

SEQUENCE OF OPERATIONS

OP. No.	OPERATION	DEPT.	OPERATION	DEPT.
1.	CHECK FOR SAFETY CLEARANCE IN STOCK.			
2.	VERIFY CORRECT SEAR LIFT WITH DIAL GAGE.			
3.	PERFORM TRICK TEST (TO NEXT INSPECTION STATION)			
4.	CHECK FOR TIGHT BEDDINGS TO START AT REAR TANG.			
5.	STAMP "O" ON ALL GUNS PASSING PROCESS.			
6.	CONTINUE WITH STANDARD ARMS SERVICE PRACTICE.			
7.	PACK WITH NEW INSTRUCTION FOLDER.			

11" - 11"

DATES AND REASONS FOR REVISIONS

DATES AND REASONS FOR REVISIONS

1/8/79 - NEW 2-8-79 REVISED

MODEL XP-100

PART NAME

Arms Service Final Inspection

PAGE

1

OF

GA. OR CAL.

PART NO.

(RECALL ONLY)

ES AND REA. NO FOR REVISIONS 1/31/79 - NEW

CRITICAL INFORMATION

EQUIPMENT-TOOLS & GAGES

^{ADDITIONAL}
NOTE: ALL ARMS SERVICE STANDARD PRACTICES
TO BE FOLLOWED AS USUAL.

1. PICK PISTOL.
2. DO TRICK TEST

ELEMENTS FOR TRICK TEST

- I. COCK PISTOL
- II MOVE SAFETY LEVER TO "ON SAFE"
POSITION.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE. (FINAL INSPECTION)							
	PART No.						
	GA.						

T NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 3
MACH. HRS. _____ DEPT. No. _____ PAGE 1 OF 9

TEST AND REPAIR FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

ELEMENTS FOR TRICK TEST CONT.

II CONT.

- THERE MUST BE NO BIND.
- THERE MUST BE A GOOD SHARP SINGLE DETENT.
- IN THE "ON SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRINGS BACK", FROM THE FULLEST REARWARD AND FORWARD POSITION.

III. PULL TRIGGER

- THERE MUST BE NO CLICK OR CATCH IN PULL.
- FIRING PIN MUST NOT FALL.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE (FINAL INSPECTION)							
	PART No.						
	GA.						

HT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 3
 IF _____ MACH. HRS. _____ DEPT. No. _____ PAGE 2 OF 2

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KINZER V. REMINGTON

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PROCESS RECORDS ASSEMBLY SHEETS

TEST AND REAS

FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

IV RELEASE TRIGGER SLOWLY.

- TRIGGER MUST MOVE TO FULL FORWARD POSITION WHEN RELEASED.

V MOVE SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.

VI RECOCK PISTOL.

VII MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TO THE FORWARD MOST NULL LOCATION.

(TWO FINGERS MAY BE NECESSARY TO POSITION SAFETY)

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE (FINAL INSPECTION)							
	PART No.						
	GA.						

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIMEMODEL No. XP-100OPER. No. 3

MACH. HRS.

DEPT. No.

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ES AND REASO FOR REVISIONS 1/31/79 - NEW

CRPTIVE INFORMATION TRICK TEST CONF. EQUIPMENT - TOOLS & GAGES

* NOTE: FORWARD MOST MILL LOCATION - IS THAT "JUST STABLE" PLACE, BETWEEN "ON" AND "OFF" SAFE, - CLOSEST TO "OFF SAFE"; - WHERE THE SAFETY LEVER WILL NOT SPRING FORWARD TO THE "OFF SAFE" POSITION WHEN RELEASED.

WILL PULL TRIGGER HARD AND UPWARD.

• THERE MUST BE NO CLICK OR CATCH IN PULL.

OPERATION DESCRIPTION	OCC. No.	STD. HRS/C	STD. No.	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE (FINAL INSPECTION)										
	PART No.									
	QA.									

WASH - 6411E/

DESCRIPTIVE INFORMATION

TRICK TEST CONT.

W. RELEASE TRIGGER SOWBY.

- TRIGGER MUST NOT CLUD AND MUST RETURN TO ^{ALL} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

8 PUSH SAFETY LEVER TO 'OFF SAFE' POSITION.

- FIRING PIN MUST NOT FALL
- SAFETY LEVER MUST SPRING TO 'OFF SAFE' POSITION BY ITSELF WHEN RUSHED FROM THE NULL LOCATION

EQUIPMENT—TOOLS & TOOLS

OPERATION DESCRIPTION	OCC. No.	STD. HRS/C	STD. No.	EFF. DATE	PART No.	QA.
ARMS SERVICE RECALL						
REPAIR PROCEDURE						
(FINAL INSPECTION)						

**GET UP
TIME**

COOLANT-

RT NAME FINAL ASSEMBLY

MODEL No. XP-100

OPER. No.:

NAME _____ MACH. HRS. _____ DEPT. No. _____ PAGE 5 OF 9

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/31/79 - NEW

DESCRIPTIVE INFORMATION

TRICK TEST CONT.

I. CONT.

- IN THE "OFF SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRINGS BACK," FROM THE FULLEST FORWARD AND REARWARD POSITION.

II. PULL TRIGGER.

- FIRING PIN MUST FALL

III. OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK.

- FIRING PIN MUST NOT FALL.

IV. REPEAT STEPS 7 thru 12.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

 OCC. No.
 STD. HRS/C
 STD. No.
 EFF. DATE

 ARMS SERVICE REPAIR
 REPAIR PROCEDURE
 (FINAL INSPECTION)

 PART No.
 GA.

 PART NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 3
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EQUIPMENT—TOOLS & GADGETS

FOR THE THIRD AND LAST TRIAL -

WIN MORE SAFETY TO 'ON SAFE' POSITION.

XV
FROM THE "ON SAFE" POSITION, MOVE
THE SAFETY LEVER TO THE FORWARD
MOST NULL LOCATION (PRECIOUSLY DEFINED)

XIII PULL TRIGGER BACK AND UPWARD.

XVII RELEASE TRIGGER SPOOKY.

- THERE MUST BE NO CLIP OR GATCH IN PULL

PART NAME FAIRHURST ASSEMBLY COOLANT _____
 SET UP TIME _____ MODEL No. SP-100 OPER. No. 3
 MACH. HRS. _____ DEPT. No. _____ PAGE 2 OF 9

TEST AND REVISIONS FOR REVISIONS 1/31/79 - NEW

SCRIPTIVE INFORMATION | EQUIPMENT - TOOLS & GAGES

1. CHECK TEST CONF.

XIII CONF.

- TRIGGER MUST HIT AND AND MUST RETURN TO ^{FALL} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

XIV. PUSH SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY MUST SPRING TO "OFF SAFE" POSITION ON ITSELF WHEN PUSHED FROM THE NULL LOCATION.
- IN THE "OFF SAFE" POSITION, THE SAFETY LEVER MUST HAVE AN OBSERVABLE

OPERATION DESCRIPTION	OCC. No.	STD. HRS/G	STD. No.	EFF. DATE				
ARMS SERVICE RECALL REPAIR PROCEDURE (FINAL INSPECTION)	PART No.							
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CRIMINATIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

TRICK TEST CONF.

xiii cont.

- SPENDS BACK, FROM THE FULLEST FORWARD AND REVERSE POSITION.

REV. CALL TRACK

- FIREARMS MUST FALL:

~~XX~~ OPEN ACTION AND CLOSE BUT FIRMLY
TO RE-COOK.

- FIRING ON MUST NOT FALL.

TRUCK TEST COMPLETE.

[illegible]

ITEM NAME FLUAL ASSEMBLY COOLANT

GET UP

MODEL NO. XP-100

OPER. NO.:

31

MACH. HR8...

DEPT. No.:

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PROCESS RECORDS ASSEMBLY SHEETS

REASON FOR REVISIONS 1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

NOTE: ALL ADDITIONAL ARMS SERVICE STANDARD
PRACTICES TO BE FOLLOWED AS USUAL.

1. PICK PISTOL.
2. DO TRICK TEST 100% - PERMANENTLY RECORD RESULTS.

ELEMENTS FOR TRICK TESTI. COCK PISTOLII. MOVE SAFETY LEVER TO "ON SAFE"
POSITION.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/G						
	STD. No.						
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ARMS SERVICE RECALL REPAIR PROCEDURE.							
	PART No.						
	GA.						

T NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

TESTS AND REAS

FOR REVISIONS

1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

ELEMENTS FOR TRICK TEST CONT.

II CONT.

- THERE MUST BE NO BIND.
- THERE MUST BE A GOOD SHARP SINGLE DETENT.
- IN THE "ON SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRINGS BACK", FROM THE FULLEST REARWARD AND FORWARD POSITION.

III. PULL TRIGGER

- THERE MUST BE NO CLICK OR CATCH IN PULL.
- FIRING PIN MUST NOT FALL.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	QA.						

RT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

YES AND REAS

FOR REVISIONS

1/31/79 - NEW

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EQUIPMENT - TOOLS & GAGES

IV RELEASE TRIGGER SLOWLY.

- TRIGGER MUST MOVE TO FULL FORWARD POSITION WHEN RELEASED.

II MOVE SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.

VI RE-COCK PISTOL.III MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TO THE FORWARD MOST NULL LOCATION.

(TWO FINGERS MAY BE NECESSARY TO POSITION SAFETY)

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RI NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No.

XP-100

OPER. No.

PE

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TRICK TEST CONF.

* NOTE: FORWARD MOST NULL LOCATION -

IS THAT "JUST STABLE" PLACE, BETWEEN
 "ON" AND "OFF" SAFE, - CLOSEST TO
 "OFF SAFE", - WHERE THE SAFETY
 LEVER WILL NOT SPRING FORWARD TO
 THE "OFF SAFE" POSITION WHEN
 RELEASED.

PULL TRIGGER HARD AND UPWARD.

