Remington Arms Company, Inc. Manufacturing Process Document

Document ID: Product Line: Trig Assy 700SS 7SS Centerfire Rifle Effective Date: 29-Nov-05 Origination Date: 31-Aug-93

General Instructions:

Use the Control Buttons above and below to access the various sections of this process. If your screen is not wide enough to display all the section data, use the arrows at the lower right to pan the desired data into view. Simply click on a tab or a button to move to that section of the document.

Process Routing Table:

Click on the button below containing the operation number you wish to view.

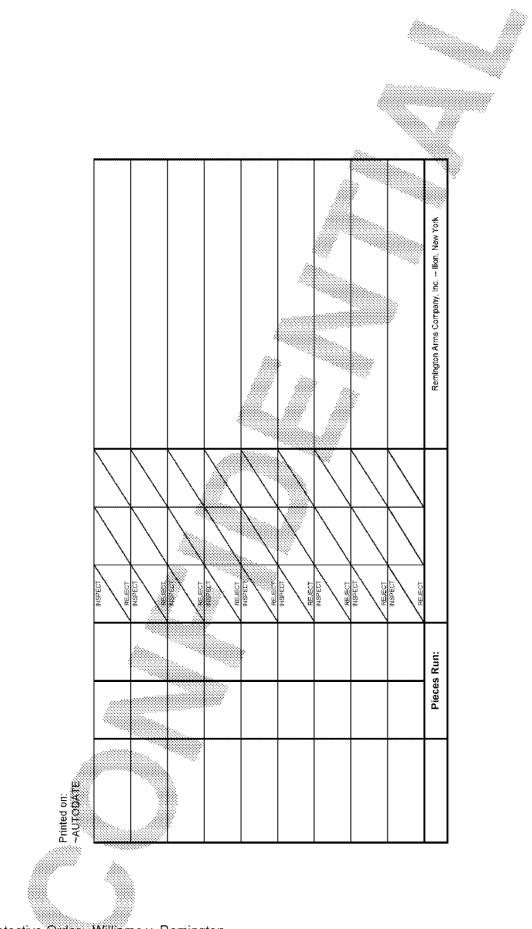
Demagnetize Springs Tap Hole in Trigger Housing Connector, Trigger, & Connector to Trigger Fit Assemble Trigger Assembly & Stage Two Adjust Trigger Assembly on Comparator 100% Assemble Trigger Assembly & Stage Three Function Check Complete Trigger Assembly 100% Trigger Assembly with Assemblers Identification Repair Rejected Trigger Assemblies

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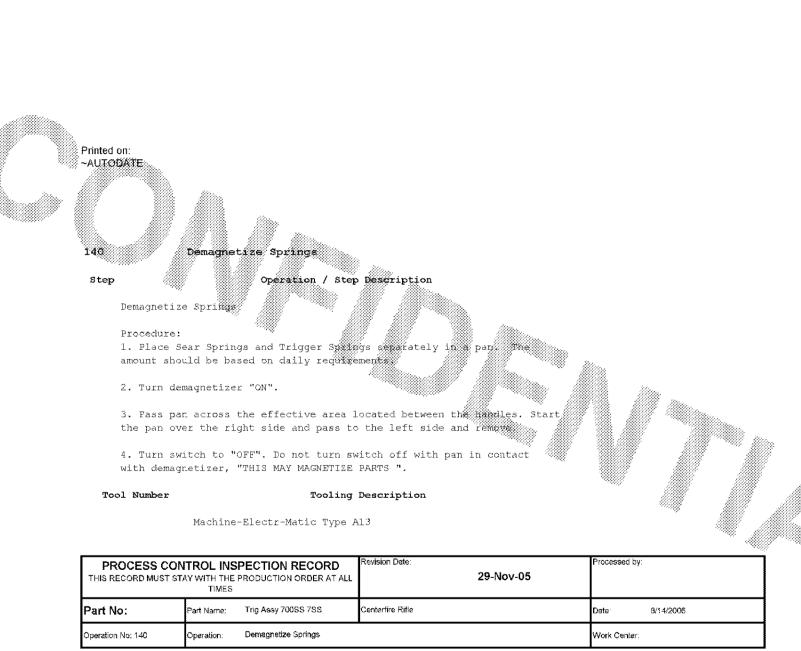


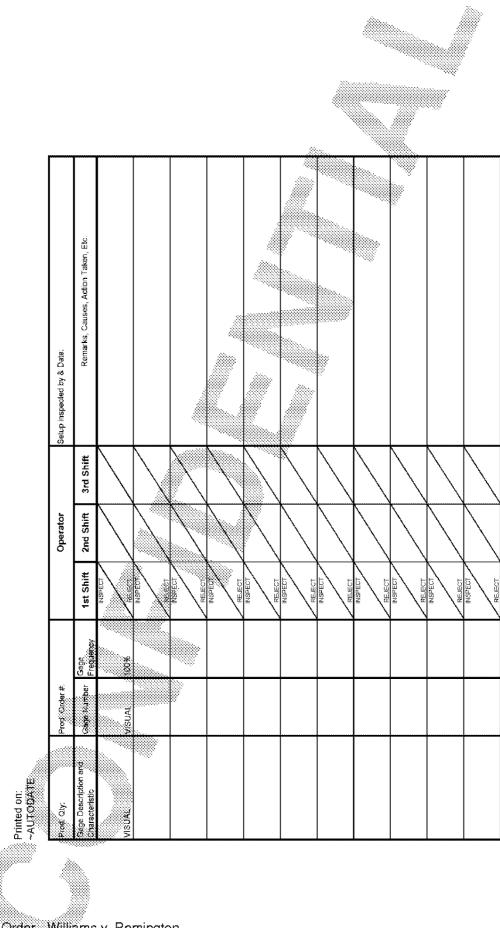
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	PROCESS CON THIS RECORD MUST ST				Revision Date		29-Nov-05		ocessed by		·		
	Part No:	Part Name:	Trig Assy 700S	S 788	Centerfire Rifle			- 20 20 20 - 2	<u></u>	3/14/2006			
	Operation No: (Enter Oper #) Operation:	(Enter the Open	ation Name in thi	s field)			N.	fork Center:				8
	Prod. Qty: Gage Description and	Prod. Order #:	0		Operator		Setup inspected by		*****				
	Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift		Remarks, Ca	uses, Action Ta	aken, Etc.			
	VISUAL	VISUAL	100%	REJECT INSPECT INSPECT INSPECT									

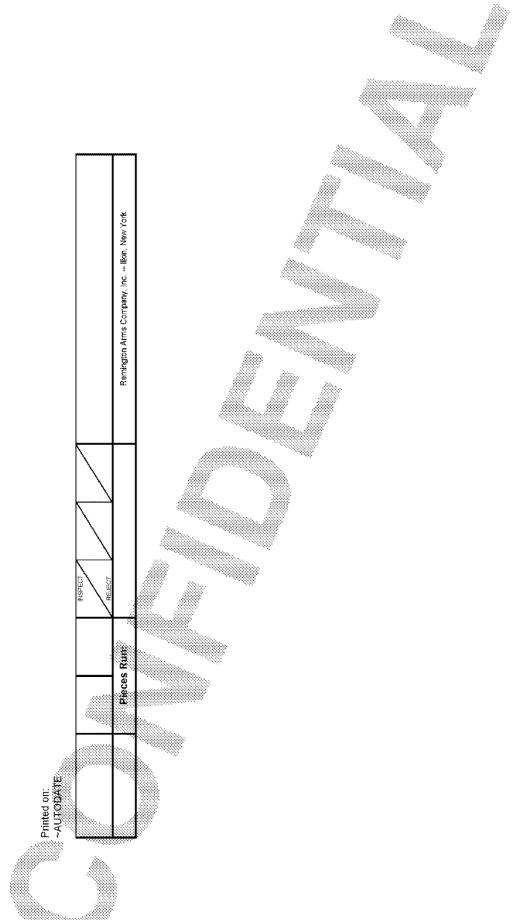






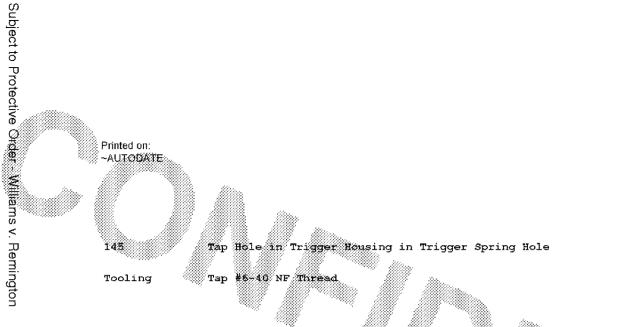


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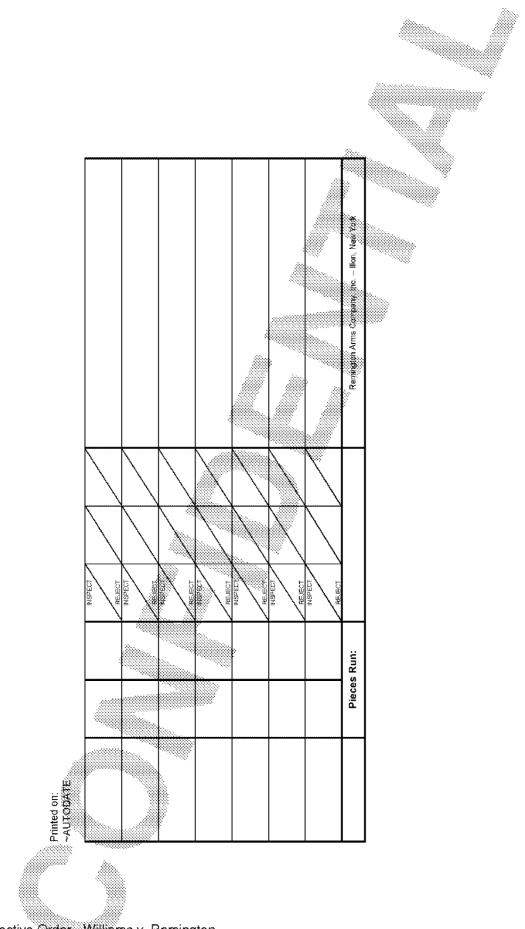
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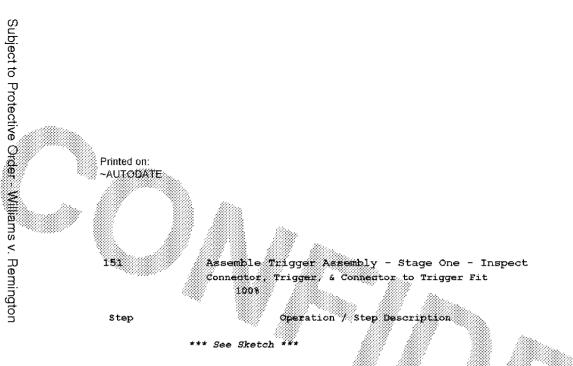
PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date		29-Nov-05	Processed by:		
Part No:	Part Name:	Trig Assy 700	65 7SS	Centerfire Rifle			Date 8	14/2006	
Operation No: 145	Operation:	Tap Hole in Tri	igger Housing in '	- Trigger Spring Ho	le		Work Center		
Prod. Qty.	Prod. Order #:			Operator		Setup inspected by & Date.			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Rémai	rks, Causes, Action ⊤al	ren, Eli c	
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Assemble Trigger Assembly - Stage One. Inspect Connector 100%, inspect Trigger 1927 and check Connector to Trigger fit 100%.

NOTE: Do all elements 100%

 Inspect long inside Connector surface, and inside surface of long (top) leg for flatness.

Hold Connector against flatness block with light finger pressure.

* If no light shows between inside surfaces of back and long leg of Connector and block surface, Connector is good.

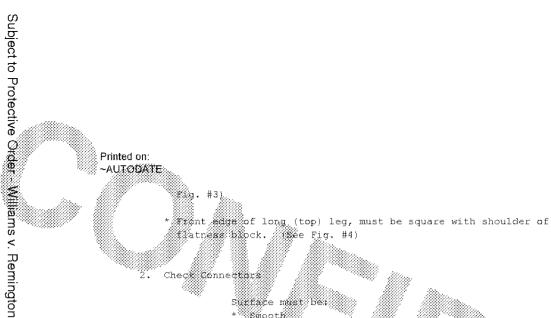
(See Figure #1)

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* If light gap shows, measure gap with a .006 shim. If gap accepts shim without moving Connector - Reject Connector. (See Fig. #2)

* Note : .006 Shim - Make new shim as required

* If Connector rocks on flatness block - reject Connector. (See



- * Snoota
- * Burr & Free at top and bottom corners and hole.
- * Dead flat within 1/327 (Minimum of end

Check for burrs and smoothness with fingertip.

