

Safety Case

OBSCURE

17946

1. The OBSCURE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced with a colored tissue dividing sheet.
2. Each operation may have several OBSCURE SHEETS. Where this is true they have been put in order according to the date when they were OBSCURED, the latest date being on top.
3. All sketch sheets precede their operation sheets and are separated from them by colored

Part: *Sub*

Part No.: 17945
Design No:

MATERIAL PROCUREMENT - RAW MATERIAL

Date: 2/5/47

Detailed Description

Pieces Required Per Assembly:

Material Specification No. : *101*

Material : *101*

Size : *3" x 5" x 10" length*

Condition : *Good*

Weight Per 100 : Calculated: *3.1* Measured: *3.1*

Additional Uses of Material :

Uses of Part : *101*

Identification of Material : Routing Ticket to be marked Mat. Spec. # *101*

Remarks:

Edge

PART

SAFETY CAM

PART No. 17945

MATERIAL PROCUREMENT - RAW MATERIAL

Date: 2/5/47

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI C-1022 or substitute
1029

Size

*.004"
: $\frac{3}{32}$ " $\pm .002$ x $\frac{5}{8}$ " $\pm .008$
- .002 - .008
x 10 to 12' lengths

Condition

: Cold Finished Strip

Temper

: Half Hard

Edge

: #3

Finish

: #2

Weight Per 100

: Calculated 3.1 Measured _____

Additional Uses of Material :

Uses of Part

: M/721 Safety Cam

Identification of Material

: Routing Ticket to be marked Mat. Spec.
101B

Remarks:

* To facilitate procurement material of $\frac{1}{16}$ "
thickness can be used instead of $\frac{1}{8}$ " as specified
to .006" .008" .010" .012" .014" .016" .018" .020"

COMPILED BY:

R.H. Grace
2/5/47

APPROVAL & DATE:

Thur 2/5/47

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: SAFETY CAM	PART NO. 17945																		
MATERIAL PROCUREMENT - RAW MATERIAL																			
Date 2/5/47																			
DISOLETE Detailed Description Pieces Required Per Assembly: 1 Material Specification No. : 101B Material : AISI C-1022 or substitute 1029 Size : .084" $\pm .002^*$ $-.002$ X 5/8" $\pm .008$ $-.008$ X 10 to 12' lengths Condition : Cold Finished Strip Temper : Half Hard Edge : #3 Finish : #2 Weight Per 100 : Calculated <u>3.1</u> Measured _____ Additional Uses of Material : Uses of Part : M/721 Safety Cam Identification of Material : Routing Ticket to be marked Mat. Spec. No. <u>101B</u> Remarks: *To facilitate procurement material up to 1/8" thickness can be used but will have to be ground to .086" - .082" before machining.	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center; font-size: 0.8em;">REV. NO.</th> <th style="text-align: center; font-size: 0.8em;">DATE</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">2/18/47</td> </tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </tbody> </table>	REV. NO.	DATE	1	2/18/47														
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1	2/18/47																		
COMPILED BY: R.H. Grace 2/5/47 APPROVAL & DATE: <i>MVA</i>																			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																			

H. H. SULLIVAN, INC.

Abner
OBSOLETE
17946

1. The OBSOLETE Process Records. In this folder are filed in order of operation numbers. Each operation is prefaced with a colored tissue dividing sheet. Each operation may have several OBSOLETE SHEETS. Where this is true they have been put in order according to the date when they were OBSOLETE, the latest date being on top.
3. All sketch sheets processed, then

Refused
OBSCURE
FEB 5 1947

Part: *Sear*

Model:
Part No.: *17046*
Eng. No.:

MATERIAL PROCUREMENT - RAW MATERIAL

Date: *2/5/47*

Detailed Description

Pieces Required Per Assembly: *1*

Material Specification No. :

Material :

Size :

Condition :

Weight Per 100 :

Calculated: *2.1* Measured:

Additional Uses of Material :

Uses of Part :

Identification of Material : Routing Ticket to be marked Mat. Spec. # *1115*

Remarks:

(Sear 17046)
Eng. 17046

J. H. [Signature]

PART No. 17946

MATERIAL PROCUREMENT - RAW MATEFIAL

Date: 2/5/47

Detailed Description

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI-C-1022 or substitute
C-1029

Size : $\frac{.054}{2/32} + .002^* \times 7/16'' + .008$
 $-.002 \times -.008$
 $\times 10 \text{ to } 12 \text{ ' lengths}$

Condition : Cold Finished Strip

Temper : Half Hard

Edge : #3

Finish : #2

Weight Per 100 : Calculated 2.1 Measured

Additional Uses of Material :

Uses of Part : M/721 Sear

Identification of Material : Routing Ticket to be marked Mat. Spec.
101B

Remarks:

Remarks:

* To facilitate placement at least up to 4' thickness can be made as will have to depend on 7'-00"-8'-00" below.

COMPILED BY: R.H.Grace
2/5/47

APPROVAL & DATES:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: SEAR		PART No. 17946																		
MATERIAL PROCUREMENT - RAW MATERIAL		Date 2/5/47																		
Detailed Description Pieces Required Per Assembly: 1 Material Specification No. : 101B Material : AISI-C-1022 or substitute C-1029 Size : .084 +.002* -.002 X 7/16" +.008 -.008 X 10 to 12' lengths Condition : Cold Finished Strip Temper : Half Hard Edge : #3 Finish : #2 Weight per 100 : Calculated <u>2.1</u> Measured _____ Additional Uses of Material : Uses of Part : M/721 Sear Identification of Material : Routing Ticket to be marked Mat. Spec. No. <u>101B</u> Remarks: *To facilitate procurement material up to 1/8" thickness can be used but will have to be ground to .086" - .082" before machining.		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">REV. NO.</th> <th style="text-align: center;">DATE</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">2/18/47</td> </tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </tbody> </table>	REV. NO.	DATE	1	2/18/47														
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COMPILED BY: R.H.Grace 2/5/47		APPROVAL & DATE: <i>[Signature]</i>																		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																				

17255-X

OBSCURE

Bolt Final Assembly

1. The OBSCURE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced with a colored tissue dividing sheet. Each operation may have several OBSCURE SHEETS. Where this true they have been put in order according to the date when they were OBSCURED, the latest date being on top.
- 2.
3. All sketch sheets precede the operation sheets and are separated by a colored tissue.

PART: FINAL BOLT ASSEMBLY		PART NO. 17255-Y	
PROCESS RECORD-ASSEMBLY			
STEP	TOOLS & GAGES		REMARKS
	TYPE	NO.	
1) Insert ejector Sprg. 17019 and ejector 17017	Fixture	C51730	
2) Insert ejector pin 17018	Hammer Fixture	C51730	
3) Insert extractor 17020-W-V			Claw must be opposite ejector hole.
4) Screw Firing Pin Assembly 17223-YW-YV into Bolt Body Assembly 17005-W-V and remove "U" spacer-B-52037 & measure Firing Pin Protrusion	Flush Pin Gage 0.075-0.045	B-52089	
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

*Relayed
7-77*

PART NO. 17255-Y

PROCESS RECORD-ASSEMBLY

STEP	TOOLS & GAGES		REMARKS
	TYPE	NO.	
1) Insert ejector Sprg. 17019 and ejector 17017	Fixture	C51730	
2) Insert ejector pin 17018	Extractor Fixture	C51730	
3) Insert extractor 17020-W-V			Claw must be opposite ejector hole.
4) Screw Firing Pin Assembly 17223-YW-YV into Bolt Body Assembly 17005-W-V and remove "U" spacer-B-52037 & measure Firing Pin Protrusion	Flush Pin Gage	B-52089 0.075-0.045	

Relayed 7-27

OBSOLETE

COMPILED BY: APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. **REVISED JUL 15 1949**

PART: <i>Bolt Final Assembly</i>		PART No. <i>17255 Y</i>
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
<i>7-25-46</i>	<i>Changed name from Final Bolt assembly to Bolt Final Assembly</i> DELETE <i>Retyped 7-29</i>	
COMPILED BY:	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

OBsolete

JAN 27 1946
-25-46

PART: BOLT FINAL ASSEMBLY		PART No. 17255Y
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
	Changed name from Final Bolt Assembly to Bolt Final Assembly	
COMPILED BY:		APPROVAL & DATE: <i>M/K 8/20/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

TPR-1

PROCESS RECORD

FINAL BOLT ASSEMBLY

17255-Y

ISSUED BY:

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

OBSOLETE

ISSUED TO: _____

DEPARTMENT

ISSUE RECORD

ASSEMBLY

OBSOLETE

ISSUED TO _____

DEPARTMENT _____

SEAR

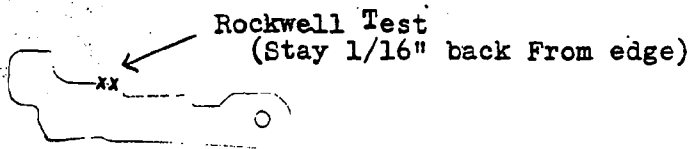
OBsolete

17946

*Abolished
Revised
1/1/47*

PART: <i>44447</i>			PART No.	
OPERATION:			OPER. No.:	
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
	<i>see</i>	<i>Inf. Part oper 28 for typing</i>		
SKETCH				
COMPILED BY:		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

7/1/47

PART 17945 <i>17946</i> <i>Before one piece like 17946</i> <i>then for heat 17946</i> <i>and one for 17945</i>		PART No. 17945
OPERATION: High Temperature Cyanide Harden, Oil Quench, Wash, Dry and Oil for Storage		OPER. No.: 17 29
HEAT TREAT Spec. No. 2387		
EQUIPMENT: Remington Gas-fired Cyanide Pot Furnace - 12" dia. x 12" deep		
DETAILED DESCRIPTION		
MATERIAL SPECIFICATION No.:		
MATERIAL:	: C-1019	
TEMPERATURE:	1575/1600°F.	
CONTAINER:	Basket - 7-1/2" dia. x 6" deep	
MAXIMUM LOAD:	400 pieces - approximately 2" depth in basket	
TIME:	20 minutes at temperature	
QUENCH:	Oil	
STANDARD PRACTICE:	#198	
Maximum Load-Wash 400 pieces		
REMARKS:		
		
HEAT TREATMENT INSPECTION Op. No.: 17		
Operation: Inspect for Rockwell Hardness		
Standard Practice	: 164 except Superficial Rockwell Machine, Plane Anvil	
Hardness Limits	: R ₁₅ N 86/92	
Appearance of Part	: Steel grey color, clean, free of salt, well oiled for storage. Next Op. No. Part Stores	
COMPILED BY: J. F. Bowling	APPROVAL & DATE: <i>1/16/47</i>	
1/16/47		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: <i>4/4/67</i>		PART No. <i>17746</i>	
OPERATION: <i>Finish Bore</i>		OPER. No.: <i>20</i>	
PROCESS RECORD			
EQUIPMENT: SPEED: MAX. PROD. PER HOUR: <i>See Safety Bore ops 22</i> <i>for tapping</i> FEED: COOLANT:			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
SKETCH			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

TR-5

*Grind
Pin
Revised
date*

PART: <i>44/47 clear</i>	PART No. <i>17946</i>
OPERATION: <i>Grind Pin - Hot surface</i>	OPER. No.: <i>18</i>

PROCESS RECORD

EQUIPMENT: <i>#2 B+S Surface Grinder</i>	
SPEED:	FEED: <i>Hand</i>
MAX. PROD. PER HOUR:	COOLANT: <i>NONE</i>

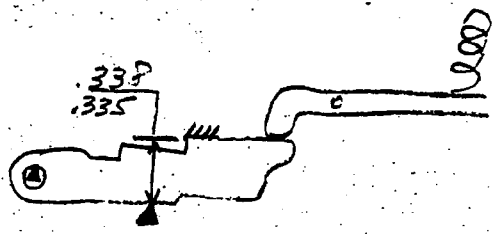
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>"K" Wheel</i>	<i>Std</i>	<i>Fixture</i>	<i>C-53245</i>
<i>Lead Gauge</i>	<i>C-53239</i>	<i>See sketch</i>	

SKETCH

*See same sketch & operation
on safety cam - 9020*

COMPILED BY: <i>[Signature]</i>	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

H. K. SULLIVAN, INC.

PART: <i>4/4/47</i> <i>Seal</i>		PART No. <i>17946</i>	
OPERATION: <i>Grind Trigger Connector surface</i>		OPER. No.: <i>16</i>	
PROCESS RECORD			
EQUIPMENT: <i>#2 B+S Surface Grinder</i>			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT: <i>NONE</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	NO.	TYPE	NO.
<i>"K" wheel</i> <i>Dial gauge</i> <i>accuracy</i> <i>of setting</i>	<i>std</i> <i>C-53239</i>	<i>Fixture</i>	<i>B-53245</i>
SKETCH			
			
COMPILED BY: <i>Bainbridge</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

M. H. SULLIVAN, INC.

Approved
Ret

PART: <i>414 L. 1</i>		PART No. <i>17946</i>	
OPERATION: <i>C' Sink to Remove Burr</i>		OPER. No.: <i>12</i>	
PROCESS RECORD			
EQUIPMENT: <i>#1 Lebed Gifford Drill Press</i>			
SPEED: <i>1800</i>		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT: <i>None</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Drill - 3/16" ?</i>	<i>B-90144W</i>	<i>Hold in hand to have</i>	
<i>90° Pt. - B-90144W</i>		<i>both sides Slight</i>	
		<i>C' Sink is desirable</i>	
SKETCH			
COMPILED BY: <i>Veteran</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

M. H. SULLIVAN, INC.

Handwritten:
 4/14/47
 Ream
 Note

PART: <i>4/14/47 Ream</i>		PART No. <i>17946</i>	
OPERATION: <i>Ream Pin Hole</i>		OPER. No.: <i>10</i>	
PROCESS RECORD			
EQUIPMENT: <i>Seland Gifford Drill Press</i>			
SPEED: <i>600</i>		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT: <i>Cornmeal or Soluble Oil</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Reamer</i>	<i>B-9079L</i>	<i>Leg</i>	<i>B-53234</i>
<i>Plug Gage</i> <i>1267-1259</i>	<i>B-5006M</i>		
SKETCH			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

M. H. SULLIVAN, INC.

Wrote 4/4/47
Revised 4/4/47
Huh

PART: SEAR		PART NO 1B-17946			
OPERATION: PURCHASED PART INSPECTION		OPER. No.: 6			
PROCESS RECORD — INSPECTION					
GAUGES		USE	AOQL	LIMITS	
TYPE	No.			MAX	MIN.
J & L Comparator					
Compar. fixt.	C-5323 0	Check dim. as shown below	7%		
Compar. Stage					
Compar. Screen	C-53232				
Plug Gage 120-123	B-50106-N	Check Pierced Hole	7%	.123	.120
SKETCH					
COMPILED BY J.F. Bowling 2/21/47		APPROVAL & DATE			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

H. K. SULLIVAN, INC.

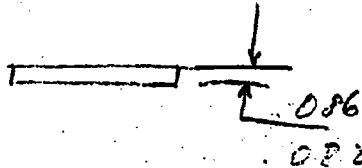
PART: *41447* *Leaf* PART No. *17946*
 OPERATION: *Grind stock to thickness (Temp)* OPER. No.: *7*

PROCESS RECORD

EQUIPMENT: *12" x 48" MATTHEW SURFACE GRINDER*
 SPEED: FEED:
 MAX. PROD. PER HOUR: COOLANT: *Emool or Sol. Oil*

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>ADJ. SNAP GAUG.</i> <i>.086..082</i>	<i>B-80138-W</i>		

SKETCH



COMPILED BY: *BOWLING*

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

M. H. SULLIVAN, INC.

PART: SEAR

PART No. 1B-17946

MATERIAL PROCUREMENT - SEMI-FINISHED COMPONENT

REV. No.	DATE
1	3/10/47

REMINGTON PLANNING

Pieces Required Per Assembly: 1

Uses of Part

: M/721 & 722

VENDOR

Material

: AISI C-1022 or substitutes *1
 1020, 1025, ~~1020~~, C-1019
 Packing slip to show material used
 for each shipment of parts.

Heat Treatment

: None

Final Appearance

: Commercial Stamping, Sheared Edge

Packaging

: Purchase Order Number and quantity
 of pieces to be shown on each con-
 tainer, the gross weight of which
 must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to
 Dodge and Romig Sampling Tables of Bell Telephone Company. Ship-
 ments will be accepted if the quality on each of the gages is suf-
 ficient to keep within the "Average Outgoing Quality Limit" listed
 on the Process Record Inspection Page.

Remarks:

COMPILED BY: J.F. Bowling
 DATE: 2/20/47

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

H. H. SULLIVAN, INC.

PART: SEAR	PART NO. 17946																		
MATERIAL PROCUREMENT - RAW MATERIAL																			
Date: 2/5/47																			
OBSOLETE REVISED APR 3 1947 Detailed Description Pieces Required Per Assembly: 1 Material Specification : 101B Material : AISI-C-102² or substitutes C-1020, C-1020, C-1025, A-2600, C-1019 *3 Size : .084 $\pm .002^*$ X 1-3/4" $\pm .008$ $-.002$ $-.008$ X 10 to 12' lengths. Condition : Cold Finished Strip Temper : Half Hard Edge : #3 Finishe : #2 Weight Per 100 : Calculated <u>2.1</u> Measured _____ Additional Uses of Material : Uses of Part : M/721 Sear Identification of Material : Routing Ticket to be marked Mat. Spec. No. <u>101B</u> Remarks: 1. This material is for shipment to stamping vendor *2. To facilitate procurement material up to 1/8" thickness can be used but will have to have operations 2 & 4 performed before shipment to vendor.	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">REV. NO.</th> <th style="text-align: center;">DATE</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">2/18/47</td> </tr> <tr> <td style="text-align: center;">2</td> <td style="text-align: center;">2/20/47</td> </tr> <tr> <td style="text-align: center;">3</td> <td style="text-align: center;">3/10/47</td> </tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </tbody> </table>	REV. NO.	DATE	1	2/18/47	2	2/20/47	3	3/10/47										
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COMPILED BY: R.H. Grace 2/5/47 APPROVAL & DATE																			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																			

PART NO.

17946

SEQUENCE OF OPERATIONS

OPER. NO.

OPERATION

DEPT.

- 1 Material Procurement (Temp)
- 2 Cut to 9' Length (Temp)
- 4 Grind to Thickness (Temp)
- Ship Stock to Vendor
- 6 Purchased Part Inspection
- 8 Wash
- 10 Bore Pin Holes
- 12 C-Tank Hole to Remove Burr
- 14 Wash
- 16 Grind Trigger Connector Surface
- 18 Grind F.P. Hd. Surface
- 20 Finish Burr
- 22 Heat Treatment (Cyanide)
- 24 " " Inspection
- 26 Inspect
- Transfer to Parts Store

COMPILED BY:

B. L. L.

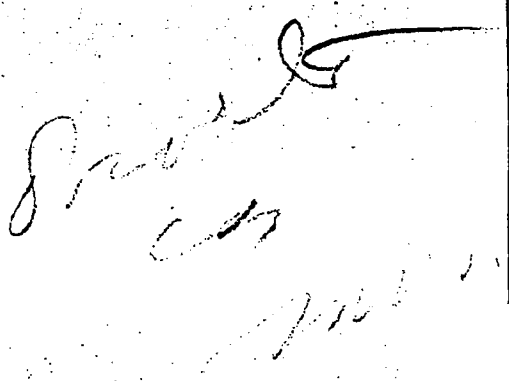
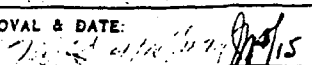
APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

LIVAN, INC.

OBSOLETE

REVISED APR 23 1947

PART: --SEAR		PART NO. 17946
SEQUENCE OF OPERATIONS		
OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp.)	
2	Cut to 4' Length (Temp.)	
4	Grind to Thickness (Temp.)	
	Ship Stock to Vendor	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'Sink. Hole to Remove Burrs	
14	Wash	
16	Grind Trigger Connector Surface	
18	Grind F. P. Hd. Surface	
20	Finish Burr	
22	Heat Treatment (Cyanide)	
24	" " Inspection	
26	Inspect	
	Transfer to Part Stores	
		
COMPILED BY: J. F. Bowling		APPROVAL & DATE: 
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

H. H. SULLIVAN, INC.

PART No. 17946

OBSCURE

REVISIONS

DEPT,

8/20/46
mm

STANIDE HARDEN

OIL QUENCH

DRYING OIL

HARDNESS

QUENCH, AIR COOL, WASH & DRY

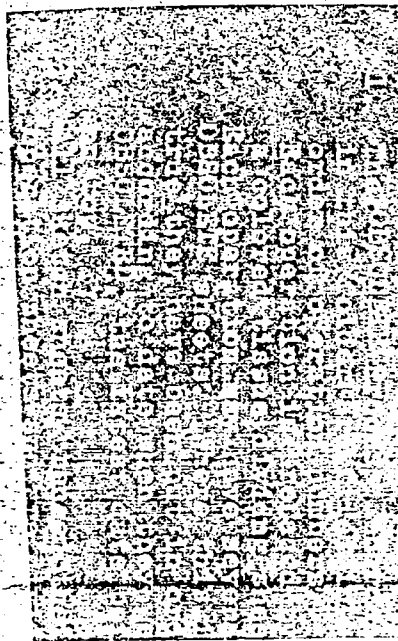
OIL FOR STORAGE

HARDNESS, COLOR & OIL

STORES:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. ILION, N. Y.