• THERE MUST BE NO CLICK OR
 CATCH IN PULL.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
 REPAIR PROCEDURE

PART No.

GA.

IT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIMEMODEL No. XP-100

OPER. No.

E

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MACHINE

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TES AND REASC FOR REVISIONS 1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

IV. RELEASE TRIGGER SLOWLY.

- TRIGGER MUST NOT BIND AND MUST RETURN TO ^{FULL} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

V. PUSH SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY LEVER MUST SPRING TO "OFF SAFE" POSITION BY ITSELF WHEN PUSHED FROM THE FULL LOCATION

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

TEST AND REAS

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1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

IX. CONT.

- IN THE "OFF SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRING BACK," FROM THE FULLEST FORWARD AND REARWARD POSITION.

XI. DULL TRIGGER.

- FIRING PIN MUST FALL.

XII. OPEN ACTION AND CLOSE BOLT FIRING TO RE-COCK.

- FIRING PIN MUST NOT FALL.

XIII. REPEAT STEPS 7 thru 12.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
 PE _____ MACH. HRS. _____ DEPT. No. _____ PAGE 6 OF 24

MACHINE

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PROCESS RECORDS ASSEMBLY SHEETS

TESTS AND REAS

FOR REVISIONS

1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

FOR THE THIRD AND LAST TRIAL -XIV MOVE SAFETY TO "ON SAFE" POSITION.XV FROM THE "ON SAFE" POSITION, MOVE
THE SAFETY LEVER TO THE FORWARD
MOST NULL LOCATION. (PREVIOUSLY DEFINED.)XVI PULL TRIGGER HARD AND UPWARD.XVII RELEASE TRIGGER SLOWLY.

• THERE MUST BE NO CLICK OR CATCH IN PULL

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

PART NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

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1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

XVII CONT.

- TRIGGER MUST NOT BIND AND MUST RETURN TO ^{FALL} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

XVIII. PUSH SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY MUST SPRING TO "OFF SAFE" POSITION BY ITSELF WHEN PUSHED FROM THE NULL LOCATION.
- IN THE "OFF SAFE" POSITION, THE SAFETY LEVER MUST HAVE AN OBSERVABLE

OPERATION DESCRIPTION	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
ARMS SERVICE RECALL REPAIR PROCEDURE						
	PART No.					
	GA.					

RT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

ES AND REASC FOR REVISIONS 1/31/79-NEW

SCRIPTIVE INFORMATION

TRICK TEST CONT.

XIII CONT.

- "SPRINGS BACK," FROM THE FULLEST FORWARD AND REARWARD POSITION.

XIV PULL TRIGGER

- FIRING PIN MUST FALL.

XV OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK.

- FIRING PIN MUST NOT FALL.

TRICK TEST COMPLETE.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	QCC. No.						
	STD. HRS/C						
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ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	QA.						

IT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

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SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

3. REMOVE BOLT ASSEMBLY FROM GUN.
4. REMOVE STOCK ASSEMBLY FROM ACTION.
5. REMOVE: SAFETY SWAP WASHER
SAFETY DETENT SPRING
SAFETY DETENT BALL
SAFETY PIVOT PIN
SAFETY ASSEMBLY
6. DRIVE OUT THE TWO (2) SEAR PINS AT
REAR OF RECEIVER TANG.
7. DROP SEAR HOUSING DOWN FROM RECEIVER SLOT.

OPERATION DESCRIPTION	OCC. No.						
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CUSTOMER SERVICE RECALL REPAIR PROCEDURE.							
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	GA.						

IT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

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CRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

8. DRIVE OUT TRIGGER PIN FROM TRIGGER HOUSING ASSEMBLY AND REMOVE SEAR HOUSING ASSEMBLY.
9. PUT REMOVED SEAR HOUSING ASSEMBLY INTO LABELED CONTAINER FOR FURTHER DISPENSATION.
10. PICK NEW SEAR HOUSING ASSEMBLY.
11. POSITION SEAR HOUSING ASSEMBLY INTO RECEIVER.
12. PICK SEAR PIN AND START, CHAMFERED END FIRST. DRIVE REAR PIN FIRST,

OPERATION DESCRIPTION	OCC. No.						
ARMS SERVICE RECALL REPAIR PROCEDURE	STD. HRS/C						
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IT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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FOR REVISIONS

1/31/79 NEW

SCRIPTIVE INFORMATION

EQUIPMENT-TOOLS & GAGES

12. CONT.

TO JUST ABOVE FLUSH WITH INSIDE OF
BOLT STOP SLOT. (TO CLEAR SAFETY ASSEMBLY
ON OPPOSITE SIDE).

DRIVE FRONT PIN SLIGHTLY BELOW FLUSH
WITH BOLT STOP SLOT.

- BOLT STOP MUST BE FREE TO ROTATE.

13. STAKE RECEIVER BELOW BOTH PINS.

14. INSERT TRIGGER INTO TRIGGER HOUSING AND
ALIGN HOLES.

15. PICK TRIGGER PIN.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
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ARM SERVICE RECALL REPAIR PROCEDURE							
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	GA.						

RT NAME FUAL ASSEMBLY COOLANT _____ SET UP _____ MODEL No. XP-100 OPER. No. _____
 MACH. HRS. _____ DEPT. No. _____ PAGE 12 OF 24
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PROCESS RECORDS/ASSEMBLY SHEETS

TES AND REAS/

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1/31/79 - KEN

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

16. POSITION AND DRIVE PIN THROUGH TRIGGER SO THAT PIN IS FLUSH WITH OUTSIDE OF TRIGGER HOUSING.

- TRIGGER MUST NOT BIND IN HOUSING - MUST RETURN FULLY FORWARD.

17. STAKE BOTH SIDES OF TRIGGER HOUSING TO RETAIN PIN.

- PULL TRIGGER AND RELEASE SLOWLY.

- TRIGGER MUST NOT BIND IN HOUSING - MUST RETURN FULLY FORWARD.

18. INSERT BOLT ASSEMBLY - COCK ACTION.

19. ADJUST SEAR SAFETY CAIK - SEAR BLOCK ENGAGEMENT.

OPERATION DESCRIPTION	OCC. No.						
ARMS SERVICE RECALL REPAIR PROCEDURE	STD. HRS/C						
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RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No.

XP-120

OPER. No.

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MACHINE

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1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

19. CONT.

- TURN TRIGGER ADJUSTING SCREW UNTIL
FIRING PIN "JUST" FALLS.
 - BACK OUT TRIGGER ADJUSTING SCREW
1 1/4 TURNS.
 - THIS PRODUCES .020 ENGAGEMENT.
 - VISUALLY CHECK FOR CORRECT ENGAGEMENT.
20. ADJUST SEAR BLOCK OVERTRAVEL.
- RE-DOCK ACTION.
 - TURN SEAR BLOCK STOP SCREW CLOCKWISE
UNTIL GUN WILL NOT FIRE.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

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ARMS SERVICE RECALL
REPAIR PROCEDURE

ITEM NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MACH. HRS

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PROCESS RECORDS ASSEMBLY SHEETS

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1/31/77 - NEW

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EQUIPMENT - TOOLS & GAGES

20. CONT.

- HOLD TRIGGER BACK AND TURN SEAR BLOCK STOP SCREW COUNTER-CLOCKWISE UNTIL FIRING PIN "JUST" FALLS.
- TURN SCREW ANOTHER 1/16 OF A TURN.
- THIS PRODUCES APPROX. .005 OVERTRAVEL BETWEEN SEAR SAFETY CAM AND SEAR BLOCK AFTER DISENGAGEMENT.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE REGAL REPAIR PROCEDURE.							
	PART No.						
	GA.						

T NAME FULL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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PROCESS RECORDS ASSEMBLY SHEETS

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21. SEAL TRIGGER ADJUSTING SCREW
AND SEAR BLOCK STOP SCREW.

22 LUBRICATE SEAR HOUSING AT DETENT INTERSECTIONS,
AND REASSEMBLE: (ALL NEW PARTS)

SAFETY ASSEMBLY - LUBRICATE CAM SURFACE

SAFETY PIVOT PIN

SAFETY DETENT BALL

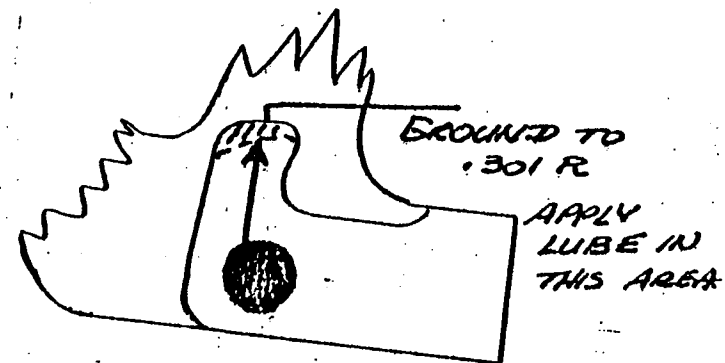
SAFETY DETENT SPRING

SAFETY SNAP WASHER - ROUNDED SIDE TO BE
TOWARD SAFETY
DETENT SPRING

• SAFETY SNAP WASHER MUST BE

EQUIPMENT - TOOLS & GAGES

MOLYNTE TYPE 'C' OR 'BN' PASTE.



OPERATION DESCRIPTION

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STD. No.

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EQUIPMENT-TOOLS & GAGES

22 CONT.

COMPLETELY CONTAINED WITHIN PILOT
PIN GROOVE.

- THE RAISED END OF DIMPLE ON SAFETY
DETENT SPRING MUST BE AT THE
LEFT END OF THE OPENING AT THE
CLOSED END OF SAFETY SOAP WASHER.

23. FUNCTION CHECK SAFETY ASSEMBLY.

- SAFETY SHOULD SOAP FREELY FORWARD AND REVERSE
- THERE MUST BE GOOD SHARP DETENTS IN
BOTH POSITIONS.

