assembler

OPERATION: Final Chamber Reaming

OPER. No.: 3

PROCESS RECORD

EQUIPMENT: Special Chambering Attachment

SPEED:

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Reamer:		Reamer Tube:	
.30-06	C-51591	.30-06, .300 H+H Mag., .300 Sav.	B-90098-W
.257 Roberts	C-51886	.270 Win.	B-90098-V
.270 Win.	C-51887	.257 Roberts	B-90098-U
.300 H+H Mag.	C-51888		
.300 Sav.	C-51889		
Hand Reamer Assembly .300 H.+H. Mag. Cte. Rim C'bore	C52431		
Heading Dummy		Heading Dummy for Shoulder	
.30-06 + R.U. .270 Win		.300 H+H Mag - Go	B-52085-W
Go	B-51995-W	.300 H+H Mag. No Go	B-52085-V
No Go	B-51995-V		
.257 Roberts		Chamber Heading Dummy Master	
Go	B-52086-W	.30-06 + R.U. .270 Win	C-52093
No Go	B-52086-V	.257 Roberts	C-52094
.300 Sav.		.300 Sav.	C-52095
Go	B-51994-W		
No Go	B-51994-V	Chamber Heading Dummy Master for Cdg. Rim C'bore - .300 H+H Mag.	B-52096
Heading Dummy for Cdg. Rim C'bore		Chamber Heading Dummy Master for Shoulder	
.300 H+H Mag. - Go	B-52084-W	.300 H+H Mag	C-52097
.300 H+H Mag. No Go	B-52084-V		

COMPILED BY: AT

APPROVAL & DATE:

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

PART: Final Assembly	PART No. Final Assembly
OPERATION: Assemble Sights	OPER. No.: 4

PROCESS RECORD - ASSEMBLY

Step	Tools *	Remarks
1. Insert Front Sight, 17026, flush with Ramp	~~1-Fibre Hammer~~	Must be tight in Dovetail
2. Insert Rear Open Sight Assembly, 17030-Y, and Open Sight Step, 17033-W	~~1-Fibre Hammer~~	Must be tight in Dovetail

* USE NORMAL COMPLEMENT OF HAND TOOLS TO ASSEMBLE AS REQUIRED.

COMPILED BY:	APPROVAL & DATE:

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

TPR-20

PART: Final Assembly	PART NO. Final Assembly
OPERATION: Assemble Sights	OPER. NO.: 4

PROCESS RECORD - ASSEMBLY

Step	Tools	Remarks
1. Insert Front Sight, 17026, flush with Ramp	1-Fibre Hammer	Must be tight in Dovetail
2. Insert Rear Open Sight Assembly, 17030-Y, and Open Sight Step, 17033-W	1-Fibre Hammer	Must be tight in Dovetail

Replaced by OBSOLETE

COMPILED BY:	APPROVAL & DATE:

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

PART: Final Assembly	PART No. Final Assembly
OPERATION: Final Assembly	OPER. No.: 5

PROCESS RECORD - ASSEMBLY

Step	Tools *	Remarks
1. Check and set Trigger pull at 4 to 5 lbs.	1 ~~Trigger Scale~~ 1 ~~1/8" Blade Screw Driver~~	
2. Position Stock 17035-W		
3. Insert Magazine Follower Assembly, 17115.		
4. Insert Trigger Guard, 17054-W AND Trigger Guide Plate, 17055		
5. Insert Front Guard Screw, 17025-W and Rear Guard Screw, 17025-V.	~~1 [illegible] Blade Screw Driver~~	
6. Insert Receiver Plug Screws (4), 17034	~~1/8" Blade Screw Driver~~	
7. Tighten Butt Plate Screws	1 ~~1/4" Blade Screw Driver~~	

* USE NORMAL COMPLEMENT OF HAND TOOLS TO ASSEMBLE AS REQUIRED.

Rejected 9/1/44

COMPILED BY:	APPROVAL & DATE:

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

IPR-20

PART: Final Assembly	PART No. Final Assembly
OPERATION: Final Assembly	OPER. No.: 5

PROCESS RECORD - ASSEMBLY

Step	Tools	Remarks
1. Check and set Trigger pull at 4 - 5#.	1-Trigger Scale 1-1/8" Blade Screw Driver	
2. Position Stock 17035-W		
3. Insert Magazine Follower Assembly, 17115.		
4. Insert Trigger Guard, 17054-W Trigger Guide Plate, 17055		
5. Insert Front Guard Screw, 17025-W and Rear Guard Screw, 17025-V.	1/4" Blade Screw Driver	
6. Insert Receiver Plug Screw (4), 17034	1/8" Blade Screw Driver.	
7. Tighten Butt Plate Screws	1/4" Blade Screw Driver	

COMPILED BY: | APPROVAL & DATE:

- REMINGTON ARMS COMPANY, INC., ILION, N. Y.

