

TITLE: Ejector Pin - (Return Plung Retain Pin)

Process Header

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Document ID: Ejt Pin	Remington Arms Company
Part Name: Ejector Pin - (Return Plung Retain Pin)	
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 287695 - Replaces Old Paper Process - Remove Use for XP100,700, & 788 Add Use for 1100,1187,3200U, & SWS	GLC 293096

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

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Process Material

Part Number	Qty	Description
17676	1	Ejector Pin - SWS
91802	1	Blank
17676	1	Return Plunger Retaining Pin - 1100,1187, & 3200U
91802	1	Blank

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Process Routing

Dept	Oper	Operation Description	Part Numbers
8551	6	Degrease, Micro-Carb Harden Oil Quench, Degrease	17676
8551	8	Inspect for File Hardness	17676
8551	10	Nitre Black, Water Quench, Wash, Dry, and Oil for Storage	17676
9257	12	Inspect for Color and Oil	17676
		To MRP Crib #29	17676

Operation Step Detail

Operation: 6

Step

Operation / Step Description

	Degrease, Micro-Carb Harden Oil Quench, Degrease
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Operation Tool Detail

Operation: 6

Tool Number

Tooling Description

Std	Micro-Carb Furnace
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Operation Procedure Notes

Operation: 6

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 114 AISI B-1113

STD. PRACTICE NO.: 198

TEMPERATURE: 1600 Degrees F - .75 Carbon Pot

MAXIMUM LOAD:

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

QUENCH: Oil

REMARKS: Degrease

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 8

Step

Operation / Step Description

Inspect for File Hardness

Operation Tool Detail

Operation: 8

Tool Number

Tooling Description

Std

File

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Operation Procedure Notes Operation: 8

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 114 AISI B-1113

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: File Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 163

HARDNESS LIMITS: File Hard

APPEARANCE OF PARTS: Steel Grey Color, Clean, Free of Oil

Operation Step Detail

Operation: 10

Step

Operation / Step Description

Nitre Black, Water Quench, Wash, Dry, and Oil for Storage

Operation Tool Detail

Operation: 10

Tool Number

Tooling Description

Std Rem. Gas Fired Nitre Pot Furnace #8 - 13-3/4"x37-1/2"x11"

Std Fine Wire Mesh Basket - 19"x12"x3"

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Operation Procedure Notes

Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 114 AISI B-1113

Std. Practice No.: 200

TEMPERATURE: 900 - 950 Degrees F

MAXIMUM LOAD: 25,000 Pcs. - (Heat Treat or Wash)

TIME: 10 Min.

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 165

HARDNESS LIMITS:

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

Operation Step Detail

Operation: 12

Step

Operation / Step Description

Inspect for Color and Oil

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Operation Procedure Notes Operation: 12

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: 114 AISI B-1113

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 165

HARDNESS LIMITS:

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

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