

TITLE: Barrel Assembly Complete XP100

Process Header

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Document ID: Bbl Assy Com XP100	Remington Arms Company
Part Name: Barrel Assembly Complete XP100	
Product Line: C/F Rifle	Effective Date: 06-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 25-Sep-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
25-Sep-1992	Retype Entire Process from 291611 - Replaces Old Paper Process - Remove .221 FB - Add New Part #'s 105865, 105858, 105859, 105856, & 105857	GLC 293057
05-Oct-1992	Correct Ejector Pin Part # in Material Listings 94555 was 17676	GLC 293084

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

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Process Material

Part Number	Qty	Description
105855	1	Barrel Assembly Complete - XP100 - .223 Rem.
105865	1	Barrel Assembly
105875	1	Bolt Assembly
91906	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
105858	1	Barrel Assembly Complete - XP100 - 7MM-08
105868	1	Barrel Assembly
105876	1	Bolt Assembly
91816	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
105859	1	Barrel Assembly Complete - XP100 - .35 Rem.
105869	1	Barrel Assembly
105876	1	Bolt Assembly
91816	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
105856	1	Barrel Assembly Complete - XP100 - 7MM BR
105866	1	Barrel Assembly
105876	1	Bolt Assembly
91816	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
105857	1	Barrel Assembly Complete - XP100 - 7MM BR
105867	1	Barrel Assembly
105876	1	Bolt Assembly
91816	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
31562	1	Barrel Assembly Complete - XP100 - .223 Rem.
34951	1	Barrel Assembly
28751	1	Bolt Assembly
97138	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
31563	1	Barrel Assembly Complete - XP100 - .35 Rem.

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Process Material

Part Number	Qty	Description
34952	1	Barrel Assembly
28753	1	Bolt Assembly
91816	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin
31561	1	Barrel Assembly Complete - XP100 - 7MM BR
34950	1	Barrel Assembly
28753	1	Bolt Assembly
91816	1	Extractor
17017	1	Ejector
17019	1	Ejector Spring
94555	1	Ejector Pin

Process Routing

Dept	Oper	Operation Description	Part Numbers
8715	490	Check for Barrel and Receiver Alignment	105855,105858,105859, 105856,105857,31561, 31562,31563
8715	500	Fit and Head Bolt Assembly to Barrel Assembly	105855,105858,105859, 105856,105857,31561, 31562,31563
8715	505	Ream Ejector Hole 100%	105855,105858,105859, 105856,105857,31561, 31562,31563
8715	515	Assemble Extractor to Bolt Assembly. Assemble Ejector Spring and Ejector to Bolt with Ejector Pin - Number Bolt	105855,105858,105859, 105856,105857,31561, 31562,31563
8715	520	List Serial Number	105855,105858,105859, 105856,105857,31561, 31562,31563
		To Final Assembly MRP Crib #29	105855,105858,105859, 105856,105857,31561, 31562,31563

Operation Step Detail

Operation: 490

Step

Operation / Step Description

Check for Barrel and Receiver Alignment

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Operation Procedure Notes Operation: 490

Description

Procedure:

- 1.) Remove Barrel Assembly from Conveyor Rack.
- 2.) Check for Barrel and Receiver Alignment. - Visual
- 3.) Place Barrels in Special XP100 Barrel Trucks.

Operation Step Detail Operation: 500

Step Operation / Step Description

Fit and Head Bolt Assembly to Barrel Assembly

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Operation Tool Detail

Operation: 500

Tool Number	Tooling Description
E-51529	Special Chamber Machine
B-51580	Fixture
B-86645	Reamer - .35 Rem.
B-90098-M	Reamer - .35 Rem.
B-54136-S	Reamer - .223 Rem.
B-45106	Reamer - 7MM-08
B-45152	Reamer - 7MM BR
B-90098	Reamer Shank - 7MM-08, 7MM BR
B-45160	Heading Dummy - Min. - 7MM BR
B-86881	Heading Dummy - Min. - .223 Rem
B-81229-B	Heading Dummy - Min. - 7MM-08
B-45161	Heading Dummy - Max. - 7MM BR
B-86882	Heading Dummy - Max. - .223 Rem.
B-81229-A	Heading Dummy - Max. - 7MM-08
B-85249	Crusher Holder - 7MM BR
B-87221	Crusher Holder - .223 Rem.
B-82745	Crusher Holder - 7MM-08

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Operation Procedure Notes Operation: 500

Description

Procedure:

- 1.) Pick Bolt Assembly and Wash.
 - a. Inspect for Rust, Mars, or Slight Scratches.
 - i. Wire Brush if Rusty.
 - b. Check for Magnaflux Stamp on Left Lug and Braze Testar on Right Lug Rear of Handle. If Either Magnaflux Stamp or the Braze Test Mark is Missing Return Assembly to the Appropriate Department.
 - c. No Brass Except Thin Line at Joint.
 - d. Bolt Lugs - No Burrs, Recoil Surfaces Good Finish, All Edges Chamfered.
 - e. Extraction Cam - No Bar Burrs.
 - f. Barrel Muzzle Visual Central. Outside of Barrel Not Visually Bowed.
- 2.) Pick Barrel Assembly.
 - a. Good Finish and Color, Mars Slight, No Seams.
 - b. No Sharp Edges at Ejection Port or Any Exposed Edges (Which Might Cause Finger Injury).
 - c. Gas Hole Present in Receiver.
 - d. (3) Plug Screw Holes Present and Tapped.
 - e. Top Plug Screw Holes in Alignment.
 - f. Barrel Muzzle Visual Central. Outside of Barrel Not Visually Bowed.
- 3.) Check for Correct Marking.
- 4.) Fit Bolt Assembly to Barrel Assembly.
- 5.) Head
 - a. Wash Chips from Action in Varmolene Tank.

TES: 1.) Crusher Holder for Records Only.

2.) Plug Available at Engineering Lab.

Operation Step Detail Operation: 505

Step Operation / Step Description

Ream Ejector Hole 100%

Operation Tool Detail Operation: 505

Tool Number Tooling Description

Std Tap Wrench

Std Reamer - (.143 Dia.)

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Operation Step Detail

Operation: 515

Operation / Step Description

Assemble Extractor to Bolt Assembly. - Assemble Ejector Spring and Ejector to Bolt with Ejector Pin - Number Bolt

Operation Tool Detail

Operation: 515

Tool Number

Tooling Description

D-45174	Fixture
A-48261	Pin Punch
Std	Ideal Etcher
C-51730	Vise Jaws
B-84831-B	Shell Head Dia. Max. Plug (.473 Dia.)

Operation Procedure Notes

Operation: 515

Description

Procedure:

- 1.) Claw of Extractor Must Be Checked on Tension Plug for Go and No-Go.
 - a. Assemble Extractor to Bolt Assembly.
- 2.) Assemble Ejector Spring and Ejector to Bolt with Ejector Pin.
 - a. Pin Must Be Drive Fit.
 - b. Ejector Must Be Free with Tension.
- 3.) Check for Extractor Movement - Max. Plug Must Depress Extractor to Bottom on Face of Bolt.
- 4.) Number Bolt to Match Receiver Serial Number with Ideal Etcher.
 - a. Use Last Four Numbers Only.

NOTE: Only Correct Components of Good Color - Not Broken or Deformed Should Be Used.

Operation Step Detail

Operation: 520

Step

Operation / Step Description

List Serial Number

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Operation Procedure Notes Operation: 520

Description

**NOTE: To Facilitate Preparation of Gun Tickets and Labels by Clerk, Record
Serial Numbers from Pistols in Lot Being Assembled.**

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