

TITLE: Trigger Guard XP100

Process Header

Process Header

Document ID: Trig Guard XP100	Remington Arms Company
Part Name: Trigger Guard XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 26-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
26-Oct-1992	Retype Entire Process from 281914 - Replaces Old Paper Process	GLC 293215

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

--

Process Material

Part Number	Qty	Description
15468	1	Trigger Guard - XP100
1501		.0169 Nylon Zytel 101 NC-10
1503		.0169 Nylon Zytel 105 BK-10A

Document Number: Trig Guard XP100 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 5

TITLE: Trigger Guard XP100

Process Routing

Dept	Oper	Operation Description	Part Numbers
8162	4	Blend Nylon Powder	15468
8162	8	Dry Nylon Powder	15468
8162	12	Injection Mold	15468
8162	16	Degate and Inspect	15468
		To MRP Crib #16	15468

Operation Step Detail

Operation: 4

Step

Operation / Step Description

	Blend Nylon Powder
--	--------------------

Operation Tool Detail

Operation: 4

Tool Number

Tooling Description

Std	Newbury H-12-200T - Type Nylon Zytel
101 NC-10	Nylon Zytel - 1 Can 25#
105 BK-10A	Nylon Zytel - 1 Can 25#
Std	Aluminum Stearate - 7 Grams
Std	Steel Barrel
Std	Balance
#280	Chem. & Met. Std. Practice

Operation Procedure Notes

Operation: 4

Description

NOTE: Blend for 20 Minutes

Operation Step Detail

Operation: 8

Step

Operation / Step Description

	Dry Nylon Powder
--	------------------

Document Number: Trig Guard XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 2

OF 5

TITLE: Trigger Guard XP100

Operation Tool Detail

Operation: 8

Tool Number

Tooling Description

Std	Newbury H-12-200T - Type Nylon Zytel
Std	Blend: Nylon Zytel 101 NC-10 Nylon Zytel 105 BK-10A Aluminum Stearate
Std	Lydon -Drying Oven
Std	Trays - 34" x 17" x 1-1/2" Deep

Operation Procedure Notes

Operation: 8

Description

Oven Dry 4 Hours @ 230 Degrees F

Note: When Holding Material for More Than 4 Hours; Reduce Temperature to 1750 Degrees F After Initial 4 Hour Cycle

Operation Step Detail

Operation: 12

Step

Operation / Step Description

Injection Mold

Operation Tool Detail

Operation: 12

Tool Number

Tooling Description

Std	Newbury H-12 - 200T - Injection Molding Machine
89898	4 Cavity J.G. Tilp Injection Mold (Serial Number)
Std	Container for Parts
Std	Container for Sprue and Runner
Std	IMS Mold Temperature Controllers

Document Number: Trig Guard XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 3

OF 5

TITLE: Trigger Guard XP100

Operation Procedure Notes

Operation: 12

Description

Material: 50% Zytel 101 NC 10 & 50% Zytel 105 BK 10A

Temperature Controller: Tank to be kept Full with Solution of Water and Sodium Nitrite 1/2 Lb./Gal. of Water

Sprue and Runner Container: To be Clean and Dry - and to be Sealed when Full to Prevent Contamination

Cylinder Temp. in Degrees F: Zone #1 - 515
Zone #2 - 510
Zone #3 - 495
Nozzle - 510

Timer Settings in Seconds: Cycle Time - 33.0
High Pressure Inject - 6.0
Low Pressure Inject - 5.0
L.P.C. Time - 3.75
Clamp Open - 2.5
Knock Out Timed - 0.0
Pre Pack - 0.0
Total Cycle - 39.25

Pressure Settings (PSI): High Inject - 1700
Low Inject - 1300

Inject Speeds: Speed #1 - Full
Speed #2 - Full

Shot Settings (In.): LS - 13 - 5.25
LS - 4 - 14.75

Mold Temp. Degrees F: Movable Side - 150
Stationary Side - 160

Shot Wt. (Gr.): Total 59.3
Parts 51.4

Remarks: K.O. Pin Size
K.O. Setting - Black
Run Full Auto.
Feed Bar 7-1/8 from Back
Max. Day Light 5-3/4"

Operation Step Detail

Operation: 16

Step

Operation / Step Description

Degate and Inspect

Document Number: Trig Guard XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 4

OF 5

TITLE: Trigger Guard XP100

Operation Tool Detail

Operation: 16

Tool Number

Tooling Description

Std Newbury H-12 - 200T - Type Nylon Zytel

Operation Procedure Notes

Operation: 16

Description

Procedure:

1. Break Parts from Gate
2. Inspect for:
 - a. Fill
 - b. Sinks
 - c. Cold Welds at Bottom of Bow
 - d. Poor Fill
3. Regrind Container

Document Number: Trig Guard XP100

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 5

OF 5