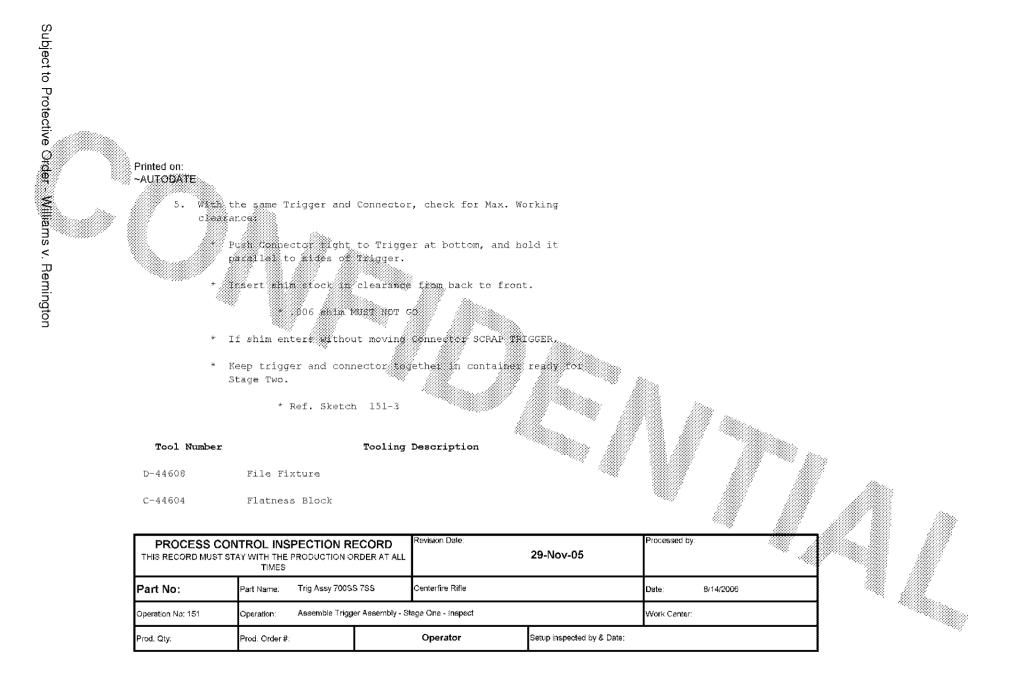
3. INSPECT TRIGGER.

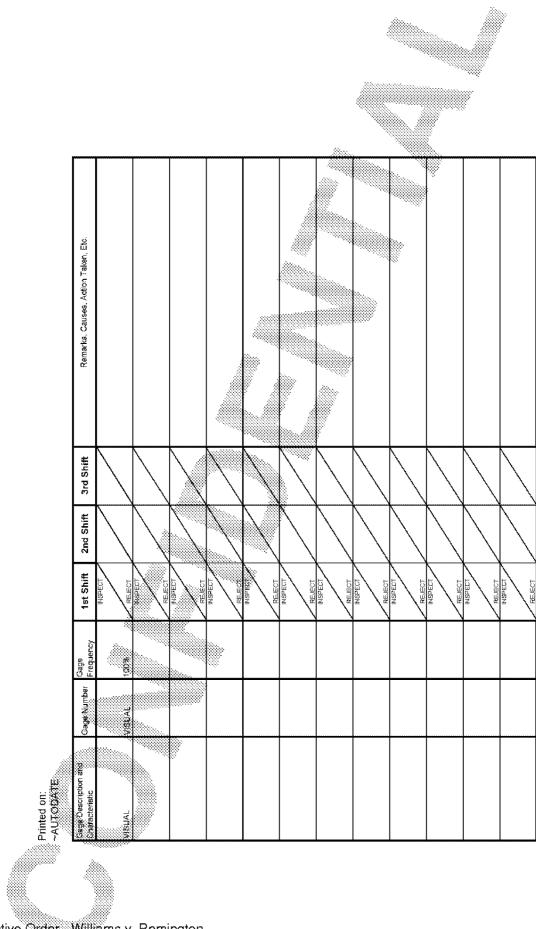
Trigger Must Have:

- * Uniform Metallic Satin Finish and Color.
- * No bleed out (white material on surface)
- * No burrs
- * No cracks or damage at pivot hole.
- 4. Fit passed Connector to passed Trigger and check for MIN. WORKING CLEARANCE. (Slip Fit)
 - * Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.

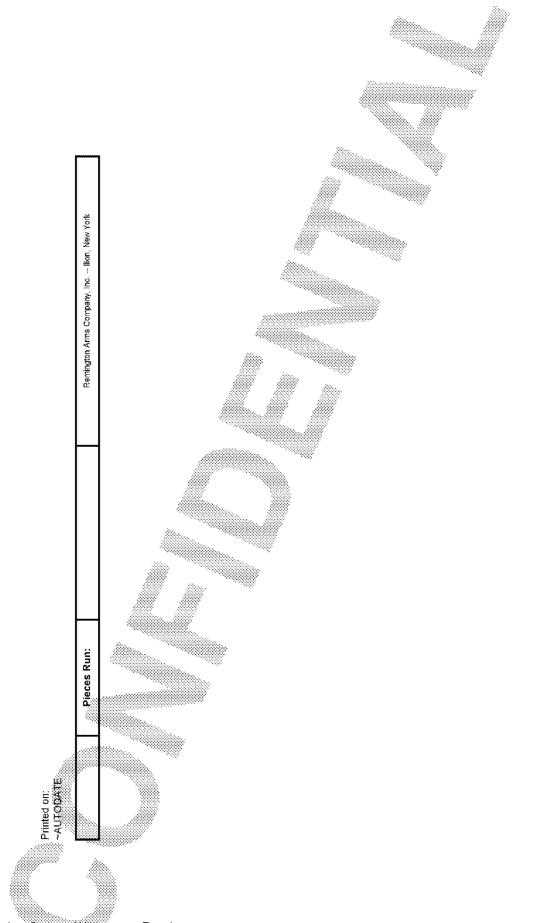
* Ref. Sketch # 151-2

* If additional clearance is needed, file bottom notch on Trigger. Filed surface must be FLAT and SQUARE with sides of trigger. Use filing fixture only. DO NOT FILE FREE HAND.



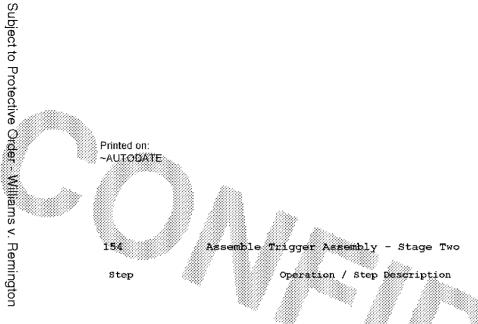


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Assembly Trigger Assembly - Stage Two

- 1. Inspect Trigger Housing:
 - * Uniform Metalic Satin Finish and Color
 - * No bleedout (White Material)
 - * Check inside Housing No burrs at holes.
 - * Clean and free of excess oil and foreign material."
- 2. Position Trigger in Housing and install Trigger Pin:
 - * Apply Dry Molykote to long leg of connector * Molykote Powder - Dry type " Z "
 - * Pin must be flush to housing on right side, left side for left hand.

- * Grip Trigger and rotate housing around Trigger Pin. Trigger must rotate freely in housing without bind.
- * Use fixture B-37211
- 3. Install:

*** See Sketch ***

- * Same Connector as fitted to Trigger (Op. #151)
- * Trigger Stop Screw Flush with hole.
- * Trigger Spring

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Trigger Screw Front - Flush with hole or below.

- (There must be adequate spring force on Connector
- white adjusting Trigger Engagement Screw.)
 - (except with Australlian)
- Trigger Engagement Screw flush with hole.
- (except with Australlian)
- Screw should have been prespated with loctite sealant
- before assembly see PROCEDURE.

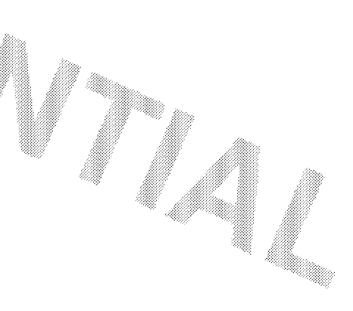
PROCEDURE FOR COATING TRIGGER ENGAGEMENT SCHEW WITH LOCTITE SEALANT:

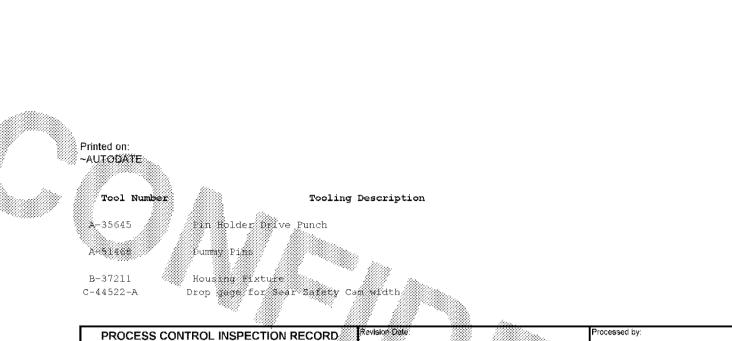
- 1. Place approximately 1000 clean, dry screws in a plastar bag.
- Pour sufficient loctite sealant into bag to evenly coat sevena with a thin film of sealant;
- 3. Agitate bag to coat all screws.
- If screws are too moist, add more screws and re-agitate. If screws are too dry, add more sealant and re-agitate.

Screws may be used immediately or stored if required.

4. Install Sear Spring and *Sear Safety Cam using Two Dummy Pins. *** See Sketch ***

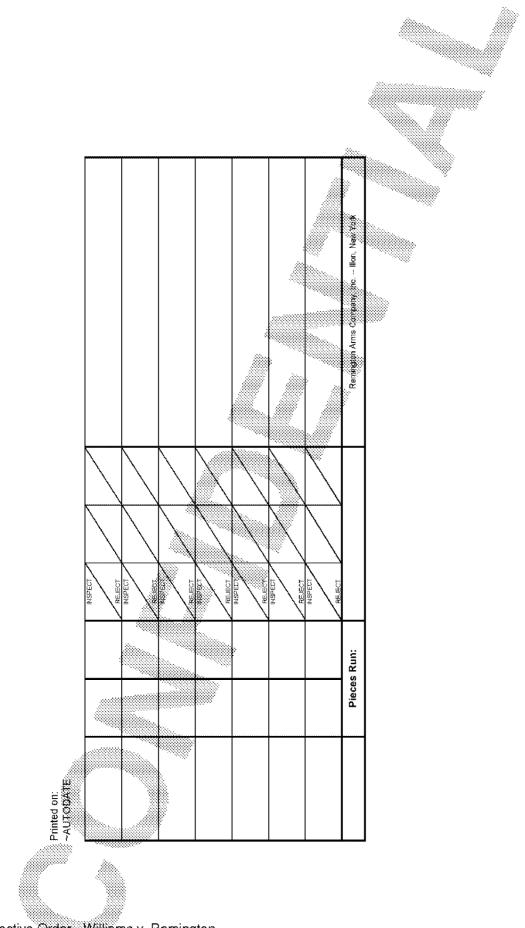
- * Use drop gauge C-44522 to inspect for straightness.
 Any sear safety cams that do not pass through the gauge are to be scrapped.
- * Visually inspect Sear Safety Cam. This must have a sharp, burr-free, square edge at the connector contact surface.(Look for a sharp ground surface on the verticle side of this edge.)
- * Depress Sear Safety Cam must move freely
- * Sear must not have dimple.
 - * Sear Safety Cam Part #15666 does not have a recessed dimple.





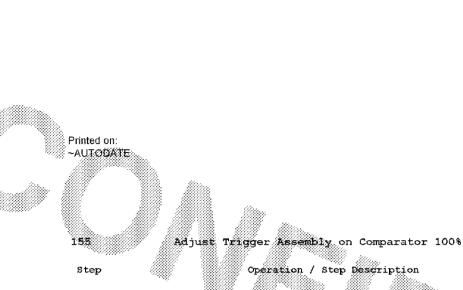
PROCESS COI THIS RECORD MUST ST		-		Revision Date		29-Noy-05		
Part No:	Part Name:	Trig Assy 7005	S 788	Centerfire Rifle		Dete: 8/14/2006		
Operation No: 154	Operation:	Assemble Trig	ger Assembly - St	age Two		Welk Center		
Prod. Qty:	Prod. Order #:			Operator		Setup inspected by & Date	*	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	REJECT					<i></i>
Drop gage for Sear Safety Cam width	C-44522-A	100%	INSPECT REJECT					
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* Align set edge of master (E-42271-A) to horizontal centerline on comparator screen C-700-CL-170.

