

TITLE: Final Assy XP100

Process Header

Process Header

Document ID: Final Assy XP100	Remington Arms Company
Part Name: Final Assy XP100	
Product Line: C/F Rifle	Effective Date: 05-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 01-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
01-Oct-1992	Retype Entire Process from 288782 - Replaces Old Paper Process - Remove 221 F.B. - Add New Matte Ramacs	GLC 293071

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

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## Process Material

Part Number	Qty	Description
925471	1	Final Assembly - XP100 7MM ER
1729	1	Bag Assembly Complete
31561	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
28600	1	Firing Pin Assembly
15447	1	Forward Receiver Screw
15485	1	Forward Receiver Screw Washer
91763	1	Front Sight Ramp
28505	1	Front Sight Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
15450	1	Rear Receiver Screw
15484	1	Rear Receiver Screw Washer
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
94749	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925492	1	Final Assembly - XP100 .223
1729	1	Bag Assembly Complete
31562	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
28600	1	Firing Pin Assembly
15447	1	Forward Receiver Screw
15485	1	Forward Receiver Screw Washer
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
15450	1	Rear Receiver Screw
15484	1	Rear Receiver Screw Washer
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin

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Part Number	Qty	Description
94749	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925473	1	Final Assembly - XP100 .35 Rem.
-----		
1729	1	Bag Assembly Complete
31563	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
28600	1	Firing Pin Assembly
15447	1	Forward Receiver Screw
15485	1	Forward Receiver Screw Washer
91763	1	Front Sight Ramp
28505	1	Front Sight Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
15450	1	Rear Receiver Screw
15484	1	Rear Receiver Screw Washer
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
94749	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925384	1	Final Assembly - XP100 .223 Rem.
-----		
1729	1	Bag Assembly Complete
105855	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw

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Part Number	Qty	Description
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925469	1	Final Assembly - XP100 7MM BR (10.5)
-----		
1729	1	Bag Assembly Complete
105856	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
97691	1	Front Sight
28505	1	Front Sight Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
97761	1	Rear Sight Assembly
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105881	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925386	1	Final Assembly - XP100 7MM BR (14.5)
-----		
1729	1	Bag Assembly Complete

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Process Material

Part Number	Qty	Description
105857	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925388	1	Final Assembly - XP100 7MM-08
-----		
1729	1	Bag Assembly Complete
105858	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front

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Process Material

Part Number	Qty	Description
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw
925390	1	Final Assembly - XP100 .35 Rem.
1729	1	Bag Assembly Complete
105859	1	Barrel Assembly Complete
91761	1	Bolt Stop
15413	1	Bolt Stop Spring
24484	1	Bolt Stop Pin
97756	1	Firing Pin Assembly
97758	1	Forward Receiver Screw
3451	1	Hang Tag (RD 6961)
993002	1	Hang Tag Label and Box End Label
97759	1	Rear Receiver Screw
97751	1	Rear Receiver Screw Escutcheon
17034	5	Receiver Plug Screw
91496	1	Safety Assembly
23222	1	Safety Detent Ball
15432	1	Safety Detent Spring
17043	1	Safety Pivot Pin
17044	1	Safety Snap Washer
26790	1	Sear Housing Assembly
24476	2	Sear Pin
105880	1	Stock Assembly
15470	1	Trigger Balance
15471	1	Trigger Balance Pin
15472	1	Trigger Balance Spring
15473	1	Trigger Housing
15474	2	Trigger Housing Screw
15469	1	Trigger Housing Screw Front
24483	1	Trigger Pin
91128	1	Sear Block Stop Screw

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Process Routing

Dept	Oper	Operation Description	Part Numbers		
8761	575	Final Assembly	925471	925492	925473
			925384	925469	925386
			925388	925390	
8785	603	Proof, Test, Test and Target	925471	925492	925473
			925384	925469	925386
			925388	925390	
8785	603J	Proof, Test, Test and Target - Rejected Guns	925471	925492	925473
			925384	925469	925386
			925388	925390	
8785	605	Inspect for Live Ammunition	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	610	Print Box End Label	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	615	Match Label to Gun and Place	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	620	Adjust Sear Housing Assembly on Comparator 100%	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	625	Assemble Stock to Action	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	626	Final Inspect - Visual	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	630	Final Inspection	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	634	Pack Authorized Gunsmith Folder	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	635	Inspect for Live Ammunition and Oil Metal Parts	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	640R	Re-Pack	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	645R	Strip Defective Barrel and Receiver Assemblies	925471	925492	925473
			925384	925469	925386
			925388	925390	