RECEIVED
JANUARY 1964
FBI - NEW YORK

DISOLVED
DEC 11 1946

PROCESS RECORD

SEAL

PART NO. 17075

(PURCHASED BY)

(TEMPORARY)

ISSUED BY

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

ISSUED TO

DEPARTMENT

OBsolete

PROCESS RECORD

SEAR

PART NO. 117045

ISSUED BY

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILLION, NEW YORK

ISSUED TO:

DEPARTMENT

77-1
RECEIVED
OBSOLETE

PROCESS RECORD

SEAR BLANK

PART NO. 17753

(PURCHASE PART)

ISSUED BY

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ELION, NEW YORK

ISSUED TO

DEPARTMENT

ABSOLUTE

PROCESS RECORD

SEAR

PART No. 17045

TO:

Copy

ISSUED BY:
TECHNICAL DEPARTMENT

ARMS DIVISION
REMINGTON ARMS COMPANY
MILTON, NEW YORK

ISSUED TO: _____ DEPARTMENT

PART No. 17045	
SEQUENCE OF OPERATIONS	
OPER. NO.	OPERATION
1	Serial Procurement
2	Cut to Length
3	Mill Top and Bottom & Burr
4	Remove Cutter Mismatch (Temporary)
5	Grind to Thickness (Temporary)
6	Tumble
7	Spot, Drill & Ream Pin Hole
8	Burr Hole
8a	Harden (Case)
8b	Inspect Hardness
9	Grind Trigger Connector Surface
10	Grind Safety Surface
11	Harden (Case)
12	Inspect Hardness
TO PART STORES	
	
COMPILED BY J. G. Bowling 11/29/46	
APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.	

H. H. SULLIVAN, INC.

PART NO. 170/5	
SEQUENCE OF OPERATIONS	
OPER. NO.	OPERATION
1	Material Procurement
2	Grind to Length
3	Grind to Thickness (Temporary)
4	Mill Top and Bottom & Burr
5	Remove Cutter Mismatch (Temporary)
6	Tumble to remove Burrs
7	Spot, Drill & Ream Pin Hole
8	C/Sink to Remove Burrs
9	Grind Trigger Connector Surface
11	Grind Safety Surface
12	Finish Burr Sides, Trigger Connector Surface and Safety Surface
13	Inspect
15	Harden (Case)
17	Inspect Hardness
18	TO PART STORES

obsolete

COMPILED BY: J. F. Bowling 1/9/47	APPROVAL & DATE: <i>MKS 1/8/47</i>
--------------------------------------	---------------------------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

DATE 2/10/47

SEQUENCE OF OPERATIONS

OPERATION	DATE	OPERATION	DEPT.
1. Material Procurement			
2. Design			
3. Check Top of Bottom			
4. Check to Widthness			
5. Spot Drill & Ream Pilot Hole			
6. Grind Top of Connector Surface			
7. Grind to Finish Surface			
8. Inspection			
9. Packaged (Case)			
10. Inspection			
11. Final Storage			

FINAL TECHNICAL
PROCESS RECORD
DATE JAN 4 1947

COMPILED BY J. E. Bowling
DATE 2/10/47

APPROVAL & DATE

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

H. W. SULLIVAN, INC.

PART No 17045

SEQUENCE OF OPERATIONS

SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1		Material Procurement	
2	1	Cut to length	
3	3	Purchase Inspection of Sear Blank	
4	5	Mill Top & Bottom	
5	7	Grind to Thickness	
6	9	Spot, Drill & Ream Pin Hole	
7	11	Grind Trigger Connector Surface	
8	13	Grind Safety Surface	
9	15	Inspect	
10	17	Harden (Case)	
11		Inspect	
		TO PART STORES	

COMPILED BY: J. P. Bowling
11/29/46

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. - ILION, N. Y.

PART 7 SEAR (TEMPORARY)		PART No. 17045
REGISTER OF ALL PROCESS RECORD REVISIONS		
DESCRIPTION OF CHANGE		
OBsolete 9-24-46 DEC 11 1946 Add temporary procurement page & process for precision cast Sear.		
COMPILED BY: R. W. Selwood 9/30/46		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: SEAR (TEMPORARY)		PART NO. 17045
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
9-24-46	Part No. 17645 of Sear Blank Material Procurement (raw material for Sear) changed to Part No. 17758. See Le. 9/17/46 in obsolete file for reference. <i>Add temporary procurement page & process for procurement cart sear.</i>	
COMPILED BY: R.W. Selwood 9/30/46		APPROVAL & DATE: <i>W/S.</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

DATE _____

DESCRIPTION OF CHANGE

COMPILED BY: R.W.Selwood
9/30/46

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

ABSOLUTE
Physician

5202

PART NO. *17045*

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE	DESCRIPTION OF CHANGE

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART No. 17045

RAW MATERIAL

Date: 5/23/46

Detailed Description

REV. NO.	DATE
1	11/17/46
2	11/18/46

AISI C-1022 or substitute AISI C-1118

AISI C-1019S

1 1/2" x 9/16" x 12' lengths
-0.003 -0.003

Condition Cold Rolled Flat Bar Stock

Weight Per 100' Calculated: 5.6 lbs. Measured:

Additional Use of Material

Use of Part 1/721 - All Calibers

Identification of Material Routing Ticket to be marked Mat. Spec. #101-K.

Remarks:

COMPILED BY: B. C. Andrews

APPROVAL & DATE

11/18/46 C. H. Grace 11/14/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

DON'T SAY IT—WRITE IT

To

FROM

DATE

Dear Blank
Material Material Room
or substitute ATST C-1019

WJF
11/16/11

121
OBsolete

PART NAME SEAR	PART NO. 1702
--------------------------	-------------------------

MATERIAL PROCUREMENT - RAW MATERIAL

DETAILED DESCRIPTION

Pieces Required Per Assembly: (1) One

Material Specification :

Material : AISI C-1019 to 1022

Size : 11/64 x 9/16 Bar - Stock Lengths
Approx. 12'

Condition : Cold Drawn

Weight Per 100 : Calculated 4.5 Measured _____
One year supply 25,000 guns
= 1120#

Additional Uses of Material :

Uses of Part : 721 All Calibers
722 All Calibers

Identification of Material : Routing Ticket to be marked Mat.
Spec. No. _____

REV. NO.	DATE

Remarks:

of good letter
see
Anderson / grave
11/16/46

COMPILED BY: T.V. Withington	APPROVAL & DATE:
11-7-46	

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

H. SULLIVAN, INC.

PART 9-21707

MATERIAL PROCUREMENT - RAW MATERIAL

DETAILED DESCRIPTION

Pieces Required Per Assembly: (1) One

Material Specification:

Material : AISI C-1019 to 1022

Size : 11/64 x 9/16 Bar - Stock Lengths
Approx. 12'

Condition : Cold Drawn

Weight Per 100 : Calculated 4.5 Measured
One year supply 25,000 guns
= 1120#

Additional Uses of Material :

Uses of Part : 721 All Calibers
722 All CalibersIdentification of Material : Routing Ticket to be marked Mat
Spec. No.

Remarks:

COMPILED BY T. V. Withington APPROVAL & DATE:

11-7-46

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

H. SULLIVAN, INC.

Revised
17/2
OBsolete

PART: SEAR BLANK (PURCHASE READY FOR DRILLING) RAW MATERIAL FOR SEAR - 17015 (TEMPORARY)		PART No. 17758
MATERIAL PROCUREMENT - FINISHED COMPONENT 8/30/46		
Detailed Description		REV. NO. DATE
Remington Planning		
Pieces Required Per Assembly: 1		
Uses of Part: M/721 - All Calibers		
M/722 - All Calibers		
Vendor:		
Material: Haynes Stellite #410 Stainless Steel		
Heat Treatment: None (will be heat treated at Remington)		
Final Appearance		
Packaging: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.		
Acceptance Testing:		
Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the Average Outgoing Quality Limit listed.		
Inspection:		
Gage No.	Type	Use
	Visual	Defects 5%
B-80031M	Ad. Snap	Check Thickness 5%
	Radius Gage	Radius on Rear End 5%
Parts to have a workman-like saddle blasted finish with no visible parting lines, and no burrs at cut off point. Parts to be clean, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.).		
COMPILED BY: B.C. Andrews		APPROVAL & DATE: 7/24/49/47
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART NO. 17045 (Temporary)
Material for Gears (Temporary)

PART NO. 17045

MATERIAL PROCUREMENT - FINISHED COMPONENT Date: 8/30/46

CONFIDENTIAL

Detailed Description

REV. NO.	DATE

Remington Planning

Pieces Required Per Assembly: 1
Uses of Part: M/721 - All Calibers
M/722 - All Calibers

Vendor

Material: Haynes Stellite #10, Stainless Steel

Heat Treatment: None

Packaging: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Inspection:

Gage No.	Type	Use	AQOL
	Visual	Defects	5%
B-80031M	Adj. Snap	Check Thickness	5%
	Radius Gage	Radius on Rear End	5%

COMPILED BY: B. C. Andrews

APPROVAL & DATE: *mfs* *PH Chase 9/30/46*

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

H. M. SULLIVAN, INC.

PART SEAR BLANK (PURCHASE READY FOR DRILLING) MATERIAL FOR SEAR - 17045 (TEMPORARY)		PART No. 17758																
MATERIAL PROCUREMENT - FINISHED COMPONENT		8/30/46																
Detailed Description		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="text-align: center;">REV. No.</th> <th style="text-align: center;">DATE</th> </tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> <tr><td> </td><td> </td></tr> </table>	REV. No.	DATE														
REV. No.	DATE																	
Remington Planning																		
Pieces Required Per Assembly: 1																		
Uses of Part : M/721 - All Calibers M/722 - All Calibers																		
Vendor																		
Material : Haynes Stellite #410 Stainless Steel																		
Heat Treatment : None (Will be heat treated at Remington)																		
Final Appearance : Parts to have a workman-like sand blasted finish with no visible parting line, and no burrs at cutoff point. Parts to be clean, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)																		
Packaging : Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.																		
Acceptance Testing																		
Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is suffi- cient to keep within the "Average Outgoing Quality Limit" listed.																		
Inspection:																		
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Gage No.</th> <th style="text-align: center;">Type</th> <th style="text-align: center;">Use</th> <th style="text-align: center;">AOQL</th> </tr> </thead> <tbody> <tr> <td> </td> <td>Visual</td> <td>Defects</td> <td>5%</td> </tr> <tr> <td>B-80031M</td> <td>Adj. Snap Gage</td> <td>Check Thickness</td> <td>5%</td> </tr> <tr> <td> </td> <td>Radius Gage</td> <td>Radius on Rear End</td> <td>5%</td> </tr> </tbody> </table>	Gage No.	Type	Use	AOQL		Visual	Defects	5%	B-80031M	Adj. Snap Gage	Check Thickness	5%		Radius Gage	Radius on Rear End	5%		
Gage No.	Type	Use	AOQL															
	Visual	Defects	5%															
B-80031M	Adj. Snap Gage	Check Thickness	5%															
	Radius Gage	Radius on Rear End	5%															
COMPILED BY: B. C. Andrews		APPROVAL & DATE: <i>MW 12/2/46</i> <i>AKH Grace 12/5/46</i>																
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																		

9-17-46

OBSCURE

Part <u>Star (Purchase ready for Assembly)</u>	Part No. <u>17045</u>																																								
Date: <u>5-23-46</u>																																									
MATERIAL PROCUREMENT - FINISHED COMPONENT																																									
Detail Description Remington Planning Pieces Required Per Assembly: <u>1</u> Uses of Part : <u>M/721 - All Calibers</u> <u>M/722 - All Calibers</u> Vendor: _____ Material : <u>Powdered Metal Products Corp. Alloy #Z-10</u> <u>Powdered Iron (Hardened)</u> Heat Treatment : <u>Harden and Temper</u> Hardness : <u>Rockwell C-40-45.</u> Packaging : <u>Purchase Order Number and quantity of pieces to be shown on</u> <u>each container, the gross weight of which must not exceed 200</u> <u>lbs.</u> Acceptance Testing : <u>Inspection will be based on statistical sampling according to Dodge and Romig</u> <u>Sampling Tables of Bell Telephone. Shipment will be accepted if the quality on each</u> <u>of the following gages is sufficient to maintain the "Average Outgoing Quality</u> <u>Limit" listed.</u> Inspection: <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 15%;">Gage No.</th> <th style="width: 25%;">Type</th> <th style="width: 40%;">Use</th> <th style="width: 20%;">AQL</th> </tr> </thead> <tbody> <tr> <td>1.</td> <td></td> <td>Hardness</td> <td>5%</td> </tr> <tr> <td>2.</td> <td>Visual</td> <td>Defects</td> <td>5%</td> </tr> <tr> <td>3. B-80013-M</td> <td>Adj. Snap</td> <td>Mat'l. Thickness</td> <td>5%</td> </tr> <tr> <td>4. B-80002-S</td> <td>Plug</td> <td>Hole Dia.</td> <td>5%</td> </tr> <tr> <td>5. D-50325</td> <td>Comparator</td> <td>Contour</td> <td>5%</td> </tr> <tr> <td>B-50156</td> <td>Fixture</td> <td></td> <td></td> </tr> <tr> <td>B-50332</td> <td>Stage</td> <td></td> <td></td> </tr> <tr> <td>C-50333</td> <td>Master</td> <td></td> <td></td> </tr> <tr> <td>6. Standard Finish Blocks</td> <td>Visual</td> <td>Surface Finish</td> <td>7%</td> </tr> </tbody> </table>		Gage No.	Type	Use	AQL	1.		Hardness	5%	2.	Visual	Defects	5%	3. B-80013-M	Adj. Snap	Mat'l. Thickness	5%	4. B-80002-S	Plug	Hole Dia.	5%	5. D-50325	Comparator	Contour	5%	B-50156	Fixture			B-50332	Stage			C-50333	Master			6. Standard Finish Blocks	Visual	Surface Finish	7%
Gage No.	Type	Use	AQL																																						
1.		Hardness	5%																																						
2.	Visual	Defects	5%																																						
3. B-80013-M	Adj. Snap	Mat'l. Thickness	5%																																						
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B-50156	Fixture																																								
B-50332	Stage																																								
C-50333	Master																																								
6. Standard Finish Blocks	Visual	Surface Finish	7%																																						
COMPILED BY: <u>B.D. Andrews</u>	APPROVAL & DATE: <u>M. J. Smith 5/27/46</u>																																								
REMINGTON ARMS COMPANY, INC., ILION, N. Y.																																									

OBsolete

Purchase ready for Assembly		Part No. 17045
MATERIAL PROCUREMENT #207 (REPLACES #207)		
Detailed Description		
Remington Planning		
Pieces Required Per Assembly: 1		
Uses of Part: M/721 - All Calibers; M/722 - All Calibers		
Vendor		
Material	Powdered Metal Products Corp. Alloy #2-10 Powdered Iron (Hardened)	
Surface Finish	63 microinch or finer surface required as indicated in sketch. All other areas as milled and satisfactory.	
		
Heat Treatment	Harden and Temper	
Hardness	Rockwell C40-45	
Packaging	Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.	
Acceptance Testing	Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Remington Telephone Company. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the average Outgoing Quality Limit listed.	

INSPECTION:

	GAGE No.	TYPE	USE	ACC.
1.			HARDNESS	390
2.		VISUAL	DEFECTS	3
3.	13-80013-M	ADJ. SAMP.	ADJ. SAMP.	5
4.	13-80002-S	PLUS	PLUS	3
5.	D-50335 13-50156 B-50332 G-50333	COMPARATOR FIXTURE STAGE MASTER SCAFFOLD	COMPARATOR	5

Screen 13-50335 Approved 2/25/46 COMPILED BY: B. C. Andrews APPROVAL & DATE: A.H. Grace 3/15/46 REMINGTON ARMS COMPANY, INC., ILION, N. Y.
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PART 8345 (Purchase ready for Assembly)

PART No. 17045

MATERIAL PROCUREMENT #869 (Replaces #849)

Detailed Description

OBSOLETE

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part

M/721 - All Calibers; M/722 - All Calibers

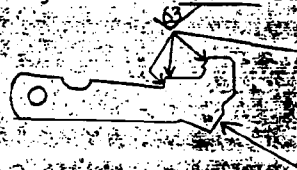
Vendor

Material

Powdered Metal Products Corp. Alloy #Z-10.
Powdered Iron (Hardened).

Surface Finish

63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory



Heat Treatment

Harden and Temper

Hardness

Rockwell C40-45

Packaging

Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the "Average Outgoing Quality Limit" listed.

Inspection type or gage

AQCL

1. Hardness	3
2. Surface Finish will be checked against Standard Finished manufactured by Baird Associates, Cambridge, Mass.	3
3. Visual inspect for Defects	3
4. Gage B-80013M	5
5. Gage B-800Q2S	3
6. Comparator	5
Fixture D-50325	
*Stage B-50156	
*Master B-50332	
Screen C-50333	

*Revised 3/25/46 R.H.

COMPILED BY: B. C. Andrews

APPROVAL & DATE: *A.H. Grace* 3/15/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART No. 17045

REPLACES PROCEDURE #829 (Replaces #643)

Description

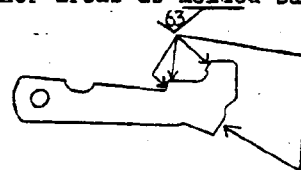
Pieces Required Per Assembly: 1

Uses of Part: M/721 - All Calibers; M/722 - All Calibers

Vendor

Material: Powdered Metal Products Corp. Alloy #Z-10.
Powdered Iron (Hardened).

Surface Finish: 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory



Heat Treatment: Harden and Temper

Hardness: Rockwell C40-45.

Packaging: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipment will be accepted if the quality on each of the following gages is sufficient to maintain the "Average Outgoing Quality Limit" listed.

Inspection Type or Gage		AOQL %
1. Hardness		3
2. Surface Finish will be checked against Standard Finished manufactured by Baird Associates, Cambridge, Mass.		3
3. Visual inspect for Defects		3
4. Gage B-80013M		5
5. Gage B-80002S		3
6. Comparator		5
Fixture	D-50325	
Stage	B-50156	
Master	C-50332	
Screen	C-50333	

*Revised 3/16/46

COMPILED BY: B. C. Andrews

APPROVAL & DATE:

W. D. Lee 3/16/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

(Classification for Assembly)

PART NO. 17045

OBsolete

MATERIAL PROCUREMENT

(Replaces #44)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part

M/721 - All Calibers; M/722 - All Calibers

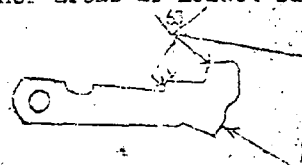
Vendor

Material

: Powdered Metal Products Corp. Alloy # Z-10.
Powdered Iron (Hardenex).

Surface Finish

: 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory.



Heat Treatment

: Harden and Temper

Hardness

: Rockwell "C" 40/45.

Packaging

: Ship in containers of 5,000 to 6,000 pieces.

Acceptance Testing

Inspection will be based on statistical sampling method. A random sample of 149 pieces will be selected from each container for inspection. If the allowable number of defects shown in the table below is not exceeded, the lot will be accepted.

Inspection
Type or Gage

Allowable Defects
in Sample
(Pieces)

AQCL - *91* *Noted*

1. Hardness
2. Surface Finish *(will be checked)*
3. Visual *Inspect for Defects*
4. Gage B-8001A
5. Gage B-8002-B
6. Comparator *Fisher D-50325*
Gage D-50156

3
313
5
3
3

(2) Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent.

Master D-50332
Screen C-50353

*Changed

31/146
2/10/16

COMPILED BY B. C. Andrews

APPROVAL & DATE *11/11/16*

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

Baird (Purchase ready for Assembly)

PART NO. 17045

MATERIAL PROCUREMENT #643* (Replaces #366)

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part : M/721 - All Calibers; M/722 - All Calibers

Vendor

Material*

: Powdered Metal Products Corp. Alloy # 7-10.
Powdered Iron (Hardened).

Surface Finish*

: 63 microinch or finer surface required as indicated
in sketch. All other areas as molded surface
satisfactory.

Heat Treatment*

: Harden and Temper

Hardness*

: Rockwell "C" 40/45.

Packaging

: Ship in containers of 5,000 to 8,000 pieces.

Acceptance Testing:*

A random sample of 145 pieces will be selected from each
container for inspection. If the allowable number of defects shown in the
table below is not exceeded, the lot will be accepted.

Inspection		Allowable Defects	AOQL
Type or Gage		in Sample (Pieces)	1
1. Hardness		7	3
2. Surface Finish(1)		7	3
3. Visual		18	7
4. Gage B-80013M		15	5
5. Gage B-8002-S		7	3
6. Comparator		15	5

(1) Visual check against Standard Finishes manufactured by
Baird Associates, Cambridge, Mass. or equivalent.

*Changed 2/8/46

COMPILED BY B. C. Andrews

APPROVAL & DATE

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Sear (Purchase ready for Assembly)	PART NO. 17045
--	----------------

OBSOLETE

MATERIAL PROCUREMENT #643* (Replaces #366) *obsolete*

Detailed Description

Remington Planning

Pieces Required Per Assembly: 1

Uses of Part: M/721 - All Calibers; M/722 - All Calibers

Vendor:

Material*: Powdered Metal Products Corp. Alloy # Z-10
Powdered Iron (Hardened)

Surface Finish*: 63 microinch or finer surface required as indicated in sketch. All other areas as molded surface satisfactory.