24. TRY SHIM TEST.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

ART NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
 YPE _____ MACH. HRS. _____ DEPT. No. _____ PAGE 17 OF 24

MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

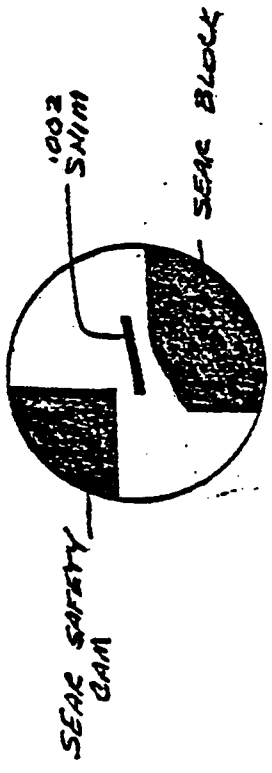
R2531256

FOR REVISIONS 12/3/79-NEW

DESCRIPTIVE INFORMATION

SHIM TEST

I PUT SAFETY LEVER TO "ON SAFE" POSITION.
II INSERT .002 SHIM FULLY INTO CHEN HOLE,
LEFT SIDE OF SEAR HOUSING.
• SHIM MUST BE BETWEEN SEAR SAFETY CAM
AND SEAR BLOCK.



EQUIPMENT - TOOLS & GAGES

.002 SHIM STOCK
NOTE: WORK, BURIED OR
DAMAGED SHIM WILL
BIND AND GIVE A
FALSE READING. REPLACE
SHIM FREQUENTLY. SHIM
MUST BE NARROW ENOUGH
TO PASS THRU CHEN
HOLE IN SEAR HOUSING.

OPERATION DESCRIPTION	OCC. No.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														</
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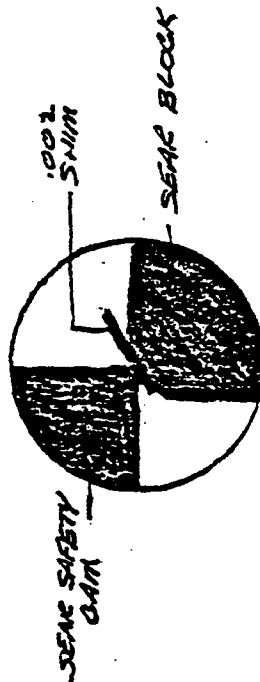
DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TO MOVE SAFETY LEVER TO "OFF SAFE" POSITION.
SLIGHTLY PULL ON SHIM WITH THUMB
AND FINGER.

• SHIM MUST REMAIN TRAPPED BETWEEN
SEAR SAFETY CAM AND SEAR BLOCK.

• IF SHIM IS FREE - RETURN TO ELEMENT #2.



OPERATION DESCRIPTION

ARMS SERVICE RECALL
REPAIR PROCEDURE

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MACH. HRS.

MODEL No. SP-100

DEPT. No.

OPER. No.

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CRYPTIVE INFORMATION

1. MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TOWARD "ON SAFE" POSITION, TO LOCATE AND STOP SAFETY LEVER AT THE FORWARD MOST NULL LOCATION.*

- IF NULL LOCATION IS PASSED (TOO FAR TOWARD "ON SAFE"), THEN RETURN TO "OFF SAFE" POSITION, AND APPROACH NULL LOCATION FROM THE "OFF SAFE" POSITION AGAIN.

* FORWARD MOST NULL LOCATION - IS THAT "JUST-STABLE" PLACE BETWEEN "ON" AND "OFF" SAFE - CLOSEST TO "OFF SAFE" - WHERE THE SAFETY LEVER WILL NOT SPRING FORWARD TO THE "OFF SAFE" POSITION WHEN RELEASED.

OPERATION DESCRIPTION	OCC. No.			PART No. GA.
	STD. HRS/C	STD. No.	EFF. DATE	
ARMS SERVICE RECALL REPAIR PROCEDURE				

CRITICAL INFORMATION

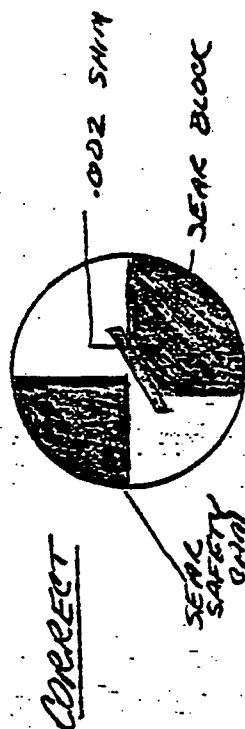
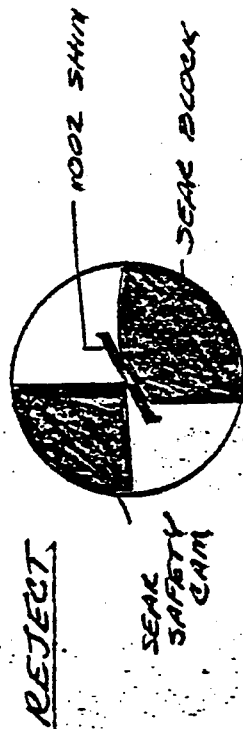
PULL WITH THE SAFETY LEVER IN THE FORWARD MOST FULL LOCATION, LIGHTLY PULL ON SHIM WITH THUMB AND FINGER.

- IF SHIM BIRDS OR HANGS UP
BETWEEN SEAR SAFETY CAN AND
SEAR BLOCK -

REFLECT AND REWORK.

REPLACE COMPLETE SEAR HOUSING ASSEMBLY
(ELEMENTS 4 & 5 ON)

- IF SKIN REMOVES FREELY, CLEARENCE IS CORRECT.

[illegible]

SET NAME FINAL ASSEMBLY COOLANT _____ SET UP _____
 TIME _____ MODEL NO. XP-100 OPER. NO. _____
 MACH. HRS. _____ DEPT. NO. _____ PAGE 21 OF 24

FOR REVISIONS

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

25. TRY TRICK TEST (PREVIOUSLY DEFINED -
PAGES #1 THRU #9.)

- IF ACTION FAILS TRUCK TEST - REPAIR BY REPLACING COMPLETE SEAR HOUSING ASSEMBLY. (ELEMENTS A3 ON)

26 PICK ORIGINAL STOCK ASSEMBLY

21. ROUTE STOCK OUT AT SAFETY CLEARANCE CUTS

- THERE SHOULD BE NO BUCKS AT ROUTED CUTS. - SQUARE IF NECESSARY.
- CLEAN STOCK WITH COMPRESSED AIR TO REMOVE ANY LOOSE BUCKS INSIDE STOCK.

[illegible]

PART NAME FWAL ASSEMBLY COOLANT-

ANALYST

MODEL NO. XP-100

OPER. NO.

3.

MACH. HRS.

DEPT. No.

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PROCESS RECORDS / ASSEMBLY SHEETS

ITEMS AND REAS

FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

28. RESTOCK ACTION.

29 CHECK FOR SAFETY CLEARANCE IN STOCK

- SAFETY SHOULD SNAP FREELY FORWARD AND REARWARD WITH NO BIND.

30. CHECK FOR TRIGGER CLEARANCE IN TRIGGER GUARD.

- TRIGGER MUST NOT TOUCH TRIGGER GUARD AT ANY POINT.

31. TRY TRICK TEST. (PREVIOUSLY DEFINED - PAGES #1 THRU #9)

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE

PART No.

GA.

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No.

OPER. No.

PE

MACH. HRS.

DEPT. No.

PAGE

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2531262

REASON

FOR REVISIONS

4/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

32. CONTINUE WITH STANDARD PRACTICE.

33. SEND TO GALLERY FOR FUNCTION TESTING.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE

PART No.

GA.

ITEM NAME FINAL ASSEMBLY COOLANTSET UP
TIME

MODEL No.

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 24 OF 24

MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2531263

SEQUENCE OF OPERATIONS

OP. No.	OPERATION	DEPT.	OP. No.	OPERATION	DEPT.
	Draw the Components shown on Oper. #575 On Crib #29		625	Assemble Stock to Action	15
575	Final Assembly	15	630	Final Inspection	15
603	Proof, Test, Test and Target	85	632	Print Box and Label	55
603J	Proof Test, Test and Target - Rejected Guns	85	633	Match Label to Gun and Place Label in Plastic Envelope	55
605	Inspect for Live Ammunition	85	635	Inspect for Live Ammunition and Oil Metal Parts, Assemble Packing Material and Pack Pistol.	55
			640R	Re-Pack	55
		55			
			645R	Strip Defective Barrel and Receiver Assemblies.	15
		55			
			650R	Repair Fire Controls	15
620	Adjust Sear Housing Assembly on Comparator, 100%	15	655R	Strip Defective Bolts (To Warehouse)	15
DATES AND REASONS FOR REVISIONS 9/29/80-New-MRP-RLJ-279162			DATES AND REASONS FOR REVISIONS		
3/20/81 - Remove Op. #610 & 615 & Added 632 & 633			- RLS - 280276		
MODEL	XP-100	PART NAME	Final Pistol Assembly		
		GA. OR CAL.	221	7 MM BR	
		PART No.	925470	925471	

SEQUENCE OPERATIONS

OP. No.	OPERATION	DEPT.	OP. No.	OPERATION	DEPT.
30	FOR TRIGGER HOUSING ASSEMBLY DRAW THE PARTS SHOWN:		15		
	Trigger Housing Ass'y. 221 & 7MM BR	16876			
	Trigger Housing	15473			
	Trigger Housing Screw Front	15469			
	Coat threads of Trigger Housing Screw and install.				
TO FINAL ASSEMBLY - CRIB #29					
DATES AND REASONS FOR REVISIONS			DATES AND REASONS FOR REVISIONS		
9/29/80 - New - RLJ - 279133					
MODEL XP-100		PART NAME	Trigger Housing Assembly		PAGE 1 OF 1
		GA. OR CAL.	221.7MM BR		
		PART No.	16876		

RD 6400

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2531265

[illegible]

PROCESS RECORD & ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 New - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

NOTE: Unless otherwise stated - All relative directions, (up, down, clockwise, etc.) are from shooter's point of view, with gun held in normal firing position.

