

Remington Arms Company, Inc.  
Manufacturing Process Document

Document ID:  
Product Line:

XMP TRIG ASSY 700 7  
C/E

**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  
Ultrasonic Clean & Rinse  
Assemble Trigger Assembly - Stage 1  
Assemble Trigger Assembly - Stage 2  
Adjust Trigger Assembly on Comparator 100%  
Function Check Complete Trigger Assembly 100%  
Repair Retected Trigger Assemblies

Effective Date: 14-Mar-08  
Origination Date: 10-Nov-05

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(Enter Oper #)

(Enter the Operation Name in this field)

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| <p><b>PROCESS CONTROL</b></p> <p><b>INSPECTION RECORD</b></p> <p>THIS RECORD MUST STAY<br/>WITH THE PRODUCTION<br/>ORDER AT ALL TIMES</p> |                                                              | Revision Date:<br><br><br><br><br><div style="text-align: right;"><b>14-Mar-08</b></div> |                                     |
|-------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------|------------------------------------------------------------------------------------------|-------------------------------------|
| Part No:                                                                                                                                  | Part Name: XVP TRIG ASSEY 700 7                              |                                                                                          | C/T                                 |
| Operation No. (Enter Oper #)                                                                                                              | Operation: _____<br>(Enter the Operation Name in this field) |                                                                                          |                                     |
| Prod. Qty.                                                                                                                                | Prod. Order #                                                |                                                                                          |                                     |
| Gage Description and Characteristic                                                                                                       | Gage Number                                                  | Gage Frequency                                                                           | Operator                            |
|                                                                                                                                           |                                                              |                                                                                          | 1st Shift    2nd Shift    3rd Shift |
| VISUAL                                                                                                                                    | V S U A L                                                    | 100%                                                                                     | INSPECT REJECT                      |
|                                                                                                                                           |                                                              |                                                                                          | INSPECT REJECT                      |
|                                                                                                                                           |                                                              |                                                                                          | INSPECT REJECT                      |
|                                                                                                                                           |                                                              |                                                                                          | INSPECT REJECT                      |
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|                                                                                                                                           |                                                              |                                                                                          | INSPECT REJECT                      |
|                                                                                                                                           |                                                              |                                                                                          | INSPECT REJECT                      |
|                                                                                                                                           |                                                              | Pieces Run:                                                                              |                                     |

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Date: <autodate>

Work Center:

Setup Inspected by & Date:

Remarks, Causes, Action Taken, Etc.

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## Demagnetize Springs

Demagnetize Springs

Procedure:

1. Place Sear Springs, Safety Detent Springs, and Trigger Pull 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 ".

[illegible]

STD. PAN 6"X3"X2"

Sld. Machine-Electr-Malic Type A13

|                                          |  |  |  |                    |                                                              |                     |                |                  |
|------------------------------------------|--|--|--|--------------------|--------------------------------------------------------------|---------------------|----------------|------------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b> |  |  |  |                    | THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                     | Revision Date: |                  |
| <b>Part No:</b>                          |  |  |  | Part Name:         |                                                              | XMP TRIG ASSY 700.7 |                | C/F              |
| Operation No. 5                          |  |  |  | Operation:         |                                                              | Demagnetize Springs |                |                  |
| Prod. Qty.                               |  |  |  | Prod. Order #.     |                                                              | <b>Operator</b>     |                |                  |
| Gage Description and Characteristic      |  |  |  | Gage Number        |                                                              | Gage Frequency      |                | <b>1st Shift</b> |
| VISUAL                                   |  |  |  | VISUAL             |                                                              | 100%                |                | <b>2nd Shift</b> |
|                                          |  |  |  |                    |                                                              |                     |                | INSPECT          |
|                                          |  |  |  |                    |                                                              |                     |                | REJECT           |
|                                          |  |  |  |                    |                                                              |                     |                | INSPECT          |
|                                          |  |  |  |                    |                                                              |                     |                | REJECT           |
|                                          |  |  |  | <b>Pieces Run:</b> |                                                              |                     |                |                  |

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| 3rd Shift | Remarks, Causes, Action Taken, Etc.             |                  |
|           |                                                 |                  |
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The below components must be Ultrasonically Cleaned before applying  
Loctite and Prior to Assembly.