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Process Routing  
Dept Oper

		Operation Description	Part Numbers		
8761	650R	Repair Fire Controls	925471	925492	925473
			925384	925469	925386
			925388	925390	
8761	655R	Strip Defective Bolts	925471	925492	925473
			925384	925469	925386
			925388	925390	
		To Warehouse	925471	925492	925473
			925384	925469	925386
			925388	925390	

Operation Step Detail

Operation: 575

Step

Operation / Step Description

Final Assembly
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Operation Tool Detail

Operation: 575

Tool Number

Tooling Description

B-86362	Special Holding Plug
A-35645	Pin Punch
Std	Molly Kote Type 'GN' Paste
Std	.002 Tempered Steel Shim Stock
C-47741	Solid Bolt
Std	1/16" Stamp
B-52089	Protrusion Gage - .075/.045

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Description

NOTE: Unless Otherwise Stated - All Relative Directions, (Up, Down, Clockwise, Etc.) are from the Shooter's Point of View with Gun Held in Normal Firing Position.

Procedure:

1. Pick Barreled Action and Inspect:
  - Good Uniform Black Color
  - No Mars or Scratches
  - Proper Roll Marks
  - Legible, Uniform Serial Number
  - Bore Must Be Concentric to Muzzle
2. Clamp in Vise
3. Assemble Three (5) Receiver Plug Screws into Receiver
4. Pick Bolt Stop Spring - Place One End of Spring into Detent in Bottom of Bolt Stop Slot
5. Pick Bolt Stop and Inspect:
  - Black color
  - Free of Burrs
6. Insert Bolt Stop into Receiver Slot, Fitting Bolt Stop Spring into Slot in Rear of Bolt Stop
7. Pick Bolt Stop Pin - Position and Drive into Receiver from Left to Right:
  - End of Pin Must Be Just Above Flush with Bolt Stop
  - Opposite End of Pin Must Not Protrude into Sear Housing Slot
8. Push Upward on Rear End of Bolt Stop and Release Slowly:
  - Bolt Stop Must Rotate Freely and Return Fully - File Receiver Slot if Necessary
9. Repeat Step (8) But Release Quickly Under Spring Tension
  - Bolt Stop Spring Must Remain in Place
10. Pick Trigger Housing and Inspect:
  - Black Color
  - No Burrs or Damage to Inside Surfaces which could Interfere with Proper Trigger Rotation
  - If Trigger Housing is Slightly Closed In, Spread with Special Holding Plug, to Align Holes with Barrel Bracket Holes
11. Assemble Trigger Housing to Barrel Bracket with Two (2) Trigger Housing Screws:
  - Trigger Housing Ears Must Be Flush to Bottom and both Sides of Barrel Bracket
  - Reject for Serious Mismatch
12. Pick Sear Housing Assembly and Inspect:
  - Swaged End of Trigger Link Pin Must Be Flush or Below Right Side Surface of Link on Sear Housing End
  - Ears of Link Must Be Straight
  - Link and Sear Block Assembly Must Move Freely in Housing