Heat Treatment*: Harden and Temper

Hardness*: Rockwell "C" 40/45

Packaging: Ship in containers of 5,000 to 8,000 pieces.

Acceptance Testing: A random sample of 145 pieces will be selected from each container for inspection. If the allowable number of defects shown in the table below is not exceeded, the lot will be accepted.

	Inspection Type or Gage	Allowable Defects in Sample (Pieces)	AOQL %
1.	Hardness	7	3
2.	Surface Finish (1)	7	3
3.	Visual	18	7
4.	Gage B-80013M	15	5
5.	Gage B-8002-S	7	3
6.	Comparator	15	5

(1) Visual check against Standard Finishes manufactured by Baird Associates, Cambridge, Mass. or equivalent.

*Changed 2/8/46

COMPILED BY B. C. Andrews	APPROVAL & DATE <i>R.H. Shaw 2/18/46</i>
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

Bolt (Purchase ready for Assembly)

PART NO. 17045

MATERIAL PROCUREMENT #366

Detailed Description

Remington Planning

Pieces Required Per Assembly

: 1

Uses of Part

: M/721 - All Calibers; M/722 - All Calibers.

Vendor

Material

: AISI C-1020 or C-1022

Surface Finish

: Flat Surface - Cold Finished Surface (Commercial)
Cross Section - All shear marks to be removed
from areas indicated in sketch. 63 microinch
finish. Other areas as sheared surface satis-
factory.

Heat Treatment

: Case Harden

Case Depth

: .005 to .008"

Hardness

: Superficial Rockwell 30H*

Final Color

: Parts to be bright, free of rust, oiled for rust
protection with light (SAE-20 or equiv.) oil.

Packaging

: Ship in containers of 5,000 to 8,000 pieces.

Acceptance Gages:

Acceptance Testing:

Chemical - Signed statement of analysis to accompany each
shipment of parts.

Hardness* -

Finish - Visual check against Standard Finishes manufactured by
Baird Assoc., Cambridge, Mass. or equiv. will be used.

Gaging -

*To be determined after initial lot is received.

COMPILED BY B. C. Andrews

APPROVAL & DATE

R. H. Shaw 4/15/45

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART:

SEAR

PART No.

17045

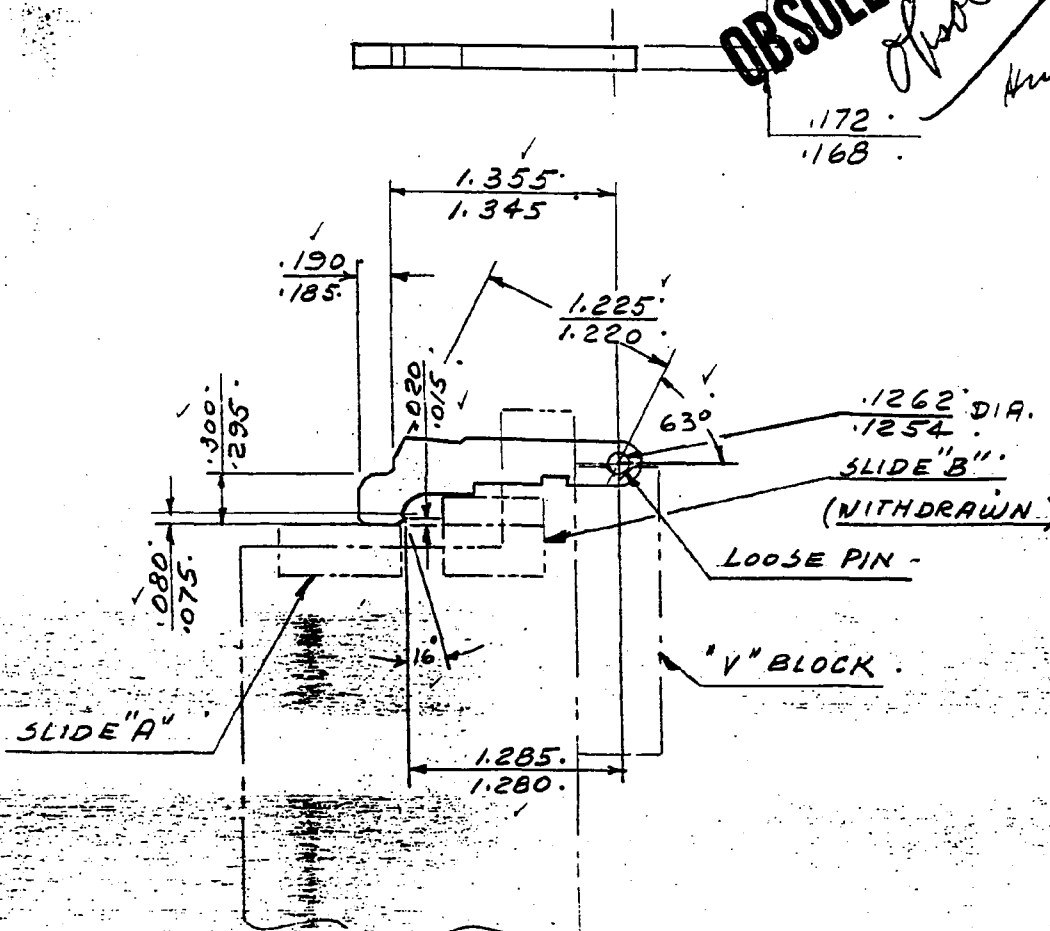
OPERATION:

FINAL

OPER. No.:

1

PROCESS RECORD — ILLUSTRATION SKETCH



SUPERSEDED
BY SKETCH OF 731-46.

Superseded by
new sketch
7-31-46

COMPILED BY:

ES&M

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

F-191Y

17B-7

PART: **SEIF**

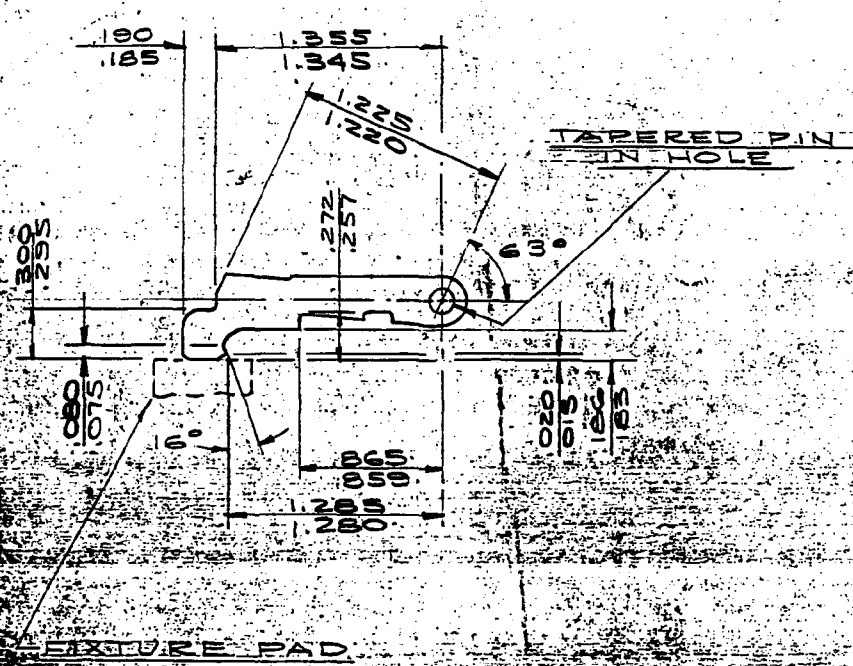
PART No. 17045

OPER. **PHASE INSPECTION**

OPER. No.: 1

OBsolete

PROCESS RECORD — ILLUSTRATION SKETCH



COMPILED BY:

APPROVAL & DATE:

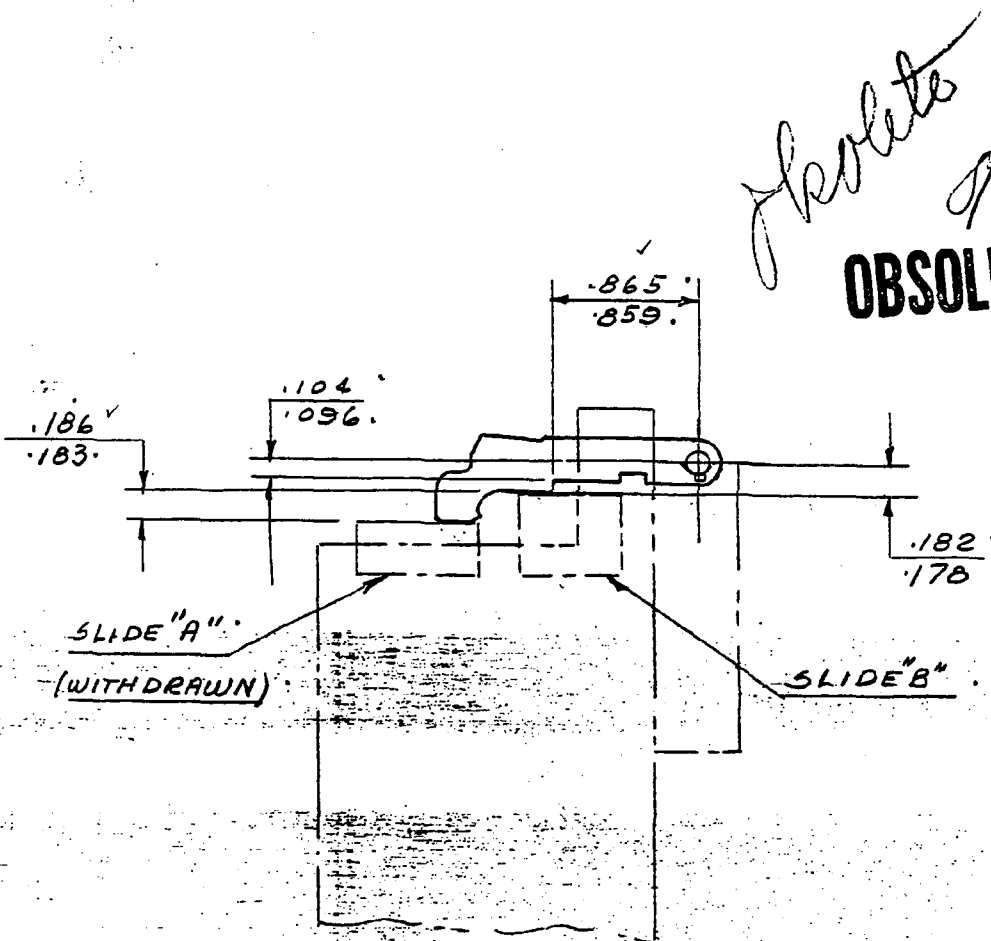
MKA 8/25/46

F.C. 7-31-46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART:	SEAR	PART No.	17045
OPERATION:	FINAL	OPER. No.:	4-9

PROCESS RECORD — ILLUSTRATION SKETCH



SUPERSEDED
BY SKETCH OF 7-31-46

Superseded by
new sketch
7-31-46

COMPILED BY:	ES&M	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

F-1.91

TPR 11

11/5
ABSOLUTE

PART No. 17045

OPER. No. 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
Type	No.		Max.	Min.
1. Visual Inspect For Defects				
2. Adj. Snap Gage	B-80013M	Check Thickness	.172	.168
3. Plug Gage	B-80002S	Check Hole	.1262	.1254
4. Comparator	D-50325	a) Set To Master		
Fixture	B-51056	b) Place Part in Comparator		
Stage	B-50332	Fixture with Taper Pin in		
Master	C-50333	Hole and Part Resting on Pad.		
Screen				
		Check the following Dimensions:		
		1.280-1.285		
		16° Angle		
		.015-.020		
		.075-.080		
		.295-.300		
		63° Angle		
		1.220-1.225		
		1.345-1.355		
		.185-.190		
		.183-.186		
		.859-.865		
		.272-.257		

COMPILED BY:

APPROVAL & DATE:

7/14 8/12/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBSOLETE

Retyped

PART No. 17045

Practical Inspection

OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
1. Visual		Visual Inspect For Defects		
2. Adj. Snap Gage	B-80013-M	Check Thickness	.172	.168
3. Plug Gage	B-80002-S	Check Hole	.1262	.125
4. Comparator		(a) Set to Master		
Fixture	D-50325	(b) Place Part In Comparator		
Stage	B-50156	Fixture With Taper Pin in		
Master	B-50332	Hole and Part Resting on		
Screen	C-50333	THE P.D.		
		Note: Slide "D" is withdrawn		
		and not in contact with		
		part.		
		Check the Following Dimensions:		
		1.280 - 1.285 ✓		
		16° Angle ✓		
		.015 - .020 ✓		
		.075 - .080 ✓		
		.295 - .300 ✓		
		63° Angle ✓		
		1.220 - 1.225 ✓		
		1.345 - 1.355 ✓		
		.185 - .190 ✓		
		.183 - .186 ✓		
		.859 - .865 ✓		
		.172 - .254 ✓		

(Continued)

fe 7/31/46
✓

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: SEAR		PART No. 17045		
OPERATION: FINAL		OPER. No.: 1		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
1.		Visual Inspect For Defects		
2. Adj. Snap Gage	B-80013-M	Check Thickness	.172	.168
3. Plug Gage	B-80002-S	Check Hole	.1262	.1254
4. Comparator Fixture State Master Screen	D-50325 B-50156 B-50332 C-50333	(a) Set to Master (b) Place Part In Comparator Fixture With Taper Pin in Hole and Part Resting on Slide "A"		
		Note: Slide "B" is withdrawn and not in contact with part.		
		Check the Following Dimensions:		
		1.280 - 1.285		
		16° Angle		
		.015 - .020		
		.075 - .080		
		.295 - .300		
		63° Angle		
		1.220 - 1.225		
		1.345 - 1.355		
		.185 - .190		
(Continued)				
COMPILED BY:		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

OBsolete

PART No. 17045	
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OPERATION: <i>Purchase Inspection</i>	OPER. No.: 1
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PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
4. CONTINUED		(c) Withdraw Slide "A" and Push Slide "B" in position. Part is now resting on Slide "B". Check the following dimensions: .183 - .186 .859 - .865 .178 - .182 .096 - .104		

fc 7/31/46

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBsolete

SEAR

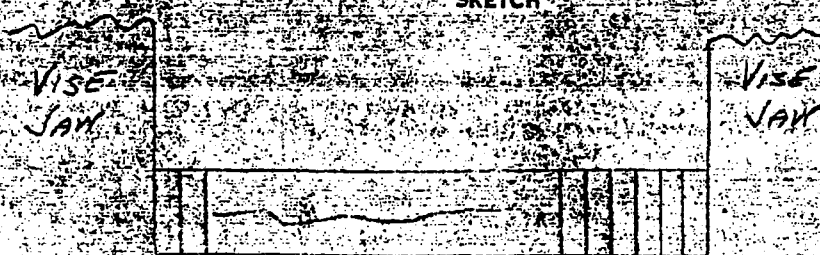
PART No. 17045

OPERATION: FINAL

OPER. No.: 1

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
4. CONTINUED		(c) Withdraw Slide "A" and Push Slide "B" in position. Part is now resting on Slide "B". Check the following dimensions: .183 - .186 .859 - .865 .178 - .182 .096 - .104		
COMPILED BY:		APPROVAL & DATE:		
- REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

		PART No. 17045	
CUT TO LENGTH		OPER. No. 1	
PROCESS RECORD			
EQUIPMENT: POWER HACK-SAW.			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Adjustable Snap Ga.-Length	B-80125-N		
SKETCH			
			
COMPILED BY: J. J. J. J. J. 11/25/46		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

38-12

OBsolete
DEC 11 1946

PART: SEAR BLANK		PART No. 17045			
OPER. No. 1		PURCHASE INSPECTION OF SEAR BLANK 17758			
(Temporary)					
PROCESS RECORD — INSPECTION					
GAUGES		USE	AOQL	LIMITS	
TYPE	No.			MAX.	MIN.
1. Visual		For Defects	5%		
2. Adjustable Snap Gage	B-80013M	Check Thickness	5%	.172	.168
3. Radius Gage Min. & Max.		To Check Radius on Hole End of Part	5%	.150	.147

SKETCH

(5)

SHOULD SHOW NO
LIGHT HERE
ON MAX GAGE

RADIUS GAGE

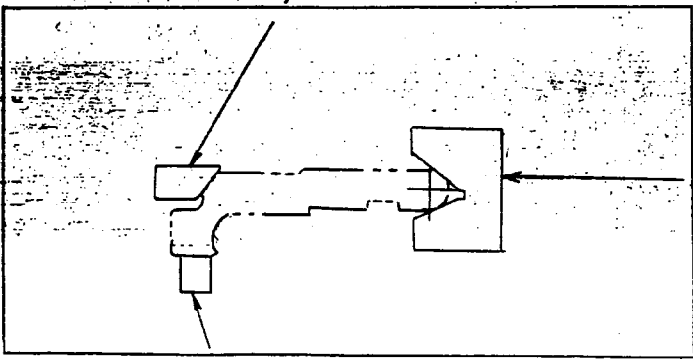
COMPILED BY: R.W. Selwood 9/26/46	APPROVAL & DATE: <i>WUP</i>
--------------------------------------	--------------------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

ULLIVAN, INC.

OBSOLETE

11/15/46

PART: SEAR HAMMER		PART No. 17045	
OPERATION: DRILL & REAM PIN HOLE (TEMPORARY)		OPER. No.: 2	
PROCESS RECORD			
EQUIPMENT: Leland Gifford Drill Press			
SPEED: 3600 Drill 2400 Ream		FEED: .003 Drill .009 Ream	
MAX. PROD. PER HOUR: 100		COOLANT: Soluble Oil	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
#31 Drill (.120) .1260 Dia. Reamer Plug Gage Go .125 & No Go .1262		Drill Jig Drill from one side and Ream from the other	
SKETCH			
			
COMPILED BY: R.W. Selwood 9/25/46		APPROVAL & DATE: MKS	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART:

SEAR

PART No.

117045

OPERATION:

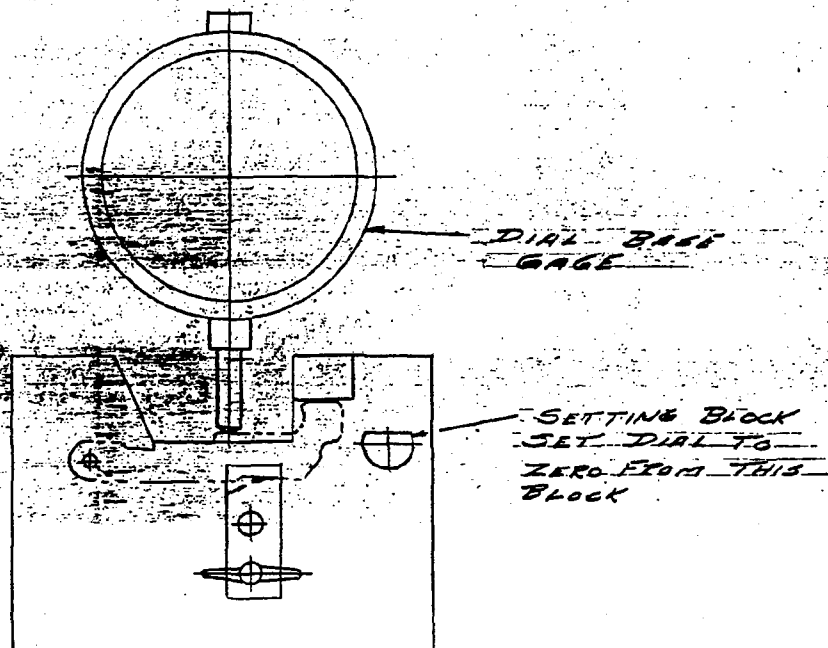
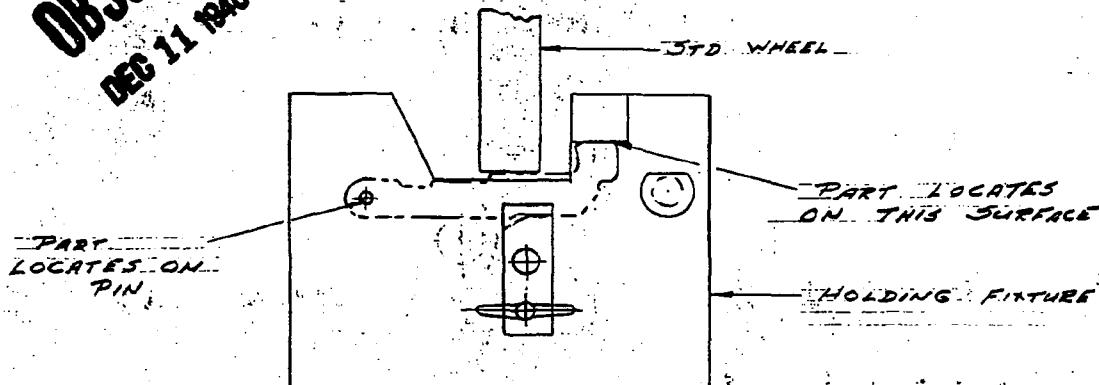
GRIND

(TEMPORARY)

OPER. No.:

3

PROCESS RECORD — ILLUSTRATION SKETCH

OBsolete
DEC 11 1948COMPILED BY: R.W. Selwood
9/26/46

APPROVAL & DATE:

MID

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

H. H. SULLIVAN, INC.

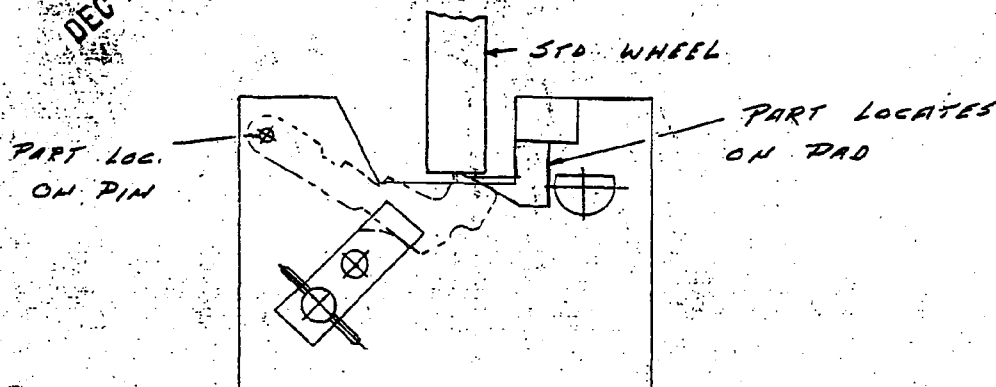
STP-7

PART: 17025	PART No. 17025
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OPERATION: GRIND (TEMPORARY)	OPER. No.: 3
-------------------------------------	---------------------

OBsolete
DEC 11 1948

PROCESS RECORD — ILLUSTRATION SKETCH



COMPILED BY: R.W. Selwood 9/26/45	APPROVAL & DATE: WNP
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBSELET
DEC 11 1946

PART: SEAR PLATE		PART No. 1713845	
OPERATION: GRIND (TEMPORARY)		OPER. No.: 3	
PROCESS RECORD			
EQUIPMENT: Brown & Sharpe Surface Grinder			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT: None	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Dial Base Gage		Holding Fixture for Grinding 2 surfaces	
		Same fixture - use to grind both surfaces.	
COMPILED BY: R.W.Selwood 9/18/46		APPROVAL & DATE: 7/10	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.			

