

TITLE: Trigger Force Screw 700

Process Header

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Document ID: Tr Force Scr 700	Remington Arms Company
Part Name: Trigger Force Screw 700	
Product Line: C/F Rifle	Effective Date: 11-Aug-1992-09:00:00
Engineering Group: Rifle	Origination Date: 31-Jul-1992

Process History

Status	Date/Time	Status Set	Responsible User
Submitted	5-AUG-1992	08:58:31.83	G.L.Cioch
Comment: ""			
Fully Approved	10-AUG-1992	08:39:18.65	R.A.Jackson
Comment:			
Normal Release	11-AUG-1992	09:06:55.79	"CART"
Comment:			

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
31-Jul-1992	New Process	GLC 292908
05-Aug-1992	Correct Reason for Chg. #292908 Due to 1 Process Becoming 3 Separate Processes from New Process to: Retype Entire Process - Replaces Old Paper Process Delete Op. #12 and Combine with Op. #10 as Operator Inspection - Update from Cyanide to Microcarb Harden Chg. Crib #28 to 29	GLC 292923

Process Approval List

Approved By:	Badge #:	Date:	Designation:
R.A.Jackson	00000	10-AUG-1992	Technical Supervisor

Process General Notes

Notes:

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Process Material

Part Number	Qty	Description
17053		Trigger Force Screw - 700,7,XP-100,40XB
91920	1	Blank

Process Routing

Dept	Oper	Operation Description	Part Numbers
9260		Purchase Inspection	91920
8551	10	Degrease, Micro-Carb Harden,Oil Quench, Degrease	17053
8551	14	Nitre Black, Water Quench, Wash and Oil	17053
9257	16	Inspect for Color, and Oil	17053
		To Trigger Assembly - MRP Crib #29	17053

Operation Step Detail

Operation:

Step

Operation / Step Description

	Purchase Inspection
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Operation Step Detail

Operation: 10

Step

Operation / Step Description

	Degrease, Micro-Carb Harden,Oil Quench,Degrease
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Operation Procedure Notes

Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon

STANDARD PRACTICE:

TEMPERATURE: 1650 +/- 10 Degrees F at .75 Carbon Potential

MAXIMUM LOAD: 15000 Pcs. Max. - 2 Baskets 7500 Pcs. per Basket

TIME: 1-1/2 Hrs. @ Temp.

QUENCH: Oil

REMARKS: Degrease

INSPECT FOR: File Hard

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Steel Gray Color - Free of Oil

Operation Step Detail

Operation: 14

Step

Operation / Step Description

Nitre Black, Water Quench, Wash and Oil

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Operation Procedure Notes

Operation: 14

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon

TEMPERATURE: 925-950 Degrees F

MAXIMUM LOAD: 1/2" in Bottom of Basket - (Approx. 15000 Pcs.)

TIME: 15 Min. Total

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

**APPEARANCE OF PARTS: Shiny Black Color, Clean, Free of Salt, Well Oiled
for Storage**

Operation Step Detail

Operation: 16

Step

Operation / Step Description

Inspect for Color, and Oil

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Operation Procedure Notes

Operation: 16

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon
TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Shiny Black, Color, Clean, Free of Salt, Well Oiled for Storage

Operation Step Detail

Operation:

Step

Operation / Step Description

To Trigger Assembly - MRP Crib #28

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