

Process Header

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Document ID: Bolt Stop XP100	Remington Arms Company
Part Name: Bolt Stop XP100	
Product Line: C/F Rifle	Effective Date: 08-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 07-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
07-Oct-1992	Retype ENTire Process from 284125 - Replaces Old Paper Process - Removed 221 FB	GLC 293099

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JACKSON			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
91761	1	Bolt Stop - XP100
C-16812	1	Blank

TITLE: Bolt Stop XP100

Process Routing

Dept	Oper	Operation Description	Part Numbers
8551	4	Neutral Salt Harden, Oil Quench, Wash and Dry	91761
8551	8	Nitre Black, Water Quench, Wash and Dry, Oil for Storage	91761
9257	12	Inspect for Rockwell Hardness	91761
		To MRP Crib #29	91761

Operation Step Detail Operation: 4

Step	Operation / Step Description
	Neutral Salt Harden, Oil Quench, Wash and Dry

Operation Tool Detail Operation: 4

Tool Number	Tooling Description
Std	Ajax Electric Neutral Salt Bath

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TITLE: Bolt Stop XP100

Operation Procedure Notes Operation: 4

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE: 1550 Degrees F

MAXIMUM LOAD:

TIME: 15 Min. @ Temp.

QUENCH: Oil

REMARKS: Wash and Dry

INSPECT FOR: Product Check for File Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Clean, Dry, Free from Salt

Operation Step Detail Operation: 8

Step Operation / Step Description

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

Operation Tool Detail Operation: 8

Tool Number Tooling Description

Std Rem. Gas Nitre Pot Furnace

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Operation Procedure Notes Operation: 8

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE: 900 Degrees F

MAXIMUM LOAD: 1000 Pcs. - Approximately 1/3 Basket

TIME: 20 Min. Total

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

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

Operation Step Detail

Operation: 12

Step

Operation / Step Description

Inspect for Rockwell Hardness

Operation Tool Detail

Operation: 12

Tool Number

Tooling Description

Std

Rockwell Hardness Tester

165

Spot Anvil

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Operation Procedure Notes Operation: 12

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness, Color, and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 164 - Spot Anvil #165

HARDNESS LIMITS: RC 37-42

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

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