Action
1. Pick Barreled ~~W/4/4/4/4~~ and Inspect:

- Good uniform black color
- No mars or scratches
- Proper roll marks
- Legible, uniform serial number
- Bore must be concentric to muzzle

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
				* NOTE: For 7MM BR, AMAC 925471, See Sheet 37 of this Operation			
	PART No.	925470	925471*				
	GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 2 OF 37
 MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - BL9100279162

DESCRIPTIVE INFORMATION

2. Clamp in Vise.
3. Assemble three (3) Receiver Plug Screws into Receiver.
 - Edge of screws must be flush to Receiver (925470, 221, Only)
4. Pick Bolt Stop Spring. Place one end of spring into detent in bottom of bolt stop slot.
5. Pick Bolt Stop and Inspect:
 - Black Color
 - Free of burrs

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 3 OF 37
 MACHINE _____

PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9729780 - Updated - MRP - HLC - 279162

DESCRIPTIVE INFORMATION

6. Insert Bolt Stop into Receiver slot, fitting Bolt Stop Spring into slot in rear of Bolt Stop.
7. Pick Bolt Stop pin, Position and drive into Receiver from left to right:
 - End of pin must be just above flush with Bolt Stop.
 - Opposite end of pin must not protrude into Sear Housing slot.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 4 OF 37
MACHINE

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/21/79 - Added file - WAW - 277931

9/29/80 - New - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Push upward on rear end of Bolt Stop and release slowly;

- Bolt Stop must rotate freely and return fully,

File Receiver slot if necessary,

Repeat but release quickly under spring tension;

- Bolt Stop Spring must remain in place,

9. Pick Trigger Housing and inspect:

- Black color
- No burrs or damage to inside surfaces which could interfere with proper Trigger rotation,

If Trigger Housing is slightly closed in, spread with special holding plug, to align holes with Barrel Bracket holes.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS DEPT. No. 15 PAGE 5 OF 37
MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/21/79 - Added tool number - WAW - 277931

9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

10. Assemble Trigger Housing to Barrel Bracket with two (2) Trigger Housing Screws;

- Trigger Housing ears must be flush to bottom and both sides of Barrel Bracket.

Reject for serious mismatch.

EQUIPMENT - TOOLS & GAGES

Special Holding Plug or B-86362

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
 TYPE MACH. HRS. 15 DEPT. No. PAGE 6 OF 37
 MACHINE

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Remove item 11 - transfered to oper. 103 - WAW - 277931
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

~~ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE.~~

~~PLANNING AND DEVELOPMENT OF THE
NATION'S COMPOUNDING~~

EQUIPMENT - TOOLS & GAGES

12. Pick Sear Housing Assembly and inspect :

- Swaged end of Trigger Link Pin must be flush or below right side surface of Link on Sear Housing end.
- Ears of Link must be straight.

OPERATION DESCRIPTION		OCC. No.					
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP _____ MODEL No. XP-100 OPER. No. 575
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 7 OF 37
MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - HLCJ - 279162

DESCRIPTIVE INFORMATION

12. Cont.
 - Link and Sear Block Assembly must move freely in housing.
 - Trigger must rotate freely.
13. Insert Sear Housing into Receiver and align Sear Pin holes of Receiver and Housing.
14. Pick Sear Pin and start, chamfered end first. Drive rear pin first, left to right, to just above flush with inside surface of Bolt Stop Slot (To clear Safety Assembly on opposite side.)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 8 OF 37
MACHINE _____

PROCESS RECORD- ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

Drive front pin, chamfered and flat, left to right,
to slightly below flush with inside surface of Bolt Stop
Slot. (To clear Bolt Stop),

15. Push upward on rear end of Bolt Stop and release
slowly;

- Bolt Stop must rotate freely and return
fully without bind.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Assembly

OCC. No.
STD. HRS/C
STD. No.
EFF. DATE

PART No.
GA.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 9 OF 37
MACHINE

DATE	DESCRIPTION	BY
3/19/79	Revised - WAW - 277724	
5/21/79	Added Pin Punch - WAW - 277931	
9/29/80	Update - MRP - RLJ - 279162	

DATES AND REASONS FOR REVISIONS **3/19/79 - Revised - WAW - 277724**

5/21/79 - Added Pin Punch - WAW - 277931

9/29/80 - Update - MRP - RLJ - 2/9/82

EQUIPMENT -- TOOLS & GAGES

16. Pick Trigger Pin. Align Trigger hole with Trigger Housing holes,

549554 - Joint Ltd

17. Position and drive pin through, left to right:
 - End of pin must be flush to slightly below at right side of Trigger Housing.
18. Pull Trigger several times and release slowly:
 - Trigger and Link must return freely and fully.

Cont.

[illegible]

PART NAME Final Pistol Assembly COOLANT SET UP TIME 575 OPER. No. 575
TYPE MACH. HRS. 15 DEPT. No. 15 PAGE 10 OF 37

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

18. (Cont.)

Push forward on Trigger to verify Trigger has returned fully.

File and/or adjust to free Trigger if necessary.

19. Stake both sides of Trigger Housing to retain Trigger Pln.

20. Retighten Trigger Housing Screws.

21. Stake Barrel Bracket at Trigger Housing screw slots to prevent screws loosening.

EQUIPMENT - TOOLS & GAGES

Center Punch

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 11 OF 37
MACHINE

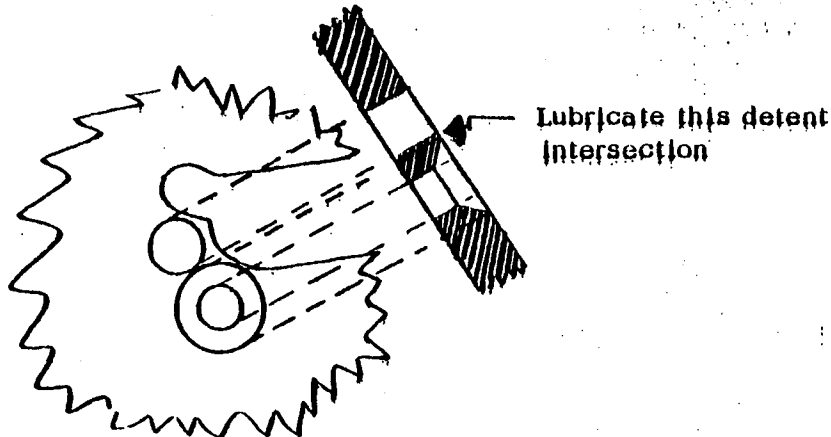
PROCESS RECORD & ASSEMBLY SHEETS

DATE AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9729780 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

22. Lubricate Sear Housing at detent holes intersection:

- Only a small amount of lubricant is required.



EQUIPMENT - TOOLS & GAGES

Moly Kote Type 'GN' Paste

OPERATION DESCRIPTION

Final Assembly

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP TIME

MODEL No. XP-100

OPER. No. 575

TYPE

MACH. HRS.

DEPT. No. 15

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MACHINE

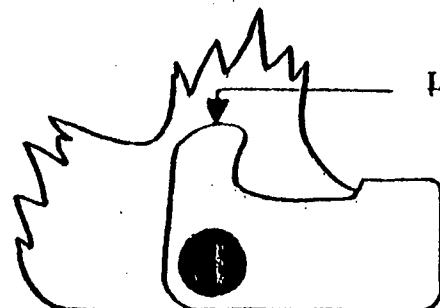
PROCESS RECORD- ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLD - 279162

DESCRIPTIVE INFORMATION

23. Lubricate cam surface of Safety Assembly:

- Only a small amount of lubricant is required.



Lubricate Cam Surface

EQUIPMENT-TOOLS & GAGES

Moly Kote Type "GN" Paste

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
MACH. HRS. DEPT. No. 15 PAGE 13 OF 37
MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

3/19/79 - Revised - WAW - 277724
 5/21/79 - Add Pin Seating - WAW - 277931
 9/29/80 - Update - MRP - 279162

DESCRIPTIVE INFORMATION

24. Assemble:

Safety Assembly

Safety Detent Ball

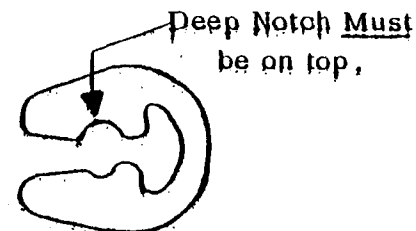
Safety Detent Spring - Visually check for correct size
 dimple

Safety Pivot Pin - Seat pin head lightly against left side of Bear Housing,

Safety Snap Washer - Side with deep notch (for Safety
 Pivot Pin) must be on top.

- Safety Snap Washer must be completely contained
 within Pivot Pin groove.

EQUIPMENT - TOOLS & GAGES



Cont.

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No. 575

TYPE

MACH. HRS.

DEPT. No. 15

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MACHINE

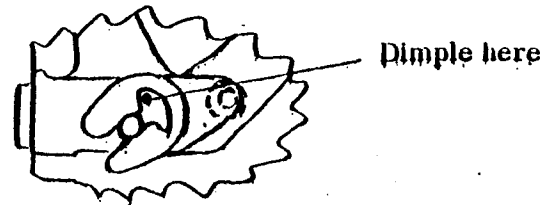
PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLO - 279182

DESCRIPTIVE INFORMATION

24. (Cont.)

- The raised end of dimple on Safety Detent Spring must be at the left of the opening, at the closed end of the Safety Snap Washer,



EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 15 OF 37
MACHINE

PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

25. Function check Safety Assembly components.

Push Safety Thumb Piece fully forward beyond detent position:

- Safety must spring return to detent position.

Push Safety Thumb Piece fully rearward beyond detent position:

- Safety must spring forward to detent position.