TPR-9

OBSOLETE
1947

PART: FINAL ASSEMBLY	PART No. FINAL ASSEMBLY
OPERATION: MARK SERIAL NUMBER ON BOLT	OPER. No.: 6

PROCESS RECORD

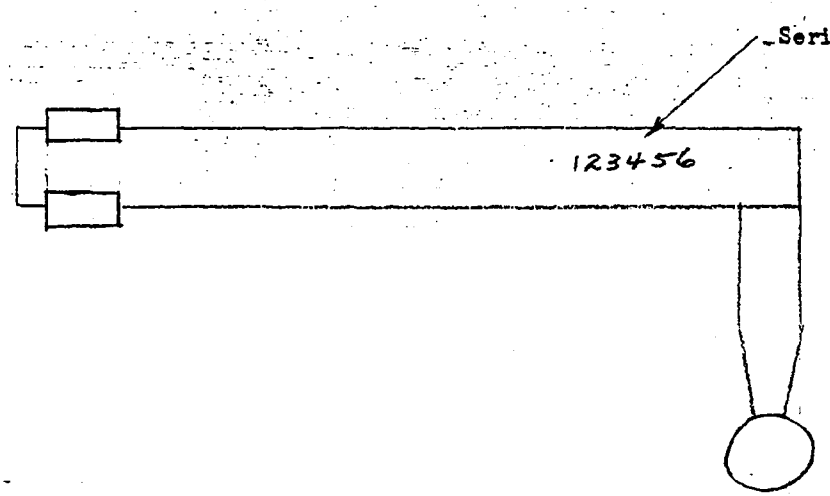
EQUIPMENT: Gorton 3U Engraver

SPEED: FEED: Hand

MAX. PROD. PER HOUR: 50 COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture	Purchase

SKETCH



COMPILED BY:	APPROVAL & DATE: MVK 8/30/46

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

OBSOLETE DEC 27 1946

PART: FINAL ASSEMBLY	PART NO. FINAL ASSEMBLY
OPERATION: MARK SERIAL NUMBER ON BOLT	OPER. No.: 6

PROCESS RECORD

EQUIPMENT: Gorton 3U Engraver

SPEED:

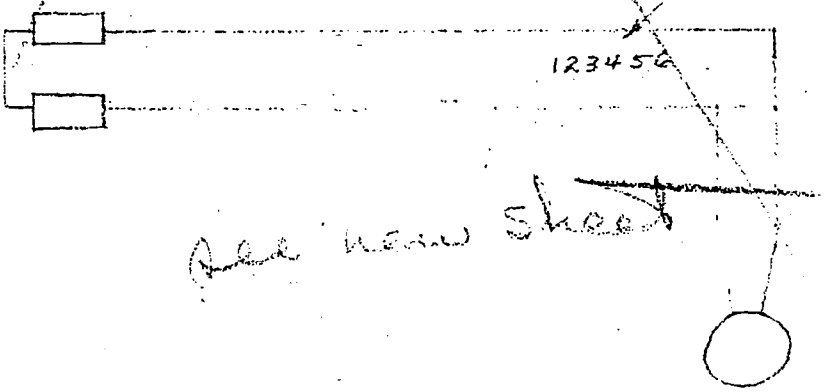
FEED: Hand

MAX. PROD. PER HOUR: 50

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture	Purchase

SKETCH



COMPILED BY:	APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. [illegible] REVISED AUG 2/61

PR-9

PART: Final Assembly

PART No. M1721 + 722 Final Assembly

OPERATION: Mark Serial Number on Bolt

OPER. No.: 6

Returned ORIGINAL DEC 27 1915

PROCESS RECORD

EQUIPMENT: Gorton 3-U Engraver

SPEED:

FEED: Hand

MAX. PROD. PER HOUR: 50

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	A-52926	1-Fixture	D-52915
1-Collet Bushing (Dwg. #B-80129W)	Gorton #9619-D	1-Adapter	B-52919
		1-Forming Guide	A-52925

SKETCH

Mitch Smith

COMPILED BY:

APPROVAL & DATE:

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

PART: Final Assembly	PART No.: Final Assembly
OPERATION: Mark Serial Number on Bolt	OPER. No.: 6

PROCESS RECORD

EQUIPMENT: Gorton 3C Engraver

SPEED: FEED: Hand

MAX. PROD. PER HOUR: 50 COOLANT: None

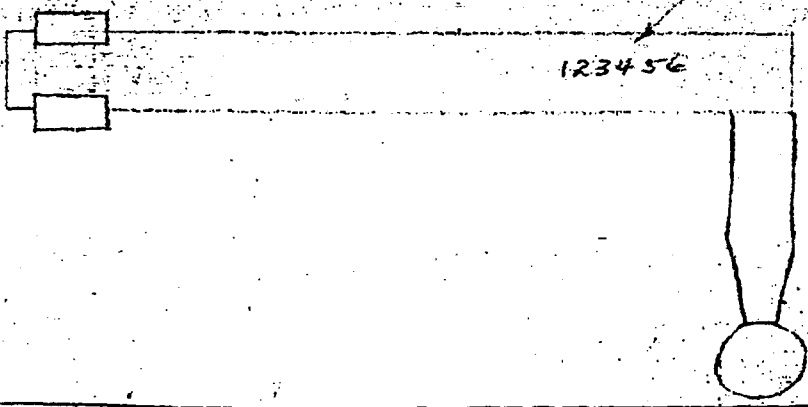
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1 - Engraving Cutter	Purchase	1 - Fixture	Purchase