CARP NO. 57045																																															
OPER. NO. 3																																															
PROCESS RECORD																																															
INSOLITE 10 EQUIP. 18 Ckt. Plain Miller SPEED 79 RPM FEED 211 Min/Min MAX. PROD. PER. 17 COOLANT Solimard Oil for Shell Garia 28G Climb																																															
TOOLS & GAUGES <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 80%;">TYPE</th> <th style="width: 20%;">NO.</th> </tr> </thead> <tbody> <tr> <td>Form Cutter (Bottom)</td> <td>C-52706</td> </tr> <tr> <td>Form cutter (Top)</td> <td>C-52707</td> </tr> <tr> <td>Arbor (#40-1-B-15-5)</td> <td>B-900370</td> </tr> <tr> <td>Adj. Snap Ga. Height</td> <td>B-801250</td> </tr> <tr> <td>Adj. Snap Ga. Height</td> <td>B-801250</td> </tr> <tr> <td>Comparator</td> <td></td> </tr> <tr> <td>Screen for Form Cut</td> <td></td> </tr> <tr> <td>Screen for Form Cut</td> <td></td> </tr> <tr> <td>Comparator</td> <td></td> </tr> <tr> <td>Fixture</td> <td>C-52702</td> </tr> <tr> <td>Locating But.</td> <td>C-52702A</td> </tr> <tr> <td>Stage</td> <td>B-801250</td> </tr> <tr> <td>Screen</td> <td>C-52702</td> </tr> </tbody> </table>	TYPE	NO.	Form Cutter (Bottom)	C-52706	Form cutter (Top)	C-52707	Arbor (#40-1-B-15-5)	B-900370	Adj. Snap Ga. Height	B-801250	Adj. Snap Ga. Height	B-801250	Comparator		Screen for Form Cut		Screen for Form Cut		Comparator		Fixture	C-52702	Locating But.	C-52702A	Stage	B-801250	Screen	C-52702	TOOL HOLDERS, JIGS & FIXTURES <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 80%;">TYPE</th> <th style="width: 20%;">NO.</th> </tr> </thead> <tbody> <tr> <td>Fixture</td> <td>D-52597</td> </tr> <tr> <td>Arbor (Bottom)</td> <td>D-52707</td> </tr> <tr> <td>Solid Jaw</td> <td>D-52707</td> </tr> <tr> <td>Overlay Jaw</td> <td>D-52707</td> </tr> <tr> <td>Solid Jaw (Top)</td> <td>D-52707</td> </tr> <tr> <td>Solid Jaw</td> <td>D-52707</td> </tr> <tr> <td>Overlay Jaw</td> <td>D-52707</td> </tr> <tr> <td>Bushing Fixture</td> <td>B-52937</td> </tr> </tbody> </table>	TYPE	NO.	Fixture	D-52597	Arbor (Bottom)	D-52707	Solid Jaw	D-52707	Overlay Jaw	D-52707	Solid Jaw (Top)	D-52707	Solid Jaw	D-52707	Overlay Jaw	D-52707	Bushing Fixture	B-52937
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Bushing Fixture	B-52937																																														
SKETCH Center Top 547 557																																															
PIECE TO BE BURRED AFTER EACH CUT ONLY LARGE BURRS NEED BE REMOVED AFTER FINISH CUT																																															
COMPILED BY: J. J. Jones 11/25/46	APPROVAL & DATE: [Signature] 11/25/46																																														
REMINGTON ARMS COMPANY, INC. ILION, N. Y.																																															

Rev
OBSOLETE

PART No. 1-70

TOP & BOTTOM

OPER. No.

PROCESS RECORD

EQUIPMENT: #1-18 Cincinnati Plain Miller

SPEED: 19 RPM

FEED: 2 3/16 /Min.

MAX. PROD. PER HOUR:

171 Pieces/Hr.

COOLANT: Soluble Oil.

Cincinnati MILL

or Steel - 5000 PG

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	NO.	TYPE	NO.
Form Cutter (Bottom)	C-52706	Fixture	D-52597
Form Cutter (Top)	C-52707	Vise Jaws. (Bottom)	D-52730W
Arbor (#40-14-B-154-3)	B-90057U	Solid Jaw	D-52729W
Adj. Snap Ga.-Height	B-80125Q	Movable Jaw	D-52730V
Adj. Snap Ga.-Height	B-80125P	Vise Jaws. (Top)	D-52729W
J & L Comparator		Solid Jaw	D-52730V
Screen for Form Cutter (Bottom)		Movable Jaw	D-52729W
Screen for Form Cutter (Top)			
J & L Comparator		BURRING FIXTURE	B-52937
Fixture	C-52724		
Locating Blk.	C-52724W		
Stage	B-50156		
Screen	C-52726		

SKETCH



547
537

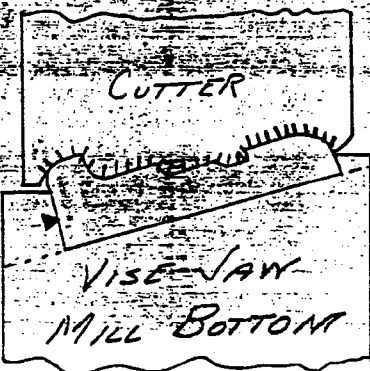
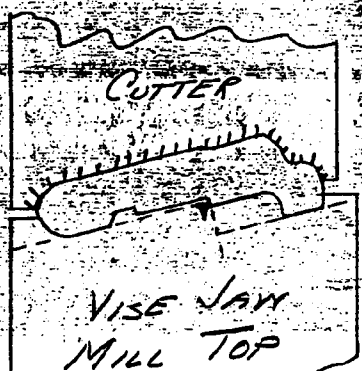
341
321

PIECE TO BE BURRED AFTER EACH CUT - ONLY

COMPILED BY: 11/25/46

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

Revised
OBSCURE
 250

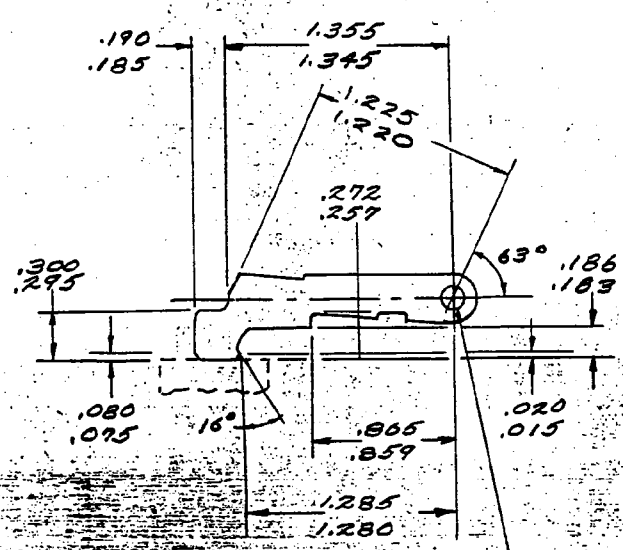
PART: SEAR		PART No. 17045	
OPERATION: MILL TOP & BOTTOM		OPER. No.: 3	
PROCESS RECORD			
EQUIPMENT: #1-18 Cincinnati Plain Miller SPEED: 73 RPM FEED: 2 3/16" / Min. MAX. PROD. PER HOUR: 171 Pieces / Hr. COOLANT: Soluble Oil.			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Form Cutter (Bottom)	C-52706	Fixture	D-52597
Form Cutter (Top)	C-52707	Vise Jaws. (Bottom)	D-52730W
Arbor (#40-1 1/4-B-15 1/2-3)	B-90057U	Solid Jaw	D-52729W
Adj. Snap Ga.-Height	B-80125Q	Movable Jaw	D-52730V
Adj. Snap Ga.-Height	B-80125P	Vise Jaws. (Top)	D-52729W
J & L Comparator		Solid Jaw	D-52730V
Screen for Form Cutter (Bottom)		Movable Jaw	D-52729W
Screen for Form Cutter (Top)			
J & L Comparator			
Fixture	C-52724		
Locating Blk.	C-52724W		
Stage	B-50156		
Screen	C-52726		
SKETCH			
			
		FINAL TECHNICAL PROCESS RECORD DATE	
COMPILED BY: A. J. Robbins 11/25/46		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: BARREL	PART No. 17045
---------------------	-----------------------

OPERATION: FINAL INSPECTION (TEMPORARY)	OPER. No.: 4
--	---------------------

OBsolete
DEC 11 1946

PROCESS RECORD — ILLUSTRATION SKETCH



TAPERED PIN
IN HOLE

COMPILED BY: R.W. Selwood 9/26/46	APPROVAL & DATE: MV
--	-------------------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

H. H. SULLIVAN, INC.

Relay
SOLETE
500

DATE: <i>1947</i>	PART No. <i>17045</i>
OPERATION: <i>Remove Cutter Mismatch</i>	OPER. No.: <i>4</i>

PROCESS RECORD

EQUIPMENT: <i>Porter Cable Sander</i>	
SPEED:	FEED:
MAX. PROD. PER HOUR:	COOLANT:

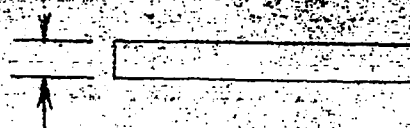
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>80 Grit Belt</i>		<i>Hold piece in hand</i>	

SKETCH

Remove Cutter mismatch
Hold piece in

COMPILED BY: <i>J. Downing</i>	APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

OBsolete

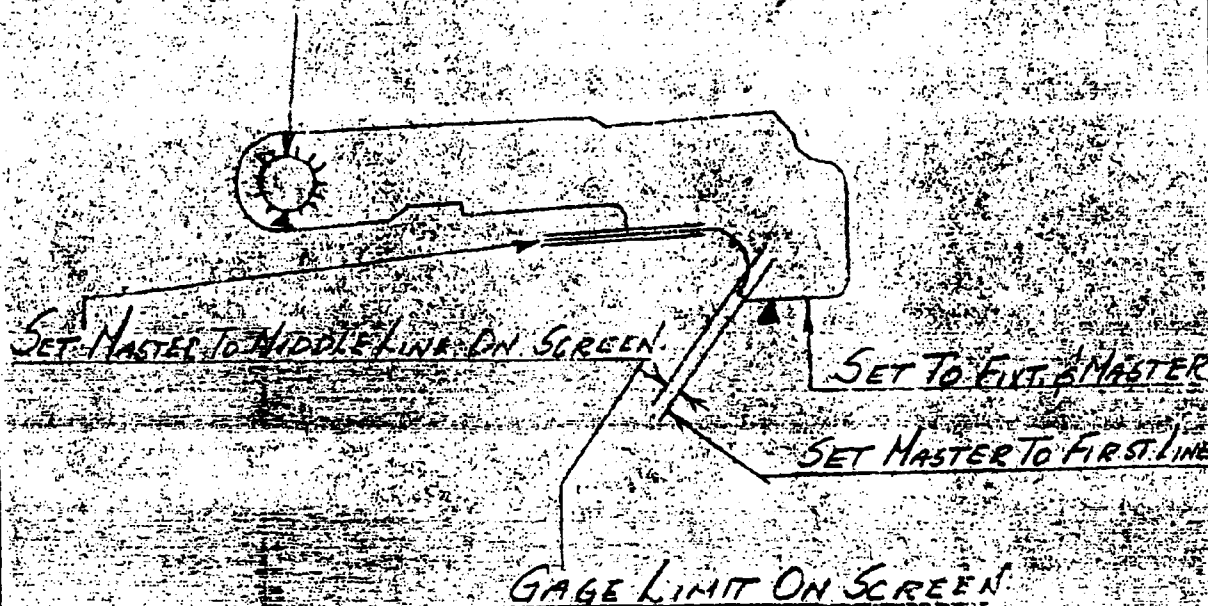
GRIND TO THICKNESS		PART No. 14645	
OPER. No. 5			
PROCESS RECORD			
EQUIPMENT		FEED:	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
ADJUSTABLE SNAP GA. *Thickness	B-80013-M		
SKETCH			
172 168 			
COMPILED BY: J. A. F. [illegible] 11/25/46		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

REAR	PART No. 17045
SPOT, DRILL & REAR PIN HOLE	OPER No. 7

INSPECTION RECORD

J. & L. Comparator
 Fixture D-50325
 Stage B-50156
 Screen C-50333
 Master B-50332

PLUG GA - DIA. OF HOLE (.1262) - B - 80002 - R



COMPILED BY: 11/25/66 APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: SEAR				PART NO. 17045		
OPERATION: SPOT, DRILL & REAM PIN HOLE				OPER. No. 7		
PROCESS RECORD						
EQUIPMENT: Leland - Gifford 3 Spindle Drill Press						
MAX. SPEED PER HOUR: 1800				COOLANT: Cim Cool or Soluble Oil		
STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	No.	TYPE	No.
1. Spot	1800	Hand	Spot Drill (B-90080-K) .126	3.21 MM	Jig	C-52690
2. Drill	1800	Hand	Drill (B-90054-T) .120	#31	Jig	C-52690
3. Ream	600	Hand	Reamer (.1258) Plug Gage .1262-.1254 See next page for comparator layout	B-90079-I B-80002-25	Jig	C-52690
NOTE: (Lift Jig Cover) to make sure no chips are in hole before reaming.						
COMPILED BY: J. F. Bowling 1/6/47			APPROVAL & DATE:			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.						

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JAN 6 1947

PART No. <i>Sear</i>	PART No. <i>17045</i>
----------------------	-----------------------

OPER. No. <i>7</i>

PROCESS RECORD

EQUIPMENT: *#1 Island Jefford 3 Spindle Drill Press*
 MAX. PROD. PER HOUR: *Cum Cool*

STATION			TOOLS & GAUGES		TOOL HOLDERS & FIXTURES	
STEPS	SPEED	FEED	TYPE	NO.	TYPE	NO.
1. <i>Spot Drill</i>	1800	HAND	<i>Spot Drill (B-90080A) .126</i>	<i>3.2 MM</i>	<i>Jig</i>	<i>C-52690</i>
2. <i>Drill</i>			<i>Drill (B-90054T) .120</i>	<i>#31</i>	<i>Jig</i>	<i>C-52690</i>
3. <i>Ream</i>			<i>Reamer (.1258)</i>	<i>B-90079L</i>	<i>Jig</i>	<i>C-52690</i>

NOTE: *LIFT Jig Cover to make sure no chips
are in hole before reaming*

COMPILED BY:

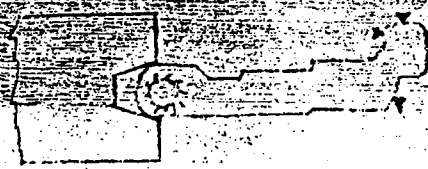
J. F. Bowlin

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

TPR-9

DISSOLETE

PART: SEAR		PART No. 17045	
OPERATION: SPOT, DRILL & REAM PIN HOLE.		OPER. No. 7	
PROCESS RECORD			
JAN 6 1947 EQUIPMENT: SPEED: MAX. PROD. PER HOUR: FEED: COOLANT:			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	NO.	TYPE	NO.
Spot Drill (3.2MM-.126)	B-90080K	Jig	C-52690
Drill (#31-.120)	B-90054T	Spot Drill (3.2MM-.126)	B-90080K
Reamer (.1258)	B-90079L	Drill (#31-.120)	B-90054T
J & Tg Comparator	B-50156	Reamer (.1258)	B-90079L
Fixture	C-50332		
Stage	B-50156		
Screen	C-50333		
Master	B-50332		
Plug Ga. - Dia. of Hole	B-80002R		
SKETCH			
			
COMPILED BY: A. J. [illegible]		APPROVAL & DATE:	
11/25/46			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: SEAR

PART No. 17045

OPERATION: SPOT, DRILL & REAM PIN HOLE.

OPER. No. 7

PROCESS RECORD

EQUIPMENT:

SPEED:

FEED:

MAX. PROD. PER HOUR:

COOLANT:

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
Plug Ga. - Dia. Of Hole	B-80002R	Jig	C-52690
J & L Comparator	B-50325	Spot Drill (3.2MM-.126)	B-900808
Fixture	B-50156	Drill (#31-.120)	B-900541
Stage	C-50333	Reamer (.1258)	B-900791
Screen	B-50332		
Master			

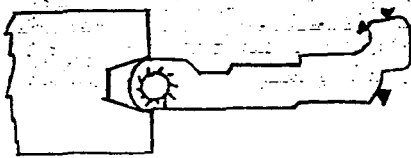
SKETCH

COMPILED BY: A. J. Robbins
11/25/46

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

Rev
OBSOLETE
JAN 1 1947

PART: SEAR		PART No. 17045	
OPERATION: SPOT, DRILL & REAM PIN HOLE.		OPER. No.: 7	
PROCESS RECORD			
EQUIPMENT:			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Plug Ga. - Dia. Of Hole	B-80002R	Jig	C-52690
J & L Comparator	B-50325	Spot Drill (3.2MM-.126)	B-90080K
Fixture	B-50156	Drill (#31-.120)	B-90054T
Stage	C-50333	Reamer (.1258)	B-90079L
Screen	B-50332		
Master			
SKETCH			
			
COMPILED BY: I. F. Webb 11/25/46		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

Retrieved
JAN 8 1947

Lead

PART No.

17045

OPERATION:

Burr Hole

OPER. No.:

8

PROCESS RECORD

EQUIPMENT:

#1 Leland - Gifford Drill Press

SPEED:

1800

FEED:

Hand

MAX. PROD. PER HOUR:

—

COOLANT:

None

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
<i>Drill - 3/16"</i> <i>90° pt.</i>	<i>B-90144-H</i>	<i>Hold in Hand to</i> <i>burr both sides.</i> <i>Slight C' Sink</i> <i>is desirable</i>	

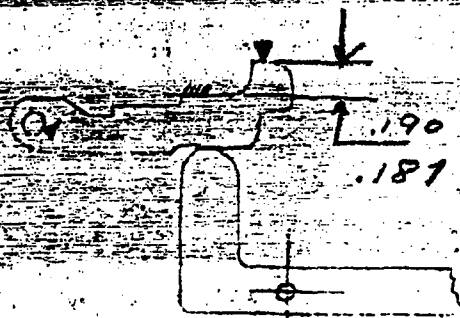
SKETCH

COMPILED BY:

J. Bowlin

APPROVAL & DATE:

REMINGTON ARMS COMPANY INC HUNTSVILLE ALA

PART No. 17045													
OPERATION: GRIND TRIGGER CONNECTOR SURFACE													
OPER. No. 9													
PROCESS RECORD													
EQUIPMENT: SPIN JAN 4 1947													
MAX. PROD. PER HOUR:													
FEED:													
COOLANT:													
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: center; padding: 5px;">TOOLS & GAUGES</th> <th colspan="2" style="text-align: center; padding: 5px;">TOOL HOLDERS, JIGS & FIXTURES</th> </tr> <tr> <th style="text-align: center; padding: 5px;">TYPE</th> <th style="text-align: center; padding: 5px;">No.</th> <th style="text-align: center; padding: 5px;">TYPE</th> <th style="text-align: center; padding: 5px;">No.</th> </tr> <tr> <td style="padding: 5px;"> Dial Gage  </td> <td style="text-align: center; padding: 5px;">C-52894</td> <td style="padding: 5px;"> Fixture </td> <td style="text-align: center; padding: 5px;">C-52735</td> </tr> </table>		TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES		TYPE	No.	TYPE	No.	Dial Gage 	C-52894	Fixture	C-52735
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES											
TYPE	No.	TYPE	No.										
Dial Gage 	C-52894	Fixture	C-52735										
SKETCH													
													
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; padding: 5px;"> COMPILED BY: 11/23/46 </td> <td style="width: 50%; padding: 5px;"> APPROVAL & DATE: TW/4 12/30/46 </td> </tr> <tr> <td colspan="2" style="text-align: center; padding: 5px;"> REVISIO </td> </tr> <tr> <td colspan="2" style="text-align: center; padding: 5px;"> REMINGTON ARMS COMPANY, INC., ILION, N. Y. </td> </tr> </table>		COMPILED BY: 11/23/46	APPROVAL & DATE: TW/4 12/30/46	REVISIO		REMINGTON ARMS COMPANY, INC., ILION, N. Y.							
COMPILED BY: 11/23/46	APPROVAL & DATE: TW/4 12/30/46												
REVISIO													
REMINGTON ARMS COMPANY, INC., ILION, N. Y.													