- 300660
- 306380
- 300664
- 300914
- 300696
- 300662
- 306381

| Step | Operation / Step Description |
|------|------------------------------|
| 1    |                              |
| 2    |                              |
| 3    |                              |
| 4    |                              |
| 5    |                              |
| 6    |                              |
| 7    |                              |
| 8    |                              |
| 9    |                              |
| 10   |                              |
| 11   |                              |
| 12   |                              |

| Tool                                                                       | Tooling Description |
|----------------------------------------------------------------------------|---------------------|
| Ultrasonic Cleaning Bath                                                   |                     |
| Generator setting - 50                                                     |                     |
| Temperature - 150°F                                                        |                     |
| Cleaner - Wintech 758 Concentration 8% (12 Parts Water 1 Part Wintech 758) |                     |
| Soak Time - 5 Min.                                                         |                     |
| <u>TANK TO BE DUMPED AND RECHARGED PRIOR TO EACH OPERATING SHIFT.</u>      |                     |
| Hot Water Rinse                                                            |                     |
| Temperature Setting - 180°F                                                |                     |
| <u>TANK TO BE DUMPED AND RECHARGED PRIOR TO EACH OPERATING SHIFT.</u>      |                     |

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Ultrasonic Clean & Rinse

RT Blocker  
TRIGGER HOUSING ASSY PLATED  
BLOCKER ADJUSTMENT SCREW  
TRIGGER PULL ADJUSTMENT SCREW  
TRIGGER ENGAGEMENT SCREW  
LH blocker  
LH TRIGGER HOUSING ASSY PLATED

Allow tanks to reach temperature.  
Place parts in appropriate basket.  
Place Basket in Wash Tank.  
Turn on Ultrasonic Control on Blue Ultrasonic Generator.  
Leave in Wash Tank for 5 Minutes.  
Lift basket from wash solution, hold for short period to drain  
the cleaner from the parts.  
Turn Off Blue Ultrasonic Generator.  
Place in Hot Water rinse moving basket up and down several times.  
Lift basket out of the rinse and allow to drain for short period.  
Remove basket from hot water rinse tank and dump parts on to  
bench top to cool.

**DO NOT BLOW OFF WITH COMPRESSED AIR.** Compressed air contains  
oil and this oil can contaminate the parts and interfere  
with the Loctite operation.

When the wash operation is complete for the shift turn off and  
unplug Ultrasonic Wash and Hot Water Rinse tank.

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|                                     |                | Revision<br>Date: 14-Mar-08 |                     |
| Part Name: XMP TRIG ASSY 700 7      |                | C/F                         |                     |
| Operation: Ultrasonic Clean & Rinse |                |                             |                     |
| Prod. Order #:                      |                | Operator                    |                     |
| Gage Number                         | Gage Frequency | 1st Shift                   | 2nd Shift 3rd Shift |
| VISUAL                              | 100%           | INSPECT<br>REJECT           |                     |
|                                     |                | INSPECT<br>REJECT           |                     |
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| Pieces Run:                         |                |                             |                     |

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Parts listed below need to be clean and dry prior to Loctite Application and Assembly.

Loctite can not be applied on the screws and threaded in the hole until final settings.  
Loctite can be applied separately.

Tooling:

Fixture press:

300660

306380

300664

300914

300696

{300662 LH blocker, 306381 LH trigger housing assy plated}

(24484, m7 bolt stop pin used in place of slave pins for all settings)

Install the Trigger into the Trigger Housing

1. Insert Trigger into the trigger housing from the bottom as shown in Figure 1.

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Assemble Trigger Assembly - Stage 1

D-55465 Used for press fit pins, RH  
D-56271 Used for press fit pins, LH

|                               |      |
|-------------------------------|------|
| RH Blocker                    |      |
| TRIGGER LOUSING ASSY PLATED   |      |
| BLOCKER ADJUSTMENT SCREW      | 660  |
| TRIGGER PULL ADJUSTMENT SCREW | NONE |
| TRIGGER ENGAGEMENT SCREW      | 660  |

Loctite



Figure 1

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**Insert the Blocker**

2. Insert the blocker with out the blocker screw through the hole in the right hand side plate of the trigger housing as shown in Figure 2.  
(apply 660 in threaded hole prior to assembly, apply only enough to slightly cover threads)

**Trigger Pivot Pin Installation**

3. Insert the **trigger pivot pin** through the hole in the blocker, the right hand side plate, and the trigger. Align the hole in the blocker with the shoulder on the trigger pin before pressing the pin into the hole in the left hand side plate. See Figure 3.