Move safety from "On Safe" to "Off Safe" position and back. Do this twice:

- Safety must spring forward into "Off Safe" position when pushed.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
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PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/21/79 - Correct part name - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

25. (Cont.)

- There must be no hang-up or hesitation between detent positions.
- The flat arm of the Safety Assembly must work freely. It must not bind on housing, Receiver slot, Link, Trigger Link Pin, or Bear Block Pin.

Adjust if necessary.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
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PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
 TYPE MACH. HRS. DEPT. No. 15 PAGE 17 OF 37
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PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW -277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

26. Pull Trigger several times and release slowly?
- Trigger must return freely and fully.
- Push forward on Trigger to verify Trigger has returned fully,

27. Stake left side of Receiver, below both Sear Pins, and Bolt Stop Pin.

EQUIPMENT - TOOLS & GAGES

Center Punch

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
TYPE MACH. HRS. DEPT. No. 15 PAGE 18 OF 37
MACHINE

PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Add lubrication element - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

28. Pick Ring Pin Assembly and inspect;

- Firing Pin point must not be marred,
- Bolt Plug must have good color and appearance. No marks or scratches.
- No rusty parts,
- No miscut or incorrect parts.

Lubricate Bolt Plug threads and Cocking Cam surface, before assembly into Bolt.

29. Assemble Firing Pin Assembly to Bolt and remove washer, so that Bolt Head Assembly is in fired position.

30. Check Ring Pin protrusion.

- 0.045 Min.
- 0.075 Max.

EQUIPMENT - TOOLS & GAGES

Molykote type "GN" paste

Protrusion Gage - #B-52089

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
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	GA.						

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R2531285

PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS							
3/19/79 - Revised - WAW - 277724 5/21/79 - Added cycling bolt - WAW - 277931							
11/2/79 - Increased adjustment - WAW - 278216							
9/29/80 - Update - MRP - RLJ - 279162							
DESCRIPTIVE INFORMATION							
31. Place Final Bolt Assembly into rearward (cocked) detent position. 32. Move safety to "Off Safe" position, insert Bolt into Receiver./ / / / / Open and close Bolt several times to distribute lubricant and verify smooth operation. 33. Initially adjust Sear Safety Cam - Sear Block engagement. (Before Comparator) Turn Trigger Adjusting Screw In slowly until firing pin "just" falls: • Back out Trigger Adjusting Screw / / / /² turns. (This produces / / /^{.030} engagement..) Cont.							
OPERATION DESCRIPTION		OCC. No.					
Final Assembly		STD. HRS/C					
		STD. NO.					
		EFF. DATE					
		PART No.					
		GA.					
PART NAME Final Pistol Assembly		COOLANT _____		SET UP TIME _____	MODEL No. XP-100		OPER. No. 575
TYPE _____		MACH. HRS. _____		DEPT. No. 15		PAGE 20 OF 37	
MACHINE _____							

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

33. (Cont.)

Visually check for correct engagement.

34. Initially adjust Sear Block overtravel. Re-cock action.

Turn Sear Block Stop Screw in until Firing Pin will not fall when Trigger is pulled.

Hold Trigger back and turn Sear Block Stop Screw out slowly until Firing Pin "just" falls.

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
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PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

34. (Cont.)

- Back out screw another 1/2 turn,
(This produces extra overtravel between Sear
Safety Cam and Sear Block after disengagement.)

35. Inspect for correct Sear Safety Cam - Sear Block
clearance with shim,

I. Put safety lever to "On Safe" position.

EQUIPMENT - TOOLS & GAGES

.002 tempered steel shim stock
Note: Worn, burred or damaged shim,
will bind.
Replace shim frequently. Shim must
be narrow enough to pass thru view
hole in Sear Housing.

OPERATION DESCRIPTION

Final Assembly

OCC. No.
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EFF. DATE

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GA.

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MACHINE

PROCESS RECORD- ASSEMBLY SHEETS

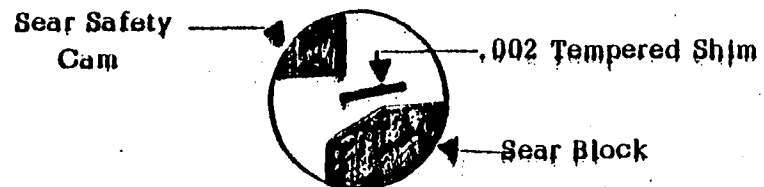
DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. (Cont.)

II. Insert .002 shim fully into view hole in left side of Sear Housing.

- Shim must be between Sear Safety Cam and Sear Block,



Cont.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD ASSEMBLY SHEETS

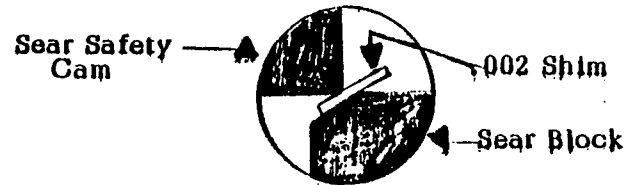
DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. (Cont.)

III. Move Safety lever to "Off Safe" position.
Lightly pull on shim with thumb and finger:

- Shim must remain trapped between Sear Safety Cam and Sear Block.
- If shim is free - return to element #2.



Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
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	EFF. DATE						
Final Assembly							
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	GA.						

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MACHINE

DATES AND REASONS FOR REVISIONS

3/19/79 - Revised - WAW - 27724

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. Cont.

IV. Move Safety Lever from "Off Safe" position toward "On Safe" position, to locate and stop Safety Lever at the forward most null location:*

- o If null location is passed (too far toward "On Safe"), then return to "Off Safe" position, and approach null location from the "Off Safe" position again.

Cont.

EQUIPMENT-TOOLS & GAGES

- * Forward Most Null Location
is that "just - stable" place between
"On" and "Off" safe, closest to "Off
Safe", where the Safety Lever will
not spring forward to the "Off Safe"
position when released.

[illegible]

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/1/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. Cont.

V. With the Safety Lever in the forward most null location, lightly pull on Shlm with thumb and finger.

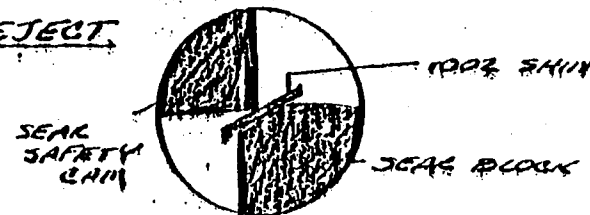
- If Shlm binds or hangs up between Sear Safety Cam and Sear Block -

Reject and rework as per process.

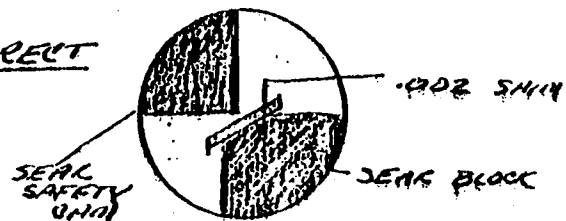
- If Shlm removes freely, clearance is correct.

EQUIPMENT - TOOLS & GAGES

REJECT



CORRECT



OPERATION DESCRIPTION

Final Assembly

OCC. No.
STD. HRS/C
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GA.

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS
9/29/80 - Updated - MRP - RLD - 2/9/82 3/19/79 - Revised - WAW - 277724

DESCRIPTIVE INFORMATION

36. Perform Trick Test,

I. Cock Pistol

II. Move Safety Lever to "On Safe" Position;

- There must be no bind.
- There must be a good sharp single detent.
- In the "On Safe" position, the Safety must have an observable "spring back", from the fullest rearward and forward positions.

III. Pull Trigger;

- There must be no click or catch in pull.
- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

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Final Assembly	STD. HRS/C						
	STD. No.						
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	GA.						

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MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW

2/21/79 - Added to element V - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

IV. Release Trigger Slowly:

- Trigger must move to full forward position when released.

V. Move Safety Lever to "Off Safe" Position:

- Firing Pin must not fall.
- Pull Trigger, Firing Pin must fall.

VI. Re-cock Pistol

Position to the Forward Most Null Location.
(Previously defined in element #35, Page 24.

Two fingers may be necessary to position Safety)

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Assembly

OCC. No.
STD. HRS/C
STD. No.
EFF. DATE

PART No.
GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No. 575

TYPE

MACH. HRS.

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MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - New - MRP - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

VIII. Pull Trigger Hard;

- There must be no click or catch in pull,

IX. Release Trigger Slowly;

- Trigger must not bind,
- Trigger must move to full forward position when released,
- Firing Pin must not fall,

X. Push Safety Lever to "Off Safe" Position?

- Firing Pin must not fall.
- Safety Lever must spring to "Off Safe" position by itself when pushed from the pull location.

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.					
	STD. HRS/C					
	STD. No.					
	EFF. DATE					
Final Assembly						
	PART NO.					
	GA.					

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MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

- In the "Off Safe" position, the Safety must have an observable "spring back" from the fullest forward and rearward position.

XI. Pull Trigger;

- Firing Pin must fall.

XII. Open action and close Bolt firmly to re-cock,

- Firing Pin must not fall.

XIII. Repeat steps 7 thru 12.

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36.(Cont.)

For the Third and Last Trial:

XIV. Move Safety to "On Safe" position,

XV. From the "On Safe" position, move the Safety Lever to the forward most null location. (Previously defined element #35, page 24.)

XVI. Pull Trigger hard,

XVII. Release Trigger slowly;

- There must be no click or catch in pull.

Cont.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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MACHINE

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

3/19/79 - Revised - WAW - 277724

5/21/79 - Revised element 37 - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

XIX. Pull Trigger;

- Firing Pin must fall.

XX. Open Action and close Bolt firmly to re-cock.

- Firing Pin must not fall.