SKETCH

OBSOLETE
Revised 1/8/x

Serial Number

123456



COMPILED BY:	APPROVAL & DATE:

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

TPR-11

OBSOLETE

PART: FINAL ASSEMBLY	PART NO. Final Assembly
OPERATION: FIRST INSPECTION	OPER. NO. 10

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Reassemble		1. Cock firing pin by retracting firing pinhead with special tool. 2. Insert bolt past bolt stop - no bind. 3. Pull back bolt to test - bolt stop should hold.		
Stamp		1. First inspection mark in bolt handle slot of stock.		
		To Gallery for Target & Test		

COMPILED BY: M. Davis

APPROVAL & DATE:

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

Page 1

TPR-11

PART: FINAL ASSEMBLY	PART NO. Final Assembly
OPERATION: First Inspection	OPER. No.: 10

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
		3. Rear Sight (Cont.) b. Both sights aligned, square, & central with butt.		
Feeler Gage		4. Opening under front end of of near sight at barrel	0.015	
Assembly Heading Plugs Min. 30-06 300 Sav. 300 Mag. 270 Win. 257 Roberts Mag 30-06 300 Sav 300 Mag. 270 Win. 257 Roberts		1. All calibers - Min. Insert heading plug in chamber and close action bolt should lock-accept if snug.		
		2/ All calibers - Max. Insert in chamber & close action - bolt must not lock and safe not go on.		
Function		1. Load (2) dummies into magazine & depress full depth with screwdrivers & release quickly - cartridges must not jump past receiver rails.		
		2. Load 2 more to fill magazine -depress (4) cartridges - should have overdraw and bolt must pass over top dummy.		
		3. Operate bolt - must feed and eject properly at normal speed without missed feeds or binding or stemming at top of chamber.		
		4. Load (1) dummy cartridge into chamber-Close bolt with normal speed-extractor must ride over rim of dummy with no bind and open bolt to eject dummy.		
		5. Operate bolt (3) times and fire - no bind - bolt		

wood plug

COMPILED BY:	APPROVAL & DATE:

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

TPR-U

PART: FINAL ASSEMBLY	PART No. Final Assembly
OPERATION: First Inspection	OPER. No.: 10

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN
		3. Rear Sight (Cont.) b. Both sights aligned, square, & central with butt.		
Feeler Gage		4. Opening under front end of of near sight at barrel	0.015	
Assembly Heading Plugs		1. All calibers - Min. Insert heading plug in chamber and close action bolt - should lock-accept if snug.		
Min. 30-06	C-52093 W	2/ All calibers - Max. Insert in chamber & close action - bolt must not lock and safe not go on.		
300 Sav.	C-52095 W			
300 Mag.	C-52097 W			
270 Win.	C-52098 W			
257 Roberts	C-52094 W			
Max. 30-06	C-52093 V	1. Load (2) dummies into magazine & depress full depth with screwdriver & release quickly - cartridges must not jump past receiver rails.		
300 Sav.	C-52095 V			
300 Mag.	C-52097 V			
270 Win.	C-52098 V			
257 Roberts	C-52093 V			
Function	C-52094 V	2. Load 2 more to fill magazine -depress (4) cartridges - should have overdraw and bolt must pass over top dummy.		
		3. Operate bolt - must feed and eject properly at normal speed without missed feeds or binding or stemming at top of chamber.		
		4. Load (1) dummy cartridge into chamber-Close bolt with normal speed-extractor must ride over rim of dummy with no bind and open bolt to eject dummy.		
		5. Operate bolt (3) times and fire - no bind - bolt		

COMPILED BY: [signature] APPROVAL & DATE:

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

PART: FINAL ASSEMBLY	PART No. Final Assembly
OPERATION: FIRST INSPECTION	OPER. No.: 10

OBSOLETE

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Assembly	Visual	1. See that gun is empty.		
		2. Check for assembly Stamp left side of barrel.		
		3. Match specification tag with gun for:		
		a. Caliber marking		
		b. Patent marking		
		c. Model no.		
		d. Serial no.		
		e. Barrel overall length		
		f. Grade		
		4. All markings to be clear & Legible.		
		5. Check for agreement of bolt & trade/commercial numbers.		
Butt Plate	Visual	1. Finish		
		a. Uniform color		
		b. No rough edges		
		c. Edge chamfered		
		2. Butt Plate screws (2) tight		
Stock	Visual	1. No checks or mutilations that can not be repaired at final inspection.		
		2. Safety Lever must clear stock		
		3. Stock Screws (2) tight		
		4. No sharp edges.		
		5. Barrel must seat in forend and return to same spot when pulled away and pushed from side to side.		
Feeler Gage		6. Barrel receiver space	0.015	
Feeler Gage		7. Margin at right side Rail Wood	0.015	
		Steel	0.010	
Feeler Gage		8. Margin around receiver Tang Wood	0.015	
		Steel	0.005	
Feeler Gage		9. Gap at Rear of Trigger Guard	0.015	0.030
Feeler Gage		10. Margin at Trigger Guide Plate Steel	0.005	