TPR-20

SOLE
DEC 19 1946

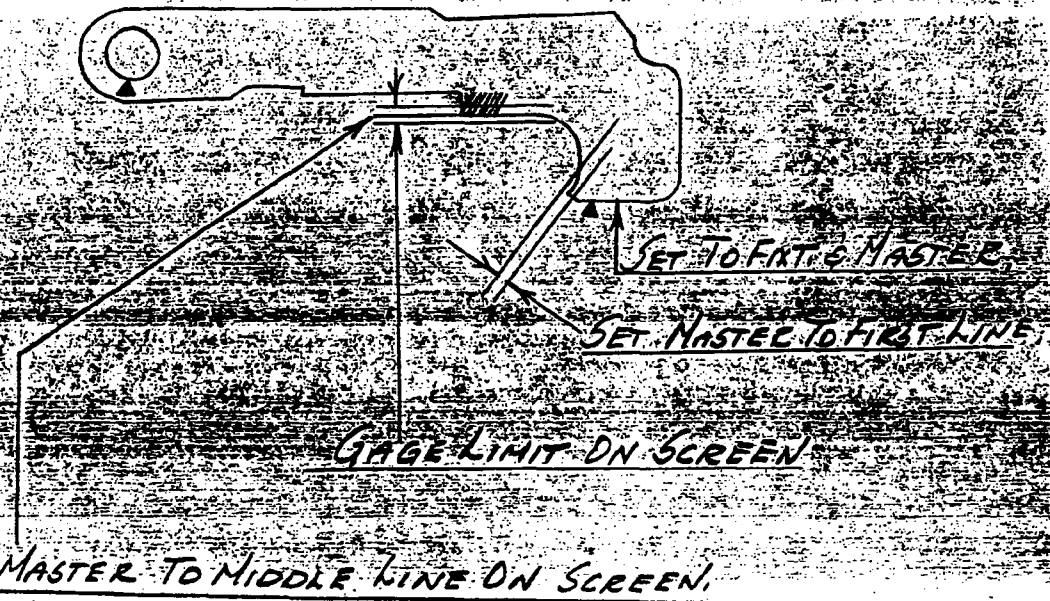
PART NAME: SEAR	PART No. 17045
-----------------	----------------

OPERATION: GRIND TRIGGER CONNECTOR SURFACE	OPER. No. 9
--	-------------

INSPECTION RECORD

J & L Comparator

Fixture D-50325
Stage B-50156
Screen C-50333
Master B-50332



COMPILED BY: J. J. Webb 11/25/46	APPROVAL & DATE:
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

AS SOLE
DEC 19 1946

REVISIONS: 17015

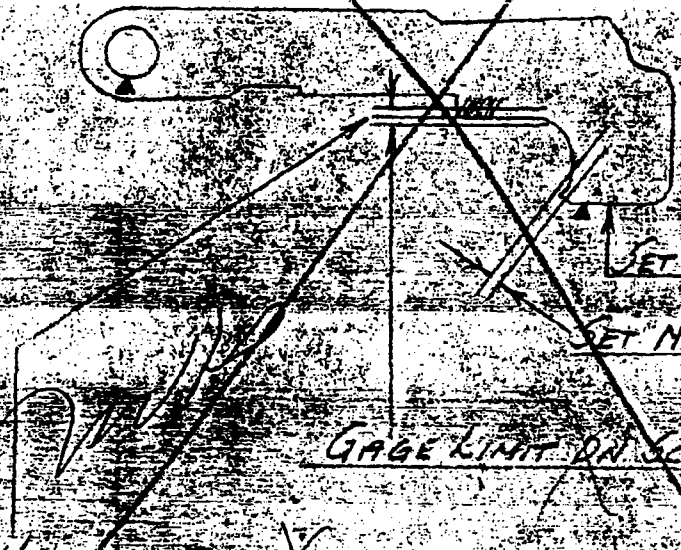
REVISION: TRIGGER CONNECTOR SURFACE

INSPECTION RECORD

Comparator
Fixture D-50325
Stage B-50176
Screen C-50337
Master A-50392

Indicator Gage C-52894
12/17/46 JP

Cancel



COMPILED BY: 12/25/46 APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

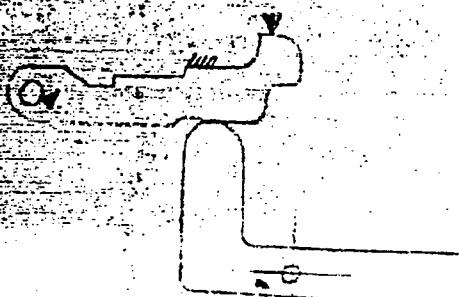
PART: **SEAR** PART No. **17045**
 OPERATION: **GRIND TRIGGER CONNECTOR SURFACE** OPER. No. **9**

PROCESS RECORD

EQUIPMENT:
 SPEED: FEED:
 MAX. PROD. PER HOUR: COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator			
Fixture	B-50325	Fixture	C-52735
Stage	B-50156		
Screen	G-50333		
Master	B-50332		
<i>Did Indicator Gage</i>	<i>C-52894</i>		

SKETCH



COMPILED BY: *W.H. 12/19/46* APPROVAL & DATE:
11/25/46
 REMINGTON ARMS COMPANY, INC., ILION, N. Y.

TPR-9

original
OB-SOLETE
DEC 12 1946

PART: SEAR	PART No. 17045
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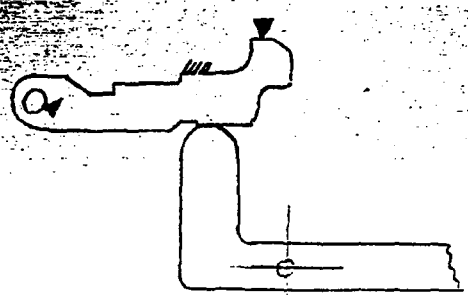
OPERATION: GRIND TRIGGER CONNECTOR SURFACE	OPER. No.: 9
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PROCESS RECORD

EQUIPMENT:	
SPEED:	FEED:
MAX. PROD. PER HOUR:	COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator			
Fixture	D-50325	Fixture	C-52735
Stage	B-50156		
Screen	C-50333		
Master	B-50332		

SKETCH



COMPILED BY: A. J. Webbing 11/25/46	APPROVAL & DATE:
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REMINGTON ARMS COMPANY INC. HARTFORD, CT.

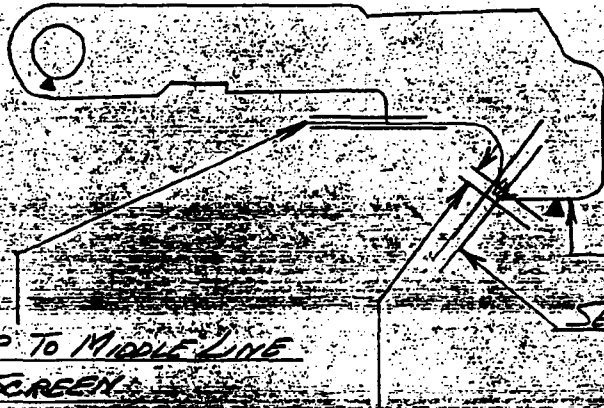
PART No. SEAR	PART No. 17045
---------------	----------------

OPER. No. GRIND SAFETY SURFACE	OPER. No. 11
--------------------------------	--------------

OBsolete
J. B. C.

INSPECTION RECORD

J. B. C. Comparator
 Fixture D-50325
 Stage B-50156
 Screen C-50333
 Master B-50332



COMPILED BY: A. F. Webbing 11/25/46	APPROVAL & DATE:
--	------------------

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

TFR-20

ORIGINAL
DEC 1964

GROUND SAFETY SURFACE

PART 12/00

OPER. No. 11

INSPECTION RECORD

COMPLETED
By: B-50325
By: B-50170
By: C-50533
Master: B-50325

Indicator G99C-C-52894
14/17/4677

Cancel



SET MASTER TO FIRST LINE

SET MASTER TO FIRST LINE

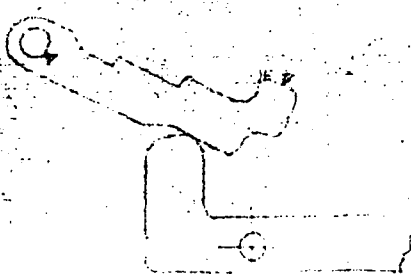
GAGE LIGHT ON GREEN

COMPLETED BY: 11/27/60

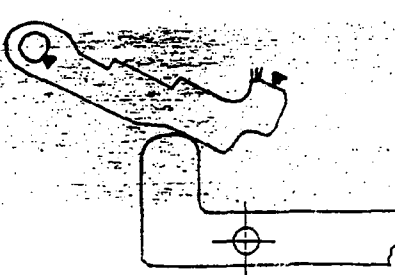
APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

CONFIDENTIAL
 DEC 19 1946

PART: SEAR		PART No. 17045	
OPERATION: GRIND SAFETY SURFACE		OPER. No. 11	
PROCESS RECORD			
EQUIPMENT:			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator Fixture Stage Screen Master <i>Indicator Gage</i> <i>did</i>	D 50325 B 50156 C 50333 B 50332 <i>C-52894</i> <i>12/17/46 JHP</i>	Fixture	C-52813
SKETCH			
 <i>W</i> <i>12/19/46</i>			
COMPILED BY: <i>A. J. Webber</i> <i>11/25/46</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

OBSOLETE
 DEC 19 1946

PART: SEAR		PART No. 17045	
OPERATION: GRIND SAFETY SURFACE		OPER. No.: 11	
PROCESS RECORD			
EQUIPMENT:			
SPEED:		FEED:	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
J & L Comparator Fixture Stage Screen Master	D-50325 B-50156 C-60333 B-50332	Fixture	C-52813
SKETCH			
			
COMPILED BY: A. J. Webbing 11/25/46		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: GEAR

PART No. 17045

OPER. No.:

PROCESS RECORD

EQUIPMENT: BLANCHARD ROTARY SURFACE GRINDER

SPEED:

FEED:

MAX. PROD. PER HOUR:

COOLANT: CIM COOL

TOOLS & GAUGES

TOOL HOLDERS, JIGS & FIXTURES

TYPE	No.	TYPE	No.
ADJUSTABLE SNAP GA.-Thickness	B-80013-M	Load Table Full	

SKETCH

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART No. <i>77048</i>	
OPER. No.:	
PROCESS RECORD	
EQUIPMENT: <i>Blanchard Rotary Surface Grinder</i>	
SPEED:	FEED:
MAX. PROD. PER HOUR:	COOLANT: <i>Cin Cool</i>
TOOLS & GAUGES	
TYPE	No.
TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.
<i>Load Table Full</i>	
SKETCH	
COMPILED BY:	
APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.	

CONFIDENTIAL



Form 100-1083

PROCESS RECORDS TURNED OVER TO PLANT

Model

74

Component Name

Engine (Gnome)

Component No.

12178

Operation

Power land (Gnome) 12178

The original vellums on this operation are being withdrawn from the working files to be turned over to the Plant.

APR 7 1947

Signature

Chapman
Process Engineer



OBsolete

MAR 20 1947

PART:

~~GEAR SPRING~~
TRIGGER SPRING

OPERATION:

PURCHASE INSPECTION

FINAL INSPECTION

PROCESS RECORD

DATE

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
1	TYPE		MAX.	MIN.
1.	Rod Collar	B-51364W B-51365W		
2.	Coates Elasticometer	Set up Elasticometer		
	Pin	B-51001		
	Ring	B-51002		
	Bushing	B-50127T		
		B-53123-S		
		B-53122-S		
3.		a. Place Bushing in platen b. Snap pin in arm c. Load beam with mean load d. Set markers on scale *(Includes 1" constant)		
4.		a. Slip spring on pin. Must fit freely. b. Check "Free Length" with pin length. Must be within 0.010 longer.		
5.		a. Place ring on platen. Raise platen to "Solid Height". Lock platen. Check ring. Ring is at "Solid Height". b. Raise and lower ring over spring to check "Solid Height" at solid height.		
6.	Visual	a. Lower platen until balance arm is on zero. Move lever arm up and down several times to get true reading. Pointer on platen must fall between tolerance markers on scale. b. Check ends Check wind		

Note: ALL Only sample springs are to be set before assembly

COMPILED BY E.K.Wheat

APPROVAL & DATE

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: ~~Trigger Spring~~ (Purchase ready for Setting)
Trigger Spring

MAN 20
DISCLOSURE

PROCUREMENT - FINISHED COMPONENT

Detailed Description

Remington-Union

Pieces Required Per Assembly: 1 (18ear Spring)
Uses of Parts: M/721 - All Calibers;
M/722 - All Calibers;

Vendor

- Material: Music Wire. Packing slip to show material used for each shipment of parts.
- Heat Treatment: Stress Relieve (See footnote)
- Set: Vendor need not remove set but parts must comply with drawing when set has been removed by holding fully compressed for 24 hrs.
- Final Color: Parts to-be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)
- Packaging: Purchase Order Number and quantity of pieces to be shown on each container, the gross weight of which must not exceed 200 lbs

Acceptance Testing:

Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

Set Sample for inspection by holding fully compressed for 24 hrs., Rod Dwg. B-51564W, Collar B51565W. Balance of lot must be set before parts are ready for assembly.

Inspection: **

Gage No.	Type	Use	AQCL
1. Coats	"Elasticometer" with }	(Free Length	7%
B-53 123-S B-51001T - Pin		(Solid Height	7%
B-53 122-S B-51000T - Ring		(I.D. of Spring	7%
B-50127T - Bushing		(O.D. of Spring	7%
		(Load at 80% Deflection	7%
2. Visual		Wind R.H.	7%
		Ends Squared and Ground	7%
		Seams, etc.	7%

** See Process Record - Inspection for Procedure.

Notes: As a matter of information only this part has been heat treated satisfactorily at Remington as follows:

Stress Relief; duPont Salt #1; 380 - 400°F; 10 minutes; water quench.

COMPILED BY: C.B. Buonassisi

APPROVAL & DATE: 5/57/46

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

TRIGGER SPRING

SEQUENCE OF OPERATIONS

SEQ. NO.

OPER. NO.

OPERATION

DEPT

Material Procurement

Purchase Inspection

Transfer to Part Stores

FINAL TECHNICAL
PROCESS RECORD
DATE

COMPILED BY: M.H.S.
7/1/46

-APPROVAL & DATE

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

Received
OBsolete

May 20 1947

PROCESS RECORD

~~GEAR SPRING~~

TRIGGER SPRING

PART NO. 19047

17978

ISSUED BY
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
MILTON, NEW YORK

ISSUED TO:

Form RT-118

PROCESS RECORDS TURNED OVER TO PLANT

Model 721

Component Name Trigger Spring

Component No. 17718

Operation Fail Short, Sequence of operation

The original vellums on this operation are being withdrawn from Engineering Files to be turned over to the Plant.

March 26, 1947

[Signature]
Process Engineer

PROCESS RECORDS TURNED OVER TO PLANT

Model 221

Component Name Trigger Spring

Component No. 17978

Operation 1 - Purchase Inspection

The original vellums on this operation are being with-
drawn from Engineering Files to be turned over to the Plant.

March 26, 1947

Date

CE
Process Engineer

FORM RT-178

PROCESS RECORDS TURNED OVER TO PLANT

Model 221

Component Name Trigger Spring

Component No. 17978

Operation Mat. Rec. - Inspected

The original vellums on this operation are being with-
drawn from Engineering Files to be turned over to the Plant.

March 26, 1947

Date

CE
Process Engineer

147036

OBSCURE FILE

TRIGGER ASSET

1. The OBSCURE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced by a colored tissue dividing sheet.
2. Each operation may have several OBSCURE sheets. Where this is true they have been put in order according to date when they were OBSCURED, the latest date being on top.
3. All sketch sheets precede their operation sheets and are divided.

PART: TRIGGER ASSEMBLY		PART No. 17036Y	
PROCESS RECORD-ASSEMBLY			
STEP	TOOLS & GAGES		REMARKS
	TYPE	NO.	
1- Insert trigger- 17048-in Housing-17039-and install Trigger Pin.-17037			Pin must be flush on Safety Side
2- Assemble following: a-Bolt Stop Release-17038 b-Safety Pivot Pin-17043 c-Safety-17040 d-Safety Detent Ball-17041 e-Safety Detent Spring-17042 f-Safety Snap Washer-17044			
3- Install Trigger Adjusting Screw-17049-Butt End.			
4- Insert Trigger Connector 17050			
5- Insert Trigger Stop Screw- 17053			
6- Install Trigger Adjusting Screw-17049-and Trigger Spring 17047.			
7- Install Sear-17045-Sear Sprgs. 17047-and Dummy Pins.	Dummy Pins	A-51468	
8- Adjust Butt End Trigger Adjustment Screw-17049			Apply pressure on Sear and tighten screw until Sear falls then back up screw $\frac{1}{2}$ turn.
9- Adjust Trigger Stop Screw- 17053			Tighten op Trigger Stop Screw until Tirgger will not disen- gage Sear. Then apply pressure on top of Sear and Trigger and back Trigger Stop Screw until Sear falls.
* USE NORMAL COMPLEMENT OF ASSEMBLING TOOLS TO PERFORM ABOVE ASSEMBLY.			
COMPILED BY:		APPROVAL & DATE: MHS 7/19/46 <i>MHS</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: TRIGGER ASSEMBLY		PART No. 17036-Y	
PROCESS RECORD ASSEMBLY			
STEP	TOOLS & GAGES		REMARKS
	TYPE	NO.	
1- Insert trigger-17048-in housing-17039-and install trigger pin. 17037	Hammer		Pin must be flush on safety side.
2- Assemble following: a-Bolt Stop Release-17038 b-Safety Pivot Pin-17043 c-Safety-17040 d-Safety Detent Ball-17041 e-Safety Detent Sprg.-17042 f-Safety Snap Washer-17044	Hammer		
3- Install trigger adjustment screw-17049-butt end.	1/8" Blade Screw Driver		
4- Insert Connector-17050			
5- Insert Trigger Stop Screw-17053	1/8" Blade Screw Driver		
6-Install Trigger Adjusting Screw-17049-and Spring 17047.	1/8" Blade Screw Driver		
7- Install sear-17045-Sear Sprgs.-17047-and Dummy Pins.	Dummy Pins	A-51468	
8-Adjust Butt end Trigger Adjustment Screw-17049	1/8" Blade Screw Driver		Apply pressure on sear and tighten screw until sear falls then back up screw 1/2 turn.
9- Adjust Trigger Stop Screw-17053	Bench Vise		Tighten up trigger stop screw until trigger will not disengage sear. Then apply pressure on top of sear and trigger and back trigger stop screw until sear falls.
COMPILED BY:		APPROVAL & DATE: <i>MKS 7/19/48</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART NAME: TRIGGER ASSEMBLY		PART No. 17036-Y	
Revised 8/22/46 OBSOLETE			
PROCESS RECORD-ASSEMBLY			
STEP	TOOLS & GAGES TYPE	NO.	REMARKS
1- Insert trigger 17048 in housing 17039 and install trigger pin 17043	Hammer		Pin must be flush on safety side.
2- Assemble following: a-Bolt Stop Release 17038 b-Safety Pivot Pin 17043 c-Safety 17040 d-Safety Detent Ball 17041 e-Safety Detent Sprg. 17042 f-Safety Snap Washer 17044	Hammer		
3- Install Trigger Adjustment Screw 17049 butt end.	1/8" Blade		
4- Insert Connector 17050			
5- Insert Trigger Stop Screw 17053	1/8" Blade		
6- Install Trigger Adjusting Screw 17049 and Spring 17047	1/8" Blade		
7- Install Sear 17045 Sear Sprgs. 17047 and Dummy Pins.	Dummy Pins	A-51468	
8- Adjust Butt end Trigger Adjustment Screw 17049	1/8" Blade		Apply pressure on sear and tighten screw until sear falls then back up screw 1 turn.
9- Adjust Trigger Stop Screw 17053	Barrel Vice		Tighten up trigger stop screw until trigger will not disengage sear. Then apply pressure on top of sear and trigger and back trigger stop screw until sear falls.
* USE NORMAL COMPLEMENT OF ASSEMBLING TOOLS TO PERFORM ABOVE ASSEMBLY.			
COMPILED BY:		APPROVAL & DATE:	
		JUL 23 1946	

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

REVISED JUL 23 1946

PART: Trigger Assembly		PART No. 17036 Y
REGISTER OF ALL PROCESS RECORD REVISIONS		
DATE	DESCRIPTION OF CHANGE	
7/19/46	Typed Process Record	
COMPILED BY:		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

8/20/46
R. H. [unclear]
Chas. [unclear]
OBSOLETE

PROCESS RECORD

TRIGGER ASSEMBLY

PART NO. 17036 Y

THIS ASSEMBLY CONSISTS OF:

Trigger 17048

Housing 17039

Trigger Pin 17037

Bolt Stop Release 17038

Safety Pin 17043

Safety Pin 17040

Safety Detent Ball 17041

Safety Detent Spring 17042

Safety Snap Washer 17044

Trigger Adjusting Screw 17049

Trigger Connector 17050

Trigger Stop Screw 17053

Trigger Spring 17047

SEAR 17045

Sear Spring 17047

ISSUED BY
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
MILTON, NEW YORK

ISSUED TO _____ DEPARTMENT _____

RECEIVED
FBI - NEW YORK
JAN 10 1964

1. The OBSOLETE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced by a colored flange dividing the OBSOLETE sheets. Where this true they have been put in or according to date when they were OBSOLETE, the latest date be on top.
2. Each operation may have several OBSOLETE sheets. Where this true they have been put in or according to date when they were OBSOLETE, the latest date be on top.
3. All sketch sheets precede the operation sheets and are divided from the OBSOLETE sheets by a colored flange.

