

Remington Arms Company, Inc.
Manufacturing Process Document

Document ID:
Product Line:

Trig Assy 7 700
Centerfire Rifle

General Instructions:
Use the Control Buttons above and below to access the various sections of this process. If your screen is not wide enough to display all the section data, use the arrows at the lower right to pan the desired data into view. Simply click on a tab or a button to move to that section of the document.

Process Routing Table:
Click on the button below containing the operation number you wish to view.

Demagnetize Springs
Clean Trigger Housing Assembly and apply rust
preventative.
Tap (3) Holes in Trigger Housing
Chase Threads and Ream Ball Hole
Assemble Trigger Assembly - Stage One -
Inspect Connector 100% - Inspect Trigger 100%
and Check Connector to Trigger Fit 100%
Assemble Trigger Assembly - Stage Two
Assemble Trigger Assembly - Stage Two
Adjust Trigger Assembly on Comparator 100%
Assemble Trigger Assembly - Stage Three
Function Check Complete Trigger Assembly 100%
Mark Correctly Assembled, Adjusted and Checked
Trigger Assembly with Assemblers Identification
To MRF Card #29
Repair Rejected Trigger Assemblies

Effective Date: 8-Dec-05
Origination Date: 12-Mar-93

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(Enter Oper #)

(Enter the Operation Name in this field)

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Demagnetize Springs

Step	Operation / Step Description
	Demagnetize Springs
	Procedure:
	1. Place Coar Springs and Trigger Springs in separate non-metallic pans not to exceed 6"X3"X2" in size.
	2. Turn demagnetizer "ON".
	3. Pass pan across the effective area located between the handles. Start the pan over the right side and pass to the left side and remove.
	4. Turn Demagnetizer "OFF". Do not turn switch off with pan in contact with demagnetizer, " THIS MAY MAGNETIZE PARTS ".

Tool Number	Tooling Description
STD.	PAN 6"X3"X2"
Std.	Machine-Electr-Matic Type A13

PROCESS CONTROL INSPECTION RECORD			
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			
Part No:	Part Name: Trlg Assy 7 700		
Operation No: 140	Operation: Demagnetize Springs		
Prod. Qty:	Prod. Order #:	Operator	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift
VISUAL	VISUAL	100%	INSPECT
			REJECT
			INSPECT
			REJECT
			INSPECT
			REJECT
			INSPECT
			REJECT
			INSPECT
			REJECT
			INSPECT
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			INSPECT
			REJECT
			INSPECT
			REJECT

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Revision Date: 8-Dec-05		Processed by:
Centerfire Rifle		Date <autodate>
		Work Center:
Setup inspected by & Date:		
2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.

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Step	Operation / Step Description
	Clean Trigger Housing Assembly and apply rust preventative.
	Procedure:
1. Load parts	a) Receive trigger housings from crib #29.
	b) Gently load trigger housings from pan into expanded metal basket.
	c) Truck basket of housings to dept. 8551.
	d) Place basket of housings in the PROCECO washer. Remember to place wire cover over basket. Washer has enough force to blow parts out.
2. Set wash time - 2 min.	
3. Set rinse time - 2 min.	
4. Start Cycle	
5. Transfer Parts to dryer	
6. Set Temperature to 350 deg. F	
7. Dry time - 20 min.	
8. Check housings carefully, and be sure they are clean and dry.	
	If necessary, use shop air to blow off housings. Always aim air flow into receptacle, never into the general atmosphere.

Tool Number	Tooling Description
STD.	PROCECO Wash Unit Model #AP-24-24-S-500-2
Std.	WINTECH 295 Rust Protector

PROCESS CONTROL INSPECTION RECORD	THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES
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Clean Trigger Housing Assembly and apply rust preventative.

Revision Date:	8-Dec-05
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Part Name:		Ing Assy / 700		Centerfire Rifle	
Operation:		Clean Trigger Housing Assembly and apply rust preventative.			
Prod. Order #:				Operator	
Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	
VISUAL	100%	INSPECT REJECT			
		INSPECT REJECT			
		INSPECT REJECT			
		INSPECT REJECT			
		INSPECT REJECT			
		INSPECT REJECT			
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Pieces Run:					

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	Date:	<autodate >
	Work Center:	
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Remarks, Causes, Action Taken, Etc.		

