

## Process Header

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Document ID: Ejt XP100 700 7	Remington Arms Company
Part Name: Ejector XP100 700 7	
Product Line: C/F Rifle	Effective Date: 07-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 06-Oct-1992

## Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
06-Oct-1992	Retype Entire Process from 284009 - Replaces Old Paper Process	GLC 293093

## Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

## Process General Notes

## Notes:

## Process Material

Part Number	Qty	Description
17017	1	Ejector - XP100, 700, 7
13974	1	Blank

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**TITLE: Ejector XP100 700 7**

**Process Routing**

Dept	Oper	Operation Description	Part Numbers
8551	10	Degrease, Inspect for Dryness	17017
8551	15	Neutral Salt Harden, Oil Quench, Degrease, Inspect for File Hardness	17017
8551	25	Nitre Draw	17017
9257	30	Inspect for Rockwell Hardness	17017
8579	35	Tumble (Wet)	17017
		To MRP Crib #29	17017

**Operation Step Detail**

Operation: 10

Step

Operation / Step Description

	Degrease, Inspect for Dryness
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**Operation Step Detail**

Operation: 15

Step

Operation / Step Description

	Neutral Salt Harden, Oil Quench, Degrease, Inspect for File Hardness
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**Operation Tool Detail**

Operation: 15

Tool Number

Tooling Description

Std	Ajax Electric or Gas Fired Neutral Salt Bath
Std	File

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Operation Procedure Notes

Operation: 15

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 1.18 Carbon Drill Rod

STD. PRACTICE NO.: 199

TEMPERATURE: 1525 - 1550 Degrees F

MAXIMUM LOAD:

TIME: 10 Min. @ Temp.

QUENCH: Oil

REMARKS:

INSPECT FOR: File Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 163

HARDNESS LIMITS: File Hard

APPEARANCE OF PARTS: Steel Gray Color, Clean, Dry, Free of Salt

Operation Step Detail

Operation: 25

Step

Operation / Step Description

Nitre Draw

Operation Tool Detail

Operation: 25

Tool Number

Tooling Description

Std

Rem. Gas Fired Nitre Pot

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Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 1.18 Carbon Drill Rod

STD. PRACTICE NO.: 202

TEMPERATURE: 625 - 650 Degrees F

MAXIMUM LOAD:

TIME: 30 min @ Total Time

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 164

HARDNESS LIMITS: RC 50-55

APPEARANCE OF PARTS: Light Blue Color, Clean, Dry, Free of Salt

Operation Step Detail

Operation: 30

Step

Operation / Step Description

Inspect for Rockwell Hardness

Operation Tool Detail

Operation: 30

Tool Number

Tooling Description

Std

Rockwell Hardness Tester

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Operation Procedure Notes

Operation: 30

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 1.18 Carbon Drill Rod

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 164

HARDNESS LIMITS: RC 50-55

APPEARANCE OF PARTS: Light Blue Color, Clean, Dry, Free of Salt

Operation Step Detail

Operation: 35

Step

Operation / Step Description

Tumble (Wet)

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Operation Procedure Notes

Operation: 35

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION:

TEMPERATURE:

MAXIMUM LOAD: Approximately 2000 Components  
- Cover with Water, #150 Alundum, & Soda Ash

TIME: Three (3) Hrs.

QUENCH: Barrel #1

REMARKS: Operation is Performed to Provide Very Slight  
Chamfer on Front End Removing Sharp Edges Resulting  
from Grind

INSPECT FOR: Chamfer on Front End

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Components Must Be Clean and Well Oiled for Storage

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