COMPILED BY: S. H. Quist

APPROVAL & DATE:

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

OBJECT

FINAL ASSEMBLY	PART NO. Final Assembly
OPERATION: FIRST INSPECTION	OPER. NO. 10

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Assembly	Visual	1. See that gun is empty.		
		2. Check for assembly Stamp left side of barrel.		
		3. Match specification tag with gun for:		
		a. Caliber marking		
		b. Patent marking		
		c. Model no.		
		d. Serial no.		
		e. Barrel overall length		
		f. Grade		
		4. All markings to be clear & Legible.		
		5. Check for assembly of butt and receiver and finish		
Butt Plate	Visual	1. Finish		
		a. Uniform color		
		b. No rough edges		
		c. Edge chamfered		
		2. Butt Plate Screws (2) tight		
Stock	Visual	1. No checks or mutilations that can not be repaired at final inspection.		
		2. Safety lever must clear stock		
		3. Stock screws (2) tight.		
		4. No sharp edges.		
		5. Barrel must seat in forend and return to same spot when pulled away and pushed from side to side.		
Feeler Gage		6. Barrel receiver space	0.015	
Feeler Gage		7. Margin at right Side of Rail — Wood	0.015	
		Steel	0.010	
Feeler Gage		8. Margin around receiver Tang — Wood	0.015	
		Steel	0.005	
Feeler Gage		9. Gap at Rear of Trigger Guard	0.015	0.030
Feeler Gage		10. Margin at Trigger Guide Plate — Steel	0.005	

COMPILED BY: J. H. Tierney

APPROVAL & DATE:

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

TPR-11

PART: FINAL ASSEMBLY	PART No. Final Assembly
OPERATION: First Inspection	OPER. No.: 10

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Function		5. (Cont.) handle must raise and lower easily.		
		6. Apply pressure on bolt handle up & down - must not cramp or bind.		
		7. Close bolt - must cam follower down in moving forward.		
		8. Open & close bolt forcibly (3) times - firing pin must not follow down.		
		9. Hold bolt handle down & pull trigger-gun must fire instantly no log due to firing pin bind. (1a)		
		10. Bolt handle must seat on receiver stop and clear stock.		
		11. Drop butt 6" to floor - must not fire until trigger is pulled.		
		12. Safety should snap both on and off when pushed in either direction.		
Seale		13. Check trigger pull - no perceptible creep or bind.		
		14. Depress bolt stop release & remove bolt - no bind.		
		15. Release firing pin by turning bolt plug - check firing pin point - no mars		
Step Gage		16. Firing Pin Protrusion	0.075	0.045

COMPILED BY: J. H. Smart | APPROVAL & DATE:

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

PART: FINAL ASSEMBLY	PART No.: Final Assembly
OPERATION: First Inspection	OPER. No.: 10

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Function		5. (Cont.) handle must raise and lower easily.		
		6. Apply pressure on bolt handle up & down - must not cramp or bind.		
		7. Close bolt - must cam follower down in moving forward.		
		8. Open & close bolt forcibly (3) times - firing pin must not follow down.		
		9. Hold bolt handle down & pull trigger-gun must fire instantly no lag due to firing pin bind. CA		
		10. Bolt handle must seat on receiver stop and clear stock.		
		11. Drop butt 6" to floor - must not fire until trigger is pulled.		
		12. Safety should snap both on and off when pushed in either direction.		
Seale		13. Check trigger pull - no perceptible creep or bind.	6#	4#
		14. Depress bolt stop release & remove bolt - no bind.		
		15. Release firing pin by turning bolt plug - check firing pin point - no mars		
Step Gage	B-52089	16. Firing Pin Protrusion	0.075	0.045

COMPILED BY: J. H. Smith | APPROVAL & DATE:

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

PART: FINAL ASSEMBLY	PART No. Final Assembly
OPERATION: FIRST INSPECTION	OPER. No.: 10

PROCESS RECORD — INSPECTION

Formerly OBSOLETE

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Trigger Guard	Visual	1. Finish a. Uniform color b. No serious mars or scratches 2. No bow in trigger guard		
Receiver	Visual	1. Finish a. Uniform Color b. No serious mars or scratches 2. All exposed edges should be chamfered. 3. Scope screw holes present 4. Firing pin head slot - free of mutilation. 5. Magazine edge must be below bullet ramp edge.		
Bolt Plug	Visual	1. Finish a. Uniform color b. No serious mars & scratches 2. Fit - Rotational clearance of bolt plug on F.P. Head must permit match at end of bolt handle at left rear of bolt with flat on bolt plug.		
Firing Pin Head	Visual	1. Finish a. Uniform Color b. No serious mars or scratches 2. No sharp edges.		
Bolt	Visual	1. Finish a. Must be bright b. No serious mars or scratches c. Back of bolt lugs must be ground finish d. No brass visible except in corners of brazed joints.		

