

Process Header

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Document ID: Sear Block Assy XP100	Remington Arms Company
Part Name: Sear Block 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 279156 - Replaces Old Paper Process	GLC 293129

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
26845	1	Sear Block Assembly - XP100
15461	1	Sear Block
15462	1	Sear Block Stud

Process Routing

Dept	Oper	Operation Description	Part Numbers
8715	55	Assemble Sear Block Assembly	26845
		To MRP Crib #29	26845

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TITLE: Sear Block Assembly XP100

Operation Step Detail

Operation: 55

Step

Operation / Step Description

Assemble Sear Block Assembly

Operation Tool Detail

Operation: 55

Tool Number

Tooling Description

Std

H 2 Greenerd Press

C-86199

Fixture

C-86199-A

Ram

Operation Procedure Notes

Operation: 55

Description

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

Procedure:

1. Visually Inspect Sear Block:

- All Holes Must Be Free of Residue - Clean with Paper Clip If Necessary
- Sear Safety Cam Contact Surface Must Be:
 - o Smooth and Uniform 1/16" Minimum
 - o All Edges Burr-Free
 - o Rear Edge Must Be Sharp - No Visible Radius
- Check for Burrs and Smoothness with Fingertip

2. Start Sear Block Stud into Sear Block Hole and Position into Fixture

3. Pull Handle on Press to Firmly Seat Sear Block Stud Shoulder

- Sear Block Stud Must Be Tight to Sear Block

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