Adjust Trigger Assembly on Comparate 100*

- Pick Trigger Sub-Assembly. Position in comparator fixture and clamp:
 - * Housing must properly contact all locators.
 - * Top of Housing must be flat on fixture.
 - * Push with thumb on rear of Trigger (toward left) This seats Trigger firmly against end of Trigger Adjusting Screw.
- 2. Adjust fixture to locate Sear on "set" line of comparator screen.
- Adjust Sear/Connector engagement (.018 .020), to correct comparator screen line by turning Trigger Engagement Screw SLOWLY CLOCKWISE (to reduce engagement).
 - * Trigger must fall within min./max. trigger lines on comparator screen.

AFTER CORRECTLY ADJUSTING SEAR/CONNECTOR ENGAGEMENT

4. Hang dead weight roller assembly in radius of trigger.

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Tool Number

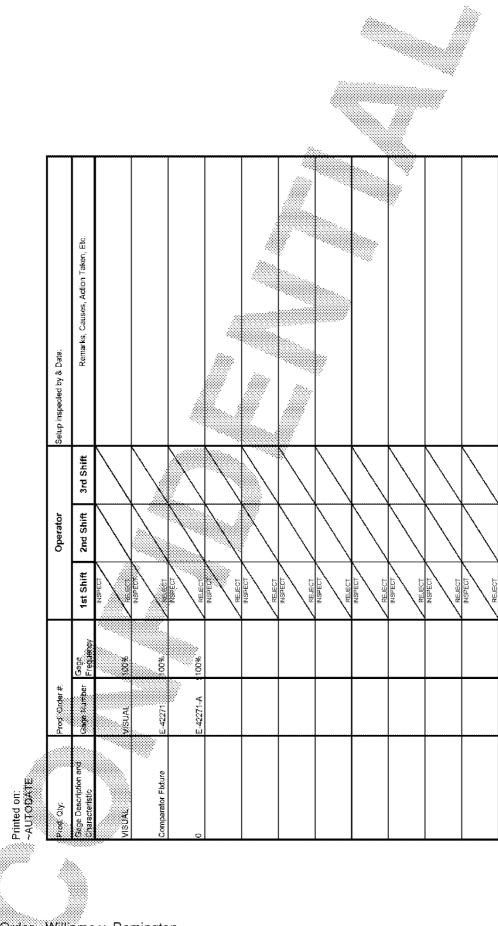
- Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-glockwise until Sear just disengages (fires).
 - Comparator fizture dead weight 4.5 lbs. (NOTE: Use this specias a general guide and adjust as needed to satisfy the finished rifle spec.)
- 6. Remove dead weight assembly from Trigger.
- 7. Hold Trigger in fired position firely with finger and:
 - * Set OVER-TRAVEL by turning Trigger stop Screw SIXWLY CLOCKWISE, until Trigger Connector touches correct line in comparator screen.

Tooling Description

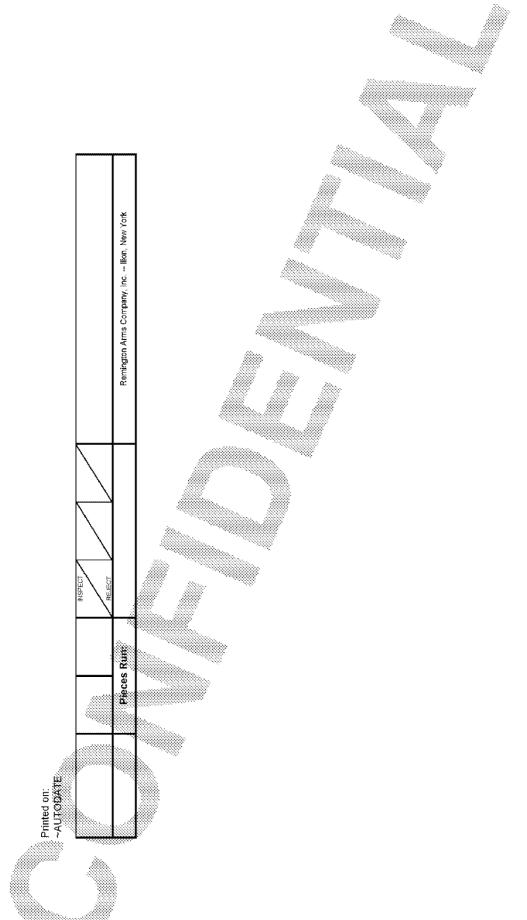
- 8. Remove Trigger Sub-Assembly from comparator rizonre.
- 9. Seal all three screws with "Duco" Cement, including strew shots.

Std.	Deltronics	Comparator	14"	(50x)
E-42271	Comparator	Fixture		
E-42271-A	Set block			
C-700-CL-170	Comparator	Screen		

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			00 N. 05	Processed by:		
Part No:	Part Name:	Trig Assy 70088 788	Centerfire Rifle	Date:	8/14/2006	
Operation No: 155	Operation:	Adjust Trigger Assembly on Con	nparator 100%	Work Center:		

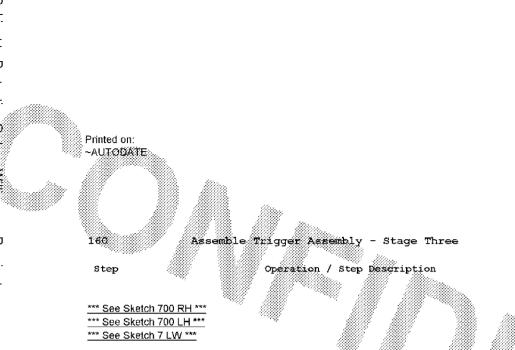


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Assemble Trigger Assembly - Stage Three

- 1. Pick correctly adjusted Trigger Sub-Assembly.
- 2. Assemble:

- Safety Detent Ball Visually inspect ball for flats or mars on ball surface.
 - Check to make sure Safety Detent Ball slides freely through mating hole in safety assembly.

Safety Detent Spring - Visually check for the presence of 2 dimples.



Sarety Smap Washer.

- A) Grient the Snap Washer such that the notched side of the Pivot Win channel is on the left after assembly. This places the die Break on the under side of the Snap Washer. (See sketch #160.)
- B) When assembling SAFETY SNAP WASHER to PTVOT PTN, make sure the SNAP WASHER is in the GROOVE on the PTVOT PIN before sliding it into position. If the SNAP WASHER rides out of groove and becomes distorted remove and discard
- C) Safety Snap Washer MUST be completely contained within Privat Pin Groove.
- D) Both raised dimples on Safety Detent Spring must be within opening of Safety Snap Washer
- 3. Push Bolt Stop Release up and down to ends of Travel several times.
 - * Bolt Stop Release must move smoothly and freely without bind.
- 4. Place assemblies in tray.

Safety Pivot Pin

Tool Number

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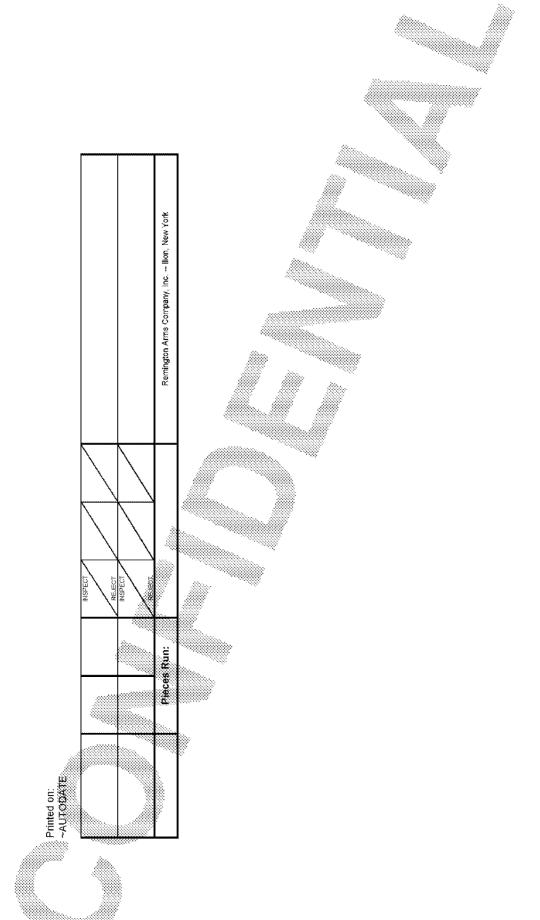
Tooling Description

Std .140 Dia plug gage

PROCESS CONTROL INSPECTION RECORD		Processed by:
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TIMES		

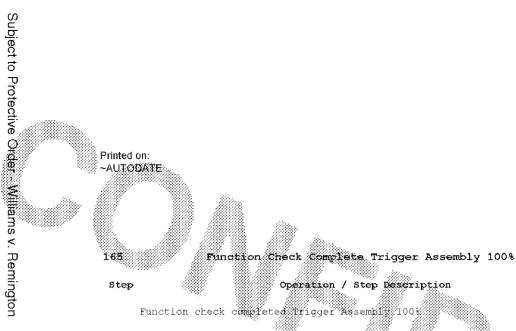
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* 1	Part No:	Part:Name:	Trig Assy 700S	S 7SS	Centerfire Rifle			Date: 8/1	4/2006	
8	Operation No: 160	Operation	Assemble Trigg	er Assembly - St	age Three			Work Center:		
	Prod Qty	Phod. Crider #:		ion	Operator		Setup inspected by & Date:			
	Of References	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks,	Gauses, Aclion ⊤ak	en, Etc.	
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NOTE: Do Steps T&2 100%

1. Put Safety in "OFF SAFE" position,

Check for:

TRIGGER RETRACTION Pull Trigger and release:

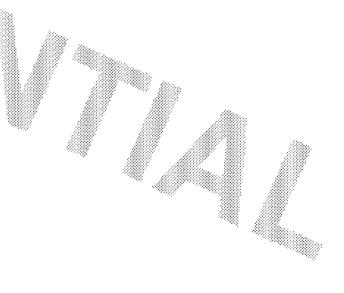
* Trigger and Connector must return freely to original position WITE SPRING FORCE.

SEAR FREEDOM Pull Trigger and hold. Depress Sear FULLY and release:

- * Sear must move freely in housing without binding. The Sear must return upward under Sear Spring force.
- 2. Operation of Safe

Push Safety Thumb Piece fully forward beyond detent position:

* Safety must spring-return rearward to detent position.



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Puzz Safety Thumb Piece fully rearward beyond detent position:

- * Safety must spring-return forward to detent position.
- Mowe Safety from "ON SAFE" to "OFF SAFE" position and back.
- Do this Twice:
 - * Safety much spring forward into "OFF SAFE" position when pushed.
 - * There must be no mang-up or hesitation between detent positions.
- 3. Check Sear Lift
 - check 10- per tray, if any are found out of spect then check entire tray 100%.

Sear lift must be between .008 min and .018 max.

* Place Trigger Assembly in gage, pump locating pins into position and clamp Zero the dial and pull safety to "On" or "S" position and read dial

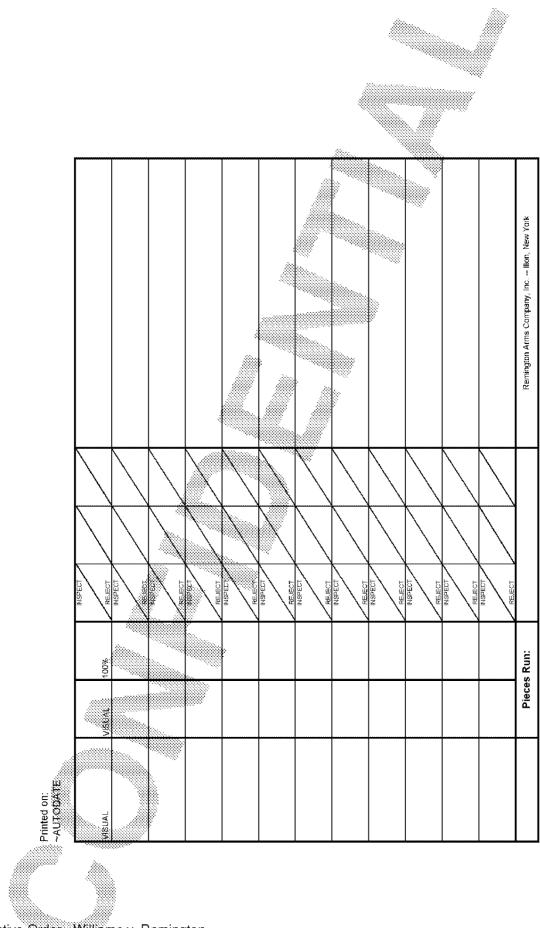
Tool Number

Tooling Description

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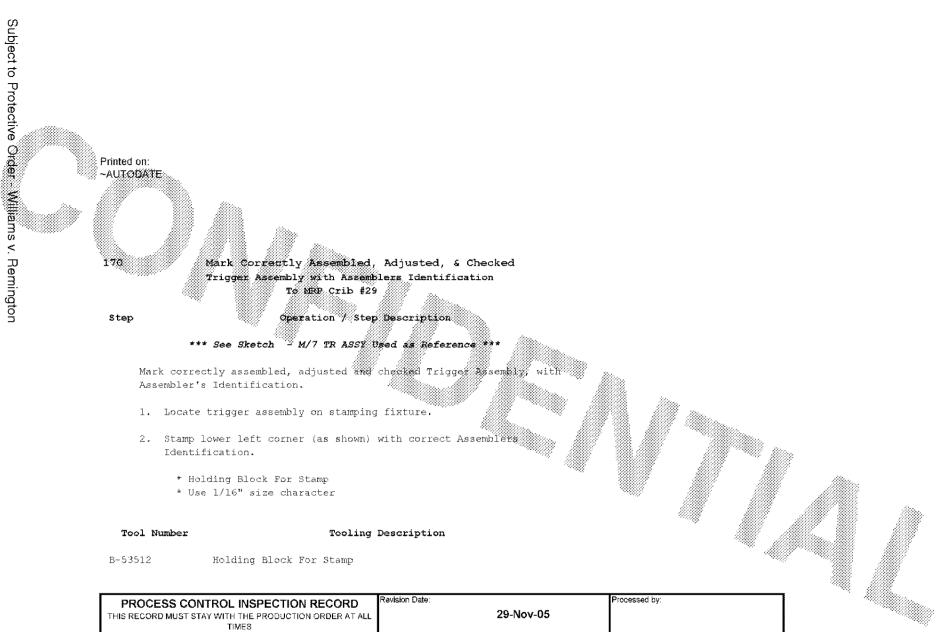
Dial Base Gage - "Sear Lift" .008 to .018

Part No:	Part Name:	Trig Assy 700S	5 7SS	Centerfire Rifle			Date:	8/14/2006	
Operation No: 165	Operation:	Function Check Complete Trigger Assembly 100%							
Prod. Qty:	Prod. Order #:			Operator		Setup inspected by & Date:			
Gage Description and Characteristic		Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.			