PART: Final Assembly		PART No. 8/1
Final Inspection		CONFIDENTIAL OBSCURE
Component	Check	Key Points
Function	Finish of bolt	Good - marks and burrs slight
	Wire brush and wipe bore	Visual for no rust or other defects.
Assemble	Insert bolt	No bind by bolt stop
	Pull back bolt to test	Bolt is locked by bolt stop.
Stamp	Final Inspection	On left side rear of barrel
	Date code mark	" " " " " "
	Send to Warehouse	
COMPILED BY: <i>JH [Signature]</i>		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Final Assembly		PART NO. 81 OBSCLETE
Final Inspection		
Component	Check	Key Points
Stock	Finish All screws Barrel must seat	No checks, mars and scratches slight per sample Tight in stock, mars and burrs slight and no bad projections.
Butt Plate	Fit at face Margin - wood or steel Finish	Max. 0.005 opening Max. 0.020 Color uniform - edges not rough - edge chamfered.
Function	Max. Heading Plug Operate bolt 3 times and fire Follow down test - open bolt full stroke and close forcibly 3 times Safe, Push on (to rear) Push on rear of firing pin head while pulling trigger Bolt Handle Push Safe off with thumb Trigger Pull Depress bolt stop release & remove bolt	Insert in chamber, close action - Bolt should not lock and safe should not go on. Accept if very snug. No bind - bolt handle raises & lowers easily. Must not fire until trigger is pulled. No bind Must not fire - notches not click. Locks down No bind - must not fire until trigger is pulled. Min. - 4#, Max 5# No creep or bind Trigger must retract after firing No bind
COMPILED BY: <i>J.H. Sweet</i>		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Final Assembly		PART No. 87
Final Inspection		
Component	Check	Key Points
Assembly	Live Ammunition Stamps: Assembly First Inspection Proof Test Target Tag	Chamber, magazine, and receiver empty, follower visible. On barrel - left side rear In bolt handle slot of stock (REP). On rear right side of barrel On rear right side of barrel " " " " " " Must match with gun
Metal Parts	Finish	Color uniform, good, finish, mars and burrs slight. No seams or red or gray browning.
Barrel	Muzzle Crown Finish Color	Good finish, no jams at edge of bore. Accept 1/16" light ring around bore, otherwise uniform.
Front Sight	Color Head ball shape Blade tight in base	Uniform - mars and scratches slight Blade staked at front of head Test with light blow - if sight moves - repair and retarget.
Rear Sight	Tight in Dovetail Line-up butt	Test with light blow - if sight moves - repair and retarget. Both sights aligned & square.
COMPILED BY: <i>J. H. Trust</i>		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Final Assembly		PART No.
Target & Test		
Test	Method	Key Points
Proof	Fire one proof cartridge	Check for distortion, cracks etc.
Align Sights	Fire sufficient shots to align sights at 100 yards	
Target	Line 5 shots at 100 yards for test to following specification	100% in 3"
	If gun does not meet above standard, fire 5 more shots total must meet specification	100% in 4" 80% in 3"
Live Ammunition	Open bolt and check receiver, chamber and magazine	
COMPILED BY: <i>H. L. Quist</i>		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

OBsolete

81.
OBSCLETE

PROCESS RECORD

FIRST INSPECTION

TARGET & TEST

FINAL INSPECTION

ISSUED BY

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

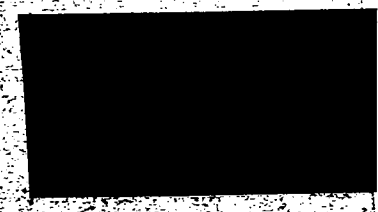
*NO longer reqd
HWH
7/30/46*

ISSUED TO: _____

DEPARTMENT

EXHIBIT NO. 1

1. The OBSOLETE Process Records in this folder are filed in order of operation numbers. Each operation is prefaced by a colored tissue dividing sheet. Each operation may have several OBSOLETE sheets. Where this is true they have been put in order according to date when they were OBSOLETE, the latest date being on top.
2. All sketch sheets precede the operation sheets and are divided in the same manner.
3. All sketch sheets precede the operation sheets and are divided in the same manner.



PROCESS RECORD

Final Assembly

ISSUED BY

TECHNICAL DEPARTMENT

ARMS DIVISION

REMINGTON ARMS COMPANY

ILION, NEW YORK

OBsolete
*plipped
8/2/46*

ISSUED TO

DEPARTMENT

PROCESS RECORD

Final Assembly

ISSUED BY _____
TECHNICAL DEPARTMENT
ARMS DIVISION
REMINGTON ARMS COMPANY
MILTON, NEW YORK

OBsolete

Rec'd 8/2

ISSUED TO: _____

DEPARTMENT

PART:		PART No.	
<i>Final Assembly</i>		<i>Final Assembly</i>	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
1	1	Engrave Serial Number	
2	2	Assemble Trigger Assembly, Bolt stop, Receiver , & receiver	
3	3	Final Chamber Ramping Final Chamber Heading	
4	4	Assemble Signals	
5	5	Final Assembly	
6	6	Mark Serial Number on Bolt Receiver Bolt	
7	10	First Inspection	
8	11	Target and Test	
9	12	Check for Live Ammunition	
10	13	Final Inspection	
COMPILED BY:		APPROVAL & DATE:	
OBsolete <i>retype</i> <i>8/2</i>			
MINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
SEQUENCE OF OPERATIONS			
SEQ. NO.	OPER. NO.	OPERATION	DEPT.
	1	Engrave Serial Number	
	2	Assemble Trigger Subassembly, Bolt stop, Spring, & receiver	
	3	Machine Chamber	
	4	Assemble Sights	
	5	Final Assembly	
	6	Number Bolt.	
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: <i>Final Assembly</i>		PART NO. <i>Final Assembly</i>	
REGISTER OF ALL PROCESS RECORD REVISIONS			
DATE	DESCRIPTION OF CHANGE		
<i>4/4/46</i>	<i>OP #1 - Added operation and fixture to be designed.</i>		
	<i>OP #2 - Added special machine and tooling to be designed.</i>		
<i>7-25-46</i>	<i>Added columnary application for Resumer B-51592 to op #3</i>		
<i>7-25-46</i>	<i>Added Resumer Tubes B-90098 W, B-90098 U, B-90098 V to op #3.</i>		
<i>7-25-46</i>	<i>Added following gages to op #3:</i>		
	<i>B-52086 W, V</i>	<i>C-52093</i>	<i>C-52095 W</i>
	<i>B-51994 W, V</i>	<i>C-52094</i>	<i>C-52093 W</i>
	<i>B-51995 W, V</i>	<i>C-52095</i>	<i>C-52094 W</i>
	<i>B-52084 W, V</i>	<i>C-52096</i>	<i>C-52097 W</i>
	<i>B-52085 W, V</i>	<i>C-52097</i>	
<i>7-25-46</i>	<i>Added turning guide A-52347 to op #1</i>		
<i>7-25-46</i>	<i>Changed sequence of operations from 1, 2, 3, 4, 5, 6 to 1, 2, 3, 5, 6, 4.</i>		
<i>7-25-46</i>	<i>Changed name of op. #3 from Machine Chamber to Final Chamber Resuming.</i>		
<i>7-25-46</i>	<i>Changed Step Gage to Fluid Lin Gage B-52089 on op #10</i>		
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART:

Final Assembly

PART No.

Final Assembly

REGISTER OF ALL PROCESS RECORD REVISIONS

DATE

DESCRIPTION OF CHANGE

4/4/46

OP.#1- Added operation and fixture to be designed,

OP.#2- Added special machine and tooling to be designed.

revised
OBSOLETE

revised

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
REGISTER OF ALL PROCESS RECORD REVISIONS			
DATE		DESCRIPTION OF CHANGE	
7-29-46		<i>assigned Op #10 to First Inspection</i>	
		<i>" Op. #12 to Target & Test</i>	
		<i>" 12 to Check for Live Ammunition</i>	
		<i>" 13 to Final Inspection</i>	
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

key put in
OBsolete

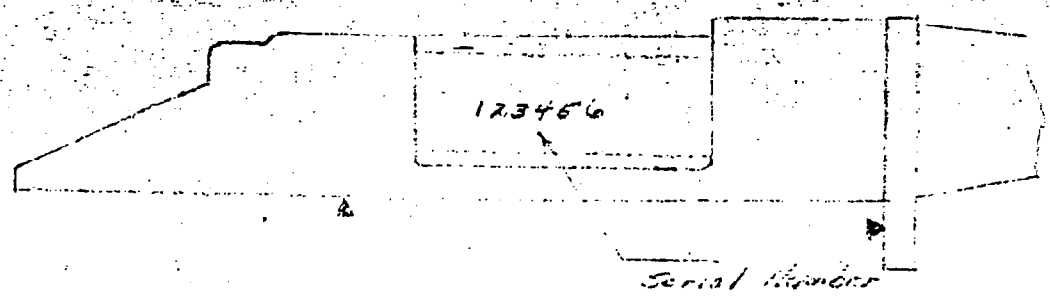
OBSOLETE
MAY 4 1947

PART: FINAL ASSEMBLY		PART NO. FINAL ASSEMBLY	
OPERATION: ENGRAVE SERIAL NUMBER		OPER. No.: 1	
PROCESS RECORD			
EQUIPMENT: Gorton 3U Engraver			
SPEED:		FEED: Hand	
MAX. PROD. PER HOUR: 50		COOLANT: None	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture to locate on O.D. and barrel bracket	D-52322
		1-Forming Guide	A-52347
SKETCH			
COMPILED BY:		APPROVAL & DATE: TWK 8/20/46	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

Retyped
OBsolete
 DEC 27 1946

PART: <i>Final Assembly</i>		PART No. <i>m17214722</i> <i>Final Assembly</i>	
OPERATION: <i>Engrave Serial Number on Receiver</i>		OPER. No.: <i>1</i>	
PROCESS RECORD			
EQUIPMENT: <i>Goston 3-U Engraver</i>			
SPEED:		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR: <i>50</i>		COOLANT: <i>none</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1 - Engraving Cutter</i>	<i>A-52926</i>	<i>1 - Fixture</i>	<i>D-52915</i>
<i>1 - Collet Bushing (Dwg. no. B-801296)</i>	<i>Goston #9619-D</i>	<i>1 - Forming Guide</i>	<i>A-52347</i>
SKETCH			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

RECEIVED
JAN 10 1951

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
OPERATION: <i>Engrave - Serial Number</i>		OPER. No.: <i>1</i>	
PROCESS RECORD			
EQUIPMENT: <i>Gorton 3U Engraver</i>			
SPEED:		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR: <i>50</i>		COOLANT: <i>None</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1- Engraving Cutter</i>	<i>Purchase</i>	<i>1- Fixture to locate on O.D. and barrel bracket.</i>	<i>Design D-52322</i>
		<i>1- FORMING GUIDE</i>	<i>A-52347</i>
SKETCH			
 <i>Serial Number</i>			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: <i>Final Assembly</i>	PART No. <i>Final Assembly</i>
OPERATION: <i>Engrave Serial Number</i>	OPER. No.: <i>1</i>

PROCESS RECORD

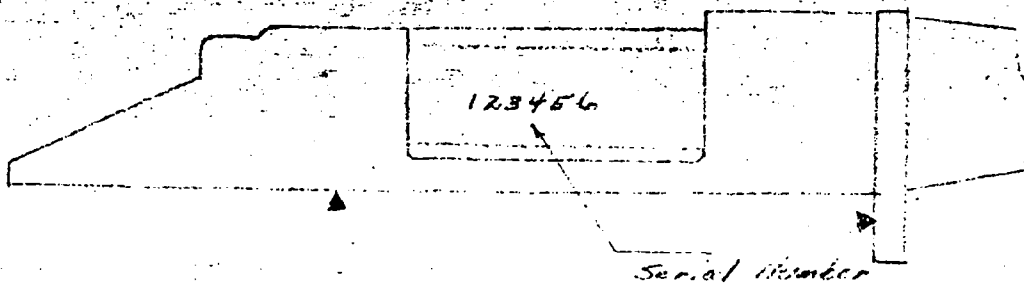
EQUIPMENT: *Corton 3L Engraver*

SPEED: *Hand* FEED: *Hand*

MAX. PROD. PER HOUR: *50* COOLANT: *None*

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1- Engraving Cutter</i>	<i>Purchase</i>	<i>1- Fixture to locate on C.D. and barrel bracket.</i>	<i>Design D-52332</i>
		<i>FORMING GUIDE, A-52347</i>	
		<i>7-24-46</i>	
		<i>QTV.</i>	

SKETCH



COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: Final Assembly		PART No. Final Assembly
OPERATION: Assemble Trigger Assembly, Bolt Stop & Receiver		OPER. No. 2
PROCESS RECORD - ASSEMBLY		
Step	Tools *	Remarks
1. Insert Trigger Assembly, 17036-Y	*	
2. Start Bolt Stop Pin, 17037-W, and Sear Pin, 17037-V, from right side.	1 Hammer	
3. Insert Bolt Stop Spring, 17012, and Bolt Stop, 17013		
4. Drive out dummy Pins with Bolt Stop Pin and Sear Pin	1 Hammer 1 Drift Punch	
5. Insert bolt and push safely on.		There must be clearance between sear and trigger.
* USE NORMAL Complement of Hand Tools To Assemble As Required		
COMPILED BY:		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Final Assembly		PART No. Final Assembly
OPERATION: Assemble Trigger Assembly, Bolt Stop & Receiver		OPER. No.: 2
PROCESS RECORD - ASSEMBLY		
Step	Tools	Remarks
1. Insert Trigger Assembly, 17036-Y		
2. Start Bolt Stop Pin, 17037-W, and Sear Pin, 17037-V, from right side.	1-Hammer	
3. Insert Bolt Stop Spring, 17013, and bolt stop, 17013		
4. Drive out dummy Pins with Bolt Stop Pin and Sear Pin	1-Hammer 1-Drift Punch	
5. Insert bolt and push safely on.		There must be clearance between gear and trigger. <i>Sear</i>
COMPILED BY:		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: <i>Final Assembly</i>	PART No. <i>Final Assembly</i>
OPERATION: <i>FINAL CHAMBER REAMING</i>	OPER. No.: <i>3</i>

PROCESS RECORD

EQUIPMENT: *Special Chambering Machine*
 SPEED: *Hand*
 MAX. PROD. PER HOUR: *Hand*
 COOLANT:

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Special Reamer for following Calibers</i>	<i>5-91</i>	<i>1- Min. Loading Plug</i>	<i>Available</i>
<i>.300 S&W</i>	<i>C-51889</i>		
<i>.257 Roberts</i>	<i>C-51886</i>		
<i>.270 Winchester</i>	<i>C-51887</i>	<i>1- Max. Loading Plug</i>	<i>Available</i>
<i>.300 H&W Magnum</i>	<i>C-51888</i>		
<i>.30-06</i>	<i>C-51591</i>		
<i>COMMONLY APPLICATION FOR REAMERS</i>	<i>B-51592</i>		

REAMER TUBE FOR SKETCH
.30-06, 300 SAV. & 300 MAG. B-90098W
 REAMER TUBE FOR *B-90098V*
.270 WINCHESTER
 REAMER TUBE FOR *B-90098U*
.257 ROBERTS

(see next page)

prepped 8/2

COMPILED BY: APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
OPERATION: <i>Final Chamber Running</i>		OPER. No.: <i>3</i>	
PROCESS RECORD			
EQUIPMENT: <i>Special Chambering Machine</i> SPEED: _____ FEED: <i>Hand</i> MAX. PROD. PER HOUR: _____ COOLANT: _____			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Special Reamer for following calibers</i> <i>300 Sad.</i> <i>257 Roberts</i> <i>270 Win.</i> <i>310 Mag.</i> <i>30-06</i>	<i>Design</i>	<i>1- Min. Heading Plug</i> <i>1- Mod. Heading Plug</i>	<i>Available</i> <i>Available</i>
SKETCH			
COMPILED BY: _____		APPROVAL & DATE: _____	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

*all parts
used*

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
OPERATION: <i>Machine Chamber</i>		OPER. No.: <i>3</i>	
PROCESS RECORD			
EQUIPMENT: <i>Special Chambering Machine</i>			
SPEED:		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Special Reamer for following Calibers</i>	<i>Design</i>	<i>1- Head Shooting Ring</i>	<i>Headstock</i>
<i>300 Sav.</i>		FIXTURE.	D-51580
<i>257 Roberts</i>			
<i>270 Win.</i>		<i>1- Head Shooting Ring</i>	<i>Headstock</i>
<i>300 H&H Mag.</i>			
<i>30-06</i>			
<i>REAMER (30-06)</i>	<i>C-51591</i>		
<i>(.257 ROB.)</i>	<i>C-51886</i>		
<i>(.270 WIN.)</i>	<i>C-51887</i>		
<i>(.300 H&H MAG.)</i>	<i>C-51888</i>		
<i>(.300 SAV.)</i>	<i>C-51889</i>		
<i>REAMER TUBE (.30-06, 300 H&H MAG., 300 SAV.)</i>	<i>B-90098-W</i>		
<i>(.270 WIN.)</i>	<i>B-90098-V</i>		
<i>(.257 ROB.)</i>	<i>B-90098-U</i>		
<i>(GO) HEADING DUMMY (.30-06) (A.U. 270 WIN.)</i>	<i>B-51995-W</i>		
<i>(No GO) " " (.30-06) (A.U. 270 WIN.)</i>	<i>B-51995-V</i>		
<i>(GO) " " (.257 ROB.)</i>	<i>B-52086-W</i>		
<i>(No GO) " " (.257 ROB.)</i>	<i>B-52086-V</i>		
<i>(GO) " " (.300 SAV.)</i>	<i>B-51994-W</i>		
<i>(No GO) " " (.300 SAV.)</i>	<i>B-51994-V</i>		
<i>(GO) " " FOR CDTG. RIM CHORE (.300 H&H MAG.)</i>	<i>B-52084-W</i>		
<i>(No GO) " " " " (.300 H&H MAG.)</i>	<i>B-52084-V</i>		
<i>(GO) " " FOR SHOULDER (.300 H&H MAG.)</i>	<i>B-52085-W</i>		
<i>(No GO) " " " " (.300 H&H MAG.)</i>	<i>B-52085-V</i>		
COMPILED BY:	APPROVAL & DATE:		
	<i>SEE OTHER SIDE OF SHEET.</i>		

REMINGTON-UMC COMPANY, INC. HARTFORD, CONN.