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Operation Procedure Notes

Operation: 575  
Description

\*\*\*\*\*Sketch Needed\*\*\*\*\*

- 25. Function Check Safety Assembly Components
  - Push Safety Thumb Piece Fully Forward Beyond Detent Position
  - Safety Must Spring Return to Detent Position
  - Push Safety Thumb Piece Fully Rearward Beyond Detent Position
  - Safety Must Spring Forward to Detent Position
  - Move Safety from "On Safe" to "Off Safe" Position and Back - Twice
  - Safety Must Spring Forward into "Off Safe" Position When Pushed
  - There Must Be No Hang-Up or Hesitation Between Detent Positions
  - The Flat Arm of the Safety Assembly Must Work Freely - It Must Not Bind on Housing, Receiver Slot, Link, Trigger Link Pin, or Sear Block Pin
  - Adjust If Necessary
- 26. Pull Trigger Several Times and Release Slowly:
  - Trigger Must Return Freely and Fully
  - Push Forward on Trigger to Verify Trigger has Returned Fully
- 27. Stake Left Side of Receiver, Below Both Sear Pins, and Bolt Stop Pin
- 28. Pick Firing Pin Assembly and Inspect:
  - Firing Pin Must Not Be Marred
  - Bolt Plug Must Have Good Color and Appearance
    - No Mars or Scratches
    - No Rusty Parts
    - No Miscut or Incorrect Parts
  - Lubricate Bolt Plug Threads and Cocking Cam Surface, Before Assembly into Bolt
- 29. Assemble Firing Pin Assembly to Bolt and Remove Washer, so that Bolt Final Assembly is in Fired Position
- 30. Check Firing Pin Protrusion
- 31. Place Final Bolt Assembly into Rearward (Cocked) Dtent Position
- 32. Move Safety to "Off Safe" Position, Insert Bolt into Receiver - Open and Close Bolt Several Times to Distribute Lubricant and verify Smooth Operation
- 33. Initially Adjust Sear Safety Cam - Sear Block Engagement (Before Comparator)
  - Apply Locknut to the Trigger Housing Engagement Screw
  - Turn Trigger Adjusting Screw SLOWLY Until Firing Pin "Just" Falls
  - Back Out Trigger Adjusting Screw (2) Turns (This Produces .030 Engagement)
  - Tighten Locknut While Holding Screw in Place (This Will Ensure No Movememnt Will Occur at Proof and Test)

\*\*\*\*\*Sketch Needed\*\*\*\*\*

- Visually Check for Correct Engagement

- 34. Initially Adjust Sear Block Overtravel

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Operation Procedure Notes      Operation: 575  
Description

- There Must Be No Click or Catch in Pull
- Firing Pin Must NOT Fall
- D. RELEASE TRIGGER SLOWLY:
  - Trigger Must Move to Full Forward Position When Released
- E. MOVE SAFETY LEVER TO "OFF SAFE" POSITION:
  - Firing Pin Must NOT Fall
  - Pull Trigger - Firing Pin Must Fall
- F. RE-COCK PISTOL
- G. POSITION SAFETY LEVER IN THE FORWARD MOST NULL POSITION (Previously Defined - Two Fingers May Be Necessary to Position the Safety)
- H. PULL TRIGGER HARD
  - There Must Be No Click or Catch in Pull
- I. RELEASE TRIGGER SLOWLY:
  - Trigger Must Not Bind
  - Trigger Must Move to Full Forward Position when Released
  - Firing Pin Must NOT Fall
- J. PUSH SAFETY LEVER TO "OFF SAFE" POSITION
  - Firing Pin Must Not Fall
  - Safety Lever Must Spring to "Off Safe" Position by Itself when Pushed from the Null Location
  - In the "Off Safe" Position the Safety Must Have an Observable "Spring Back" from the Fullest Forward and Rearward Position
- K. PULL TRIGGER
  - Firing Pin MUST Fall
- L. OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK
  - Firing Pin Must NOT Fall
- M. REPEAT STEPS G - L

## FOR THE THIRD AND LAST TRIAL

- N. MOVE SAFETY TO "ON SAFE" POSITION
- O. FROM THE "ON SAFE" POSITION MOVE THE SAFETY LEVER TO THE FORWARD MOST NULL LOCATION - (PREVIOUSLY DEFINED)
- P. PULL TRIGGER HARD
- Q. RELEASE TRIGGER SLOWLY
  - There Must Be No Click or Catch in Pull
  - Trigger Must Not Bind
  - Trigger Must Return to Full Forward Position When Released
  - Firing Pin Must NOT Fall
- R. PUSH SAFETY LEVER TO "OFF SAFE" POSITION:
  - Firing Pin Must NOT Fall
  - Safety must Spring to "OFF SAFE" Position When Pushed from the Null Location
- S. PULL TRIGGER
  - Firing Pin MUST Fall
- T. OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK
  - Firing Pin Must NOT Fall