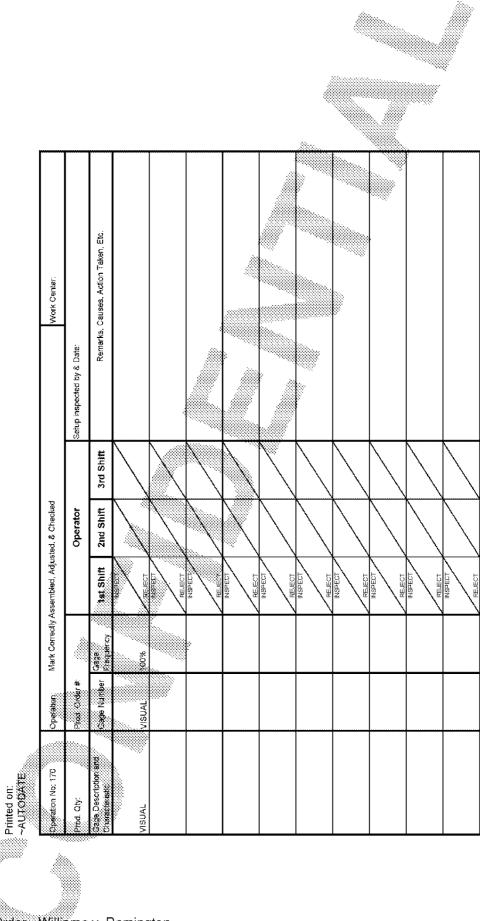


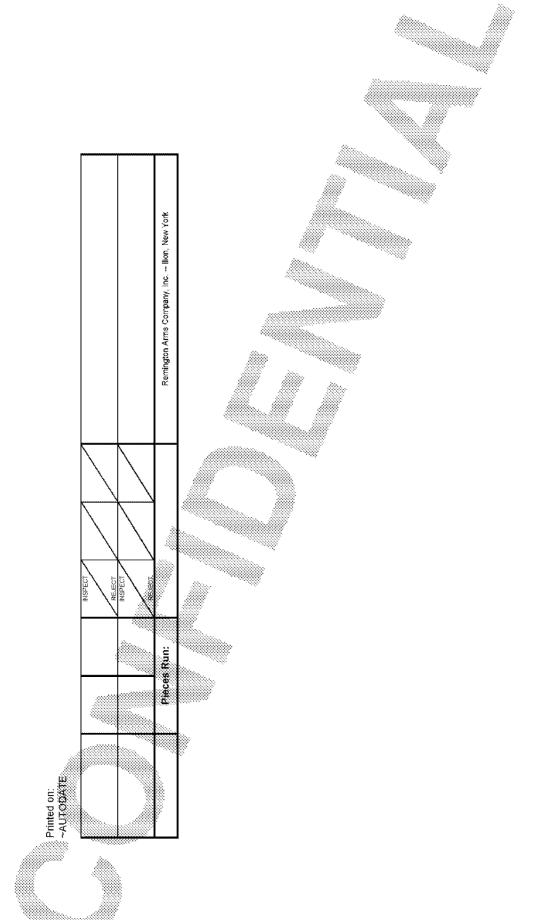
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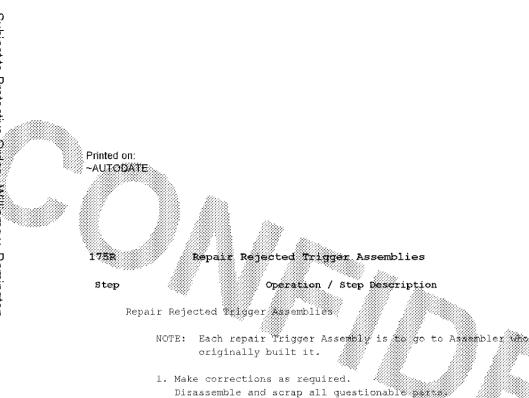
		PECTION RECORD PRODUCTION ORDER AT ALL	00 11-1-07	Processed by:	
Part No:	Part Name:	Trig Assy 700SS 78S	Centerfire Rifle	Date:	8/14/2006





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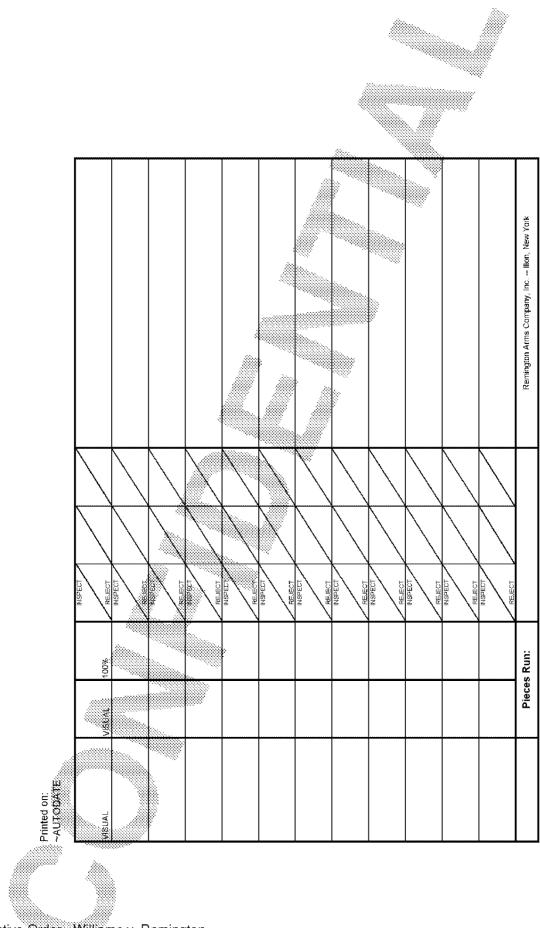




Note: If part of the repair sequence involves removal of the SAFETY SNAP WASHER discard washer after removal and replace with NEW SAFETY SNAP WASHER.

 Return Trigger Assembly to process at point where it will again receive all applicable adjustments and function checks.

PROCESS COI THIS RECORD MUST ST				Revision Date:		29-Nov-05	Processed by:		
Part No:	Part Name:	Trig Assy 700S	S 7SS	Centerfire Riffe			Date:	8/14/2006	
Operation No: 175R	Operation:	Repair Rejected	l Trigger Assemt		Work Center:				
Prod. Qty:	Prod. Order #:			Operator		Setup inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.			



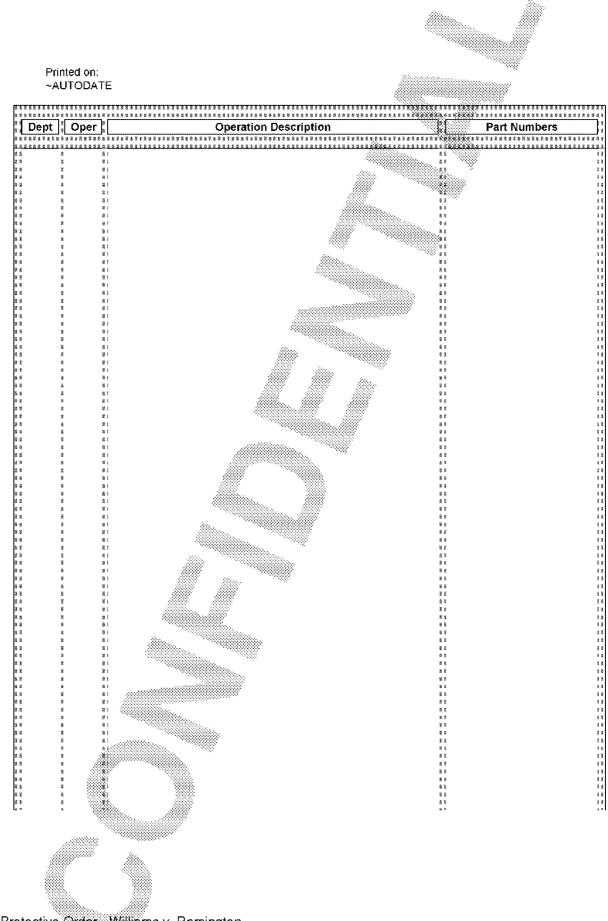
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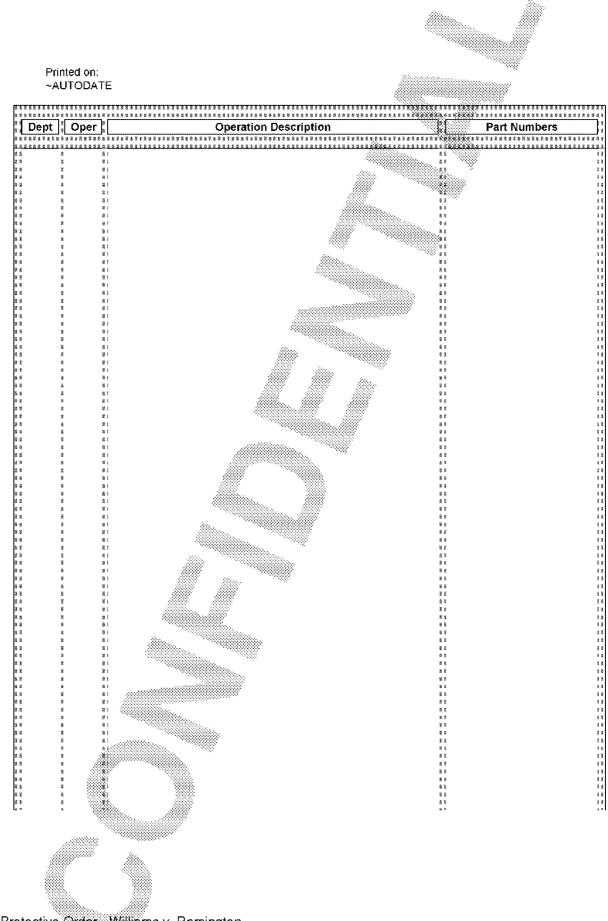
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8773	145	Tap Hole in Trigger Housing		88 9 9 88	861 97490	97954
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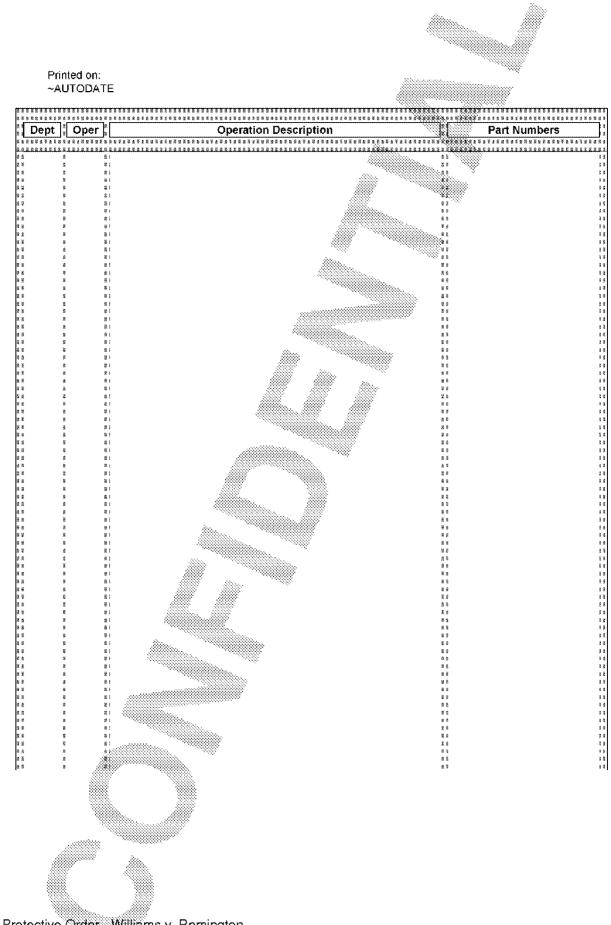
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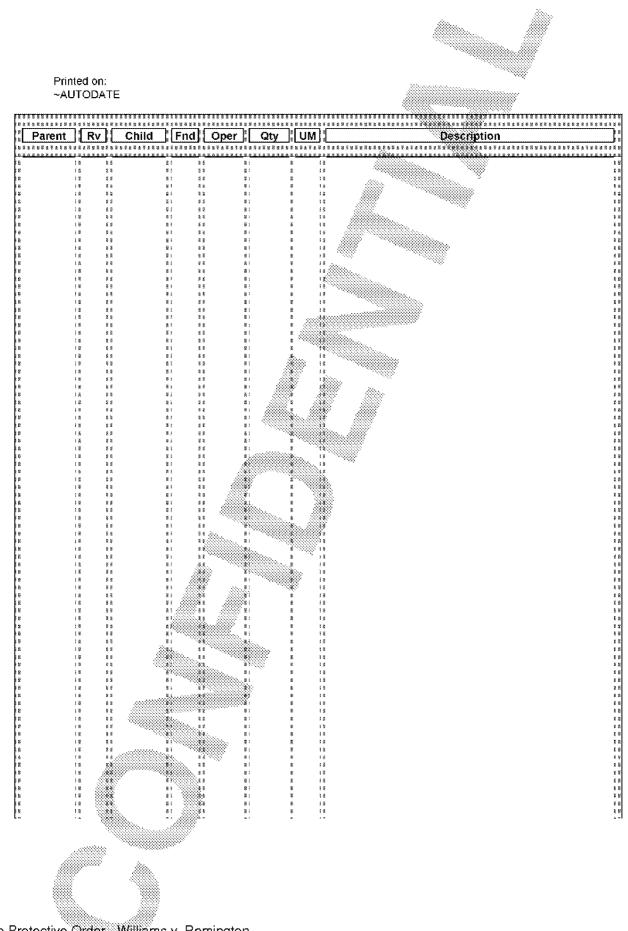


