

**TITLE: FORWARD REC SCR ESCUTCHEON PM XP100**

**Process Header**

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Document ID: FORWARD REC SCR ESCUTCHEON PM XP100	Remington Arms Company
Part Name: FORWARD REC SCR ESCUTCHEON PM XP100	
Product Line: RIFLE	Effective Date: 04-NOV-1992-09:00:00
Engineering Group: RIFLE	Origination Date: 31-OCT-1992

**Process Revision Reasons**

Date:	Reason For Revision:	Eng Log #:
31-OCT-1992	RETYPE PROCESS FROM 290152 - REPLACES OLD PAPER COPY	ERF 293292

**Process Approval List**

Approved By:	Badge #:	Date:	Designation:
JACKSORA			

**Process Material**

Part Number	Qty	Description
15448	1	FORWARD REC SCR ESCUTCHEON PM - XP100
5873	1	POWDER METAL BLANK

**Process Routing**

Dept	Oper	Operation Description	Part Numbers
8119	22	STRADDLE MILL FLAT	15448
8119	25	ROUGH AND FINISH HOLLOWMILL STEM CHAMFER AND FACE TOP AND HOLE ON BOTTOM.	15448
8119	40	BURR AND BREAK .032 R. ON FRONT SHOLDER	15448
8579	47	SUPERSHEEN	15448
8579	50	BLACK OXIDE COLOR	15448
		TO MRP CRIB #16	

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Operation Step Detail

Operation: 22

Step

Operation / Step Description

STRADDLE MILL FLAT

Operation Tool Detail

Operation: 22

Tool Number

Tooling Description

D-85580

FIXTURE

B-85620W&V

SET OF CUTTERS

STD.

ARBOR

B-85510

SNAP GAGE "A" .286 - .274

B-85582

PLUG GAGE - CHECK BOTH SIDES "B" .143 - .137

C-85583

FLUSH PIN GAGE "C" .970 - .960

Operation Procedure Notes

Operation: 22

Description

NOTE: ON GAGE #85510 "NO GO" MAY GO ONE SIDE

Operation Step Detail

Operation: 25

Step

Operation / Step Description

ROUGH AND FINISH HOLLOWMILL STEM CHAMFER AND FACE TOP AND HOLE ON BOTTOM

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TITLE: FORWARD REC SCR ESCUTCHEON PM XP100

Operation Tool Detail

Operation: 25

Tool Number	Tooling Description
D-85513	JIG
C-85520	HOLDING BLOCK
A-85617V	HOLLOW MILL - ROUGH
A-85617W	HOLLOW MILL - FINISH
A-85618	FACING AND CHAMFERING TOOL SEVERANCE STOP - C'SINK CUTTER SC-10-45deg. C/L ANGLE - 250 PILOT SEVERANCE STOP - C'SINK CUTTER SHANK FM2
B-85511	SNAP GAGE - "A" .415 - .405
C-85515	FLUSH PIN GAGE - "B" .780 - .775
B-85519	FLUSH PIN GAGE (SET UP) "C" .513 - .507
A-85619	ROTARY STOP (2 REQUIRED)
C-85521	F.P. GAGE - "D" .725 - .720

Operation Procedure Notes

Operation: 25

Description

\*\*\*\*\*SKETCH NEEDED\*\*\*\*\*

Operation Step Detail

Operation: 40

Step	Operation / Step Description
	BURR AND BREAK .032 R ON FRONT SHOULDER

Operation Tool Detail

Operation: 40

Tool Number	Tooling Description
STD.	FILE NOTE: 1/32 RADIUS REQUIRED

Operation Procedure Notes

Operation: 40

Description

\*\*\*\*\*SKETCH NEEDED\*\*\*\*\*

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TITLE: FORWARD REC SCR ESCUTCHEON PM XP100

Operation Step Detail

Operation: 47

Step

Operation / Step Description

SUPERSHEEN

Operation Tool Detail

Operation: 47

Tool Number

Tooling Description

STD.

CHIP #4

STD.

MACHINE: DB-400

Operation Procedure Notes

Operation: 47

Description

CHIP QUANTITY- 50% BBL. CAPACITY

18RPM

# PCS.- 1000 PER COMPARTMENT

GRIND - #4 CHIP - IMMUNOL 6oz - WATER LEVEL - TIME 4hrs. - RINSE 3 TIMES

SEPARATE FROM CHIP AND OIL

Operation Step Detail

Operation: 50

Step

Operation / Step Description

BLACK OXIDE COLOR

Operation Procedure Notes

Operation: 50

Description

NOTE: PART IS MADE FROM POWDER METAL

TO AVOID SALT BLEED OUT - QUENCH PARTS IN HOT WATER IMMEDIATELY FOLLOWING  
COLOR BATH.

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