37. Put Safe in "Off Safe" position.

Re-cock action,

Push with steady pressure on the end of Firing Pin

head. ~~XXXXXXXXXXXXXXXXXXXX~~ (Use suitable non-marring means);

- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Assembly

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

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PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

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TYPE

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PROCESS RECORD- ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

38. Check Notch Escape.

Put Safe In "Off Safe" Position
Hold Trigger Back.
Close Bolt Slowly.

- Firing Pin Must Follow Down.

39. Use dummy cartridges to check feeding, extraction and ejection.

Adjust if necessary.

40. Assemble Rear Sight Nut and Rear Sight to Rib with Rear Sight Screw. (925470, 221, Only)

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
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MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 5/21/79 - Included washers - WAW - 277931
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

41. Assemble Rib to Barrel Assembly with 2 Rib Screws,
Do not tighten, (925470, 221, Only)
42. Assemble Front Sight to Rib with Front Sight Screws and
Sight Washers, (925470, 221, Only)
43. Assemble Rear Sight Screw and Sight Washer to Rib
thru Rear Sight, (925470, 221, Only)
44. Position Rib in extreme rear position, and tighten
all screws. (925470, 221, Only)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. NO.						
	EFF. DATE						
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/14/79 - Added letter "O" - WAW - 277906
 5/21/79 - Modified element 45 - WAW - 277931
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

45. Mark Assembler's identification on gun ticket.
Hand stamp letter "O" on left rear horizontal flat of Receiver Tang.
46. Pick correct ticket and fill in.
47. If repairs from test are necessary, work must be done by the assembler who built and stamped the action.

EQUIPMENT - TOOLS & GAGES

1/16" Stamp

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
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Final Assembly							
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 2/26/80 - New Operation - ZJK - 278589
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

NOTE :

Same as Sheets 1-36 except for the following elements.

3. Assemble (5) Rec, Plug Screws into Receiver.
40. OMIT - Assemble rear Sight Nut & Rear Sight to Rib with R. S. Screw.
41. OMIT - Assemble Rib to Barrel with 2 Rib Screws.
42. OMIT - Assemble Front Sight to Rib.
43. OMIT - Assemble Rear Sight Screw, etc, to Rib.
44. OMIT - Position Rib & tighten all screws.
- 44-5 Assemble Front Sight Ramp to Barrel with Front Sight Screw. (925471, 7MM BR, only)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.					
Final Assembly (7MM BR Rem. only)	STD. HRS/C					
	STD. No.					
	EFF. DATE					
	PART No.	925471				
	GA. 7MM BR					

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 37 OF 37
MACHINE Bench

PROCESS RECORDS ASSEMBLY SHEETS

26

DATES AND REASONS FOR REVISIONS **5/13/63 - Made regular**
3/1/68 - Chg. reading - MT - 265929
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

Proof Test, Test and Target Pistol

EQUIPMENT - TOOLS & GAGES

Proof Test, Test
Targeting Jack

OPERATION DESCRIPTION

Proof Test, Test and Target

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

QA.

925470

221

925471

7MM BR

PART NAME

Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No.

YP100

OPER. No. 603

TYPE

MACH. HRS.

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1

MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R2531303

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804

5/21/79 - Added word to item 1 - WAW - 277931
9/29/80 - Update - MRP - RLS - 279182

DESCRIPTIVE INFORMATION

1. Pick Barreled Action,
2. Inspect for live ammunition;
 - Chamber must be empty,
3. Air-clean Sear Block and Sear Safety Cam thru Sear Housing opening.

(Do this away from comparator)

EQUIPMENT - TOOLS & GAGES

J & L TC -10 Comparator with 20 power projection lens assembly.

Standard air line nozzle,

Comparator Template
A-XP-100-37 (See Pg. 7)

Comparator Fixture

NOTE: Realign lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light beam from condensing lens to projection lens must be parallel. Adjust as required. Refer to Pg. 7 of J & L Operating Manual.

OPERATION DESCRIPTION	OCC. No.						
Adjust Sear Housing Assembly on Comparator 100%.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.	925470	925471				
	GA.	221	7MM BR				

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
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PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

4. Put Safety Lever in "OFF SAFE" position.
5. Place action in fixture and secure.
6. Push Bolt Stop to free position and secure with a non-marring means.
7. Close Bolt.
8. Move fixture to position Sear Safety Cam vertical surface to engagement set line of comparator overlay.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Adjust Sear Housing Assembly
on Comparator 100%.

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620

TYPE MACH. HRS. DEPT. No. 15 PAGE 2 OF 7

MACHINE

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

9. Check Sear Safety Cam - Sear Block engagement
(.015 - .020);

- ◆ Must be within tolerance lines of Comparator overlay.

A. If engagement is more than max, line:

Turn Trigger Adjusting Screw slowly clockwise (viewed from Muzzle end) until engagement comes within tolerance lines.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Sear Housing Assembly on Comparator 100% ,							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
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PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

9. (Cont'd.)

B. If engagement is less than min. line:

Raise Bolt Handle (actually lowering handle while action is in the fixture) and turn Adjusting Screw counter clock-wise,

Close Bolt Handle (Sear Block will not always follow as Trigger Adjusting Screw is turned counter-clockwise with Bolt closed),

Return to 9A

10. Pull Trigger to drop Firing Pin.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Adjust Sear Housing Assembly
on Comparator 100%.

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

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MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

11. Move fixture to position Sear Safety Cam vertical surface to overtravel "set" line on Comparator overlay.

12. Hold Trigger back firmly against Stop Screw.

- Clearance between Sear Safety Cam and Sear Block must be within overtravel tolerance lines on Comparator overlay (.005 - .015).

A. If overtravel is less than min. line;

Turn Sear Block Stop Screw counter-clockwise until clearance is within tolerance lines.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Adjust Sear Housing Assembly on Comparator 100%.

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
TYPE MACH. HRS. DEPT. No. 15 PAGE 5 OF 7
MACHINE

PROCESS RECORD- ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Add to element 15 - WAW - 277931
9/29/80 - Update - MRP - 279162

DESCRIPTIVE INFORMATION

12. (Cont'd)

B. If overtravel is more than max, line:

Turn Sear Block Stop Screw clockwise until clearance
is within tolerance lines.

13. Remove Bolt Stop means.

14. Remove Action from fixture.

15. Seal both screws with "Duco" cement, including screw slots.
• Cement must not interfere with link freedom,

EQUIPMENT-TOOLS & GAGES

"Duco" Cement

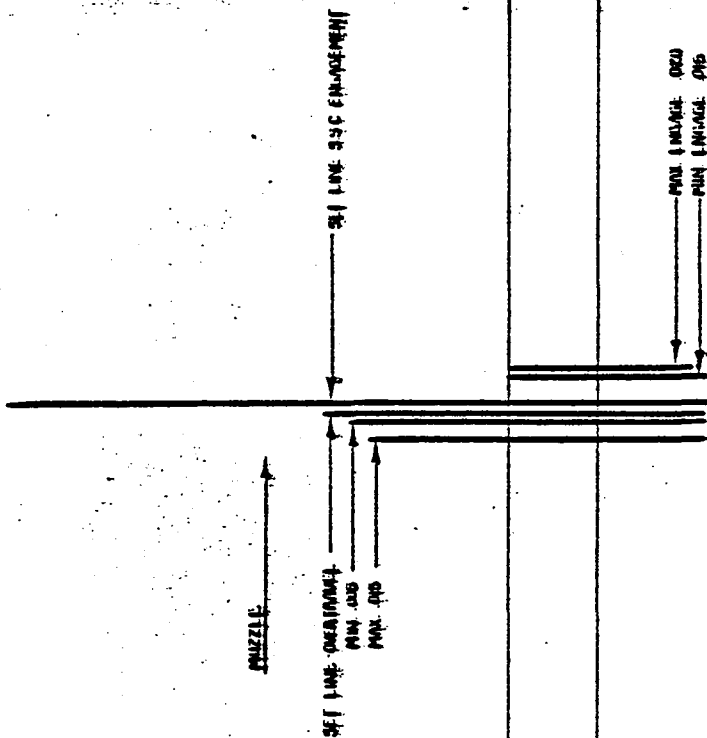
OPERATION DESCRIPTION	OCC. No.						
Adjust Sear Housing Assembly on Comparator 100%.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
TYPE MACH. HRS. DEPT. No. 15 PAGE 6 OF 7
MACHINE

REASONS FOR REVISIONS
9/29, - Update - MRP - R.L.J. - 279162

830

DESCRIPTIVE INFORMATION



DATE	NO.	REVISION
9/29/79	1	Update - MRP - R.L.J. - 279162
DATE	NO.	REVISION
9/29/79	1	Update - MRP - R.L.J. - 279162
DATE	NO.	REVISION
9/29/79	1	Update - MRP - R.L.J. - 279162

PART NAME Final Pistol Assembly SET UP TIME 100 OPER. No. 620
TYPE MACH. HRS. 15 DEPT. No. 7 PAGE 7 OF 7
MACHINE

Form R. D. 446a

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

4. Lubricate Trigger balance - See Illustration.

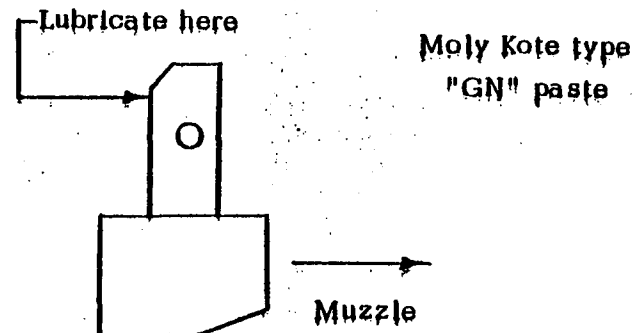
5. Select Stock Assembly and Inspect:

- Reasonably uniform medium lustre.
- No splits, cracks or breaks.
- No mars or scratches.
- No missing parts.

6. Assemble Trigger balance sub-assembly to Stock:

- Trigger balance must be installed correctly (See Illustration).