## 37. Put Safe in "OFF SAFE" Position

- Re-Cock Action
  - A. Push with Steady Pressure on the End of Firing Pin Head - (Use Suitable Non-marring Means) - Remove Bolt Assembly
  - B. Insert Solid Bolt - Apply Steady Pressure of 6-8 Lbs. at Rear of Bolt Tool, with Safe in the "OFF SAFE" Position
- Firing Pin Head Must Not Move Forward
- Tool Must Remain Engaged with Sear

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Operation Procedure Notes      Operation: 603

Description

Procedure:

Inspect Pistol for Live Ammunition:

1. Make Sure that the Safety is in the "S" Position
2. Pull Bolt Fully to Rear
3. Visually Inspect - Chamber Must Be Empty and there Must Be No Ammo in the Receiver

Operation Step Detail      Operation: 603J

Step	Operation / Step Description
	Proof, Test, Test and Target - Rejected Guns

Operation Procedure Notes      Operation: 603J

Description

Procedure:

Inspect Pistol for Live Ammunition:

1. Make Sure that the Safety is in the "S" Position
2. Pull Bolt Fully to Rear
3. Visually Inspect - Chamber Must Be Empty and there Must Be No Ammo in the Receiver

Operation Step Detail      Operation: 605

Step	Operation / Step Description
	Inspect for Live Ammunition

Operation Procedure Notes      Operation: 605

Description

Procedure:

Inspect Pistol for Live Ammunition:

1. Make Sure that the Safety is in the "S" Position
2. Pull Bolt Fully to Rear
3. Visually Inspect - Chamber Must Be Empty and there Must Be No Ammo in the Receiver

Operation Step Detail      Operation: 610

Step	Operation / Step Description
1	Print Box End Label

Operation Procedure Notes      Operation: 610

Description

Procedure:

1. Log onto Printer (Start of Shift)
2. Push Gun Truck to Coder Station
3. Code Guns On Truck
  - a. Lift Gun - Check for Live Ammo
  - b. Type in Serial Number from Receiver
  - c. Type in Index Number from Production Tickets
4. Tear Off Labels
5. Place in Proper Gun Pouches
6. Push Gun Truck to Holding Area

Operation Step Detail      Operation: 615

Step	Operation / Step Description
1	Match Label to Gun and Place

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Operation Step Detail

Operation: 620

Step

Operation / Step Description

Adjust Sear Housing Assembly on Comparator 100%

Operation Tool Detail

Operation: 620

Tool Number

Tooling Description

Std	J & L TC-10 Comparator with 20 Power Projection Lens Assembly
Std	Air Line Nozzle
A-XP-100-37	Comparator - Template
	Comparator - Fixture
Std	Inhibisol
Std	Freon Tank
Std	Vibra-tite
Std	"Duco" Cement

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## Description

## Procedure:

1. Pick Barreled Action
2. Inspect for Live Ammunition:
  - Chamber Must Be Empty
3. Air-Clean Sear Block and Sear Safety Cam thru Sear Housing Opening
  - DO THIS AWAY FROM COMPARATOR

NOTE: Realign Lamphouse Each Time Bulb is Replaced - This Centralizes Bulb Filament On Optical Axis - Light Beam from Condensing Lens to Projection Lens Must Be Parallel - Adjust As Required - Refer to Pg.7 of J & L Operating Manual

4. Put Safety Lever in "OFF SAFE" Position
5. Place Action in Fixture and Secure
  - A. Remove Trigger Engagement Screw & the Locknut
    - a. Degrease the Threaded Hole in the Trigger Housing Using Inhibisol
    - b. Degrease Trigger Housing Screw in the Freon Tank and Let Dry
    - c. Apply Vibra-tite to the Trigger Housing Screw
      - Check Screws for the Absence of Oil, If Oil Exists Repeat Step b
      - Using a Trigger Housing Bracket, Insert Screw One Turn - This Will Hold the Screw While You Apply the Vibra-tite
      - Apply Vibra-tite Evenly Over the Full 360 Degrees and Over the Entire Length of the Screw - Be Careful Not to Apply Vibra-tite to the Screw Slot or On the Point
      - Curing Time is to be a Minimum of 45 Min. Before Assembly with Optimum Assembly Time of 3 to 4 Hours - Only Apply Vibra-tite to the Screws to be Used in the Following (8) Hour Period