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Tap (3) Holes in Trigger Housing

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Tap (3) Holes in Trigger Housing

STD 2 Flute #6 40 NF GH2 H.S. Cobalt Tap

STD Pneumatic Bench Top Tapper

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Centerfire Rifle		Date <autodate>
		Work Center:
		Setup Inspected by & Date:
2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
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Chase Threads and Ream Ball Hole

Step	Operation / Step Description
	Chase Threads and Ream Ball Hole
	Procedure:
	1. Chase Threads in Trigger Stop Screw Hole
	2. Chase Threads in Engagement Screw Hole
	3. Chase Threads in Field Adjustment Screw Hole
	4. Ream Field Adjustment Screw Hole
	5. Ream Trigger Ball Screw Hole

Tool Number	Tooling Description
STD	2 Flute #6-40 NF-GH2 H.S. Cobalt Tap
STD	.1425 DIA REAMER
STD	Pneumatic Bench Top Tapper
C-90059-R	ESS TAP #6-36 NF-2

PROCESS CONTROL INSPECTION RECORD			
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			
Part No:	Part Name: Trig Assy 7 700		
Operation No: 147	Operation: Chase Threads and Ream Ball Hole		
Prod. Qty:	Prod. Order #:	Operator	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift
VISUAL	VISUAL	100%	INSPECT
			REJECT
			INSPECT
			REJECT
			INSPECT
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			REJECT
			INSPECT
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			REJECT

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Centerfire Rifle		Date <autodate>
		Work Center:
		Setup Inspected by & Date:
2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.

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			REJECT
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Operation Step Detail	Operation: 151
Step	Operation / Step Description

Assemble Trigger Assembly - Stage One
Inspect Connector 100%, inspect Trigger 100% and check Connector to
Trigger fit 100%.

NOTE: Do all elements 100%

1. Inspect long inside Connector surface, and inside surface of long
(top) leg for flatness.

Hold Connector against flatness block with light finger pressure.

* If no light shows between inside surfaces of back and long leg
of Connector and block surface, Connector is good.

(See Figure #1)

* If light gap shows, measure gap with a .006 shim. If gap accepts
shim without moving Connector - Reject Connector. (See Fig. #2)

* Note : .006 Shim - Make new shim as required

* If Connector rocks on flatness block - reject Connector. (See
Fig. #3)

* Front edge of long (top) leg, must be square with shoulder of
flatness block. (See Fig. #4)

2. Polish Connectors

- Surface must be:
- * Smooth
 - * Burr Free at top and bottom corners and hole.
 - * Dead flat within $1/32"$ (Minimum of end.

Check for burrs and smoothness with fingertip.

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Assemble Trigger Assembly - Stage One -
Inspect Connector 100% - Inspect Trigger 100%
and Check Connector to Trigger Fit 100%

*** See Sketch ***

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3. INSPECT TRIGGER.

- Trigger Must Have:
- * Uniform Metallic Satin Finish and Color.
 - * No bleed out (white material on surface)
 - * No burrs
 - * No cracks or damage at pivot hole.

4. Fit passed Connector to passed Trigger and check for MAX. WORKING CLEARANCE. (Slip Fit)

- * Connector must rotate freely around bottom (short) leg, without binding or drag of Trigger.

* Ref. Sketch # 151-2

- * If additional clearance is needed, file bottom notch on Trigger. Filed surface must be FLAT and SQUARE with sides of trigger. Use filing fixture only. DO NOT FILE FREE HAND.

5. With the same Trigger and Connector, check for Max. Working clearance:

- * Push Connector right to trigger at bottom, and hold it parallel to sides of Trigger.

- * Insert Shim stock in clearance from back to front.

* .006 inch MUST NOT GO

- * If shim enters without moving Connector SCRAP TRIGGER.

- * Keep trigger and connector together in container ready for Stage Two.

* Ref. Sketch 151-3

Operation Tool Detail

Operation: 151

Tool Number	Tooling Description
D-44608	File Fixture
C-44604	Flatness Block

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Revision Date:
8-Dec-05

Part Name:		Trig Assy 7 700			Centerfire Rifle	
Operation:		Assemble Trigger Assembly - Stage One -				
Prod. Order #:		Operator				
Gage Number		1st Shift		2nd Shift		
Gage Frequency		3rd Shift				
VISUAL		100%				
		INSPECT REJECT				
		INSPECT REJECT				
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Assemble Trigger Assembly - Stage Two

Step	Operation / Step Description
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2. Inspect Trigger Housing:
- * Black color
 - * No bleedout (White Material)
 - * Check inside Housing - No burrs at holes.
 - * Clean and free of excess oil and foreign material.
 - * Parts should have a light coating of "GEC GUARD" and be free of foreign material.