EQUIPMENT--TOOLS & GAGES



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action,							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
TYPE MACH. HRS. DEPT. No. 15 PAGE 2 OF 10
MACHINE

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 5/21/79 - Added Bolt removal note - WAW - 277931
 9/29/80 - Update - MRP - RLCJ - 279162

DESCRIPTIVE INFORMATION

7. Assemble Stock Assembly to Action with forward and rear screws. Bolt must be removed to expose rear screw,
- Trigger must be central in Trigger Guard, It must not touch at any point,
 - Receiver Tang must be fully seated in Stock at rear,
 - Safety must snap freely forward and rearward with no bind on Stock or Receiver.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Assemble Stock to Action.

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

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MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
5/21/79 - Corrected number - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Perform trick test.

I. Cock Pistol

II. Move Safety Lever to "ON SAFE" position;

- There must be no bind,
- There must be a good, sharp single detent.
- In the "ON SAFE" position, the Safety must have an observable "spring back" from the fullest rearward and forward positions.

III. Pull Trigger:

- There must be no click or catch in pull.
- Firing pin must not fall,

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action,							
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	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
TYPE MACH. HRS. DEPT. No. 15 PAGE 4 OF 10
MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS

4/23/79 - New - WAW - 277804

5/21/79 - Added item to V and corrected VIII - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont'd.

IV. Release Trigger Slowly;

- Trigger must move to full forward position when released.

V. Move Safety Lever to "OFF SAFE" position,

- Firing Pin must not fall.

- Pull Trigger, Firing Pin must fall,

VI. Re-cock Pistol

VII. Move Safety Lever from "OFF SAFE" position to the forward most null location. (Previously defined in Element #175, Page 24. Two fingers may be necessary to position Safety.),

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Assemble Stock to Action,

OCC. No.

STD. HRS/C

STD. NO.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

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TYPE

MACH. HRS.

DEPT. No. 15

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PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804 9/29/80 - Update - MRP - RLJ - 279162																															
DESCRIPTIVE INFORMATION 8. <u>Cont.</u> VIII. <u>Pull Trigger Hard;</u> • There must be no click or catch in pull; IX. <u>Release Trigger slowly;</u> • Trigger must not bind, • Trigger must move to full forward position when released, • Firing Pin must <u>not</u> fall.				EQUIPMENT - TOOLS & GAGES 																											
OPERATION DESCRIPTION Assemble Stock to Action,	QCC. No. STD. HRS/C STD. No. EFF. DATE PART No. GA.																														
<table style="width:100%; border: none;"> <tr> <td style="width:30%;">PART NAME</td> <td style="width:20%;">Final Pistol Assembly</td> <td style="width:10%;">COOLANT</td> <td style="width:10%;">SET UP TIME</td> <td style="width:10%;">MODEL No.</td> <td style="width:10%;">XP-100</td> <td style="width:10%;">OPER. No.</td> <td style="width:10%;">625</td> </tr> <tr> <td>TYPE</td> <td></td> <td></td> <td>MACH. HRS.</td> <td>DEPT. No.</td> <td>15</td> <td>PAGE</td> <td>6 OF 10</td> </tr> <tr> <td colspan="8" style="text-align: center;">MACHINE</td> </tr> </table>								PART NAME	Final Pistol Assembly	COOLANT	SET UP TIME	MODEL No.	XP-100	OPER. No.	625	TYPE			MACH. HRS.	DEPT. No.	15	PAGE	6 OF 10	MACHINE							
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 2/9/82

DESCRIPTIVE INFORMATION

8. X. Push Safety Lever to "OFF SAFE" Position:

- Firing Pin must not fall.
- Safety Lever must spring to "OFF SAFE" position by itself when pushed from this pull location.
- In the "OFF SAFE" position, the Safety must have an observable "spring back" from the fullest forward and rearward positions.

XI. Pull Trigger:

- Firing Pin must fall.

XII. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
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	EFF. DATE						
Assemble Stock to Action,							
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	GA.						

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

B. Cont.

XIII. Repeat Steps 7 thru 12 once.

FOR THE THIRD AND LAST TRIAL

XIV. Move Safety to "ON SAFE" position.

XV. From the "ON SAFE" position, move the Safety Lever to the forward most null location, (Previously defined Element 175, Page 24.)

XVI. Pull Trigger hard.

EQUIPMENT-TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New WAW - 277804
9729/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont,

XVII. Release Trigger slowly;

- There must be no click or catch in pull,
- Trigger must not bind,
- Trigger must return to full forward position when released,
- Firing Pin must not fall,

XVIII. Push Safety Lever to "OFF SAFE" position.

- Firing Pin must not fall,
- Safety must spring to "OFF SAFE" position when pushed from the null location,

EQUIPMENT--TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Assemble Stock to Action,	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont.

XIX. Pull Trigger

- Firing Pin must fall.

XX. Open Action and close Bolt forcibly to re-cock;

- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Assemble Stock to Action,

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

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GA.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

See Sheets 2 thru 14 for Procedure

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Inspection

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

925470

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PART NAME Final Pistol Assembly COOLANT

TYPE

SET UP
TIME

MACH. HRS.

MACHINE

MODEL No. XP-100

DEPT. No. 15

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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804																
9/29/80 - Update - MRP - RLJ - 279162																
DESCRIPTIVE INFORMATION																
<u>I. Ammunition Inspection</u> Inspect Gun for live ammunition: • Chamber must be empty and there must be no live ammunition present.																
<u>II. Receiver Roll Markings</u> Must be present, clear, distinct and visible above Stock. <table style="width: 100%; margin-top: 10px;"> <thead> <tr> <th style="text-align: left; width: 50%;"><u>Type</u></th> <th style="text-align: left; width: 50%;"><u>Location</u></th> </tr> </thead> <tbody> <tr> <td>• Remington - In Script</td> <td>Left side, center.</td> </tr> <tr> <td>• Model XP-100</td> <td>Left side, below "Remington".</td> </tr> <tr> <td>• Serial Number and alphabetic prefix</td> <td>Left side, forward of above items.</td> </tr> </tbody> </table>		<u>Type</u>	<u>Location</u>	• Remington - In Script	Left side, center.	• Model XP-100	Left side, below "Remington".	• Serial Number and alphabetic prefix	Left side, forward of above items.							
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• Remington - In Script	Left side, center.															
• Model XP-100	Left side, below "Remington".															
• Serial Number and alphabetic prefix	Left side, forward of above items.															
<u>III. Barrel Roll Markings</u> Must be present, clear, distinct and visible above side of Stock. <table style="width: 100%; margin-top: 10px;"> <thead> <tr> <th style="text-align: left; width: 50%;"><u>Type</u></th> <th style="text-align: left; width: 50%;"><u>Location</u></th> </tr> </thead> <tbody> <tr> <td>• Remington Arms Co., Inc. Ilion, New York Made in U.S.A.</td> <td>Left side</td> </tr> <tr> <td>• .221 Rem. Fireball</td> <td>Left side, rear of above item.</td> </tr> <tr> <td>• Des. 201, 366</td> <td>Right side, toward rear,</td> </tr> <tr> <td>• Pat. 3,255,545</td> <td>Right side, below above item.</td> </tr> </tbody> </table>		<u>Type</u>	<u>Location</u>	• Remington Arms Co., Inc. Ilion, New York Made in U.S.A.	Left side	• .221 Rem. Fireball	Left side, rear of above item.	• Des. 201, 366	Right side, toward rear,	• Pat. 3,255,545	Right side, below above item.					
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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

IV. Barrel Stamp Markings

Must be present, clear, distinct and visible above Stock.

<u>Type</u>	<u>Location</u>	<u>Example</u>
• Magnaflux mark	Right side, rear	
• Proof	Right side, near Barrel Bracket, above center-line of Barrel	
• Test and Target	Just forward of Proof Stamp	
• Assembler	Left side, forward of Receiver, above centerline of Barrel	2

V. Bolt Markings

Must be present, clear and distinct.

<u>Type</u>	<u>Location</u>
• Bolt head pull test - Prick Punch	Right side Lug
• Proof mark - Prick Punch	Bottom of Bolt Handle
• Bolt Handle braze test - Prick Punch	Rear of Bolt Handle
• Magnaflux Bolt Assembly Inspection - Prick Punch	Left side Lug
• Serial Number, must match Receiver, Last 4 digits	Bottom rear of Bolt body

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 630
TYPE Final Inspection MACH. HRS. _____ DEPT. No. 15 PAGE 3 OF 14
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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804			
2/26/80 - Added .221 Rem only - ZJK - 278589			
9/29/80 - Update - MRP - RLJ - 279162			
DESCRIPTIVE INFORMATION			
VI. <u>Barrel Finish</u> • Must be uniform, Black color, medium lustre finish - free of seams and stress marks, • Muzzle crown must be reasonably smooth with no burrs, jams or deformation in bore, • Bore must be concentric with muzzle O.D, VII. <u>Rib</u> (.221 Rem. only) • Barrel Rib, (Black Nylon), must present a reasonably uniform lustre, oiled, clean and free of breaks, splits, cracks or flashing, • No bad scratches or abrasions, • Rib tight to Barrel and screw slots not mutilated, • Rib must conform to contour of Barrel full length. No excessive openings at sides, • As viewed from rear, top of Rib must be straight and reasonably flat full length,			
PART NAME <u>Final Pistol Assembly</u> COOLANT _____ SET UP TIME _____ MODEL No. <u>XP-100</u> OPER. No. <u>630</u> TYPE <u>Final Inspection</u> MACH. HRS. _____ DEPT. No. <u>15</u> PAGE <u>4</u> OF <u>14</u> MACHINE _____			