**Fixture press:**  
D-55465, RH  
D-56271, LH

**Add Blocker Hold Down Stud**

4. Insert the **blocker hold down stud** through the upper blocker and tap with hammer to start in the hole the trigger housing per Figure 4. Insert a 3.119" gage pin into the trigger pull screw hole. Place assembly into press fixture, and press the stud into

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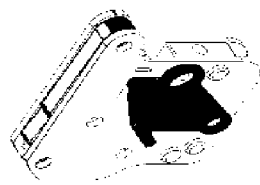


Figure 2

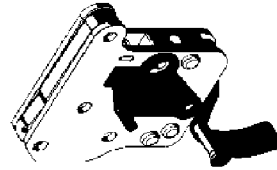


Figure 3

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the hole in the trigger housing until opening in the trigger housing aligns with the hole in the trigger housing. Remove 0.119" pin.

**Insert the Safety**

5. Slide the safety assembly or into the opening at the rear of the trigger assembly as shown in Figure 5. Bias the camming leg of the safety against the inside surface of the right hand side plate of the trigger housing. Insert a bolt stop pin thru the pivot hole to temporarily secure the safety to the housing.

**Insert the Safety Detent Spring**

6. Slide the safety assembly's offset leg over the post on the blocker. Before allowing the post to snap into the slot on the safety, insert the short leg of the **safety detent spring** into the hole in the blocker and align the long leg of the spring with the small hole in the safety assembly as shown in Figure 6.

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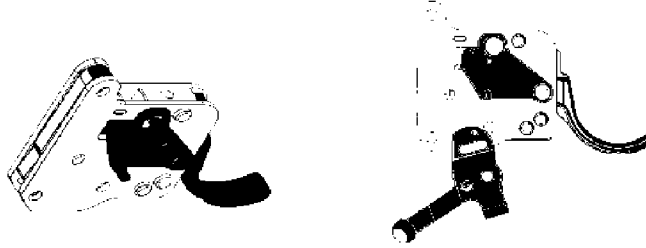


Figure 4

Figure 5

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**Install Trigger Pull Screw and Trigger Pull Spring**

7. Insert the **trigger pull screw** and **trigger pull spring** through the hole in the front spacer of the trigger assembly as shown in Figure 7.  
Adjust them inward until the screw head is 2 to 3 turns below the outer edge of the spacer.  
(No loctite used on this screw, Duco cement after final setting at final assembly)

**Install Bolt Stop Release and Trigger Pivot Pin Retaining Ring**

8. Place the **bolt stop release** against the left hand side plate such that its upper hole is aligned with the safety pivot hole in the trigger housing and the lower hole is over the end of the trigger pin. Insert the **trigger pivot pin retaining ring** over the Trigger Pivot Pin, use assembly tool C-56231.

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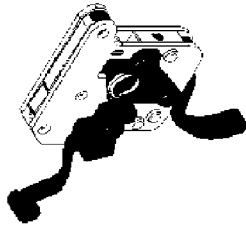


Figure 6



Figure 7

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NEVER REUSE TRIGGER PIVOT PIN AND RETAINING CLIP AFTER REMOVING THEM.

