

**TITLE: Trigger Housing Screw Front XP100**

**Process Header**

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Document ID: Trig Hous Scr Front XP100	Remington Arms Company
Part Name: Trigger Housing Screw Front 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 285852 - Replaces Old Paper Process - Chg. Description Op.#5	GLC 293289

**Process Approval List**

Approved By:	Badge #:	Date:	Designation:
Jacksora			

**Process General Notes**

**Notes:**

**Process Material**

Part Number	Qty	Description
15469	1	Trigger Housing Screw, Front - XP100
16504	1	Blank

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**Process Routing**

pt	Oper	Operation Description	Part Numbers
8551	5	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease, Wash	15469
8551	10	Lindberg Draw, Air Cool	15469
9257	12	Inspect for Hardness	15469
8579	15	Black Oxide, Oil with Steelgard	15469
		(To Trigger Housing Assembly)	15469
		To MRP Crib #29	

**Operation Step Detail**

Operation: 5

Step	Operation / Step Description
	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease, Wash

**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 Front 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**

**Lindberg Draw, Air Cool**

**Operation Tool Detail      Operation: 10**

**Tool Number      Tooling Description**

**Std      Lindberg Furnace**

**Std      Basket - 12"x20"x2" Deep**

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**TITLE: Trigger Housing Screw Front XP100**

**Operation Procedure Notes      Operation: 10**

**Description**

**PROCESS RECORD - HEAT TREAT SPECIFICATION**

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

**TEMPERATURE: 350 - 400 Degrees F**

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

**TIME: 1 Hr. @ Temp.**

**QUENCH: Air Cool**

**REMARKS:**

**INSPECT FOR:**

**HEAT TREAT INSPECTION:**

**STANDARD PRACTICE NO:**

**HARDNESS LIMITS:**

**APPEARANCE OF PARTS: Free of Oil**

**Operation Step Detail      Operation: 12**

**Step      Operation / Step Description**

**Inspect for Hardness**

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**TITLE: Trigger Housing Screw Front XP100**

**Operation Procedure Notes      Operation: 12**

**Description**

**PROCESS RECORD - HEAT TREAT SPECIFICATION**

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

**TEMPERATURE:**

**MAXIMUM LOAD:**

**TIME:**

**QUENCH:**

**REMARKS:**

**INSPECT FOR: File Hardness**

**HEAT TREAT INSPECTION:**

**STANDARD PRACTICE NO:**

**HARDNESS LIMITS:**

**APPEARANCE OF PARTS: Free of Oil**

**Operation Step Detail      Operation: 15**

**Step      Operation / Step Description**

**Black Oxide, Oil with Steelgard**

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**TITLE: Trigger Housing Screw Front XP100**

**Operation Procedure Notes      Operation: 15**

**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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