

**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**

Part 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**

**MOLD**

**CYCLE**

**JGT Serial No.:            6982**  
**Type:                    Tunnel Gated**  
**No. of Cavities:        4**  
**Knockout Setting:      Max.**  
**Temp. Stationary Side: 130 Degrees F**  
**Temp. Moving Side:    130 Degrees F**

**Inject:                   8 Seconds**  
**Cure:                    30 Seconds**  
**Prepack:                0 Seconds**  
**Clamp Open Time: 2 Seconds**

**CLAMP**

**INJECTION PRESSURE - 1200 Lbs.**

**Adjust Clamp Toggle for Maximum Clamping Pressure**

**FEED ADJUSTMENT - Adjust for Minimum Inventory**

**TEMPERATURES**

**SHOT WEIGHT - 5 Grams**

**Plastifying Cylinder      575**  
**Nozzle Variac Setting     70**

**Semi - Automatic**  
**Full Automatic            YES**  
**Air Blast                  YES**

**REMARKS: Adjust Operating Conditions Until Cold Weld Marks are Gone and Parts Fall from Mold**

**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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