3. Position Trigger in Housing and install Trigger Pin:
- * Use fixture B-37211 to hold Housing.
 - * While holding the Connector on the Trigger in the assembled position (see sketch #51-3), dip the long leg of the Connector and top of the Trigger into Molykote powder, dry, Type "Z".
 - * Use pin holding punch A-33645 to start the Trigger Pivot Pin in the housing after locating Trigger and Connector.
 - * Assemble Trigger and Connector into the Housing by driving the Pin by hammer until it is flush to the Housing on the Safety do not side.
 - * Grip Trigger and rotate housing around Trigger Pin. Trigger must rotate freely in housing without bind.

*** See Sketch ***

4. Install:
- * Trigger Stop Screw - Flush with hole.
 - * Trigger Spring
 - * Trigger Screw Front - Flush with hole or below.
(There must be spring force on Connector while adjusting Trigger Engagement Screw.)
 - * Trigger Engagement Screw - flush with hole.
 - Screw should have been precoated with Loctite sealant before assembly - see PROCEDURE.

*** See Sketch ***

PROCEDURE FOR COATING TRIGGER ENGAGEMENT SCREW WITH LOCTITE SEALANT:

1. Place approximately 1000 clean, dry screws in a plastic bag.
2. Pour sufficient Locite sealant into bag to evenly coat screws with a thin film of sealant.
3. Agitate bag by hand to coat all screws.

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4. Visually inspect screws to see if coating is adequate. Remove
b coated screws from the bag and compare to a dry uncoated
screw under a 5X magnifying lamp:
- a) All threads must be entirely coated with Loctite.
 - b) Threads should not be dripping excess Loctite.
 - c) Threads should not be filled completely from the base (root)
of the thread to the top (O.D.) of the thread.
5. If screws are not entirely coated:
- a) After full agitation (determined by the visual inspection),
add more sealant to the bag of screws and re-agitate.
 - b) If screws have excess coating of Loctite after full agita-
tion, add more screws to the bag and re-agitate.
 - c) Visually inspect in the same way indicated in step 4 after
any re-agitation.

Screws may be used immediately or stored if required. The Loctite
sealant is anaerobic and will only dry in the absence of air.

c. Install Sear Spring and *Sear Safety Cam using Two Dummy Pins.

*** See Sketch ***

- * Use drop gauge C-44522 to inspect for straightness.
Any sear safety cams that do not pass through the gauge are to
be scrapped.
- * Visually inspect Sear Safety Cam. This must have a sharp,
burr-free, square edge at the connector contact surface. (Look
for a sharp ground surface on the verticle side of this edge.)
- * Depress Sear Safety Cam - must move freely
- * Sear must not have dimple.

* Sear Safety Cam - Part #15666 does not have a recessed
dimple.

Tool Number	Tooling Description
B-37211	Housing Fixture
A-35645	Pin Holder Drive Punch
A-51468	Dummy Pins
Std.	5X magnifying fluorescent lamp
Std.	Hammer - Stanley Compo-Cast 8oz.
C-44522-A	Drop Gauge for Sear Safety Cam Width

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Operation Step Detail	Operation: 154
Step	Operation / Step Description

Assembly Trigger Assembly - Stage Two

1. Inspect Trigger Housing:
- * Uniform Metallic Satin Finish and Color

* No bleedout (White Material)

* Check inside Housing - No burrs at holes.

* Clean and free of excess oil and foreign material.
2. Position Trigger in Housing and install Trigger Pin:
- * Apply Dry Molykote to long leg of connector

* Molykote Powder - Dry type " Z "

* Pin must be flush to housing on right side, left side for left hand.

* Grip Housing and rotate Trigger around Trigger Pin. Trigger must rotate freely under its own weight.