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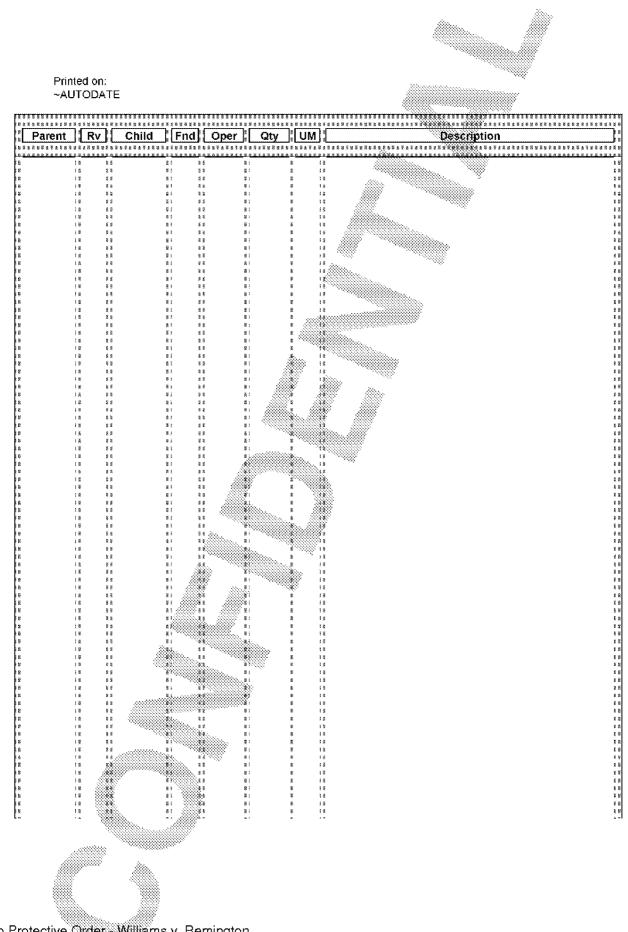
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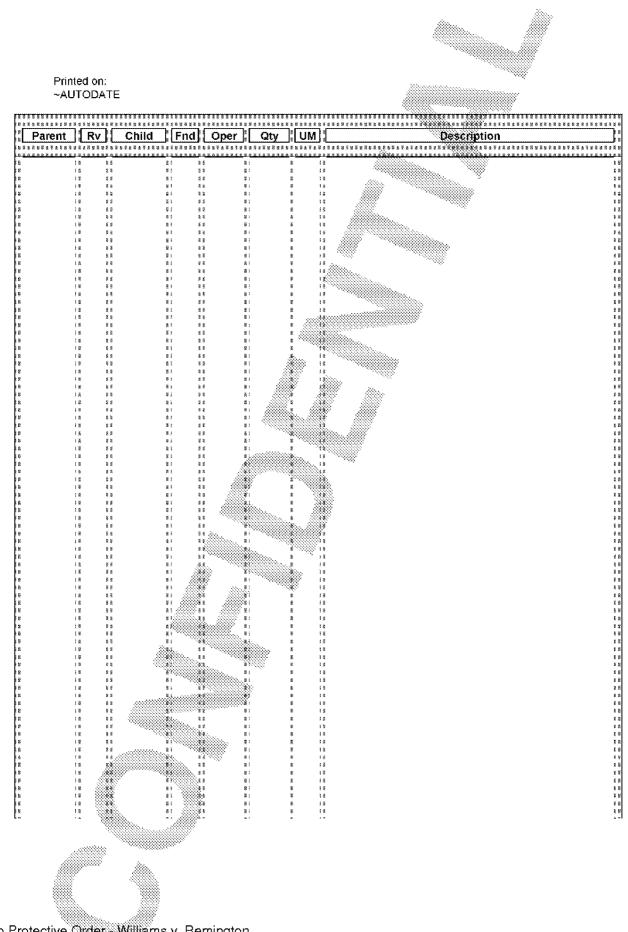
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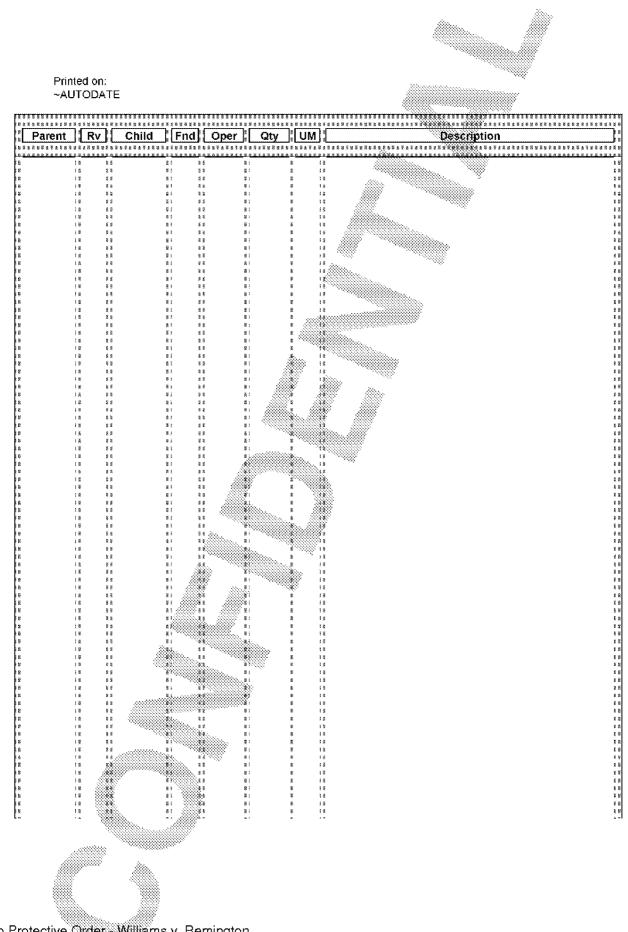


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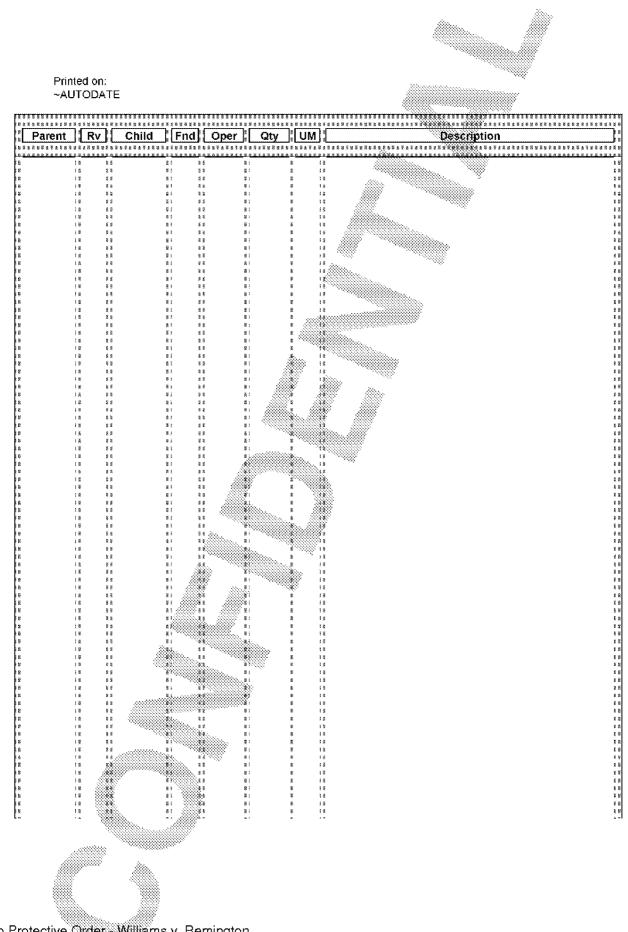


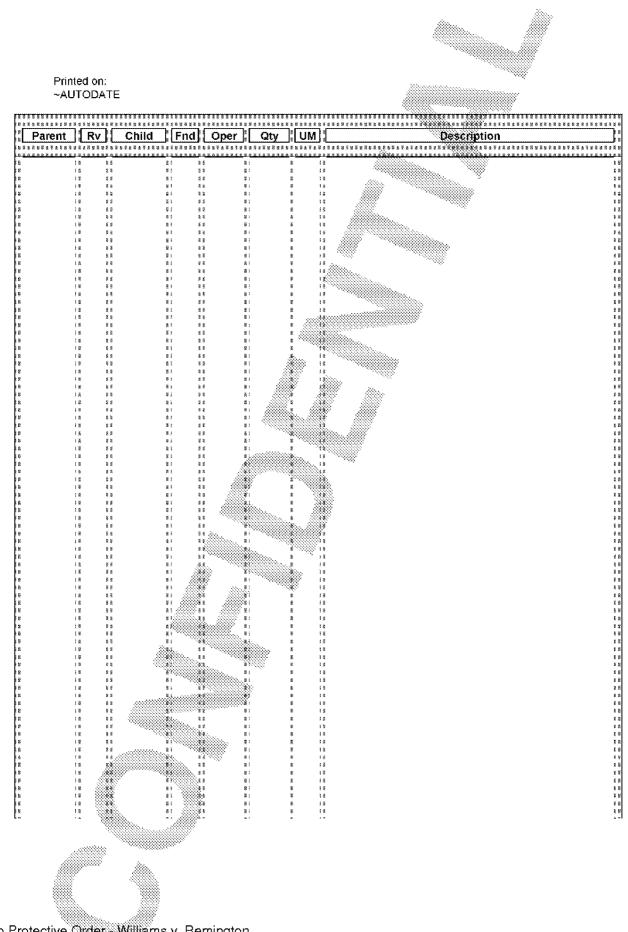
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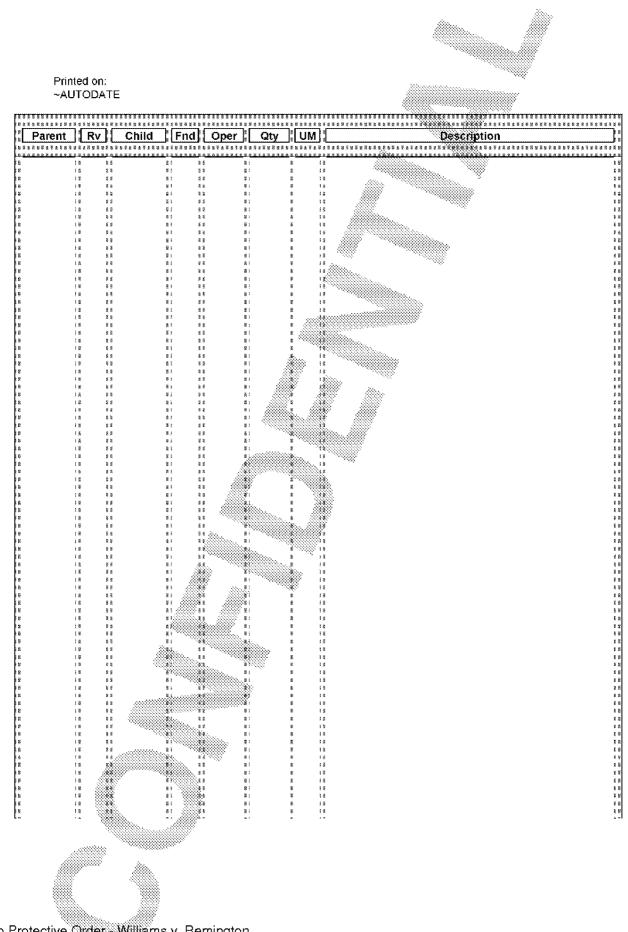