COMPILED BY: H. H. Faust | APPROVAL & DATE:

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

PART: FINAL ASSEMBLY	PART NO. FINAL ASSEMBLY
OPERATION: TARGET & TEST	OPER. No.: 11

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Proof Test		1. Visual for first inspection mark. 2. Fire one proof cartridge - check for cracks, distortion, etc. 3. Stamp proof mark on barrel.		
Align Sights & Target Gun		1. Check for proof mark. 2. Load four cartridges & run through action without firing - check for feeding, extraction ejection and marking case or bullet. 3. Reload and fire to align sights at 100 yd.		
Accuracy Test		1. Fire (5) shots at 100 yds - all shots must fall in 3" circle. 2. Repeat above if first test fails. 3. If second test fails return for repair. 4. Stamp target and test mark on right hand side of barrel.		
		~~To Final Inspection~~		

COMPILED BY: APPROVAL & DATE:

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

TPR-11

PART: FINAL ASSEMBLY	PART No. FINAL ASSEMBLY
OPERATION: TARGET & TEST	OPER. No.:

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Proof Test		1. Visual for first inspection mark. 2. Fire one proof cartridge - check for cracks, distortion, etc. 3. Stamp proof mark on barrel.		
Align Sights & Target Gun		1. Check for proof mark. 2. Load four cartridges & run through action without firing - check for feeding, extraction ejection and marking case or bullet. 3. Reload and fire to align sights at 100 yd.		
Accuracy Test		1. Fire (5) shots at 100 yds - all shots must fall in 3" circle. 2. Repeat above if first test fails. - 3. If second test fails return for repair. 4. Stamp target and test mark on right hand side of barrel.		
	~~To Final Inspection~~			

COMPILED BY:	APPROVAL & DATE:

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

PART: Firing Pin

PART NO.: Firing Pin

OPERATION: Check for Loc Concentricity

OPER. No.: 12

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Fixed		Check for Loc concentricity to Check for misalignment of Firing Pin with Bolt		

OBSOLETE

COMPILED BY:

APPROVAL & DATE:

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

PART: FINAL ASSEMBLY | PART No.: Final Assembly

OPERATION: FINAL INSPECTION | OPER. No.: 13

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Assembly	~~Visible~~ Visual	1. Check for live ammunition chamber, magazine, and receiver empty, follower visible. 2. Check stamps: a. Assembly - On barrel left side rear. b. First inspection - In bolt handle slot of stock c. Proof - (REP) On rear right side of barrel d. Target & test - On rear right side of barrel. 3. Tag - must match with gun.		
Stock	~~Visible~~ Visual	1. Finish - no check, mars and only slight scratches 2. Set screws tight in stock, mars and burrs slight and no bad projections. 3. Barrel must seat and return to same position when pulled away and moved from side to side.		
Barrel	Visual	1. Finish a. Color uniform b. No serious mars or scratches. c. No jams at muzzle crown. d. Accept 1/16" light ring around bore.		
Sights (Front & Rear)	Visual	1. Finish a. Color uniform b. No serious mars or scratches 2. Check both sights for tightness in dovetail with		

COMPILED BY: | APPROVAL & DATE:

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

OBSOLETE

PART: FINAL ASSEMBLY	PART No.: Final Assembly
OPERATION: FINAL INSPECTION	OPER. No.: 13

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Cont. Sights (Front & Rear)	Visual	2. cont. light blow of copper hammer - if sight moves repair and re-target.		
		3. Both sights must be aligned and square with butt.		
Function, 30-06	C-52093 V	1. Max. heading plug - insert in chamber, close action - bolt should not lock and safe should not go on. Accept if very snug.		
300 Sav	C-52095 V			
300 mag	C-52097 V			
257 Robt	C-52093 V			
270 Win	C-52094 V	2. Operate bolt (3) times and fire - no bind, bolt handle raises and lowers easily.		
		3. Open and close bolt forcibly (3) times - trigger must not follow down.		
		4. Push "On" safe - no bind.		
		5. Push safe off with thumb - no bind, must not fire until trigger is pulled.		
Scale		6. Trigger pull - no perceptible creep or bind trigger must retract after firing.	5#	4#
Function	Visual	7. Wire brush and wipe bore - check for rust or other defects.		
Assembly		1. Insert bolt - no bind by bolt stop		
		2. Pull back bolt to test - bolt stop must stop bolt.		
Stamp		1. Final inspection mark on left side rear of barrel.		