* Use fixture B-37211
3. Install:
- * Same Connector as fitted to Trigger (Op. #151)

* Trigger Stop Screw #14633 (Dwg. A-14633)

* Trigger Spring #14635 (Dwg. A-14635)

* Trigger Spring Front #14634 (Dwg. A-14634)

* Trigger Screw Front #90568 (Dwg. B-90568)

* Trigger Ball #23223 (Dwg. B-23220)

* Trigger Engagement Screw #91128 (Dwg. B-91128)
4. Install Sear Spring and *Sear Safety Cam using Two Dummy Pins.
- * Polish Sear pad - Must be flat and have surface finish of 16 μ in or better

Surface must be:

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Assemble Trigger Assembly - Stage Two
Check for Burrs and Polish 100 %

*** See Sketch ***
*** See Sketch ***
*** See Sketch ***

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- * Smooth
- * Burr - Free at top and bottom corners and hole.
- * Dead flat within $1/32$ " (Minimum of end.

Check for burrs and smoothness with fingertip.

- * Use drop gauge C-44522 to inspect for straightness.
Any gear safety cams that do not pass through the gauge are to be scrapped.
- * Visually inspect Sear Safety Cam. This must have a sharp, burr-free, square edge at the connector contact surface.(Look for a sharp ground surface on the verticle side of this edge.)
- * Depress Sear Safety Cam - must move freely
- * Sear must not have dimple.

* Sear Safety Cam - Part #15666 does not have a recessed dimple.

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires!).

6. Check For Adjustability
To ensure that the spring and ball are not restricted
Turn Trigger Adjusting Screw clock-wise and repeat step #5

- Adjust Trigger Assy. in Comparator Fixture dead weight Equivalent

7. Adjust Overtravel and Connector engagement to .018 to .020
Ensure there is NO creep

8. Hold Trigger in fired position firmly with finger and:

- * Set OVER-TRAVEL by turning Trigger Stop Screw SLOWLY CLOCKWISE, until Trigger Connector touches correct line in comparator screen.

9. Prick punch Housing at Trigger Screw Front & glue Trigger Engagement Screw and Trigger Stop Screw.

10. Prick punch Housing at Front Ball Hole

Operation Tool Detail

Operation: 155

Tool Number

Tooling Description

A-35640

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as required to meet Final Inspection Requirements of 2.5 - 3.5 lbs.

Pin Holder Drive Punch

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B-37211

S.d.

S=d.

C-14522-2

E-42271

C-700-CL-

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Dummy Pins
Housing Fixture

Drop Gage for Sear Safety Cam Width

Deltronics Comparator 14" (50X)
Comparator Fixture
Comparator Screen

		Revision Date: 8-Dec-05		
Part Name:		Trig Assy 7 700		Centerfire Rifle
Operation:		Assemble Trigger Assembly - Stage Two		
Prod. Order #:		Operator		
Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
VISUAL	100%	INSPECT REJECT		
C-44522-A	100%	INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
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Pieces Run:				

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Remarks, Causes, Action Taken, Etc.	
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Step	Operation / Step Description
	* Align set edge on master (E-42271-A) to horizontal centerline on comparator screen C-700-CL-170.
	Adjust Trigger Assembly on Comparator 100%
1.	Pick Trigger Sub-Assembly. Position in comparator fixture and clamp: * Housing must properly contact all locators. * Top of Housing must be flat on fixture. * Push with Thumb on rear of Trigger (toward left). This seats Trigger firmly against end of Trigger Adjusting Screw.
2.	Adjust fixture to locate Sear on "set" line of comparator screen.
3.	Adjust Sear/Connector engagement (.018 - .020), to correct comparator screen line by turning Trigger Engagement Screw SLOWLY CLOCKWISE (to reduce engagement).
	* Trigger must fall within min./max. trigger lines on comparator screen.
	AFTER CORRECTLY ADJUSTING SEAR/CONNECTOR ENGAGEMENT
4.	Hang dead weight roller assembly in radius of trigger.
5.	Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).
	Comparator fixture dead weight - 4.5 lbs.
6.	Remove dead weight assembly from Trigger.
7.	Fold Trigger in fired position firmly with finger and: * Set OVER-TRAVEL by turning Trigger Stop Screw SLOWLY CLOCKWISE, until Trigger Connector touches correct line in comparator screen.

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Adjust Trigger Assembly on Comparator 100%

(NOTE: Use this spec as a general guide and adjust as
needed to satisfy the finished rifle spec.)

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9. Seal all three screws with "Ducol" Cement, including screw slots.