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|-------------------------------------|--|--------------------------------------------------------------|--|
| PROCESS CONTROL INSPECTION RECORD   |  | THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |
| Part No:                            |  |                                                              |  |
| Operation No. 10                    |  |                                                              |  |
| Prod. Qty:                          |  |                                                              |  |
| Gage Description and Characteristic |  |                                                              |  |
| VISUAL                              |  |                                                              |  |
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|                                                |                | Revision Date: 14-Mar-08 |           |           | Processed by:                                   |
| Part Name: XVP TRIG ASSY 700 7                 |                | C/F                      |           |           | Date:                                           |
| Operation: Assemble Trigger Assembly - Stage 1 |                |                          |           |           | Work Center:                                    |
| Prod. Order #:                                 |                | Operator                 |           |           | Setup inspected by & Date:                      |
| Gage Number                                    | Gage Frequency | 1st Shift                | 2nd Shift | 3rd Shift | Remarks, Causes, Action Taken, Etc.             |
| VISUAL                                         | 100%           | INSPECT<br>REJECT        | /         | /         |                                                 |
|                                                |                | INSPECT<br>REJECT        | /         | /         |                                                 |
| Pieces Run:                                    |                |                          |           |           | Remington Arms Company, Inc. -- Ilion, New York |

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**Assemble the Sear Safety Cam into the Trigger Housing**

9. Place the front end of **sear safety cam** into the **trigger housing** as shown in Figure 3. - Insert a m7 bolt stop pin through the trigger housing and sear pivot hole to retain the sear safety cam in the trigger housing.

**Insert the Sear Spring**

10. Place the sear spring on the sear spring support in the trigger housing as shown in Figure 9. - Rotate the tail of the sear safety cam downward until it passes the rear trigger assembly mounting hole and insert a m7 bolts stop pin to hold it down. Check to ensure the sear spring is properly located in the housing and on the sear safety cam.

**Install Safety Pivot Pin**

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Assemble Trigger Assembly - Stage 2

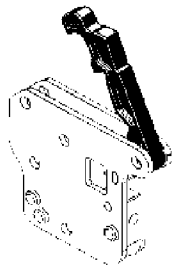


Figure 8

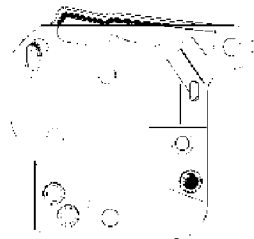


Figure 9

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11. Insert the **safety pivot pin** through the holes in the bolt stop release, trigger housing and safety and push it until the shoulder contacts the left hand side plate of the trigger housing as shown in Figure 10. The bolt stop release pin will be pushed out of the trigger housing.

**Add Safety Retainer**

12. Install the **safety retainer** on the safety pivot pin. Orient the safety retainer so that the legs stick up away from the safety assembly as shown in Figure 11. Make sure the all of retainer's legs are snapped into the groove in the safety pivot pin or the retainer can come off.

NEVER reuse the retainers after removing them

**Insert the Trigger Engagement Screw**

13. Insert the **engagement screw** into the rear hole of the trigger housing as shown in Figure 12. Use permanent Loctite (660) to secure the screw( DICO cement after Final set).  
NOTE: ROLL ENTIRE LENGTH OF THREAD IN LOCTITE 660 TO INSURE FULL APPLICATION.

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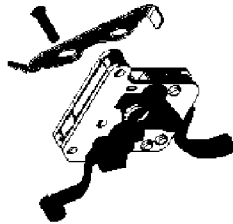


Figure 10

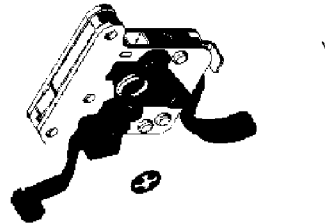


Figure 11

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**Loctite Blocker Screw**  
14. Thread the **blocker screw** into the **blocker** as shown in Figure 13.  
Use permanent Loctite (660) to secure the screw, the screw must be clean as noted in Operation 10.  
NOTE: ROLL ENTIRE LENGTH OF THREAD IN LOCTITE 660 TO INSURE FULL APPLICATION.

|                                     |  |                                                              |  |
|-------------------------------------|--|--------------------------------------------------------------|--|
| PROCESS CONTROL INSPECTION RECORD   |  | THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |
| Part No:                            |  |                                                              |  |
| Operation No: 20                    |  |                                                              |  |
| Pmd. Qty:                           |  |                                                              |  |
| Gage Description and Characteristic |  |                                                              |  |
| VISUAL                              |  |                                                              |  |
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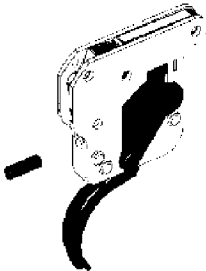


