

TITLE: Trigger Link XP100

Process Header

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Document ID: Trig Link XP100	Remington Arms Company
Part Name: Trigger Link 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 279148 - Replaces Old Paper Process	GLC 293211

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15458	1	Trigger Link - XP100
16325	1	Blank

Process Routing

Dept	Oper	Operation Description	Part Numbers
8579	5	C'Sink (4) Places	15458
8579	10	Black Oxide Color	15458
		To Sear Housing Assembly	15458

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Operation Step Detail

Operation: 5

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Operation / Step Description	Time (min)	Notes
1. Initial Setup and Calibration	15	Check instrument calibration and reagent concentrations.
2. Sample Preparation	20	Prepare samples and standards according to protocol.
3. Measurement Phase	45	Perform measurements and record data.
4. Data Analysis	30	Analyze collected data and generate reports.
5. Cleanup and Maintenance	15	Clean equipment and maintain records.
Total Time	115	

C'Sink (4) Places

Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

C-85135

Holding Block

A-85370

C' Sink

A-86123

Flush Pin Gage - Depth - .031/.021

Operation Step Detail

Operation: 10

Step

Operation / Step Description	Time (min)	Notes
1. Initial Setup	5	Check equipment, reagents, and safety protocols.
2. Sample Collection	10	Collect samples from the designated area.
3. Sample Processing	15	Grind samples, add reagents, and mix thoroughly.
4. Analysis	20	Run the analysis on the prepared samples.
5. Data Collection	10	Record the results of the analysis.
6. Cleanup	5	Wash equipment and dispose of waste properly.
7. Final Report	10	Compile the data into a final report.
Total Time	75	

Black Oxide Color

Operation Procedure Notes

Operation: 10

Description

SMALL PARTS BLACK OXIDE COLOR

BLACK OXIDE RACK/FIXTURE:

LOAD SIZE:

STEP	PROCESS SEQUENCE	TEMPERATURE	CONCENTRATION	IMERSION TIME
1	Alkaline Clean	212 F	7-9%	3-5 Minutes
2	Cold Water Rinse	Ambient	-----	1 Minute
3	Muriatic Acid	Ambient	15-17%	10-15 Seconds
4	Cold Water Rinse	Ambient	-----	1 Minute
5	Black Oxide #1	290 F	6.5-6.8 lbs/gal	30 Minutes
6	Cold Water Rinse	Ambient	-----	1 Minute
7	Black Oxide #2	300 F	7.0-7.3 lbs/gal	30 Minutes
8	Hot Water Rinse	212 F	-----	1 Minute
9	Braze Color	185 F	1.0-1.3 lbs/gal	30 Minutes
10	Hot Water Rinse	212 F	-----	1 Minute
11	Steelgard	Ambient	15-20%	30 Seconds

NOTE FOR POWDER METAL AND M.I.M. PARTS

* Increase immersion time on step #3 to 30-45 seconds.

* Increase immersion time on step #8 to 30 minutes.

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