NOTE: When Two-Thirds of the Bottle has been Consumed Dispose of the Existing Vibra-tite Due To the Evaporation of the Thinner

6. Push Bolt Stop to Free Position and Secure with a Non-Marring Means
7. Close Bolt
8. Move Fixture to Position Sear Safety Cam Vertical Surface to Engagement Set Line of Comparator Overlay
9. Check Sear Safety Cam - Sear Block Engagement (.020/.015)
  - Must Be Within Tolerance Lines of Comparator Overlay
  - A. If Engagement is More than Max. Line:
    - Turn Trigger Adjusting Screw Slowly Clockwise (Viewed From Muzzle End) Until Engagement Comes Within Tolerance Lines
  - B. If Engagement is Less than Min. Line:
    - Raise Bolt Handle (Actually Lowering Handle While Action is In the Fixture) and Turn Adjusting Screw Counter-Clockwise
    - Close Bolt Handle (Sear Block Will Not Always Follow as Trigger Adjusting Screw is Turned Counter-Clockwise with Bolt Closed)
      - Return to 9A
  - C. Remove Slave Sear Block Stop Screw
    - Degrease Stop Screw the Same As Step 5 b
  - D. Apply Vibra-tite Using the Same Parameters as Step 5 c, But Holding the

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Operation Procedure Notes      Operation: 620  
Description

Screw by the Slotted Head Durring Application  
E. Curing Time is to be a Minimum of 45 Min. Before Assembly with Optimum  
Assembly Time of 3 to 4 Hours - Only Apply Vibra-tite to the Screws to  
be Used in the Following (8) Hour Period

NOTE: When Two-Thirds of the Bottle has been Consumed Dispose of the Existing  
Vibra-tite Due To the Evapaoration of the Thinner

- 10. Pull Trigger to Drop Firing Pin
- 11. Move Fixture to Position Sear Safety Cam Vertical Surface to Overtravel  
"Set" Line On Caomparator Overlay
- 12. Hold Trigger Back Firmly Against Stop Screw
  - Clearance Between Sear Safety Cam and Sear block Must Be Within  
Overtravel Tolerance Lines On Comparator Overlay (.015/.005)
  - A. If Over Travel is Less than Min. Line:
    - Turn Sear Block Stop Screw Counter-Clockwise Until Clearance is  
Within Tolerance Lines
  - B. If Overtravel is More than Max. Line:
    - Turn Sear Block Stop Screw Clockwise Until Clearance is Within  
Tolerance Lines
- 13. Remove Bolt Stop Means
- 14. Remove Action from Fixture
- 15. Seal Both Screws with "Duco" Cement Including Slot Screws
  - Cement Must Not Interfere with Link Freedom

Operation Step Detail      Operation: 625

Step      Operation / Step Description

Assemble Stock to Action

Operation Tool Detail      Operation: 625

Tool Number      Tooling Description

Std      Molly Kote Type "GN" Paste

Description

Procedure:

1. Pick Barreled Action and Inspect:
  - No Mars or Scratches
  - Legible Proof, Test, Target Stamps
2. Tighten Barreled Action in Vise
3. Insert Receiver Screw Washers in C' Bore on Underside of Receiver
4. Assemble Trigger Balance Pin and Spring to Trigger Balance
5. Lubricate Trigger Balance
- \*\*\*\*\*Sketch Needed\*\*\*\*\*
6. Select Stock Assembly and Inspect:
  - Reasonably Uniform Matt Finish
  - No Splits, Cracks, or Breaks
  - No Mars or Scratches
  - No Missing Parts
7. Assemble Trigger Balance Sub-Assembly to Stock:
  - Trigger Balance Must Be Installed Correctly
- \*\*\*\*\*Sketch Needed\*\*\*\*\*
8. Assemble Stock Assembly to Action with Forward and Rear Screws - Bolt Must Be Removed to Expose Rear Screw
  - Trigger Must Be Central in Trigger Guard - It Must Not Touch At Any Point
  - Receiver Tang Must Be Fully Seated in Stock at Rear
  - Safety Must Snap Freely Forward and Rearward with No Bind on Stock or Receiver
9. Perform Trick Test
  - A. COCK PISTOL
  - B. MOVE SAFETY LEVER TO "ON SAFE" POSITION:
    - There Must Be No Bind
    - There Must Be A Good Sharp Single Detent
    - In the "On Safe" Position, the Safety Must Have an Observable "Spring Back" from the Fullest Rearward and Forward Positions
  - C. PULL TRIGGER:
    - There Must Be No Click or Catch in Pull
    - Firing Pin Must NOT Fall
  - D. RELEASE TRIGGER SLOWLY:
    - Trigger Must Move to Full Forward Position When Released
  - E. MOVE SAFETY LEVER TO "OFF SAFE" POSITION:
    - Firing Pin Must NOT Fall
    - Pull Trigger - Firing Pin Must Fall
  - F. RE-COCK PISTOL
  - G. MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TO THE FORWARD MOST NULL LOCATION (Previously Defined in Operation #575 - Two Fingers May Be Necessary to Position the Safety)
  - H. PULL TRIGGER HARD
    - There Must Be No Click or Catch in Pull
  - I. RELEASE TRIGGER SLOWLY:

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## Description

NOTE: The Final Assembler Who Assembled the Pistol is to Perform the Visual Inspection and to Identify the Passed Pistol with His Assembler's Stamp

## Procedure:

## 1. AMMUNITION INSPECTION

## A. Inspect Gun for Live Ammunition

- Chamber Must Be Empty and There Must Be No Live Ammunition Present

## 2. RECEIVER ROLL MARKINGS

- Must Be Present, Clear, Distinct, and Visible Above Stock

## TYPE

## LOCATION

- |                                       |                                   |
|---------------------------------------|-----------------------------------|
| - Remington - In Script               | Left Side, Center                 |
| - Model XP-100                        | Left Side, Below "Remington"      |
| - Serial Number and Alphabetic Prefix | Left Side, Forward of Above Items |

## 3. BARREL ROLL MARKINGS

- Must Be Present, Clear, Distinct, and Visible Above Side of Stock

## TYPE

## LOCATION

- |  |                              |
|--|------------------------------|
| - Remington Arms Co., Inc.<br>Ilion, New York Made in U.S.A. | Left Side                    |
| - Des. 201,366   | Right Side, Toward Rear      |
| - Pat. 3,255,545   | Right Side, Below Above Item |

## 4. BARREL STAMP MARKINGS

- Must Be Present, Clear, Distinct, and Visible Above Stock

## TYPE

## LOCATION

- |                   |  |
|-------------------|--|
| - Magnaflux Mark  | Right Side, Rear   |
| - Proof           | Right Side, Near Barrel Bracket,<br>Above Centerline of Barrel |
| - Test and Target | Just Forward of Proof Stamp                                    |
| - Assembler       | Left Side, Forward of Receiver,<br>Above Centerline of Barrel  |

## 5. BOLT MARKINGS

- Must Be Present, Clear, and Distinct

## TYPE

## LOCATION

- |  |                          |
|--|--------------------------|
| - Bolt Head Pull Test - Prick Punch                        | Right Side Lug           |
| - Proof Mark - Prick Punch                                 | Bottom of Bolt Handle    |
| - Bolt Handle Braze Test - Prick Punch                     | Rear of Bolt Handle      |
| - Magnaflux Bolt Assembly Inspection<br>- Prick Punch      | Left Side Lug            |
| - Serial Number, Must Match Receiver<br>- Last Four Digits | Bottom Rear of Bolt Body |

## 6. BARREL FINISH

- Must Be Uniform - Black Color, Medium Lustre Finish - Free of Seams and Stress Marks

