TITLE: Sear Housing Assembly XP100

Process Header

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Document ID: Sear Hous Assy XP100	Remington Arms Company
Part Name: Sear Housing Assembly XP100	
Product Line: C/F Rifle	Effective Date: 13-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 10-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:	
10-Oct-1992	Retype Entire Process from 288973 - Replaces Old Paper Process - Remove Expired Operation 50T	GLC	293130

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksoRA			

Process General Notes

Notes:

Process Material

Part Number	Qnty	Description
26790	1	Sear Housing Assembly - XP100
14269	1	Sear Safety Cam
24477	1	Sear Block Pin
15456	1	Sear Block Spring
15457	1	Trigger
15458	1	Trigger Link
15459	2	Trigger Link Pin
15460	2	Trigger Link Roller
26845	1	Sear Block Assembly
51468	2	Dummy Assembly Pins
15452	1	Sear Housing

TITLE: Sear Housing Assembly XP100

Process Routing

Dept	Oper	Operation Description	Part Numbers
8761	55	Assemble Sear Housing Assembly	26790
		To MRP Crib #29	26790

Operation Step Detail Operation: 55

Step	Operation / Step Description
	Assemble Sear Housing Assembly

Operation Tool Detail Operation: 55

Tool Number	Tooling Description
D-85455	Fixture
Std	Crocus Cloth
Std	Screwdriver
A-35645	Pin Punch

Operation Procedure Notes Operation: 55

Description

Procedure:

1. Pick Sear Block Assembly

2. Polish Sear Safety Cam Contact Surface
   - Use New Crocus Cloth
   - Keep Rear Edge Sharp

3. Pick Roller
   - Roller Must Be Burr-Free

4. Insert Roller into Sear Block Assembly Link Pin Hole

5. Pick Trigger Link
   - Black Color
   - Ears Must Be Straight (Both Ends)
   - Holes Must BE Counter-Sunk (Both Ends)

6. Assemble Trigger Link (Housing End - End Away From Square Hole) Over Sear Block

**********SKETCH NEEDED**********

7. Insert Trigger Link Pin (With Head to the Left) and Swage End
   - Swage Must Be On Right Side
   - Swage Must Be Flush or Below Surface
   - Sear Block Must Freely Rotate About Pivot Pin

8. Pick Trigger
   - Good Black Color
   - Striations On Bow Uniform
   - Improved Design at Top Front - Machined Slot Omitted

9. Insert One Roller Into Link Pivot Hole
   - Roller Must Be Burr-Free

10. Assemble Trigger Link Over Trigger
    - Ears of Trigger Link Must Be Straight - Not Bowed In

11. Insert Trigger Link Pin and Swage End
    - Swage Must Be Flush or Below Surface
    - Trigger Must Fully Rotate FREELY Around Pin and Roller

12. Pick Sear Housing
    - Black Color
    - Sharp Corner at Intersection of the Two Safety Detent Holes - NO FLAT

**********SKETCH NEEDED**********

    - Uniform Opening at Top for Safety Cam
    - Weld at Front of Housing Must Not Interfere with Sear Block Screw Hole

14. Test Weld
    - Pry Sear Housing with Medium Force on Screw Driver to Test for Good Weld

      o To Test Weld:

Continued ...
Operation Procedure Notes Operation: 55
Description

- Insert Screw Driver in Front Under Weld
- Pivot Screw Driver Downward to Test Weld

- Weld Must Remain Good

**********SKETCH NEEDED**********

15. Assemble Trigger Link Assembly into Sear Housing, and Insert Sear Block Pin - Drive Pin Left to Right
    - This is Easiest Done by Pivoting Sear Block Assembly Fully Forward
      - Hold Vertically - and Place Sear Housing Over It
    - Pin Must Be Flush On Right Side and Tight In Housing
    - Sear Block Assembly and Trigger Link Must Be Free In Housing
      o Hold Sear Housing - Move Link Forward and Backward
    - Link and Sear Block Assembly Must Move Freely
      o Press Left End of Sear Block Pin Firmly Against Bench Block
    - Pin Must Not Move - Stake Housing at Right Side If Required

16. Pick Sear Safety Cam
    - There Must Be NO Burrs On Any Surface
    - There Must Be NO Dimple Above Sear Cam Notch for Spring

**********SKETCH NEEDED**********

    - Use Sear Safety Cam #14269 ONLY - DO NOT SUBSTITUTE

17. Assemble Sear Safety Cam into Sear Housing with Dummy Pin

18. Drop Sear Block Spring into Position On Sear Block Stud

19. Rotate Sear Safety Cam into Position In Sear Cam Notch

20. Install Rear Dummy Pin Over Sear Safety Cam

21. Check for Correct Sear Safety Cam Freedom and Spring Force
    - Sear Safety Cam Must Not bind in Housing
      o Pull Link Forward and Hold - Then Depress SearSafety Cam at Top Rear and Release
    - Sear Block Must Fully Depress and Return to Full Upward Position Against Dummy Pin
    - Sear Block Must Fully Rotate Under Sear Safety Cam
      o Hold Sear Housing Pull Trigger Link and Release
    - Sear Block Must Return Under Sear Housing with Spring Force