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2/26/80 - Added .221 Rem. - ZJK - 278589																		
9/29/80 - Update - MRP - RLJ - 279162																		
DESCRIPTIVE INFORMATION																		
VIII. Sights • Front sight screwed tightly to Barrel, central on Rib and parallel with line of sight - not bent, tipped or deformed, (.221 Rem, only) • Rear Sight Ramp screwed tightly - reasonably central to Rib or Barrel • Rear Sight Leaf reasonably central crosswise on ramp - set screw tight in position, • Rear Sight Eye Piece - top approximately flush with top surface of Leaf - set screw tight. • Rear Sight Assembly must be level, crosswise, with Front Sight and with line of sight, as viewed from rear - not tipped, twisted or bent. IX. Receiver Finish • All outside exposed surfaces must have a smooth, polished finish, uniform black in color, free of burrs, jams, or dents, • Ejection port edges must not be sharp, chipped or marred, • Receiver Plug Screws must be present in front (2) and top rear (1). Slots not mutilated, • Gas escape hole must be present at front right side of Receiver and show a minimum of 1/2 of hole above Stock.																		
<table style="width: 100%; border: none;"> <tr> <td style="width: 35%;">PART NAME <u>Final Pistol Assembly</u></td> <td style="width: 15%;">COOLANT _____</td> <td style="width: 15%;">SET UP TIME _____</td> <td style="width: 15%;">MODEL No. <u>XP-100</u></td> <td style="width: 20%;">OPER. No. <u>630</u></td> </tr> <tr> <td>TYPE _____</td> <td>MACH. HRS. _____</td> <td>DEPT. No. <u>15</u></td> <td>PAGE <u>5</u></td> <td>OF <u>14</u></td> </tr> <tr> <td colspan="5" style="text-align: center;">MACHINE _____</td> </tr> </table>				PART NAME <u>Final Pistol Assembly</u>	COOLANT _____	SET UP TIME _____	MODEL No. <u>XP-100</u>	OPER. No. <u>630</u>	TYPE _____	MACH. HRS. _____	DEPT. No. <u>15</u>	PAGE <u>5</u>	OF <u>14</u>	MACHINE _____				
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DESCRIPTIVE INFORMATION																		
X. <u>Barrel and Receiver Fit</u> ● Barrel, Barrel Bracket and Receiver must be tight at joint, ● Must be in alignment lengthwise, XI. <u>Stock Assembly</u> A. Stock and Trigger Guard ● Stock must present a reasonably uniform brown-grained medium lustre; clean and free of breaks, splits and cracks, ● Any dull spots must not sharply contrast. ● Slight acid marks (at sides of striations) permissible, but no blisters or bubbles. ● No bad scratches or abrasions. ● Trigger Guard must present good uniform black finish - not chipped or marred. ● Trigger Guard must fit well in Stock at sides and around ends. ● Molding mark inside guard must not be sharp - no protruding flash. ● Trigger opening clean, not broken through or chipped at edges.																		
<table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">PART NAME <u>Final Pistol Assembly</u></td> <td style="width: 15%;">COOLANT _____</td> <td style="width: 15%;">SET UP TIME _____</td> <td style="width: 15%;">MODEL No. <u>XP-100</u></td> <td style="width: 22%;">OPER. No. <u>630</u></td> </tr> <tr> <td colspan="2">TYPE _____</td> <td>MACH. HRS. _____</td> <td>DEPT. No. <u>15</u></td> <td>PAGE <u>6</u> OF <u>14</u></td> </tr> <tr> <td colspan="5" style="text-align: center;">MACHINE _____</td> </tr> </table>				PART NAME <u>Final Pistol Assembly</u>	COOLANT _____	SET UP TIME _____	MODEL No. <u>XP-100</u>	OPER. No. <u>630</u>	TYPE _____		MACH. HRS. _____	DEPT. No. <u>15</u>	PAGE <u>6</u> OF <u>14</u>	MACHINE _____				
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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
9-29-80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XI. Stock Assembly - (Cont'd)

B. Striations

- Must be distinct, uniform and complete full length. Spacer and Grip Diamond not striated,

C. Checkering

- Must be distinct and good form - not abraded or flattened - complete on both sides of Grip.

D. Fore End Spacer and Tip

- Must be tight to Stock,
- Spacer must not be broken and must conform to contour of Stock and Tip,

E. Diamond Inserts

- Must be clean white in color and tight in Stock,
- Must be a good fit in cavities. No appreciable openings.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 630
TYPE Final Inspection MACH. HRS. _____ DEPT. No. 15 PAGE _____ OF 14
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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
5/21/79 - Delete "Free Float" test - WAW - 277931
9/29/80 - Update - MRP - BLJ - 279162

DESCRIPTIVE INFORMATION

XII. Stock Fit

A. To Receiver

- Receiver must fit tightly in Stock.
- Receiver Tang must seat fully in Stock at rear. It must not protrude beyond Stock at rear.
- Must be a good fit at both sides full length.

B. To Barrel

- Must show a reasonably uniform opening on both sides for full length forward of Barrel Bracket.

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DESCRIPTIVE INFORMATION													
XIII. Bolt Assembly ● Bolt Plug and Firing Pin Head - Good smooth finish with uniform Black color, ● Bolt Handle, Bolt Body, Bolt Head have good smooth bright finish. No rust, excess braze, bad nicks or burrs, Rub marks on body are acceptable, ● Bottom "half ball" of "S" Bolt Handle - serrated with no burrs or sharp edges, ● Sear notch at front of Firing Pin Head - good smooth finish - no deep lines. ● Rear surfaces of Locking Lugs must be smooth - no deep lines. ● Gas escape hole must be present in bottom front. ● Bolt face must be smooth - no deep rings, ● Extreme front face of Bolt (shroud) must be smooth and flat. ● Extractor and rivet present - good claw - not broken or damaged. Depress Ejector with hand punch and release: ● Must depress at least flush with Bolt face and return to forward position freely under spring tension ● Must be retained by Ejector Pin.													
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5/21/79 - Added to element XVI - WAW - 277931			
2/26/80 - Added Gages - ZJK - 278589			
9/29/80 - Update - MRP - RLJ - 279162			
DESCRIPTIVE INFORMATION			
XIV. <u>Heading</u> Cock Pistol, Place Heading Plug into Chamber, Move Bolt to forward position and rotate clockwise, <u>Do not use excessive force,</u> A. <u>On Min. Plug</u> B-85239 - .221 Rem. B-45160 - 7MM BR Rem. • Bolt must fully close, B. <u>On Max. Plug</u> B-85240 - .221 Rem. B-45161 - 7MM BR Rem. • Bolt must not fully close,			
XV. <u>Function</u> With dummy cartridges, check for proper feeding, extraction and ejection.			
XVI. <u>Trigger Pull</u> MEASURE pull with spring scale: • Gun must fire with 1 1/2 to 2 3/4 lbs. force. • Trigger must be central in Trigger Guard, It must not touch at any point, Adjust if necessary.			
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5/21/79 - Add to element 5 - WAW - 277931													
9/29/80 - Update - MRP - RLJ - 279162													
DESCRIPTIVE INFORMATION													
XVII. <u>Perform Trick Test</u> 1. <u>Cock Pistol</u> 2. <u>Move Safety Lever to "ON SAFE" position;</u> • There must be no bind. • There must be a good, sharp single detent. • In the "ON SAFE" position, the Safety must have an observable "spring back" from the fullest rearward and forward positions. 3. <u>Pull Trigger</u> • There must be no click or catch in pull. • Firing Pin must <u>not</u> fall. 4. <u>Release Trigger slowly;</u> • Trigger must move to full forward position when released. 5. <u>Move Safety Lever to "OFF SAFE" position;</u> • Firing Pin must <u>not</u> fall • Pull Trigger, Firing Pin must fall. 6. <u>Re-cock Pistol</u>													
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DESCRIPTIVE INFORMATION

7. Move Safety Lever from "OFF SAFE" position to the forward most null location
(Two fingers may be necessary to position Safety).

DEFINITION: Forward Most Null Location

Is that "Just Stable" place, between "ON" and "OFF" Safe, closest to
"OFF SAFE", where the Safety Lever will not spring forward to the
"OFF SAFE" position when released.

8. Pull Trigger Hard;

- There must be no click or catch in pull.

9. Release Trigger slowly:

- Trigger must not bind.
- Trigger must move to full forward position when released.
- Firing Pin must not fall.

10. Push Safety Lever to "OFF SAFE" position;

- Firing Pin must not fall.
- Safety Lever must spring to "OFF SAFE" position by itself when pushed from the null position.
- In the "OFF SAFE" position, the Safety must have an observable "spring back" from the fullest forward and rearward positions.

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XVII. <u>Trick Test Cont.</u> 11. <u>Pull Trigger:</u> • Firing Pin <u>must</u> fall, 12. <u>Open Action and close Bolt forcibly to re-cock:</u> • Firing Pin <u>must not</u> fall, 13. <u>Repeat Steps 7 thru 12 once.</u> <u>FOR THE THIRD AND LAST TRIAL</u> 14. <u>Move Safety to "ON SAFE" position,</u> 15. <u>From the "ON SAFE" position, move the Safety Lever to the forward most null location.</u> 16. <u>Pull Trigger hard</u> 17. <u>Release Trigger slowly</u> • There must be no click or catch in pull. • Trigger must not bind, • Trigger must return to full forward position when released. • Firing Pin <u>must not</u> fall.															
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9/29/80 - Update - MRP - RLJ - 279162																
DESCRIPTIVE INFORMATION																
XVII. <u>Trick Test</u> - (Cont'd) 18. <u>Push Safety Lever to "OFF SAFE" position:</u> • Firing Pin <u>must not</u> fall. • Safety must spring to "OFF SAFE" position when pushed from the null location. 19. <u>Pull Trigger:</u> • Firing Pin <u>must</u> fall. 20. <u>Open Action and close Bolt forcibly to re-cock.</u> • Firing Pin <u>must not</u> fall. XIX. <u>Stamp Receiver</u> If pistol meets <u>all</u> inspection requirements, stamp assembler's mark and date code stamp on left rear side of Receiver,																
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