Figure 12



(blocker is already in trigger assembly)

Figure 13

|                                                |  |                |          |                          |           |                            |                                                 |  |  |
|------------------------------------------------|--|----------------|----------|--------------------------|-----------|----------------------------|-------------------------------------------------|--|--|
|                                                |  |                |          | Revision Date: 14-Mar-08 |           |                            |                                                 |  |  |
| Part Name: XVP TRIG ASSY 700.7                 |  |                |          | C/F                      |           |                            |                                                 |  |  |
| Operation: Assemble Trigger Assembly - Stage 2 |  |                |          |                          |           |                            |                                                 |  |  |
| Prod. Order #                                  |  |                | Operator |                          |           | Setup inspected by & Date: |                                                 |  |  |
| Gage Number                                    |  | Gage Frequency |          | 1st Shift                | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc.             |  |  |
| VISUAL                                         |  | 100%           |          | INSPECT<br>REJECT        |           |                            |                                                 |  |  |
|                                                |  |                |          | INSPECT<br>REJECT        |           |                            |                                                 |  |  |
| Pieces Run:                                    |  |                |          |                          |           |                            | Remington Arms Company, Inc. -- Ilion, New York |  |  |

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| Tool Number         | Tooling Description |
|---------------------|---------------------|
| E-55423             |                     |
| E-55466             |                     |
| D-700-CI-252, Rev 3 |                     |
| D-700-CI-254        |                     |

"Loctite will start to cure in 3 to 7 minutes"

"Make sure final settings are complete before loctite starts to cure"

Note: Use 50X magnification for making all adjustments using Comparator

15) Mark correctly assembled and adjusted trigger assembly with adjuster's identification

Locate trigger assembly on stamping fixture.

NOTE: MAKE SURE STAMP POSITION ON HOUSING DOES NOT DEFORM HOUSING (i.e. PLACE STAMP OVER A SPACER BLOCK)

Stamp adjusters identification on the right hand side above the top rivet and below the safety,  
Stamp should also be as close to the rear of the assembly as reasonable.

\*Holding block for stamp E-53512

\*Use 1/16" size character

16) Setting Trigger / Sear Engagement - Use the Upper Zone on Comparator Screen as Marked

The Trigger and Sear engagement setting is done with the safety in the FIRE position.

When mounting the Fire Control in the comparator fixture, use thumb pressure to push the assembly  
firmly against the rear stops before engaging the toggle clamp.

16a) With the Sear held against the trigger, focus the screen image and align the Sear edge front  
face to the set edge line on the comparator screen. Without adjusting the fixture location, re-focus the  
comparator for a sharp image of the trigger. Turn the engagement screw to position the trigger edge  
within the .021" MAX and 0.019" MIN lines on the comparator screen. See Figure 14.

Note: For all screw settings, the tools must be removed carefully to prevent unwanted adjustments.

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Adjust Trigger Assembly on Comparator 100%

Comparator fixture RH SPL  
Comparator fixture LH SPL  
Comparator Screen, RH  
Comparator Screen, LH



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17) **Setting Trigger Pull Force - Use the Upper Zone on Comparator Screen as Marked**

Adjust the Trigger pull force with the sear held against the trigger and the safety in the **FIRE** position. Hang a 5.5 pound load from the trigger and adjust the Trigger Pull Screw until the Trigger rotates from underneath the Sear Safety Cam, allowing the Cam to drop. See Figure 15

18) **Cycle and Recheck**

Remove the weight from the Trigger, release the toggle clamp, and allow the Sear and Trigger to re-engage. Dry cycle the fire control a minimum of 5 times. Recheck engagement and Trigger pull and adjust as necessary.