Tool Number

Tooling Description

S=d.

E-42271

L-42271-A Set block

C-700-CL-170

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Deltronics Comparator 14" (50X)
Comparator Fixture
Comparator Screen

		Revision Date: 8-Dec-05		
Part Name: Trig Assy 7 700		Centerfire Rifle		
Operation: Adjust Trigger Assembly on Comparator 100%				
Prod. Order #:		Operator		
Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
VISUAL	100%	INSPECT		
		REJECT		
		INSPECT		
		REJECT		
		INSPECT		
		REJECT		
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Assemble Trigger Assembly - Stage Three

*** See Sketch for 700 RH ***
*** See Sketch for 700 LH ***
*** See Sketch for 7 LW ***

Step	Operation / Step Description
	Assemble Trigger Assembly - Stage Three
1.	Pick correctly adjusted Trigger Sub-Assembly.
2.	Assemble: Bolt Stop Release - Do not use twisted or bent parts. File inside surface flat if necessary. Safety Assembly - Check minimum width of "U" bend between safety arm and cam with .140" plug, 100%. - While holding the safety assembly by the safety arm button, dip the "U" bend of the safety assembly into Molykote powder, dry, Type "Z". Safety Detent Ball - Visually inspect ball for flats or marks on ball surface. - Check to make sure Safety Detent Ball slides freely through mating hole in safety assembly. Safety Detent Spring - Visually check for the presence of 2 dimples. Safety Pivot Pin Safety Snap Washer. A) Orient the Snap Washer such that the notched side of the Pivot Pin channel is on the left after assembly. This places the die break on the under side of the Snap Washer.(See sketch #160.) B) When assembling SAFETY SNAP WASHER to PIVOT PIN, make sure the SNAP WASHER is in the GROOVE on the PIVOT PIN before sliding it into position. If the SNAP WASHER rides out of groove and becomes distorted remove and discard. C) Safety Snap Washer MUST be completely contained within Pivot Pin Groove.

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- | Tool Number | Tooling Description |
|-------------|---------------------|
| d | .140 Plug gage |

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Function Check Complete Trigger Assembly 100%

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* Place Trigger Assembly in gage, pump locating pins into position and clamp. Zero the dial and pull safety to "On" or "S" position and read dial.

Tool Number

Tooling Description

D-42614

[illegible]

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Dial Base Gage - "Sear Lift" - .006 to .018

		Revision Date: 8-Dec-05		
Part Name: Trig Assy 7 700		Centerfire Rifle		
Operation: Function Check Complete Trigger Assembly 100%				
Prod. Order #		Operator		
Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
VISUAL	100%	INSPECT REJECT		
D-42614	100%	INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
		INSPECT REJECT		
Pieces Run:				

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	Processed by:
	Date: <autodate>
	Work Center:
Setup inspected by & Date:	
Remarks, Causes, Action Taken, Etc.	
Remington Arms Company, Inc. -- Ilion, New York	

Sheet 63 of 78

Mark Correctly Assembled, Adjusted and Checked
Trigger Assembly with Assemblers Identification
To MRP Crib #29

*** See Sketch ***

Mark correctly assembled, adjusted and checked 'Rigger Assembly, with Assembler's Identification.

1. Locate trigger assembly on stamping fixture.
2. Stamp lower left corner (as shown) with correct Assemblers Identification.

- * Holding block for stamp B-53512
* Use 1/16" size character

[illegible]

BARBER - RE 0001254

Sheet 65 of 78

Repair Rejected Trigger Assemblies

Repair Reflected Trigger Assemblies

NOTE: Each repair Trigger Assembly is to go to Assembler who originally built it.

1. Make corrections as required.
Disassemble and scrap all questionable parts.

Note: If part of the repair sequence involves removal of the SAFETY SNAP WASHER discard washer after removal and replace with NEW SAFETY SNAP WASHER.

2. Return Trigger Assembly to process at point where it will again receive all applicable adjustments and function checks.

