

TITLE: Trigger Housing Screw XP100

Process Header

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Document ID: Trig Hous Scr XP100	Remington Arms Company
Part Name: Trigger Housing Screw XP100	
Product Line: C/F Rifle	Effective Date: 03-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 Entire Process from 283474 - Replaces Old Paper Process - Chg. Description Op.#5	GLC 293290

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15474	1	Trigger Housing Screw - XP100
16506	1	Blank

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Process Routing

Qt Oper	Operation Description	Part Numbers
8551 5	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease, Wash	15474
8551 10	Nitre Black, Water Quench, Wash and Dry	15474
9257 15	Inspect for Color and Oil	15474
	To MRP Crib #29	15474

Operation Step Detail

Operation: 5

Step

Operation / Step Description

	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease, Wash
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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: Trigger Housing Screw XP100

Operation Procedure Notes Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: .75 Carbon Pot. @ 1600 Degrees F

MAXIMUM LOAD: 5000 Pcs. - 2 Baskets 2500 Pcs per Basket

TIME: 1.5 Hrs. @ Temp.

QUENCH: Oil

REMARKS: Wash

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 and Dry

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: Trigger Housing Screw XP100

Operation Procedure Notes Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: 900 - 950 Degrees F

MAXIMUM LOAD: 5000 Pcs. per Basket

TIME: 15 - 20 Min. @ Temp.

QUENCH: Water

REMARKS:

INSPECT FOR: Color

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Uniform Black Color, Free of Salts, Well Oiled

Operation Step Detail Operation: 15

Step Operation / Step Description

Inspect for Color and Oil

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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: Uniform Black Color, Free of Salts, Well Oiled

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