COMPILED BY: [signature] APPROVAL & DATE:

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

PART: FINAL ASSEMBLY	PART No. Final Assembly
OPERATION: FINAL INSPECTION	OPER. No.: 13

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	LIMITS MAX.	LIMITS MIN.
Stamp (Cont.)		2. Date code mark on left side rear of barrel. 3. Sign tag		
		Send to Warehouse		

Revised 8/2
OBSOLETE

COMPILED BY: [signature] APPROVAL & DATE:

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

OBSOLETE
REVISED APR 23 1947

PART: SAFETY CAM

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp.)	
2	Cut to ~~#~~ Length (Temp.)	
4	Grind to Thickness (Temp.)	
	Ship Steel to Vendor for Stamping (Temp.)	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'sink Hole to Remove Burr	
14	Wash	
16	Grind Bottom of Safety Notch	
18	Grind Safety Notch	
20	Grind F. P. Rd. Surface	
22	[illegible]	
24	[illegible] (Cyanide)	
26	Heat Treat Inspection	
28	[illegible]	
	Transfer to Part Stores	
26	Hi Temp Cyanide Harden, Oil Quench	
28	Wash & Dry, No oil	
28	Inspect for File Hardness	
30	Temper Draw, Water Quench, Dri-Cool Wash Alloy Oil for Storage	
32	Inspect for Rockwell Hardness Color Code	
34	Transferring	

COMPILED BY: [illegible] APPROVAL & DATE: [illegible]

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

SULLIVAN INC.

OBSOLETE
REVISED APR 23 1947

PART: SAFETY CAM

DATE 7-7-25

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp.)	
2	Cut to 4! Length (Temp.)	
4	Grind to Thickness (Temp.)	
	Ship Steel to Vendor for Stamping (Temp.)	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'sink Hole to Remove Burr	
14	Wash	
16	Grind Bottom of Safety Notch	
18	Grind Safety Notch	
20	Grind F. & P. Hd. Surface	
22	Finish Burr	
24	Heat Treatment (Cyanide)	
26	Heat Treat Inspection	
28	Inspect	
	Transfer to Part Stores	

COMPILED BY: J. F. Bowling | APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

PART: Safety Lever | PART No. 17995

OBSOLETE REVISED APR 4 1941

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp)	
2	Cut to 4" Length (Temp)	
4	Grind to Thickness (Temp)	
	Ship Steel to Vendor for Stamping (Temp)	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'Sink Hole to Remove Burr	
14	Wash	
16	Grind Bottom of Safety Notch	
18	Grind Safety Notch	
20	Grind F.P. Hd Surface	
22	Finish Burr	
24	Heat Treatment (Cyanide)	MHS
26	Heat Treat Inspection	
28	Inspect	
	Transfer to Parts Stores	

COMPILED BY: | APPROVED & DATE:

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

SAFETY CAM 17945

MATERIAL PROCUREMENT - RAW MATERIAL Date 2/5/47

Detailed Description

REV. NO.	DATE
1	2/18/47
2	2/20/47
3	3/10/47

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI C-1022 or substitutes [redacted] C-1020, [redacted] C-1025, [redacted] C-1019

Size : .084" +.002 -.002 X [redacted] +.008 -.008 X 10 to 12' lengths

Condition : Cold Finished Strip

Temper : Half Hard

Edge : ##3

Finish : #2

Weight Per 100 : Calculated 3.1 Measured

Additional Uses of Material :

Uses of Part : M/721 Safety Cam

Identification of Material : Routing Ticket to be marked Mat. Spec. No. 101B

Remarks:

1. This material is for shipment to stamping vendor.
2. To facilitate procurement material up to 1/8" thickness can be used but will have to have operations 2 & 4 performed before shipment to vendor.

COMPILED BY: R.H.Grace 2/5/47 | APPROVAL & DATE: 3/11/47

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

PART: SAFETY CAM 17945

OBSOLETE

MATERIAL PROCUREMENT – SEMI-FINISHED

DATE
3/10/47

REMINGTON PLANNING

Pieces Required Per Assembly: 1

Uses of Part : M/721 & 72

VENDOR

Material : AISI 1022 or substitutes ~~1019~~, 1020, 1025, ~~[redacted]~~, C-1019
Packing slip to show material used for each shipment of parts.

Heat Treatment : None

Final Appearance : Commercial Stamping, Sheared Edge except for shaved edge as noted on inspection process.

Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which 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 on the Process Record Inspection Page.

Remarks:

COMPILED BY: J. F. Bowling
DATE: 2/20/47

APPROVAL & DATE:

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

H. H. SULLIVAN, INC.

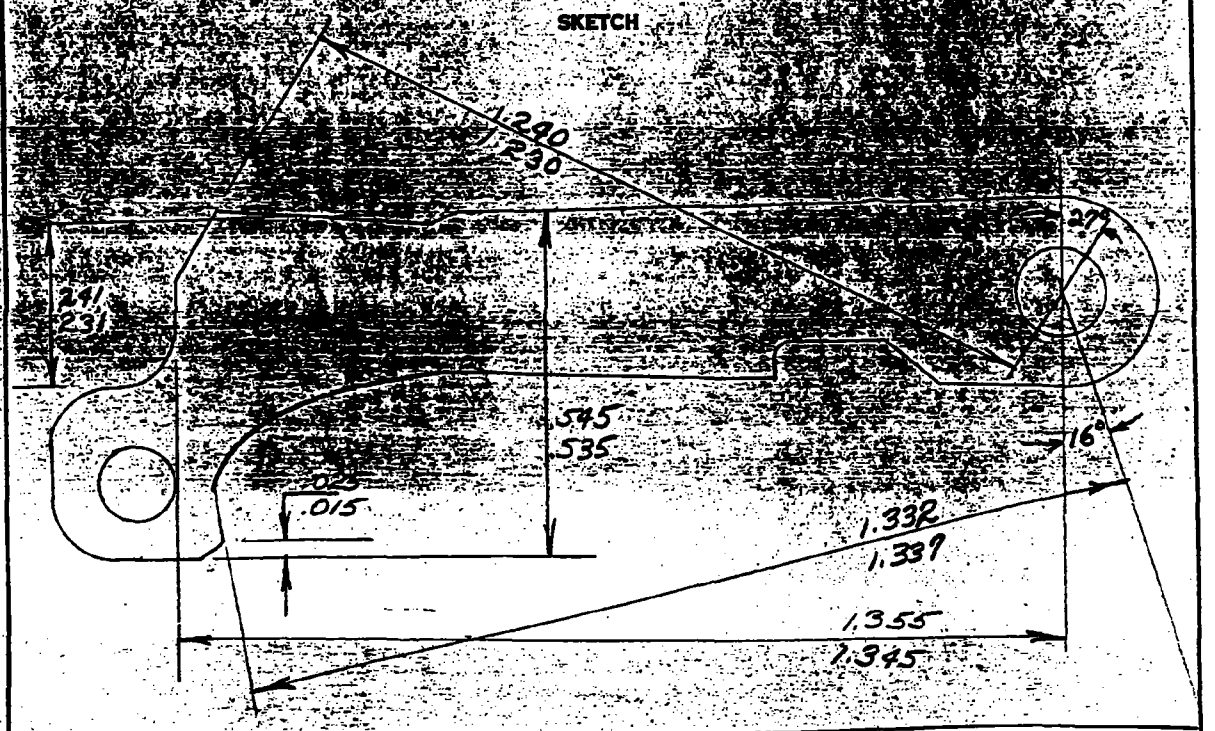
PART: SAFETY CAM — PART No. 19-17925

OPERATION: PURCHASED PART INSPECTION — OPER. No.:

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES No.	USE	AOQL	LIMITS MAX.	LIMITS MIN.
J & L Comparator					
Compar. Fixt.		Check Dim. as shown below	7%		
Compar. Stage					
Compar. Screen					
Adj. Snap Gage		Check height of bump	7%	.115	.110
Plug Gage		Check Pierced Hole	7%	.123	.120

SKETCH



COMPILED BY: J. F. Bowling 2/21/47 — APPROVAL & DATE: MHS

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

J. J. SULLIVAN, INC.

OBSOLETE

REVISED APR 4

PART: Safety Cam

OPERATION: Hand Feed Thickness (Temp.)

PROCESS RECORD

EQUIPMENT: 12"x48" MATTISON SURFACE GRINDER

SPEED:

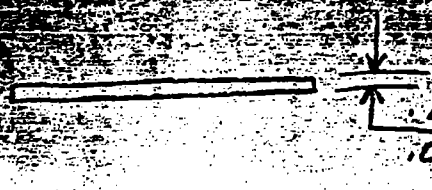
FEED:

MAX. PROD. PER HOUR:

COOLANT: Concentrate Sol. Oil

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
ADJ. SNAP GA. .086-.082 3/16	B-80138-W		

SKETCH



COMPILED BY: Bowling

APPROVAL & DATE:

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

OBSOLETE
REVISED APR. 1947

PART [illegible] SAFETY CAT

OPERATION PURCHASED PART INSPECTION

PROCESS RECORD — INSPECTION

GAUGES TYPE	GAUGES NO.	USE	LIMITS MAX.	LIMITS MIN.
J & L Comparator				
Compar. Fixt.	C-53230	Check Dim. as shown below		
Compar. Screen	C-53232			
1" Micrometer Adj. Snap Gage	1.5Td	Check height of bump	.125	.110
Plug Gage .ED-43	S-8006 N	Check Pierced Hole	.130	.120

SKETCH

COMPILED BY J. F. Howling 2/21/47 | APPROVAL & DATE MHS

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

SULLIVAN INC.