[illegible]

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[illegible]

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Dept	Oper	Operation Description	Part Numbers	
9132	1	Issuc from Crib	26345 32895 92458	
			202446 27591 202906	
8773	140	Demagnetize Springs	92458 26345 32895	
			202446 27591 202906	
8773	143	Clean Trigger Housing Assembly and apply rust preventative.	92458 26345 32895	
			202446 27591 202906	
8773	145	Tap Hole in Trigger Housing	92458 26345 32895	
			202906	
8773	147	Chase Threads and Ream Ball Hole	202446 27591	
8773	151	Assemble Trigger Assembly - Stage One - Inspect Connector 100% - Inspect Trigger 100% and Check Connector to Trigger Pin 100%	92458 26345 32895	
			202446 27591 202906	
8773	154	Assemble Trigger Assembly - Stage Two	92458 26345 32895	
			202906	
8773	155	Assemble Trigger Assembly - Stage Two	202446 27591	
8773	158	Adjust Trigger Assembly on Comparator 100%	92458 26345 32895	
			202906	
8773	160	Assemble Trigger Assembly - Stage Three	92458 26345 32895	
			202446 27591 202906	
8773	165	Function Check Complete Trigger Assembly 100%	92458 26345 32895	
			202446 27591 202906	
8773	170	Mark Correctly Assembled, Adjusted and Checked Trigger Assembly with Assemblers Identification To MR2 Crib #23	92458 26345 32895	
			202446 27591 202906	
8773 175R		Repair Rejected Trigger Assemblies	92458 26345 32895	
			202446 27591 202906	

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
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	15400	30	140	1	Trigger Spring
	15481	50	154	1.000	Trigger Stop Screw
26345					TRIGGER ASSEMBLY - 700
	15178	40	160	1	Bolt Stop Release
	92297	160	160	1	Safety Assembly
	23222	120	160	1	Safety Detent Ball
	15368	20	140	1	Safety Detent Spring
	17043	70	160	1	Safety Pivot Pin
	17044	80	160	1	Safety Snap Washer
	15566	60	154	1	Sear Safety Cam
	17047	90	140	1	Sear Spring
	109835	10	151	1	Trigger
	17053	100	154	1	Trigger Screw Front
	19461	110	151	1	Trigger Connector
	91128	150	154	1	Trigger Engagement Screw
	26355	140	151	1	Trigger Housing Assembly
	202540	130	154	1	Trigger Pin
	15400	30	140	1	Trigger Spring
	15481	50	154	1.000	Trigger Stop Screw
32895					TRIGGER ASSEMBLY 700 L.H.
	90555	130	160	1.000	Bolt Stop Release
	92296	150	160	1.000	Safety Assembly
	23222	100	160	1.000	Safety Detent Ball
	92546	160	140	1.000	Safety Detent Spring
	17043	50	160	1.000	Safety Pivot Pin
	17044	60	160	1.000	Safety Snap Washer
	15566	40	154	1.000	Sear Safety Cam
	17047	70	140	1.000	Sear Spring
	109835	10	151	1.000	Trigger
	17053	80	154	1.000	Trigger Screw Front
	19461	90	151	1.000	Trigger Connector
	91128	140	154	1.000	Trigger Engagement Screw
	32905	120	151	1.000	Trigger Housing Assembly
	202540	110	154	1.000	Trigger Pin
	15400	20	140	1.000	Trigger Spring
	15481	30	154	1.000	Trigger Stop Screw
202446					Trigger Assembly - XR-100
	91828	150	160	1	Bolt Stop Release
	91853	160	160	1	Safety Assembly
	23222	110	160	1	Safety Detent Ball
	15368	20	140	1	Safety Detent Spring
	17043	60	160	1	Safety Pivot Pin
	17044	70	160	1	Safety Snap Washer
	15566	50	154	1	Sear Safety Cam

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	17047	80	140	1	Sear Spring
	109835	10	151	1	Trigger
	23223	170	155	1	Trigger Ball Front
	19461	100	151	1	Trigger Connector
	91128	140	155	1	Trigger Engagement Screw
	30785	130	151	1	Trigger Housing Assembly
	202540	120	155	1	Trigger Pin
	13753	90	155	1	Trigger Screw Front
	14535	30	140	1	Trigger Spring
	14534	180	140	1	Trigger Spring Front
	14533	40	155	1	Trigger Stop Screw
27591					Trigger Assembly - XR-100
	15478	150	160	1	Bolt Stop Release
	92297	160	160	1	Safety Assembly
	23222	110	160	1	Safety Detent Ball
	15368	20	140	1	Safety Detent Spring
	17043	60	160	1	Safety Pivot Pin
	17044	70	160	1	Safety Snap Washer
	15566	50	155	1	Sear Safety Cam
	17047	80	140	1	Sear Spring
	109835	10	151	1	Trigger
	23223	170	155	1	Trigger Ball Front
	19461	100	151	1	Trigger Connector
	91128	140	155	1	Trigger Engagement Screw
	30785	130	151	1	Trigger Housing Assembly
	202540	120	155	1	Trigger Pin
	13753	90	155	1	Trigger Screw Front
	14535	30	140	1	Trigger Spring
	14534	180	140	1	Trigger Spring Front
	14533	40	155	1	Trigger Stop Screw