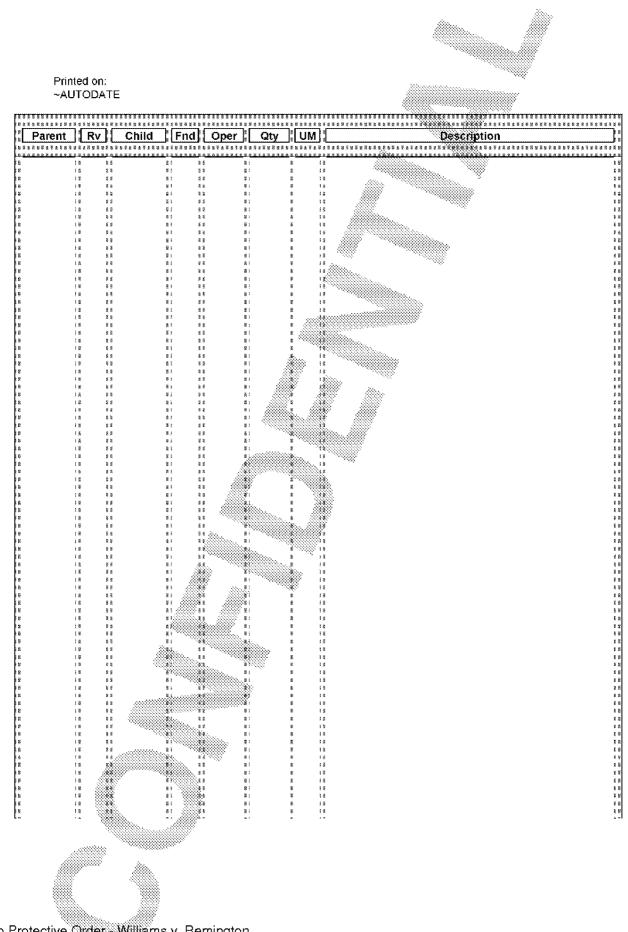


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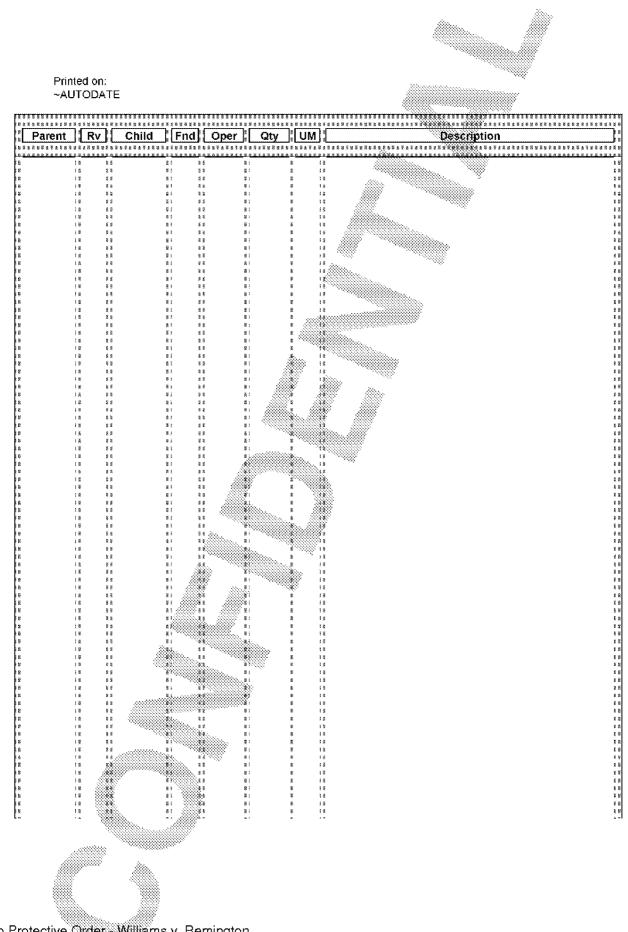




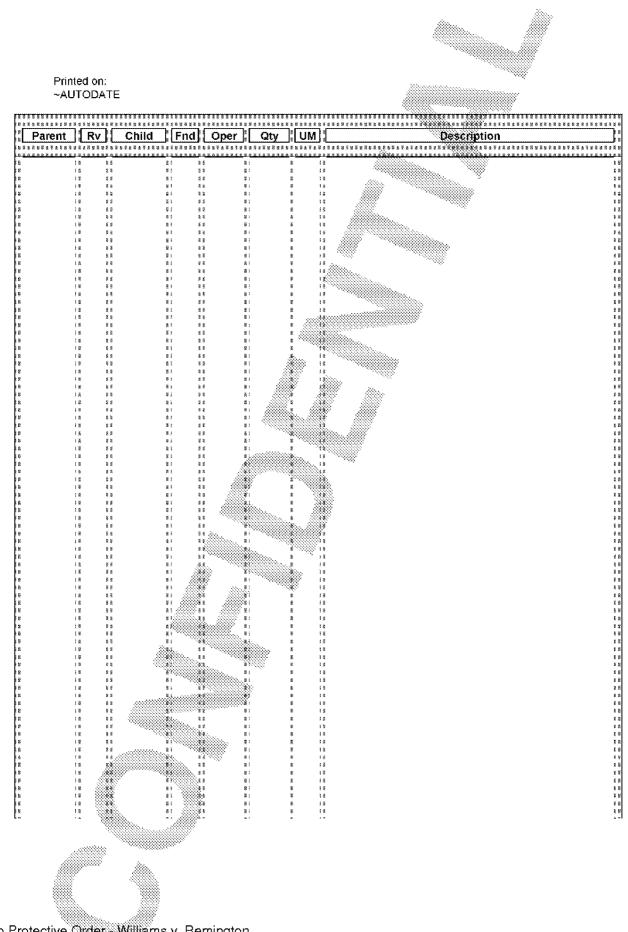




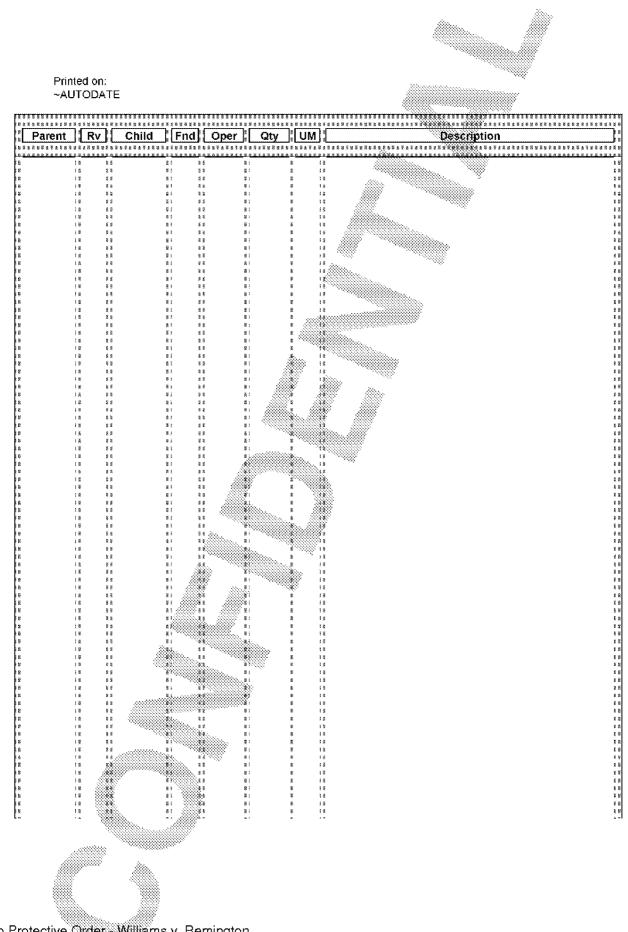
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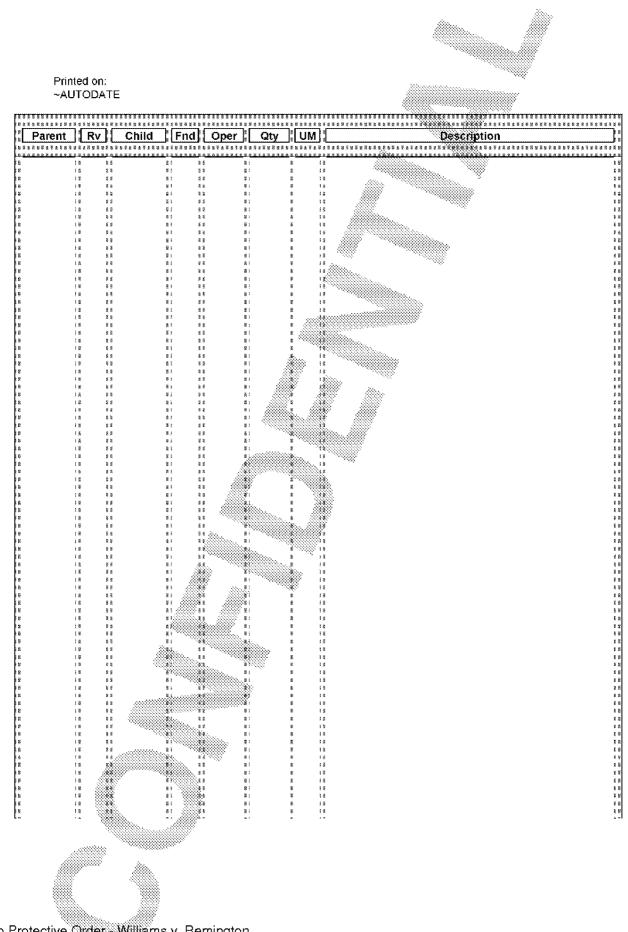
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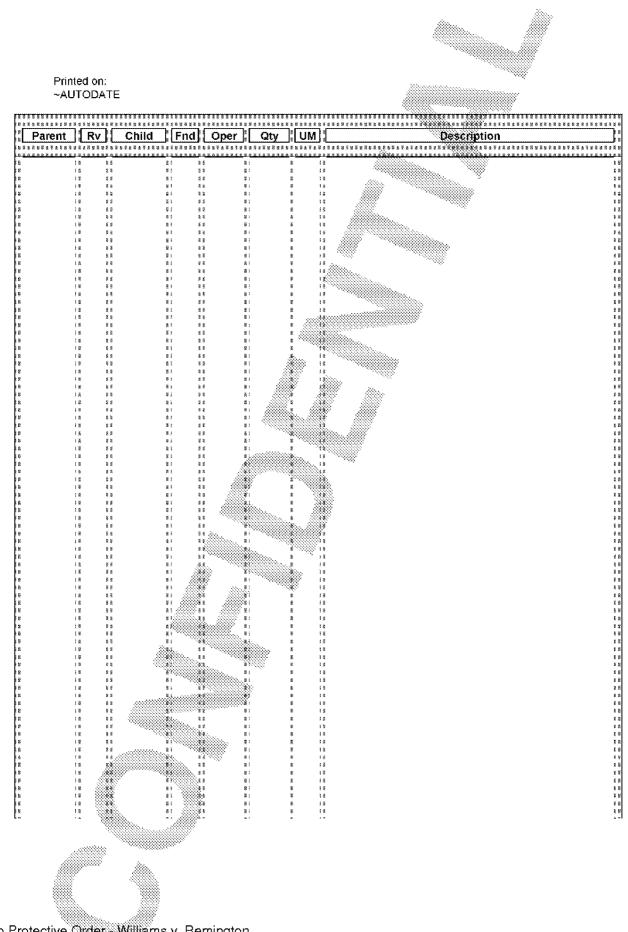