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Operation Tool Detail

Operation: 630

Tool Number	Tooling Description
E-45160	Min. Heading Plug - 7MM BR
E-86881	Min. Heading Plug - .223 Rem.
E-TS-4333	Min. Heading Plug - .35 Rem.
E-45161	Max. Heading Plug - 7MM BR
E-86883	Max. Heading Plug - .223 Rem.
E-84290	Max. Heading Plug - .35 Rem.
Std	Spring Scale

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## Description

## Procedure:

1. MATCH LABEL TO SERIAL NUMBER
2. HEADING
  - Cock Pistol Place Heading Plug Into Chamber - Move Bolt To Forward Position and Rotate Clockwise - DO NOT USE EXCESSIVE FORCE
  - A. On Min Plug - Bolt MUST FULLY Close
  - B. On Max Plug - Bolt MUST NOT Fully Close
3. FUNCTION
  - With Dummy Cartridges, Check for Proper Feeding, Extraction, and Ejection
4. TRIGGER PULL
  - MEASURE Pull with Spring Scale:
    - Gun Must Fire with 1-1/2 to 2-3/4 Lbs. Force
    - Trigger Must Be Central in Trigger Guard - It Must Not Touch At Any Point - Adjust If Necessary
5. PERFORM TRICK TEST
  - A. Cock Pistol
  - B. Move Safety Lever to "ON SAFE" Position:
    - There Must Be No Bind
    - There Must Be A Good Sharp Single Detent
    - In the "On Safe" Position, the Safety Must Have an Observable "Spring Back" from the Fullest Rearward and Forward Positions
  - C. Pull Trigger:
    - There Must Be No Click or Catch in Pull
    - Firing Pin Must NOT Fall
  - D. Release Trigger Slowly:
    - Trigger Must Move to Full Forward Position When Released
  - E. Move Safety Lever to "OFF SAFE" Position:
    - Firing Pin Must NOT Fall
    - Pull Trigger - Firing Pin Must Fall
  - F. Re-Cock Pistol
  - G. Moving Safety Lever from "OFF SAFE" Position to the Forward Most Null Position (Previously Defined Op.#575 - Two Fingers May Be Necessary to Position the Safety)
  - H. Pull Trigger Hard
    - There Must Be No Click or Catch in Pull
  - I. Release Trigger Slowly:
    - Trigger Must Not Bind
    - Trigger Must Move to Full Forward Position when Released
    - Firing Pin Must NOT Fall
  - J. Push Safety Lever to "OFF SAFE" Position
    - Firing Pin Must Not Fall
    - Safety Lever Must Spring to "Off Safe" Position by Itself when Pushed from the Null Location
    - In the "Off Safe" Position the Safety Must Have an Observable "Spring Back" from the Fullest Forward and Rearward Position
  - K. Pull Trigger
    - Firing Pin MUST Fall
  - L. Open Action and Close Bolt Forcibly to Re-Cock
    - Firing Pin Must NOT Fall
  - M. Repeat Steps G - L

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Operation Procedure Notes      Operation: 635

Description

Procedure:

1. Inspect for Live Ammunition
2. Oil Metal Parts
3. Match Label to Serial Number
4. Match Bolt to Receiver Number - Close Bolt and Fire Pistol Down
5. Pack Pistol in Case  
- Place Instruction Folder in Case
6. Pack Case in Carton and Seal

Operation Step Detail      Operation: 640R

Step      Operation / Step Description

Re-Pack

Operation Procedure Notes      Operation: 640R

Description

Re-Pack Pistol

Operation Step Detail      Operation: 645R

Step      Operation / Step Description

Strip Defective Barrel and Receiver Assemblies

Operation Step Detail      Operation: 650R

Step      Operation / Step Description

Repair Fire Controls

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Operation Procedure Notes      Operation: 650R

Description

NOTE: Repair Defective Fire Controls - Make Sure All Moving Parts Move Freely  
and Engagement Surfaces are Clean and Burr-Free

Operation Step Detail      Operation: 655R

Step      Operation / Step Description

Strip Defective Bolts

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