

**TITLE: Rear Receiver Screw XP100**

**Process Header**

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Document ID: Rear Rec Scr XP100	Remington Arms Company
Part Name: Rear Receiver Screw XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 30-Oct-1992

**Process Revision Reasons**

Date:	Reason For Revision:	Eng Log #:
30-Oct-1992	Retype Entire Process from 283475 - Replaces Old Paper Process - Revise Heat Treat Process Changes Op.#5 Description - Add 97759	GLC 293278

**Process Approval List**

Approved By:	Badge #:	Date:	Designation:
Jacksora			

**Process General Notes**

**Notes:**

**Process Material**

Part Number	Qty	Description
15450	1	Rear Receiver Screw - XP100
16503	1	Blank
97759	1	Rear Receiver Screw - XP100
97762	1	Blank

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**Process Routing**

Opt	Oper	Operation Description	Part Numbers
8551	5	Degrease, Carbo-Nitride (MicroCarb) Harden Oil Quench, Degrease	15450, 97759
8551	10	Nitre Black, Water Quench, Wash, Dry and Oil	15450, 97759
9257	15	Inspect for Oil and Color	15450, 97759
		To MRP Crib #29	15450, 97759

**Operation Step Detail**

Operation: 5

**Step**

**Operation / Step Description**

	Degrease, Carbo-Nitride (MicroCarb) Harden Oil Quench, Degrease
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**Operation Tool Detail**

Operation: 5

**Tool Number**

**Tooling Description**

Std	Micro-Carb Furnace
Std	Basket - 12"x20"x2" Deep

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**TITLE: Rear Receiver Screw XP100**

**Operation Procedure Notes      Operation: 5**

**Description**

**PROCESS RECORD - HEAT TREAT SPECIFICATION**

**MATERIAL & SPECIFICATION: .08/.20 Carbon Steel**

**TEMPERATURE: .75 Carbon Potetial - 1600 Degrees F**

**MAXIMUM LOAD: 3000 Pcs - 2 Baskets 1500 Pcs per Basket**

**TIME: 1.5 Hrs. @ Temp.**

**QUENCH: Oil**

**REMARKS: Degreased**

**INSPECT FOR: File Hard to Insure Proper Quench**

**HEAT TREAT INSPECTION:**

**STANDARD PRACTICE NO:**

**HARDNESS LIMITS:**

**APPEARANCE OF PARTS: Free of Oil**

**Operation Step Detail      Operation: 10**

**Step      Operation / Step Description**

**Nitre Black, Water Quench, Wash, Dry and Oil**

**Operation Tool Detail      Operation: 10**

**Tool Number      Tooling Description**

**Std      Nitre Black Bath**

**Std      Basket - 12"x20"x3" Deep with Handle**

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**TITLE: Rear Receiver Screw XP100**

**Operation Procedure Notes      Operation: 10**

**Description**

**PROCESS RECORD - HEAT TREAT SPECIFICATION**

**MATERIAL & SPECIFICATION: .08/.20 Carbon Steel**

**TEMPERATURE: 925 - 950 Degrees F**

**MAXIMUM LOAD: 3000 Pcs per Basket**

**TIME: 15 - 20 Min. @ Temp.**

**QUENCH: Water**

**REMARKS:**

**INSPECT FOR: Color and Oil**

**HEAT TREAT INSPECTION:**

**STANDARD PRACTICE NO:**

**HARDNESS LIMITS:**

**APPEARANCE OF PARTS: Free from Salts Well Oiled**

**Operation Step Detail      Operation: 15**

**Step      Operation / Step Description**

**Inspect for Oil and Color**

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TITLE: Rear Receiver Screw XP100

Operation Procedure Notes

Operation: 15

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free from Salts, Well Oiled

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