

TITLE: Safety Button XP100

Process Header

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

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
08-Oct-1992	Retype Entire Process from 279150 - Replaces Old Paper Process	GLC 293110

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
91495	1	Safety Button - XP100
1501		Raw Material - .0135 Lbs. - Zytel 105-BK-10A
1503		Raw Material - .0135 Lbs. - Zytel 101-NC-10

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Process Routing

Opt	Oper	Operation Description	Part Numbers
8162	5	Blend Nylon Powder	91495
8162	10	Dry Nylon Powder	91495
8162	15	Injection Mold	91495
8579	20	Tumble to Remove Sharp Corners	91495
		To MRP Crib #29	91495

Operation Step Detail

Operation: 5

Step	Operation / Step Description
	Blend Nylon Powder

Operation Tool Detail

Operation: 5

Tool Number	Tooling Description
Std	Mini-Jector Molding Press - Type Zytel BK-10 Blend
Std	Tumbler
Std	Steel Barrel
1501	Zytel 105-BK-10A - 1 Can (25 Lb.)
1503	Zytel 101-NC-10 - 1 Can (25 Lb.)

Operation Procedure Notes

Operation: 5

Description
NOTE: Blend for Twenty Minutes.

Operation Step Detail

Operation: 10

Step	Operation / Step Description
	Dry Nylon Powder

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Operation Procedure Notes      Operation: 10

Description

NOTE: Oven Dry 4 Hours @ 230 Degrees F  
- When Drying Material Reduce Temperature to 170 Degrees F After Initial  
4 Hour Cycle

Operation Step Detail      Operation: 15

Step      Operation / Step Description

Injection Mold

Operation Tool Detail      Operation: 15

Tool Number      Tooling Description

65 HA 100	Mini-Jector Molding Press - Type Zytel BK-10 Blend 4 Cavity Mold JGT Number 6982 Serial No. 89928 Insert : Serial No: 89928-B
Std	Mold Temperature Controller
Std	Container for Parts

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**Operation Procedure Notes      Operation: 15**

**Description**

- NOTES: 1. Use Mold Base Serial No. 89928 and Insert Serial No. 89928-B for Safety Button - The Insert Button is on the Back of the Insert**
- 2. The XP100 Safety Buttons Will Have an X Molded On the Bottom of them in order to Distinguish Them from the 788**

<b>MOLD</b>	<b>CYCLE</b>
JGT Serial No.:            6982	Inject:                    8 Seconds
Type:                      Tunnel Gated	Cure:                     30 Seconds
No. of Cavities:          4	Prepack:                 0 Seconds
Knockout Setting:        Max.	Clamp Open Time: 2 Seconds
Temp. Stationary Side: 130 Degrees F	
Temp. Moving Side:      130 Degrees F	
<b>CLAMP</b>	<b>INJECTION PRESSURE - 1200 Lbs.</b>
Adjust Clamp Toggle for Maximum Clamping Pressure	<b>FEED ADJUSTMENT - Adjust for Minimum Inventory</b>
<b>TEMPERATURES</b>	<b>SHOT WEIGHT - 5 Grams</b>
Plastifying Cylinder      575	Semi - Automatic
Nozzle Variac Setting     70	Full Automatic            YES
	Air Blast                   YES
<b>REMARKS: Adjust Operating Conditions Until Cold Weld Marks are Gone and Parts Fall from Mold</b>	

**Operation Step Detail            Operation: 20**

**Step                              Operation / Step Description**

**Tumble to Remove Sharp Corners**

**Operation Tool Detail            Operation: 20**

**Tool Number                      Tooling Description**

**Std                                5 Lb. Tumbling Barrel**

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Operation Procedure Notes      Operation: 20

Description

Number of Pcs.:      1000

Media:                J-Stars

Compound:            501x4 Oz.

Water:                1 Quart

Time:                 3 Hours

Rinse

To Unload Tip Barrel - Rotate with Water Running In to Float Parts Out of Barrel

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