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
OPERATION: <i>Machine Chambering</i>		OPER. No.: <i>3</i>	
PROCESS RECORD			
EQUIPMENT: <i>Special Chambering Machine</i>			
SPEED: <i>Hand</i>		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Special Chambering Machine</i>	<i>1-1</i>	<i>1-1</i>	<i>1-1</i>
<i>300-500</i>		<i>1-1</i>	<i>1-1</i>
<i>250-300</i>		<i>1-1</i>	<i>1-1</i>
<i>200-250</i>		<i>1-1</i>	<i>1-1</i>
<i>150-200</i>		<i>1-1</i>	<i>1-1</i>
<i>100-150</i>		<i>1-1</i>	<i>1-1</i>
<i>75-100</i>		<i>1-1</i>	<i>1-1</i>
<i>50-75</i>		<i>1-1</i>	<i>1-1</i>
<i>25-50</i>		<i>1-1</i>	<i>1-1</i>
<i>10-25</i>		<i>1-1</i>	<i>1-1</i>
<i>5-10</i>		<i>1-1</i>	<i>1-1</i>
<i>2-5</i>		<i>1-1</i>	<i>1-1</i>
<i>1-2</i>		<i>1-1</i>	<i>1-1</i>
<i>0-1</i>		<i>1-1</i>	<i>1-1</i>
SKETCH			
RETYPE AS PER ATTACHED SHEETS 8/5/46			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FINAL ASSEMBLY		PART No. FINAL ASSEMBLY	
OPERATION: FINAL CHAMBER HEAMING		OPER. No.: 3	
PROCESS RECORD			
EQUIPMENT: Special Chambering Machine			
SPEED:		FEED: Hand	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Special Reamer for Following Calibers:		1- Min. Heading Plug	Available
.300 Savage	C-51889		
.257 Roberts	C-51886	1- Max. Heading Plug	Available
.270 Winchester	C-51887		
.300 H. H. Magnum	C-51888		
.30-06	C-51591		
Colmoney Application for Reamers	B-51592		
Reamer Tube for .30-06, .300 Sav. & .300 Mag.	B-90098W		
Reamer Tube for .270 Winchester	B-90098V		
Reamer Tube for .257 Roberts	B-90098U		
Heading Dummies For:			
.257 Roberts	B-52086W,V		
.300 Savage	B-51994W,V		
.30-06, .270 Win.	B-51995W,V		
Heading Devices for: Cartridge Rim Counterbore:			
.300 Magnum	B-52084W,V		
Heading Devices for: Shoulder			
.300 Magnum	B-52085W,V		
Chamber Heading Dummy Master:			
.30-06, .270 Win.	C-52093		
.257 Roberts	C-52094		
.300 Savage	C-52095		
COMPILED BY:	APPROVAL & DATE: <i>mvp 8/20/46</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

Obscured

PART: FINAL ASSEMBLY		PART No. FINAL ASSEMBLY	
OPERATION: FINAL CHAMBER REAMING		OPER. No.: 3	
PROCESS RECORD			
EQUIPMENT: Special Chambering Machine			
SPEED:		FEED: Hand	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Reamer: .30-06 .257 Robts. .270 Win. .300 H & H Mag. .300 Sav.	C-51591 C-51886 C-51887 C-51888 C-51889	Reamer Tube: .30-06, .300 H & H Mag., .300 Sav. .270 Win. .257 Robts.	B90098W B90098X B90098U
Hand Reamer Assembly .300 H & H Mag. Ctg. Rim Counterbore	C-52431	Fixture	D-515B0
Reading Dummy .30-06 & Added Use .270 Win. Go No Go	B-51995W B-51995V	Reading Dummy for Shoulder Shoulder .300 H & H Mag. Go .300 H & H Mag. No Go	B52085W B52085V
.257 Robts. Go No Go	B-52086W B-52086V	Chamber Reading Dummy Master .30-06 & Added Use .270 Win .257 Robts. .300 Sav.	C52093 C52094 C-52095
.300 Sav. Go No Go	B-51994W B-51994V	Chamber Reading Dummy Master For Cdg. Rim C'bore .300 H & H Mag.	B-52096
300 H & H Mag. C'dc Rim C'bore Co Taper Test Plug For Master No G.	B-52084W B-52084V	Chamber Reading Dummy Master For Shoulder .300 H & H Mag.	C-52097 B-52096
.30-06 Added Use .270 Win. .257 Robts. .300 Sav.	C-52093W C-52094W C-52095W	Chamber Reading Dummy Master For Shoulder .300 H & H Mag.	B-52097
.300 H & H Mag. For Ctg. Rim Counterbore Shoulder	C-52097W		
COMPILED BY: AT		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

Op # 3
Final Assembly

Heading Dummies:

.257 Roberts	B-52086 W, V
.300 Savage	B-51994 W, V
.30-06, .270 WIN.	B-51995 W, V

Heading Dummies for
Cartridge Rim Counterbore:

.300 Magnum	B-52084 W, V
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Heading Dummies for
Shoulder

.300 Magnum	B-52085 W, V
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Chamber Heading
Dummy Master:

.30-06, .270 WIN.	C-52093
.257 Roberts	C-52094
.300 Savage	C-52095

Cartridge Rim Counterbore
Heading Dummy Master:

.300 Magnum	C-52096
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Shoulder heading
Dummy Master:

.300 Magnum	C-52097
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Taper Test Plug for
Master:

.300 Savage	C-52095 W
.30-06, .270 WIN.	C-52093 W
.257 Roberts	C-52094 W
.300 Magnum	C-52097 W

Rec'd 8/2
1964

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
OPERATION: <i>Final Chamber Reaming</i>		OPER. No.: <i>3</i>	
PROCESS RECORD			
EQUIPMENT: <i>Special Chambering Machine</i>			
SPEED:		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT:	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Reamer:</i>		<i>Reamer Tube:</i>	
<i>.30-06</i>	<i>C-51591</i>	<i>.30-06, .300 H&H</i>	<i>B-90098-W</i>
<i>.257 Robts</i>	<i>C-51886</i>	<i>Mag., .300 Jar</i>	<i>B-90098-V</i>
<i>.270 Win.</i>	<i>C-51887</i>	<i>.270 Win.</i>	<i>B-90098-V</i>
<i>.300 H&H Mag.</i>	<i>C-51888</i>	<i>.257 Robts</i>	<i>B-90098-V</i>
<i>.300 Jar.</i>	<i>C-51889</i>		
<i>Hand Reamer Assembly</i>		<i>Heading Dummy for</i>	
<i>.300 H&H Mac. Ctg. Rim</i>	<i>C-52431</i>	<i>Shoulder</i>	
<i>Heading Dummy</i>		<i>.300 H&H Mag. - G.O.</i>	<i>B-52085-W</i>
<i>.30-06 & H.V. .270 Win</i>	<i>G.O. B-51995-W</i>	<i>.300 H&H Mag. No G.O.</i>	<i>B-52085-V</i>
<i>No G.O. B-51995-V</i>		<i>Chamber Heading Dummy</i>	
<i>.257 Robts</i>	<i>G.O. B-52086-W</i>	<i>Master</i>	
<i>No G.O. B-52086-V</i>		<i>.30-06 & H.V. .270 Win</i>	<i>C-52093</i>
<i>.300 Jar</i>	<i>G.O. B-51994-W</i>	<i>.257 Robts</i>	<i>C-52094</i>
<i>No G.O. B-51994-V</i>		<i>.300 Jar.</i>	<i>C-52095</i>
<i>Heading Dummy for</i>		<i>Chamber Heading Dummy</i>	
<i>Edg. Rim C' bore</i>		<i>Master for Edg. Rim</i>	
<i>.300 H&H Mag. - G.O.</i>	<i>B-52084-W</i>	<i>C' bore - .300 H&H Mag.</i>	
<i>.300 H&H Mag. No G.O.</i>	<i>B-52084-V</i>	<i>Chamber Heading Dummy</i>	
		<i>Master for Shoulder</i>	
COMPILED BY: <i>AT</i>		APPROVAL & DATE: <i>.300 H&H Mag. C-52097</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: Final Assembly		PART NO. Final Assembly
OPERATION: Assemble Sights		OPER. No.: 4
PROCESS RECORD - ASSEMBLY		
Step	Tools *	Remarks
1. Insert Front Sight, 17026, flush with Ramp	1 Fibre Hammer	Must be tight in Dovetail
2. Insert Rear Open Sight Assembly, 17030-Y, and Open Sight Step, 17033-W	1 Fibre Hammer	Must be tight in Dovetail
* USE NORMAL COMPLEMENT OF HAND TOOLS TO ASSEMBLE AS REQUIRED. <i>prop'd by</i> <i>17026</i>		
COMPILED BY:	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

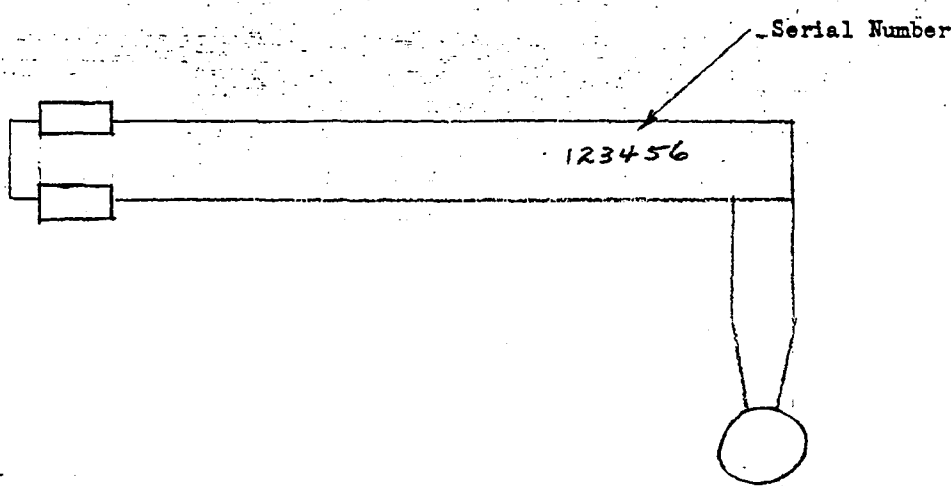
PART: Final Assembly		PART No. Final Assembly
OPERATION: Assemble Sights		OPER. No.: 4
PROCESS RECORD - ASSEMBLY		
Step	Tools	Remarks
1. Insert Front Sight, 17026, flush with Ramp	1-Fibre Hammer	Must be tight in Dovetail
2. Insert Rear Open Sight Assembly, 17030-Y, and Open Sight Step, 17033-W	1-Fibre Hammer	Must be tight in Dovetail
COMPILED BY:		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

rechecked
OBSOLETE

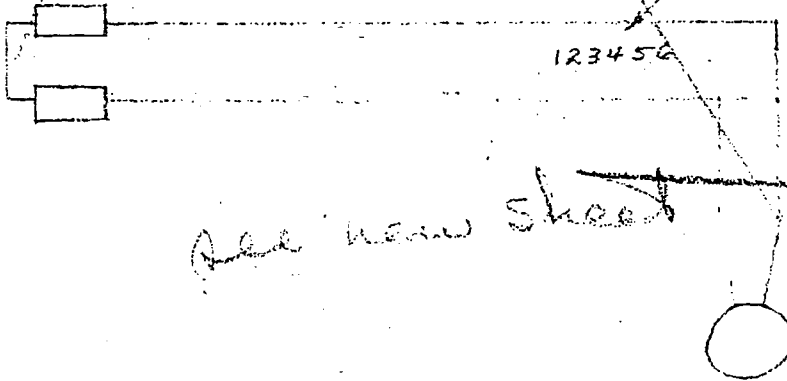
PART: Final Assembly		PART No. Final Assembly
OPERATION: Final Assembly		OPER. No.: 5
PROCESS RECORD - ASSEMBLY		
Step	Tools *	Remarks
1. Check and set Trigger pull at 4 to 5 lbs.	1 Trigger Scale 1 1/8" Blade Screw Driver	
2. Position Stock 17035-W		
3. Insert Magazine Follower Assembly, 17115.		
4. Insert Trigger Guard, 17054-W and Trigger Guide Plate, 17055		
5. Insert Front Guard Screw, 17025-W and Rear Guard Screw, 17025-V.	1 1/8" Blade Screw Driver	
6. Insert Receiver Plug Screws(4), 17034	1 1/8" Blade Screw Driver	
7. Tighten Butt Plate Screws	1 1/8" Blade Screw Driver	
* USE NORMAL COMPLEMENT OF HAND TOOLS TO ASSEMBLE AS REQUIRED.		
<i>Received</i> <i>000000</i> <i>7/1/46</i>		
COMPILED BY:	APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

PART: Final Assembly		PART No. Final Assembly
OPERATION: Final Assembly		OPER. No.: 5
PROCESS RECORD - ASSEMBLY		
Step	Tools	Remarks
1. Check and set Trigger pull at 4 - 5#.	1-Trigger Scale 1-1/8" Blade Screw Driver	
2. Position Stock 17035-W		
3. Insert Magazine Follower Assembly, 17115.		
4. Insert Trigger Guard, 17054-W Trigger Guide Plate, 17055		
5. Insert Front Guard Screw, 17025-W and Rear Guard Screw, 17025-V.	1/4" Blade Screw Driver	
6. Insert Receiver Plug Screw (4), 17034	1/8" Blade Screw Driver.	
7. Tighten Butt-Plate Screws	1/4" Blade Screw Driver	
COMPILED BY:	APPROVAL & DATE:	
- REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

OBsolete
JAN 4 1947

PART: FINAL ASSEMBLY		PART No. FINAL ASSEMBLY	
OPERATION: MARK SERIAL NUMBER ON BOLT		OPER. No.: 6	
PROCESS RECORD			
EQUIPMENT: Gorton 3U Engraver			
SPEED:		FEED: Hand	
MAX. PROD. PER HOUR: 50		COOLANT: None	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture	Purchase
SKETCH			
			
COMPILED BY:		APPROVAL & DATE: <i>mvt 8/30/46</i>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

OBSCURE
DEC 27 1946

PARTS FINAL ASSEMBLY		PART NO. FINAL ASSEMBLY	
OPERATION: MARK SERIAL NUMBER ON BOLT		OPER. No.: 6	
PROCESS RECORD			
EQUIPMENT: Gorton 3U Engraver			
SPEED:		FEED: Hand	
MAX. PROD. PER HOUR: 50		COOLANT: None	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
1-Engraving Cutter	Purchase	1-Fixture	Purchase
SKETCH			
			
COMPILED BY:		APPROVAL & DATE: <i>7/17/47 1/10/47</i>	
REMINGTON ARMS COMPANY, INC. REVISED AUG 2/61			

Retrieved
ORCA
DEC 27 1945

PART: <i>Final Assembly</i>		PART No. <i>71721 + 722</i> <i>Final Assembly</i>	
OPERATION: <i>Mark Serial Number on Bolt</i>		OPER. No.: <i>6</i>	
PROCESS RECORD			
EQUIPMENT: <i>Gorton 3-V Engraver</i>		FEED: <i>Hand</i>	
SPEED:		COOLANT: <i>None</i>	
MAX. PROD. PER HOUR: <i>50</i>			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1- Engraving Cutter</i>	<i>A-52926</i>	<i>1 Fixture</i>	<i>D-52915</i>
<i>1- Collet Bushing</i>	<i>Gorton</i>	<i>1- Adapter</i>	<i>B-52919</i>
<i>(Dwg. # B-80129W)</i>	<i># 9619-D</i>	<i>1- Forming Guide</i>	<i>A-52925</i>
SKETCH			
<i>Mitch Smith</i>			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: <i>Final Assembly</i>		PART No.: <i>Final Assembly</i>	
OPERATION: <i>Mark Serial Number on Bolt</i>		OPER. No.: <i>6</i>	
PROCESS RECORD			
EQUIPMENT: <i>Gorton 36 Engraver</i>			
SPEED:		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR: <i>50</i>		COOLANT: <i>None</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1-Engraving Cutter</i>	<i>Purchase</i>	<i>1- Fixture</i>	<i>Purchase</i>
SKETCH			
OBSOLETE <i>revised 11/8/7</i> <i>Serial Number</i> 123456			
COMPILED BY:		APPROVAL & DATE:	

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

OBSOLETE

PART: FINAL ASSEMBLY		PART NO. Final Assembly	
OPERATION: FIRST INSPECTION		OPER. No. 10	
PROCESS RECORD — INSPECTION			
GAUGES		USE	LIMITS
TYPE	NO.		MAX. MIN.
Reassemble		1. Cock firing pin by retracting firing pinhead with special tool. 2. Insert bolt past bolt stop - no bind. 3. Pull back bolt to test - bolt stop should hold.	
Stamp		1. First inspection mark in bolt handle slot of stock.	
To Gallery for Target & Test			
COMPILED BY: <i>A. H. G. [Signature]</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

TPR-11

PART: FINAL ASSEMBLY		PART NO. Final Assembly		
OPERATION: First Inspection		OPER. No.: 10		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Feeler Gage Assembly Heading Plugs Min. 30-06 300 Saw. 300 Mag. 270 Win. 257 Rem. Max 30-06 300 Saw. 300 Mag. 270 Win. 257 Rem. Function		3. Rear Sight (Cont.) b. Both sights aligned, square, & central with butt. 4. Opening under front end of of near sight at barrel 1. All calibers - Min. Insert heading plug in chamber and close action bolt should lock-accept if snug. 2/ All calibers - Max. Insert in chamber & close action - bolt must not lock and safe not go on. 1. Load (2) dummies into magazine & depress full depth with screwdrivers & release quickly - cartridges must not jump past receiver rails. 2. Load 2 more to fill magazine - depress (4) cartridges - should have overdraw and bolt must pass over top dummy. 3. Operate bolt - must feed and eject properly at normal speed without missed feeds or binding or stemming at top of chamber. 4. Load (1) dummy cartridge into chamber - Close bolt with normal speed - extractor must ride over rim of dummy with no bind and open bolt to eject dummy. 5. Operate bolt (3) times and fire - no bind - bolt	0.015	
COMPILED BY:		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

poly bag
SAFE

wood plug

PART: FINAL ASSEMBLY		PART No. Final Assembly		
OPERATION: First Inspection		OPER. No.: 16		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Feeler Gage		3. Rear Sight (Cont.) b. Both sights aligned, square, & central with butt.		
Assembly Heading Plugs		4. Opening under front end of of rear sight at barrel	0.015	
Min. 30-06	C-52093 W	1. All calibers - Min. Insert heading plug in chamber and close action bolt should lock-accept if snug.		
300 Saw	C-52095 W			
300 Mag	C-52097 W			
300 With	C-52098 W			
257 Rifle	C-52094 W	2/ All calibers - Max. Insert in chamber & close action - bolt must not lock and safe not go on.		
Min. 30-06	C-52093 V			
300 Saw	C-52095 V			
300 Mag	C-52097 V			
257 Rifle	C-52094 V			
Function		1. Load (2) dummies into magazine & depress full depth with screwdriver & release quickly - cartridges must not jump past receiver rails.		
		2. Load 2 more to fill magazine - depress (4) cartridges - should have overdraw and bolt must pass over top dummy.		
		3. Operate bolt - must feed and eject properly at normal speed without missed feeds or binding or stemming at top of chamber.		
		4. Load (1) dummy cartridge into chamber - Close bolt with normal speed - extractor must ride over rim of dummy with no bind and open bolt to eject dummy.		
		5. Operate bolt (3) times and fire - no bind - bolt		
COMPILED BY: J. H. [Signature]		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: FINAL ASSEMBLY
 PART No. Final Assembly
 OPERATION: FIRST INSPECTION
 OPER. No. 10

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Assembly	Visual	1. See that gun is empty. 2. Check for assembly Stamp left side of barrel. 3. Match specification tag with gun for: a. Caliber marking b. Patent marking c. Model no. d. Serial no. e. Barrel overall length f. Grade 4. All markings to be clear & legible. 5. Check for agreement of barrel and receiver serial numbers.		
Butt Plate	Visual	1. Finish a. Uniform color b. No rough edges c. Edge chamfered 2. Butt Plate screws (2) tight		
Stock	Visual	1. No checks or mutilations that can not be repaired at final inspection. 2. Safety Lever must clear stock 3. Stock screws (2) tight 4. No sharp edges 5. Barrel must seat in forend and return to same spot when pulled away and pushed from side to side.		
Feeler Gage		6. Barrel receiver space	0.015	
Feeler Gage		7. Margin at right side Rail	0.015	
			Steel	0.010
Feeler Gage		8. Margin around receiver Tang	0.015	
			Wood	0.005
Feeler Gage		9. Gap at Rear of Trigger Guard	0.015	0.030
Feeler Gage		10. Margin at Trigger Guide Plate	0.005	
			Steel	

COMPILED BY: S. H. Quist
 APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART NO.		Final Assembly	
OPERATION		OPER. NO. 70	
PROCESS RECORD — INSPECTION			
GAUGES		USE	LIMITS
TYPE	No.		MAX. MIN.
Assembly	Visual	1. See that gun is empty. 2. Check for assembly Stamp left side of barrel. 3. Match specification tag with gun for: a. Caliber marking b. Patent marking c. Model no. d. Serial no. e. Barrel overall length f. Grade 4. All markings to be clear & legible.	
Butt Plate	Visual	1. Finish a. Uniform color b. No rough edges c. Edge chamfered 2. Butt Plate screws (3) tight	
Stock	Visual	1. No checks or mutilations that can not be repaired at final inspection. 2. Safety lever must clear stock. 3. Stock screws (3) tight. 4. No sharp edges. 5. Barrel must seat in, or end and return to same spot when pulled away and pushed from side to side.	
Feeler Gage		6. Barrel receiver space	0.018
Feeler Gage		7. Margin at right side of Rail	0.015
Feeler Gage		8. Margin around receiver Tang	0.015
Feeler Gage		9. Gap at Rear of Trigger Guard	0.015
Feeler Gage		10. Margin at Trigger Guide Plate	0.005
COMPILED BY: <i>L.H. Tins</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

PART: FINAL ASSEMBLY		PART No. Final Assembly		
OPERATION: First Inspection		OPER. No.: 10		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Function		5. (Cont.) handle must raise and lower easily.		
		6. Apply pressure on bolt handle up & down - must not cramp or bind.		
		7. Close bolt - must cam follower down in moving forward.		
		8. Open & close bolt forcibly (3) times - firing pin must not follow down.		
		9. Hold bolt handle down & pull trigger-gun must fire instantly no lag due to firing pin bind. (a)		
		10. Bolt handle must seat on receiver stop and clear stock.		
		11. Drop butt 6" to floor - must not fire until trigger is pulled.		
		12. Safety should snap both on and off when pushed in either direction.		
Seale		13. Check trigger pull - no perceptible creep or bind.		
		14. Depress bolt stop release & remove bolt - no bind.		
		15. Release firing pin by turning bolt plug - check firing pin point - no mars		
Step Gage		16. Firing Pin Protrusion	0.075	0.045
COMPILED BY: J. H. [Signature]		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART:	FINAL ASSEMBLY	PART No.	Final Assembly
OPERATION:	First Inspection	OPER. No.	10