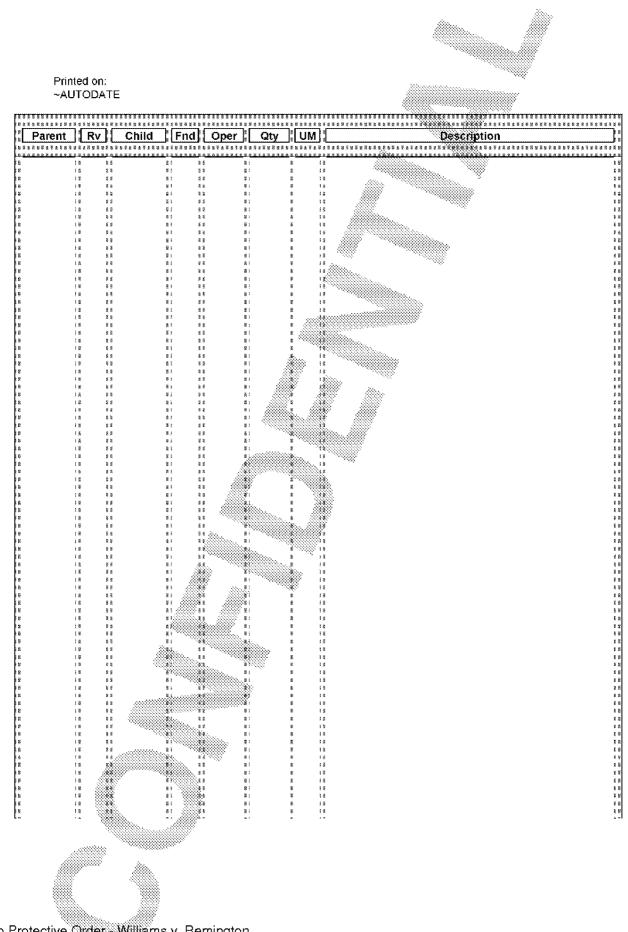
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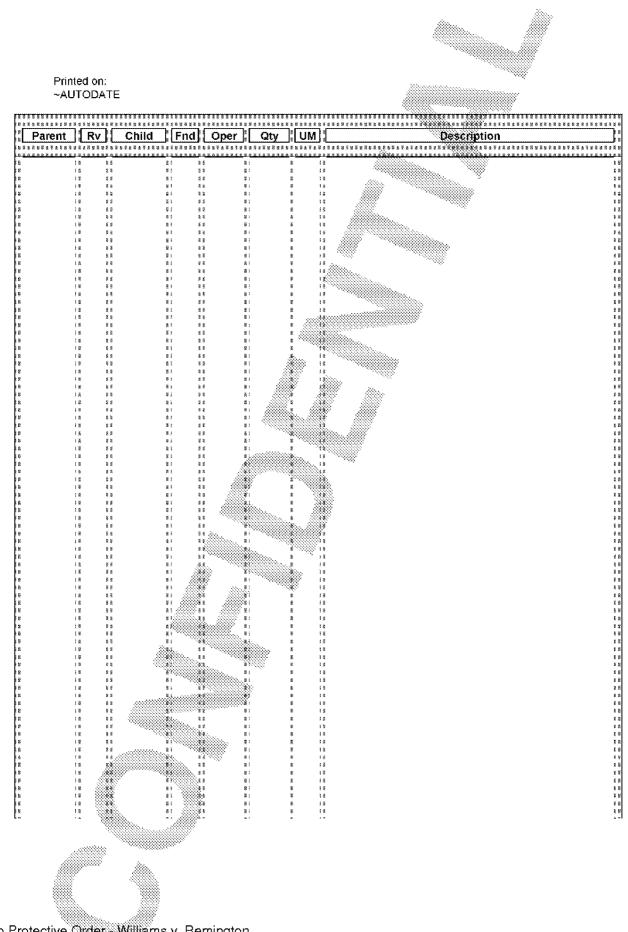
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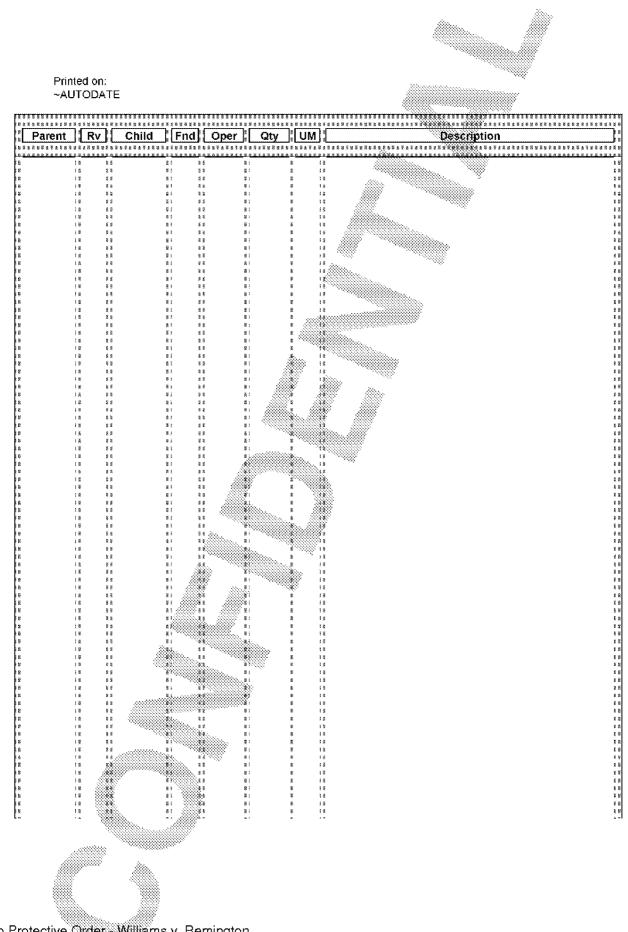


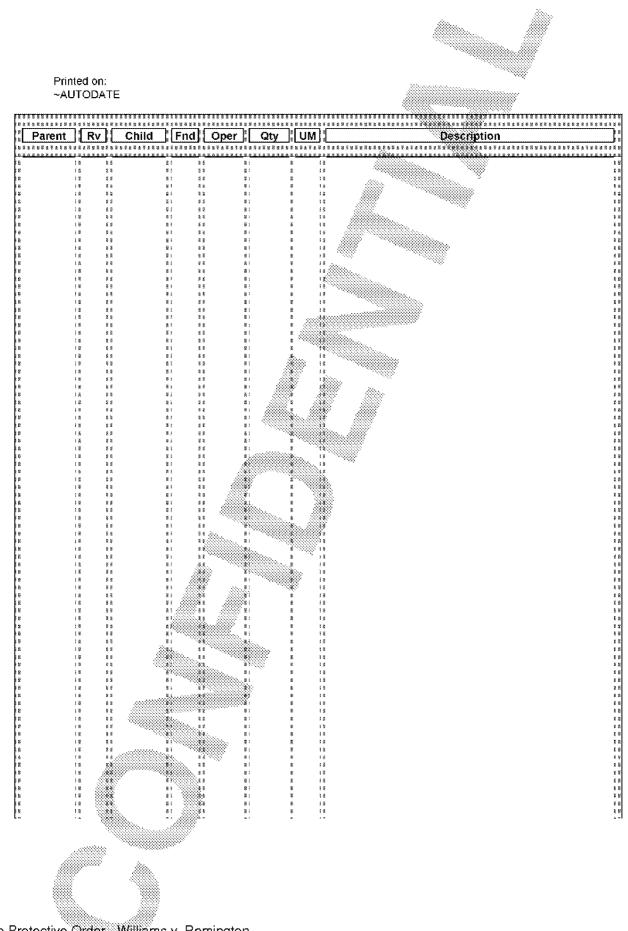


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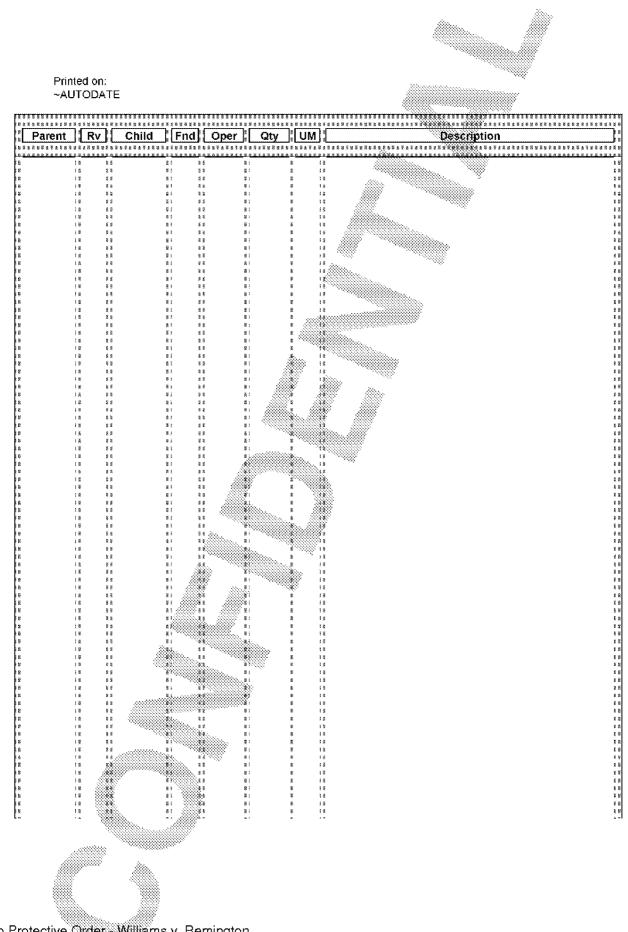


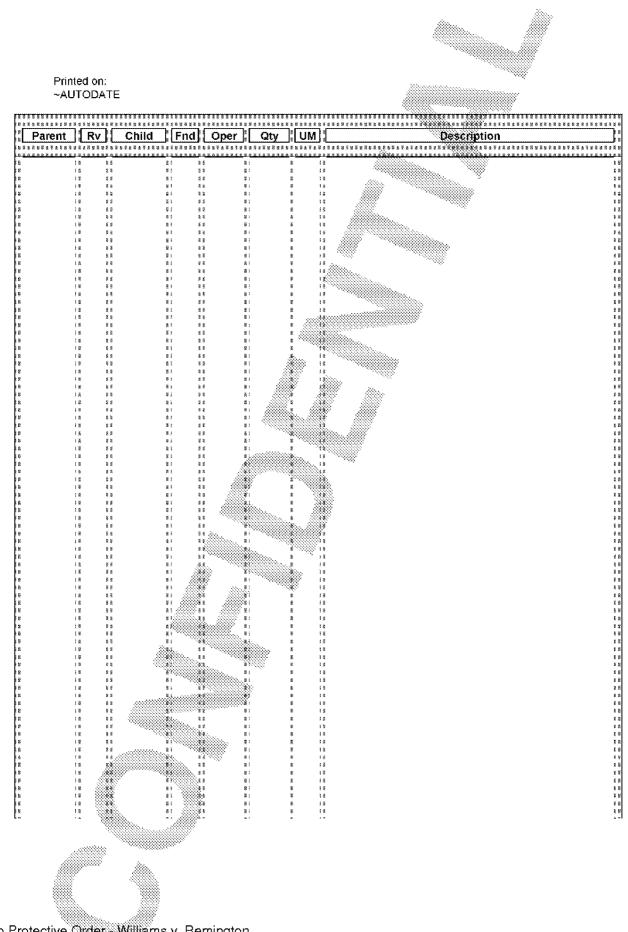
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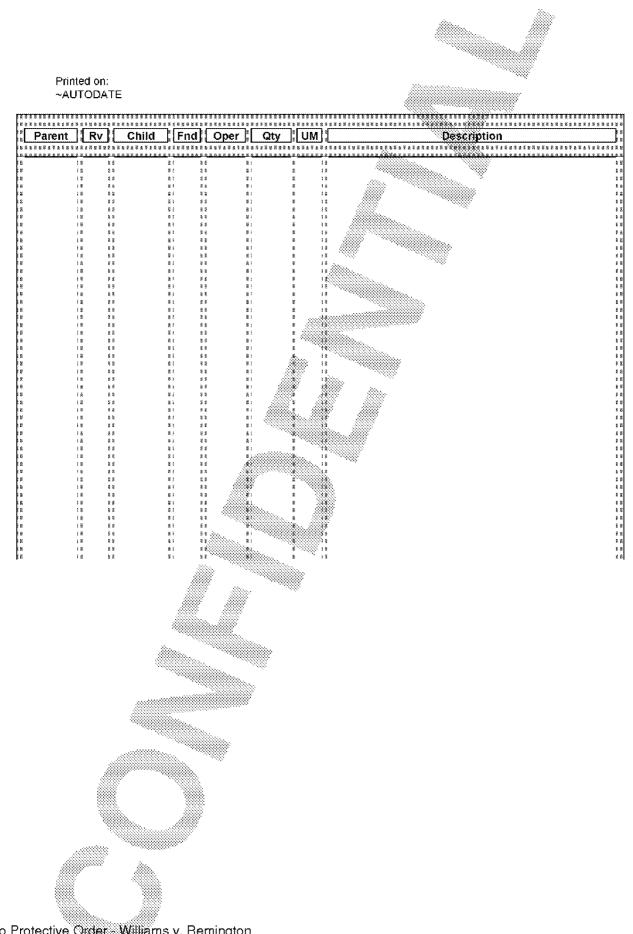




