

TITLE: Firing Pin Assy XP100

Process Header

Process Header

Document ID: Firing Pin Assy XP100	Remington Arms Company
Part Name: Firing Pin Assy XP100	
Product Line: C/F Rifle	Effective Date: 12-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 287462 - Replaces Old Paper Process - Remove Op.#'s 110 & 120 - Move Op.#100 to 120 and Update - Remove Wip #94233 - Add 97756 with Bolt Plug 97757	GLC 293107
09-OCT-1992	OBSOLETE - PAPER ONLY - PARTS ALREADY IN ANOTHER PROCESS - FIRING PIN ASSY 700 7 100	GLC 293122

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

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Process Material

Part Number	Qty	Description
28600	1	Firing Pin Assembly - XP100
15676	1	Bolt Plug
15410	1	Firing Pin
17022	1	Firing Pin Cross Pin
23321	1	Firing Pin Head
15411	1	Main Spring
97756	1	Firing Pin Assembly - XP100 Matte
97757	1	Bolt Plug
15410	1	Firing Pin
17022	1	Firing Pin Cross Pin
23321	1	Firing Pin Head
15411	1	Main Spring

Process Routing

Dept	Oper	Operation Description	Part Numbers
8502	120	Assemble Firing Pin, Main Spring, Bolt Plug, and Firing Pin Head	28600, 97756
		To MRP Crib #29	28600, 97756

Operation Step Detail

Operation: 120

Step	Operation / Step Description
	Assemble Firing Pin, Main Spring, Bolt Plug, and Firing Pin Head

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Operation Tool Detail

Operation: 120

Tool Number	Tooling Description
Std	Delta Drill Press
Std	#42 Drill - (.0935 Dia.)
	Speed: 2268
	Feed: Hand
E-89082	Fixture
D-52025	Fixture - (Alternate)
Std	Chuck
C-52025-B	Locating Block

Operation Procedure Notes

Operation: 120

Description

Procedure:

NOTE: Put Cloth Pad Under Bolt Plug Before Drilling to Prevent Marring

1. Place Assembly Components in Fixture & Compress
- BE SURE SLIDE IS EQUAL TO RED LINE
2. Drill Firing Pin Cross Pin Hole
3. Drive In Firing Pin Cross Pin
4. Firing Pin Cross Pin Must Be Through Both Sides of the Firing Pin Head

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