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Date:	Reason for Revision:	Eng:	Log #:
23-Apr-01	Copied entire process from VAXcamps #303575	RLJ	304220
4-Oct-01	Revised hanging weight specification in operation 155.	RLJ	305072
16-Mar-02	Added gage D-42614 to operation 165 for records.	RLJ	305776
14-Feb-03	Added OP #145 (Tap Hole) to reflect current process.	ATM	308577
13-Jul-04	202446 - Trigger Assembly - XR-100	GLC	312191
13-Jan-05	Trigger Pin p/n 202540 was 24477	AJL	313546
10-Feb-05	Added OP#143 Clean Trigger Housing Assembly and Apply Rust Preventative.	AJL	313561
11-Feb-05	Added Details to OP#143 and OP#145	AJL	313564
15-Feb-05	Op#143 Dept. 8772 was 8448	AJL	313842
15-Feb-05	Revised OP#143 Details, Added OP#147 Added Details to OP#151, Added OP#155 Changed O'd OP#155 to OP#158	AJL	313843
17-Feb-05	Op#143 Dry Time was 3 min. Now 20 min.	AJL	313844
18-Feb-05	Added Trigger Pull Weight to OP#155	AJL	313845
19-Apr-05	XR-100 Replace Trigger with 109835 was 13280	SRF	314643
25-Apr-05	Op#143 Tap (3) Holes was Spring Hole only	AJL	313859
15-Sep-05	Material section: 202446 (XR-100) - changed trigger screw from 90568 to 13733 per DCR# 16011.	PJZ	314610
28-Oct-05	Added part #27591 per NP2 #2005-ML73, DCR #16082.	MFS	315950
4-Nov-05	DEPT 8773 WAS 8772 FOR OP#140, 143, 145, 147, 151, 154, 155, 158, 160, 163, 170, & 175R	GLC	316017
29-Nov-05	Op. 158 - added Set Block E-42271-A and detail to "align	PJZ	316076

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set edge or master to horizontal centerline on comparator screen", & added detail in step #3 "trigger must fall within min/max trigger lines on comparator screen."
Op. 165 - added detail to step #3 to check sear lift 10% per tray, if any are found out of spec then check entire tray 100%.

8-Dec-05 ADD PT#202906 - TRIGGER ASSEMBLY - 40SSA

GLC 316233

Dept Num Procedure by Steps Safety Key Points

Type "Ctrl+h" from the desired destination to insert this form. Execute *before* the next form below.

PROCESS CONTROL INSPECTION RECORD				
THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR				
		Part Name:		Trig Assy 7 700
Operation No: Part No:		Operation:		Part Name:
Furnace and Load Number		Draw	Temp	Furnace Date Hardness Specification HRC
HRC		Tester No		H15n Tester No
35				60
36				61
37				62
38				63
39				64
40				65
41				66
42				67
43				68
44				69
45				70
46				71
47				72
48				73

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49	74
50	75
51	76
52	77
53	78
54	79
55	80

Type "Ctrl+r" *from the desired destination* to insert this form. Execute *after* the HTPCIR above.

PROCESS RECORD - HEAT TREAT SPECIFICATION

Process

Material:
Furnace:
Rack:
Maximum Load:

Temperature:
Soak Time:
Carbon %:
Quench:
Wash:
Notes:

Inspection

Hardness:

Break Test:
Color Only:
Appearance of Parts:

95	51	6 - 50	6	3
96	52	51 - 100	7	3
97	53	101 - 200	7	3
98	54	201 - 800	16	1
99	55	801 - 3000	17	1
100	56	3001 - 20000	27	2
101	57			
Rev 0				

Unassigned Button Clicked

You have clicked a button that is not assigned to a process sheet

Click the button to return to the Header Sheet