OBSOLETE
REVISED APR 4 1947

PART: Safety Pin

OPERATION: Ream Pin Hole

OPER. NO.: 10

PROCESS RECORD

EQUIPMENT: Leland Gifford Drill Press

SPEED: 600

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT: Arcol or Lt. Oil

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Reamer	B-900794	Jig	B-53234
Plug Gage .1267-.1259	B-Ba106-M		

SKETCH

MHS

COMPILED BY: Bowling

APPROVAL & DATE:

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

OBSOLETE
REVISED APR 1947

PART: ~~SEAR~~ Lift Bar Hook

OPERATION: C'SINK TO REMOVE BURRS

OPER. NO. 72

PROCESS RECORD

EQUIPMENT: #1 Leland-Gifford Drill Press

SPEED: 1800

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Drill - 3/16" 90° pt.	B-90144W	Hold in Hand to burr both sides. Slight c'sink is desirable	

SKETCH

MHS

COMPILED BY: J. F. Bowling 1/9/47

APPROVAL & DATE: MHS 1/10/47 JM 1/14/47

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

OBSOLETE
REVISED APR

PART NO. 1187[illegible]

OPERATION: Grind Bottom of Safety Surface — OPER. NO. 16

PROCESS RECORD

EQUIPMENT: #2 B&S Surface Grinder

SPEED:

FEED: Hand

MAX. PROD. PER HOUR:

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Dial Gage	C-53239	Fixture	C-53250
1" Micrometer	Std.		

SKETCH

Safety Blank

.531
.528

MHS

COMPILED BY: Bowling

APPROVAL & DATE:

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

PAUL SULLIVAN, INC.

OBSOLETE

PART: Safety Cam

DATE: 1945

OPERATION: Grind Safety Notch

OPER. NO.: 28

PROCESS RECORD

EQUIPMENT: #2 B & S Surface Grinder

SPEED:

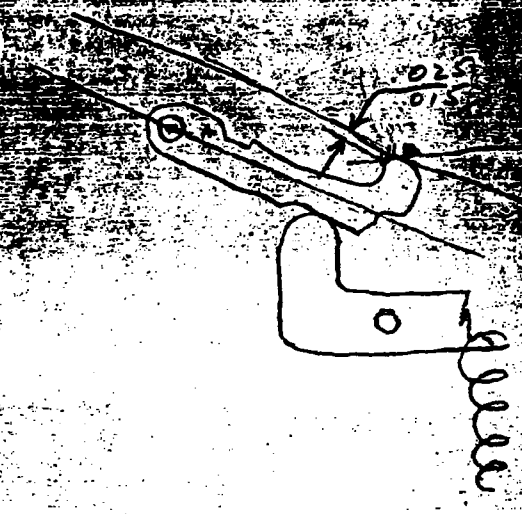
FEED: Hand

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
"K" Wheel	Std	Fixture	C-53250
Dial Gage	C-52894		

SKETCH



MHS

COMPILED BY: Bowling

APPROVAL & DATE:

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

SULLIVAN, INC.

OBSOLETE
REVISED APR 4 19[illegible]

PART: Safety & Cam

OPERATION: Grind Firing Pin Hd. Surface

PROCESS RECORD

EQUIPMENT: #2 B+S Surface Grinder

SPEED:

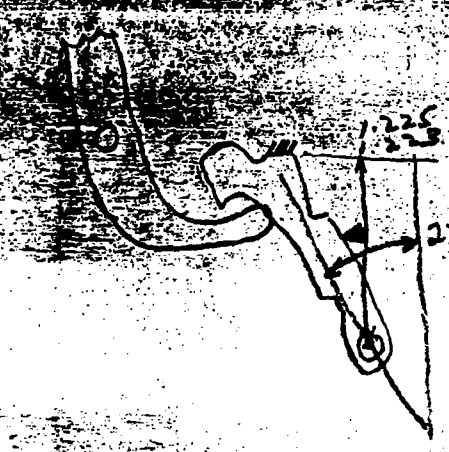
FEED: Hand

MAX. PROD. PER HOUR:

COOLANT: None

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
5" Wheel	Std	Fixture AU	C-53250
Dial Gage AU	C-53239		

SKETCH



MHS

COMPILED BY: Boughton

APPROVAL & DATE:

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

OBSOLETE
REVISED APR

PART: Safety Cam

OPER. NO.: 1045

OPERATION: Finish Burr Sides Safety Notch Firing Pin Hol Surface

OPER. NO.: 22

PROCESS RECORD

EQUIPMENT:

SPEED:

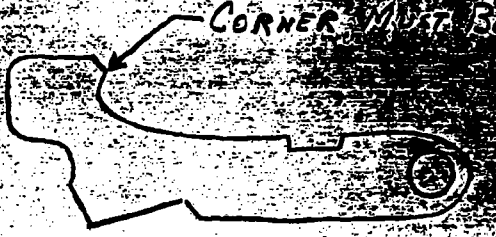
FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
File			

SKETCH



MHS

COMPILED BY: Bowling

APPROVAL & DATE:

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

SULLIVAN, INC

OBSOLETE
REVISED APR 4 1961

PART:

OPERATION: Harden

OPER. NO. 624

PROCESS RECORD

EQUIPMENT:

SPEED:

FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.

Harden
See Page for Gear
according to
Tip up
also Heat Treat Sp

MHS

SKETCH

COMPILED BY:

APPROVAL & DATE:

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