

PART: Bolt Stop Spring (Purchase ready for Assembly)

PART No. 1702

Date 4-17-46

MATERIAL PROCUREMENT #1005 Rev.1

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

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

Vendor

Material : Music Wire

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 for rust protection with light (SAP-20 or equiv.) oil.

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 Testings

Inspection will be used 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 only for 24 hrs. using Rod, Dwg. B51364U and Collar, Dwg. B51365U, before inspecting. Remainder of lot need not be set because set is automatically removed in use.

Inspections **

Gage No.	Type	Has	AOQL
Coats	"Elasticometer"	{ Free Length	7%
		{ Solid Height	7%
B-51001-W Pin }		{ I.D. of Spring	7%
B-51000-W Ring }		{ O.D. of Spring	7%
B-50127-W Bushing }		{ Load at 80% Deflection	7%
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: B.C. Andrews

APPROVAL & DATE: P.H. Kline 4/19/46

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