PROCESS RECORD — INSPECTION

GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Function		5. (Cont.) handle must raise and lower easily.		
		6. Apply pressure on bolt handle up & down - must not cramp or bind.		
		7. Close bolt - must cam follower down in moving forward.		
		8. Open & close bolt forcibly (3) times - firing pin must not follow down.		
		9. Hold bolt handle down & pull trigger-gun must fire instantly no lag due to firing pin bind.		
		10. Bolt handle must seat on receiver stop and clear stock.		
		11. Drop butt to floor - must not fire until trigger is pulled.		
		12. Safety should snap both on and off when pushed in either direction.		
Seale		13. Check trigger pull - no perceptible creep or bind.	6*	4*
		14. Depress bolt stop release & remove bolt - no bind.		
		15. Release firing pin by turning bolt plug - check firing pin point - no mars		
Step Gage	B-52089	16. Firing Pin Protrusion	0.075	0.045

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART: FINAL ASSEMBLY		PART No. Final Assembly		
OPERATION: FIRST INSPECTION		OPER. No. 10		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Trigger Guard	Visual	1. Finish a. Uniform color b. No serious mars or scratches 2. No bow in trigger guard		
Receiver	Visual	1. Finish a. Uniform Color b. No serious mars or scratches 2. All exposed edges should be chamfered. 3. Scope screw holes present 4. Firing pin head slot - free of mutilation. 5. Magazine edge must be below bullet ramp edge.		
Bolt Plug	Visual	1. Finish a. Uniform color b. No serious mars & scratches 2. Fit - Rotational clearance of bolt plug on F.P. Head must permit match at end of bolt handle at left rear of bolt with flat on bolt plug.		
Firing Pin Head	Visual	1. Finish a. Uniform Color b. No serious mars or scratches 2. No sharp edges.		
Bolt	Visual	1. Finish a. Must be bright b. No serious mars or scratches c. Back of bolt lugs must be ground finish d. No brass visible except in corners of brazed joints.		
COMPILED BY: <i>L. H. Hunt</i>		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: FINAL ASSEMBLY		PART No. FINAL ASSEMBLY		
OPERATION: TARGET & TEST		OPER. No.: 11		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Proof Test		1. Visual for first inspection mark. 2. Fire one proof cartridge - check for cracks, distortion, etc. 3. Stamp proof mark on barrel.		
Align Sights & Target Gun		1. Check for proof mark. 2. Load four cartridges & run through action without firing - check for feeding, extraction ejection and marking case or bullet. 3. Reload and fire to align sights at 100 yd.		
Accuracy Test		1. Fire (5) shots at 100 yds - all shots must fall in 3" circle. 2. Repeat above if first test fails. 3. If second test fails return for repair. 4. Stamp target and test mark on right hand side of barrel.		
		To Final Inspection		
COMPILED BY: <i>[Signature]</i>		APPROVAL & DATE: <i>[Signature]</i>		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: FINAL ASSEMBLY		PART No. FINAL ASSEMBLY		
OPERATION: TARGET & TEST		OPER. No.:		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Proof Test		1. Visual for first inspection mark. 2. Fire one proof cartridge - check for cracks, distortion, etc. 3. Stamp proof mark on barrel. <i>on right hand side of barrel</i>		
Align Sights & Target Gun		1. Check for proof mark. 2. Load four cartridges & run through action without firing - check for feeding, extraction ejection and marking case or bullet. 3. Reload and fire to align sights at 100 yd. <i>2 above</i>		
Accuracy Test		1. Fire (5) shots at 100 yds - all shots must fall in 3" circle. 2. Repeat above if first test fails. - <i>100% of 10 shots in 4" circle - 80% in 3" circle</i> 3. If second test fails return for repair. 4. Stamp target and test mark on right hand side of barrel.		
To Final Inspection <i>To Live Ammunition Inspector</i>				
COMPILED BY: <i>L.H. Smith</i>		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: <i>Final Assembly</i>		PART No. <i>Final Assembly</i>	
OPERATION: <i>Check for line communication</i>		OPER. No.: <i>12</i>	
PROCESS RECORD — INSPECTION			
GAUGES		USE	LIMITS
TYPE	NO.		MAX. MIN.
	<i>Visual</i>	<i>Check for line communication in chamber, magazine, and barrel. Follow up with note.</i>	
		<i>To Final Assembly</i>	
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

OBSOLETE

PART NO. FINAL ASSEMBLY		PART NO. Final Assembly		
OPERATION: FINAL INSPECTION		OPER. NO. B		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Assembly	Visible <i>Visual</i>	1. Check for live ammunition chamber, magazine, and receiver empty, follower visible. 2. Check stamps: a. Assembly - On barrel left side rear. b. First inspection - In bolt handle slot of stock c. Proof - (REP) On rear right side of barrel d. Target & test - On rear right side of barrel. 3. Tag - must match with gun.		
Stock	Visible <i>Visual</i>	1. Finish - no check, mars and only slight scratches 2. Set screws tight in stock, mars and burrs slight and no bad projections. 3. Barrel must seat and return to same position when pulled away and moved from side to side.		
Barrel	Visible <i>Visual</i>	1. Finish a. Color uniform b. No serious mars or scratches. c. No jams at muzzle crown. d. Accept 1/16" light ring around bore.		
Sights (Front & Rear)	Visible <i>Visual</i>	1. Finish a. Color uniform b. No serious mars or scratches 2. Check both sights for tightness in dovetail with		
COMPILED BY: <i>[Signature]</i>		APPROVAL & DATE: _____		

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

FINAL ASSEMBLY		PART No. Final Assembly		
OPERATION: FINAL INSPECTION		OPER. No. 13		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Cont. Sights (Front & Rear)	Visual	2. cont. light blow of copper hammer - if sight moves repair and re-target.		
Function	Visual	3. Both sights must be aligned and square with butt.		
30-06	C-52093V	1. Max. heading plug - insert in chamber, close action - bolt should not lock and safe should not go on. Accept if very snug.		
30-06	C-52095V	2. Operate bolt (3) times and fire - no bind, bolt handle raises and lowers easily.		
300 mag	C-52097V	3. Open and close bolt forcibly (3) times - trigger must not follow down.		
257 Rott	C-52093V	4. Push "On" safe - no bind.		
270 Win	C-52094V	5. Push safe off with thumb - no bind, must not fire until trigger is pulled.		
Scale	Visual	6. Trigger pull - no perceptible creep or bind trigger must retract after firing.		
Function	Visual	7. Wire brush and wipe bore - check for rust or other defects.		
Assembly	Visual	1. Insert bolt - no bind by bolt stop		
		2. Pull back bolt to test - bolt stop must stop bolt.		
Stamp	Visual	1. Final inspection mark on left side rear of barrel.		
COMPILED BY: <i>[Signature]</i>		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

PART: FINAL ASSEMBLY		PART No. Final Assembly		
OPERATION: FINAL INSPECTION		OPER. No.: 13		
PROCESS RECORD — INSPECTION				
GAUGES		USE	LIMITS	
TYPE	No.		MAX.	MIN.
Stamp (Cont.)		2. Date code mark on left side rear of barrel. 3. Sign tag		
	Send to Warehouse			
EMPILED BY: <i>[Signature]</i>		APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC., ILION, N. Y.				

Revised 8/12
OBsolete

Obsolete

REVISED APR 23 1947

PART SAFETY CAM

SEQUENCE OF OPERATIONS

OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp.)	
2	Cut to 1" Length (Temp.)	
4	Grind to Thickness (Temp.)	
	Ship Steel to Vendor for Stamping (Temp.)	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'sink Hole to Remove Burr	
14	Wash	
16	Grind Bottom of Safety Notch	
18	Grind Safety Notch	
20	Grind P. P. Ed. Surface	
22	Grind P. P. Ed. Surface	
24	Heat Treatment (Cyanide)	
26	Heat Treat Inspection	
28	Final Inspection	
	Place Part in Storage	
26	1st Temp Cyanide Hardening, Oil Quench	
28	Wash & Dry. No oil	
28	Inspect for File Hardness	
30	Nitro Draw, Water Quench, Air Cool, Wash & Dry	
	Oil for storage	
32	Inspect for Rockwell Hardness Color Pack	
34	Final Inspection	
APPROVAL & DATE:		
REMINGTON ARMS COMPANY, INC. ILION, N. Y.		

RETYPE
OBSOLETE

REVISED APR 23 1947

PART: SAFETY CAM		DATE: 5/7/45
SEQUENCE OF OPERATIONS		
OPER. NO.	OPERATION	DEPT.
	Material Procurement (Temp.)	
2	Cut to 4' Length (Temp.)	
4	Grind to Thickness (Temp.)	
	Ship Steel to Vendor for Stamping (Temp.)	
6	Purchased Part Inspection	
8	Wash	
10	Ream Pin Hole	
12	C'sink Hole to Remove Burr	
14	Wash	
16	Grind Bottom of Safety Notch	
18	Grind Safety Notch	
20	Grind F.P. Hd. Surface	
22	Finish Burr	
24	Heat Treatment (Cyanide)	
26	Heat Treat Inspection	
28	Inspect	
	Transfer to Part Stores	
COMPILED BY: J. F. Bowling		APPROVAL & DATE:
REMINGTON ARMS COMPANY, INC., ILION, N. Y.		

H. M. SULLIVAN, INC.

PART:

PART No.

17995

SEQUENCE OF OPERATIONS

OP. NO.	OPERATION	DEPT.
	Material Procurement (Temp)	
2-	Cut to 4' Length (Temp)	
4-	Grind to thickness (Temp)	
	Ship steel to Vendor for stamping (Temp)	
6-	Purchased Part Inspection	
8-	Wash	
10-	Ream Pin Hole	
12-	C-Sink Hole to Remove Burr	
14-	Wash	
16-	Grind Bottom of Safety Notch	
18-	Grind Safety Notch	
20-	Grind F.P. Hd Surface	
22-	Finish Burr	
24-	Heat Treatment (Cyanide)	MHS
26-	Heat Treat Inspection	
28-	Inspect	
	Transfer to Parts Store	

COMPILED BY:

APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SAFETY CAM

17945

MATERIAL PROCUREMENT - RAW MATERIAL

Date: 2/5/47

Detailed Description

REV. NO.	DATE
1	2/18/47
2	2/20/47
3	3/10/47

Pieces Required Per Assembly: 1

Material Specification No. : 101B

Material : AISI C-1022 or substitutes C-1020, C-1025, C-1019

Size : .084" $\pm$.002" X 3/4" $\pm$.008" X 10 to 12" lengths

Condition : Cold Finished Strip

Temper : Half Hard

Edge : ##3

Finish : #2

Weight Per 100 : Calculated - 2.14 Measured

Additional Uses of Material :

Uses of Part : M/721 Safety Cam

Identification of Material : Routing Ticket to be marked Mat. Spec. No. 101B

Remarks:

1. This material is for shipment to stamping vendor.
2. To facilitate procurement material up to 1/8" thickness can be used but will have to have operations 2 & 4 performed before shipment to vendor.

[Handwritten signature]

COMPILED BY: R.H. Grace
2/5/47

APPROVAL & DATE: *[Signature]* 2/5/47

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PART:

SAFETY CAM

17945

MATERIAL PROCUREMENT - SEMI-FINISHED COMPONENT

REMINGTON PLANNING

Pieces Required Per Assembly: 1

Uses of Part

: M/721 & 722

VENDOR

Material

: AISI 1022 or substitute
 1020, 1025, 1045, C-1019
 Packing slip to show material used
 for each shipment of parts.

Heat Treatment

: None

Final Appearance

: Commercial Stamping, Sheared Edge
 except for shaved edge as noted on
 inspection process.

Packaging

: Purchase Order Number and quantity
 of pieces to be shown on each con-
 tainer, the gross weight of which
 must not exceed 200 lbs.

Acceptance Testing:

Inspection will be based on statistical sampling according to
 Dodge and Romig Sampling Tables of Bell Telephone Company. Ship-
 ments will be accepted if the quality on each of the gages is suf-
 ficient to keep within the "Average Outgoing Quality Limit" listed
 on the Process Record Inspection Page.

Remarks:

COMPILED BY J. F. Bowling

APPROVAL & DATE

DATE:

2/20/47

REMINGTON ARMS COMPANY, INC. ILION, N. Y.

H. H. SULLIVAN, INC.

4-15-47

PART: SAFETY CAM		PART No. 15-1795			
OPERATION: PURCHASED PART INSPECTION		OPER. No. 15-1795			
PROCESS RECORD — INSPECTION					
GAUGES		USE	AQL	LIMITS	
TYPE	No.			MAX.	MIN.
J & L Comparator		Check Dim. as shown below	7%		
Compar. Fixt.					
Compar. Stage					
Compar. Screen					
Adj. Snap Gage		Check height of bump	7%	.115	.110
Plug Gage		Check Pierced Hole	7%	.123	.120
SKETCH					
COMPILED BY: J. F. Howling		APPROVAL & DATE: <i>MHS</i> <i>JAYMAN</i>			
2/21/47					
REMINGTON ARMS COMPANY, INC., ILION, N. Y.					

DISCIPLE
REVISU APP

PART: *Safety Cam*
OPERATION: *Grind To Thickness (Temp)*

PROCESS RECORD

EQUIPMENT: *12x98" MATTHEW SPENCE GRINDER*
SPEED: *515*
MAX. PROD. PER HOUR: *515*
FEED: *1/2"*
COOLANT: *Emulsion*

TOOLS & GAUGES		TOOL HOLDERS, VIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>ADJ. SNAP GAUGE</i> <i>.086 .082</i> <i>hard</i> <i>3/4"</i>	<i>B-80138-W</i>	<i>Lathe</i>	

SKETCH

.086
.082 MHS

COMPILED BY: *Born 1/1/66* APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N.Y.

RECEIVED APR 1 1947

SAFETY CAN		OPERATION		PURCHASED PART INSPECTION	
PROCESS RECORD		INSPECTION			
TYPE OF GAUGES		USE	NO.	LIMITS	
TYPE OF GAUGES		USE	NO.	MAX.	MIN.
J & L Comparator		Check Dim. as shown below			
Compar. Fixt.	C-53230				
Compar. Screen	C-53232				
1.1 Micrometer	578	Check height of bump		115	110
Plug Gage 1/20-1/32	B-50064N	Check Pierced Hole		115	120
SKETCH					
COMPILED BY J. P. HOWLAND		APPROVAL & DATE			
2/21/47		MHS			
REMINGTON ARMS COMPANY, INC. ILION, N. Y.					

ABSOLUTE
REVISED 1944

OPERATION: <i>Safety Pin</i>		PART NO. <i>7775</i>	
OPERATION: <i>Pearl Run Hole</i>		OPER. NO. <i>18</i>	
PROCESS RECORD			
EQUIPMENT: <i>Selandifford Drill Press</i>			
SPEED: <i>600</i>		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT: <i>Lincoln or Hot Oil</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Reamer</i>	<i>B-90079L</i>	<i>Lig</i>	<i>B-53234</i>
<i>Plug Gage</i> <i>1267-1259</i>	<i>B-80106-M</i>		
SKETCH			
COMPILED BY: <i>Bowling</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

MHS

COLETT
REVIEW

PART: <u>SEAR</u> <i>Left Cam</i>		PART NO. <u>113</u>	
OPERATION: <u>C'SINK TO REMOVE BURRS</u>		OPER. NO. <u>112</u>	
PROCESS RECORD			
EQUIPMENT: <u>#1 Leland-Gifford Drill Press</u>			
SPEED: <u>1800</u>		FEED: <u>Hand</u>	
MAX. PROD. PER HOUR:		COOLANT: <u>None</u>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
Drill - 3/16" 90° pt.	B-90144W	Hold in Hand to burr both sides. Slight sink is desirable	
SKETCH			
COMPILED BY: <u>J. F. Bowling</u> <u>1/9/47</u>		APPROVAL & DATE: <u>MFA 1/10/47</u> <u>1/14/47</u>	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

MHS

ABSOLUTE
REVISED

Part No. *10045*

OPERATION: *Grind Bottom of Safety Surface* Order No. *1/1*

PROCESS RECORD

EQUIPMENT: *#2 B75 Surface Grinder*
SPEED: *Hand*
MAX. PROD. PER HOUR: *None*
FEED: *Hand*
COOLANT: *None*

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Dial Gauge</i>	<i>C-53239</i>	<i>Fixture</i>	<i>C-53250</i>
<i>1" Wheel</i>	<i>Std</i>		

SKETCH

Grind to 1/2" at a time



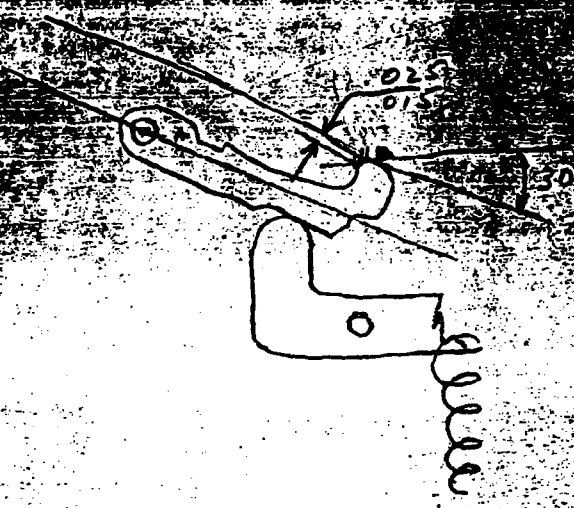
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MHS

COMPILED BY: *BOWLING* APPROVAL & DATE:

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

DESOLETE
REVIEW

PART: <i>Safety Alarm</i>		DATE: <i>7/7/51</i>	
OPERATION: <i>Grinds Safety Notch</i>		CUT: <i>0.8</i>	
PROCESS RECORD			
EQUIPMENT: <i>#2 B. & S. Surface Grinder</i>			
SPEED:		FEED: <i>Hand</i>	
MAX. PROD. PER HOUR:		COOLANT: <i>None</i>	
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>1" Wheel</i>	<i>Std</i>	<i>Fixture</i>	<i>C-53250</i>
<i>Dial Gauge</i>	<i>C-52894</i>		
SKETCH			
			
COMPILED BY: <i>BOWLING</i>		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			

OPPOSITE
REVIEW APR 1 1941

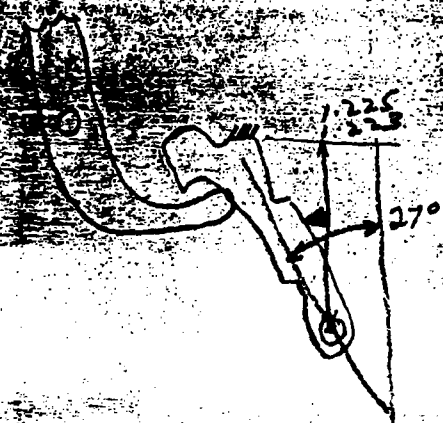
PART: <i>Safety Cam</i>	DATE: <i>7/5</i>
OPERATION: <i>Grind Firing Pin Hd. Surface</i>	OPER. NO.: <i>25</i>

PROCESS RECORD

EQUIPMENT: <i>#2 B+S Surface Grinder</i>	FEED: <i>Hand</i>
SPEED:	COOLANT: <i>None</i>
MAX. PROD. PER HOUR:	

TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>Hand Wheel</i>	<i>Std</i>	<i>Fixture</i>	<i>10</i>
<i>Dial Gauge</i>	<i>AU C-53239</i>		<i>C-53250</i>

SKETCH

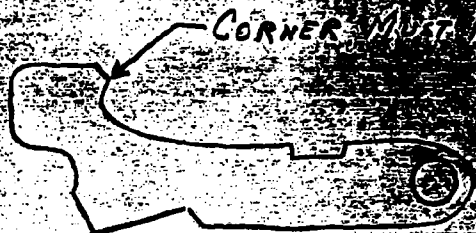


MHS

COMPILED BY: <i>Bousling</i>	APPROVAL & DATE:
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REMINGTON ARMS COMPANY, INC., ILION, N. Y.

DISCONTINUED
 REVISED APR 1944

PART: <i>Safety Cam</i>		DATE: <i>RDY</i>											
OPERATION: <i>Finish Bore slides Safety Notch Firing Pin Rod surface</i>		OPER. NO.: <i>22</i>											
PROCESS RECORD													
EQUIPMENT: _____ SPEED: _____ FEED: _____ MAX. PROD. PER HOUR: _____ COOLANT: _____													
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES											
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SKETCH  MHS													
COMPILED BY: <i>Bowling</i>		APPROVAL & DATE: _____											
REMINGTON ARMS COMPANY, INC., ILION, N.Y.													

ORSONITE
REV. 11-19-41

OPERATION: <i>Harden</i>		DATE: <i>11/14</i>	
PROCESS RECORD			
EQUIPMENT:		FEED:	
SPEED:		COOLANT:	
MAX. PROD. PER HOUR:			
TOOLS & GAUGES		TOOL HOLDERS, JIGS & FIXTURES	
TYPE	No.	TYPE	No.
<i>See Hardener</i> <i>Page for</i>		<i>See</i>	
<i>Sketch</i> <i>type up</i>		<i>according to</i>	
<i>also Heat treat</i>			
COMPILED BY:		APPROVAL & DATE:	
REMINGTON ARMS COMPANY, INC. ILION, N. Y.			

MHS