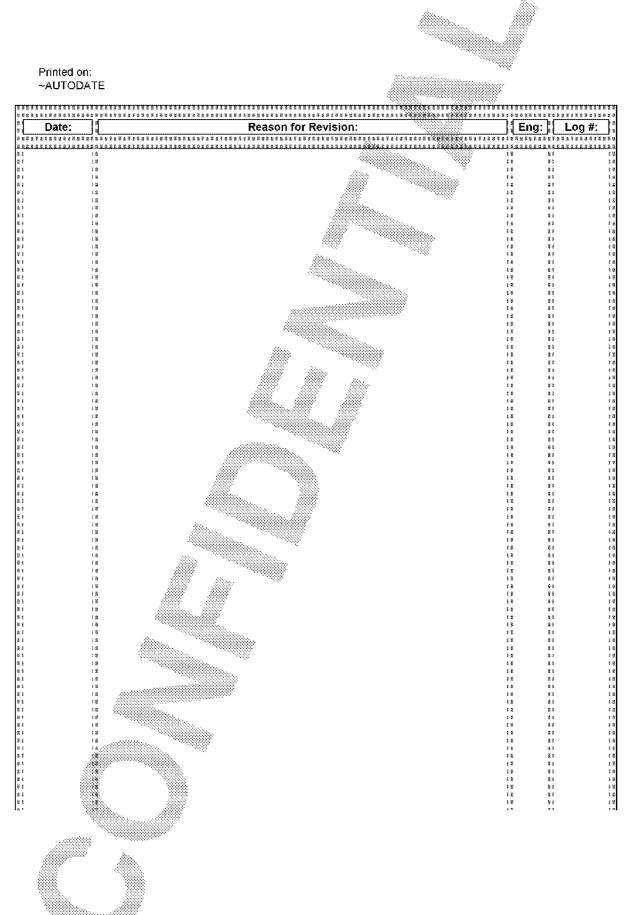
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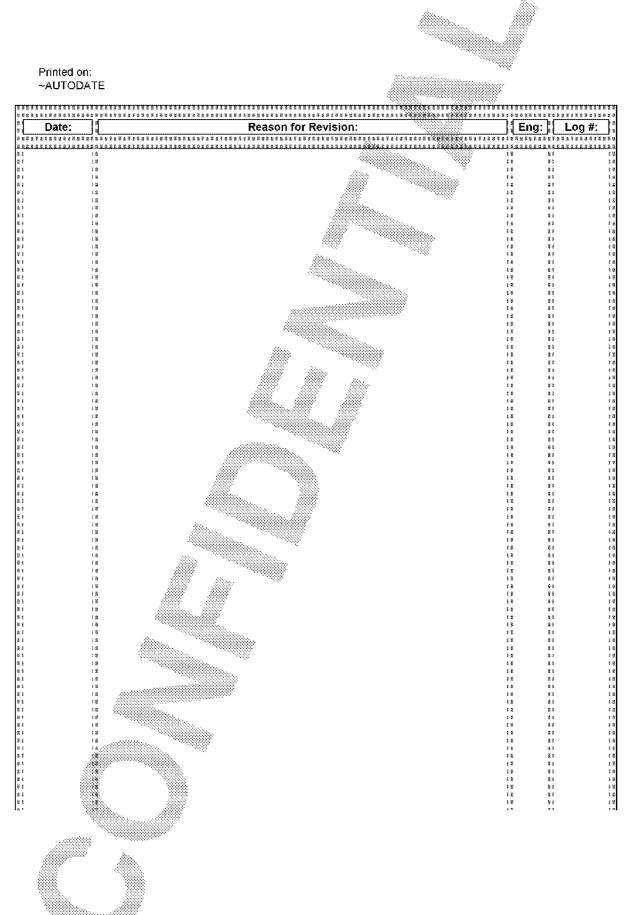




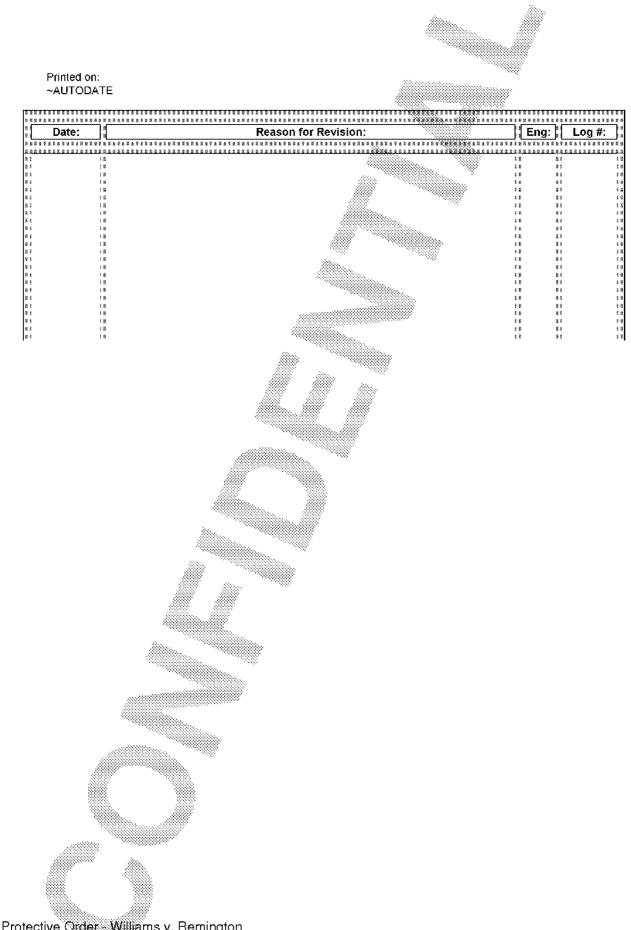
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23-Apr-01	Copied entire process from VAXcamps #202324	i RLJ	** .	30422
04 Aat 01	Revised hanging weight specification in operation 155.	8 E	2 S 2 S	30507
04-000-01	Revised hanging weight specification operation (200).	#RLJ	¥ é . 8 ≦	50507
14-Feb-03	Add OP #145 (Tap Hole)	**AFH	84 84	30857
		8 8 8 8		
13-Jan-05	Trigger pin p/n 202540 was 24477	: AJL	# 5 # 5	31355
		5 M 8 W 2 -	85 88 88	
	DEPT#8773 WAS 8772 FOR OP#140, 180, 151, 154, 155, 160,	¦≇ ax GLC	88 . 81 `	31602
	165, 170, & 175R	9 X 3 8 7 8	8 2 8 2 9 9	
OG MARY OF	Op. 155 - added Set Block 18,422712A and detail to "align	¥≞ ≇≇₽JZ	¥ š	31607
	set edge on master to horizontal renterizine on comparator	1 E U Z	# j # 1	21007
	screen", & added detail in step #3 "trigger must fall	2 H X D	* 2 7 8	
	within min/max trigger lines on comparator screen."	1 0 1 0	20 20	
	⁷ Op. 165 - added detail step #20 to chee k sear lift &	5 21 8 21	\$ \$ \$ \$	
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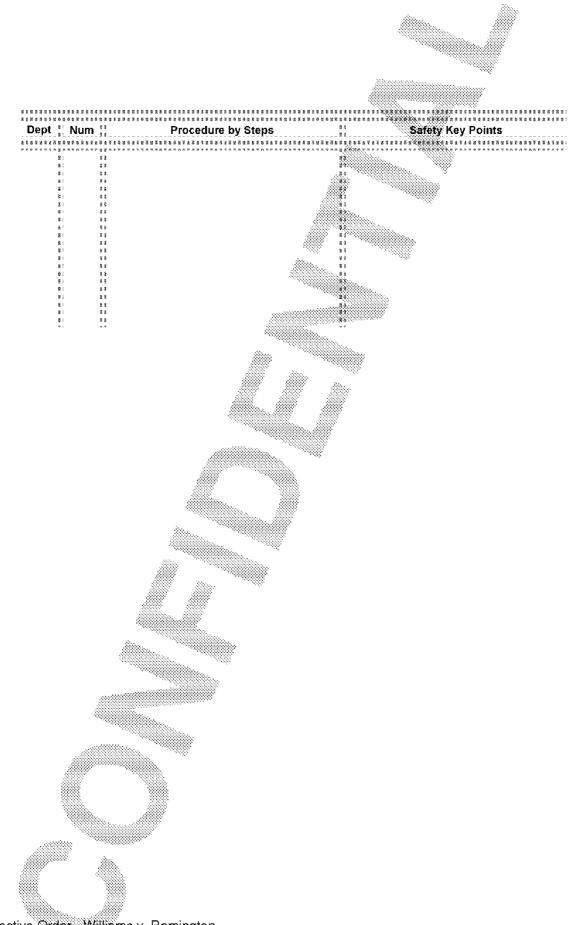


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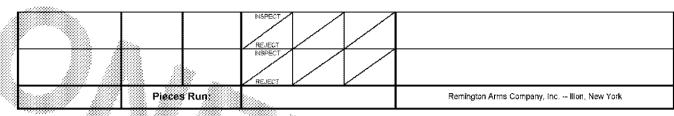
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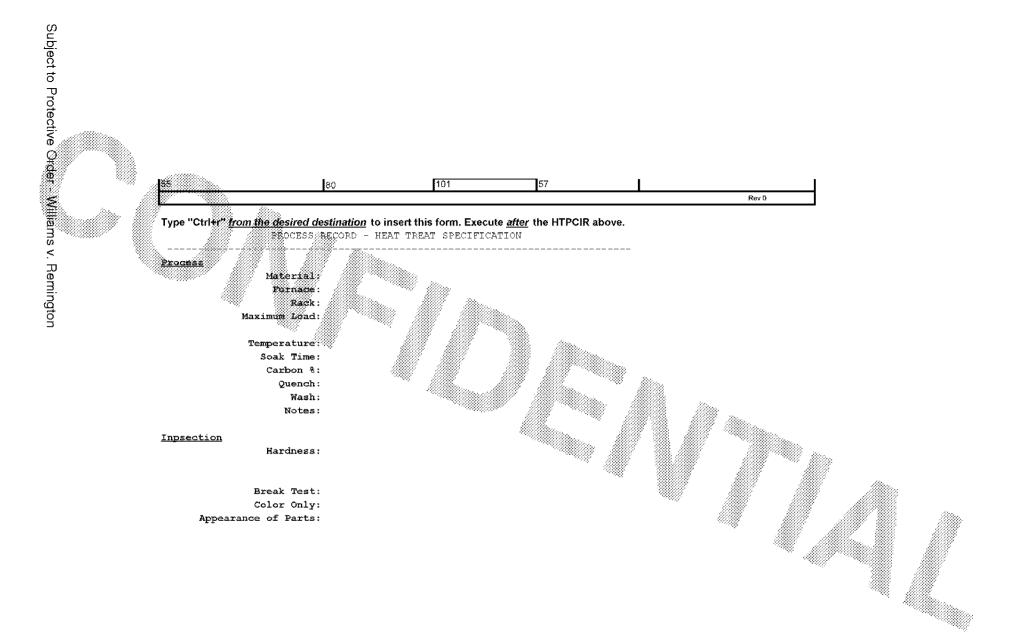
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	SS CONTROL I	HE PRODUCTI		Revision Date:		Processed by:			
Part No:	Part Nam	Trig Ass	y 700SS 7SS	Centerfire Rifl	e		Date:	8/14/2006	
Operation No. P	art No. Operation	Part Nat	ne.				Work Center:		
Prod. Oty.	Prod. Ord	Prod. Order #		Operator		Setup inspected by & Date:			
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PROCESS CON			200	Revision Date:	29-Nov-05			inspected by:				
THIS RECORD MUST REM	IAIN IN BEAT TA YEAR	CAT INPSECTION	ON FOR ONE	Part:No.		Prod. Qty:		Production Order #:				
	Part Name:	Trig Assy 700SS	6 7SS	Centertire Rifl	e 🦉		in.					
Operation No: Part No:	Operation:	Part Name:				Waark Center		inspec. Date:	8/14/2006			
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			HRc	INSPECT REJECT	H15n	INSPECT REJECT	H45n	INSPECT RÉJECT	NSPECT	REJECT		
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Click the button to return to the Header Sheet

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