19) **Setting the Blocker Screw - Use the Lower Zone on Comparator Screen as Marked**

Release the toggle clamp and move the Safety to the **SAFE** position. Remount the assembly in the fixture and bring the trigger edge to a sharp focus. Align the Trigger with the set edge for Blocker Screw Adjustment as marked on the Comparator screen. Adjust the Blocker Screw inward until there is 0.003" MIN to 0.006" MAX visible motion of the trigger when pulled with a 7 pound load. Ideally, the blocker screw setting should be made to show visible Trigger motion just past the MIN position line on the comparator screen. Recheck and adjust as necessary. See Figure 16

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Direction and location for setting trigger pull force

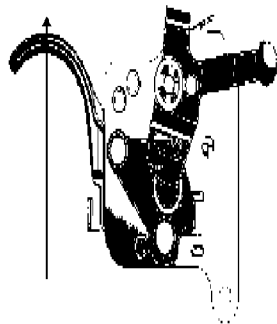
Figure 15



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Figure 14

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Trigger / Sear Engagement



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- 20) **Inspection**  
Return the Safety to **FIRE**. Check engagement. Adjust as needed.  
Recheck trigger pull at 5.5 lbs. Adjust as needed.  
Move the Safety to the **SAFE** position. Check blocker screw setting. Adjust as needed.  
**NOTE: An adjustment for one setting dictates the other setting must be re-checked.**

- 21) **Loctite Cure Time**  
Allow LOCTITE 660 to cure for a minimum of 24 hours at room temperature or 2 hours at 120 Deg  
before performing function checks. Note: mark cure cycle information on all loads.

| PROCESS CONTROL INSPECTION RECORD   |  | THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |
|-------------------------------------|--|--------------------------------------------------------------|
| Part No:                            |  |                                                              |
| Operation No: 30                    |  |                                                              |
| Prod. Qty:                          |  |                                                              |
| Gage Description and Characteristic |  |                                                              |
| VISUAL                              |  |                                                              |
|                                     |  |                                                              |
|                                     |  |                                                              |

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Figure 16

|                                                       |                |                          |           |           |
|-------------------------------------------------------|----------------|--------------------------|-----------|-----------|
|                                                       |                | Revision Date: 14-Mar-08 |           |           |
| Part Name: XMP TRIG ASSY 700 7                        |                | C/F                      |           |           |
| 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                   |           |           |
| Pieces Run:                                           |                |                          |           |           |

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3" Max Movement with 7 lb Load on Trigger

|                                                 |                  |
|-------------------------------------------------|------------------|
|                                                 | Processed by:    |
|                                                 | Date: <autodate> |
|                                                 | Work Center:     |
| Setup Inspected by & Date:                      |                  |
| Remarks, Causes, Action Taken, Etc.             |                  |
|                                                 |                  |
|                                                 |                  |
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| Step | Operation / Step Description                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
|------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|      | Function check completed Trigger Assembly 100%                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|      | NOTE: Do A-L Elements 100%, but not until after completion of LOCTITE 660 cure cycle, as defined in previous operation: 24 hours at room temperature, or 2 hours at 120 Deg.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| 1.   | Apply Molycoat to top surface of trigger.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |
| 2.   | Put Safety in "FIRE" position.<br><br>Check for:<br><br>TRIGGER RETRACTION<br>Pull Trigger and release:<br><br>* Trigger must return freely to original position<br>WITH SPRING FORCE.<br><br>BLOCKER SCREW MOVEMENT<br>Using a 1/16" allen wrench and 2 finger pressure, lightly torque the blocker screw in each direction. No screw movement is allowed.<br><br>TRIGGER ENGAGEMENT SCREW MOVEMENT<br>Using a 1/16" allen wrench and 2 finger pressure, lightly torque the trigger engagement screw in each direction. No screw movement is allowed.<br><br>SEAR FREEDOM<br>Pull Trigger and hold. Depress Sear FULLY and release:<br><br>* Sear must move freely in housing without binding. The Sear must return upward under Sear Spring force. |
| 3.   | Put Safety in "SAFE" position.<br>Apply finger pressure to trigger. No movement of trigger from under sear should be visible.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |
| 4.   | Operation of Safety<br><br>Move Safety from "SAFE" to "FIRE" position and back.<br>Do this TWICE:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| 5.   | Visual Inspection of Safety Retainer                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |

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Function Check Complete Trigger Assembly 100%

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Make sure the all of retainer's legs are snapped into the groove in the safety pivot pin

6. Visual inspection of Safety Detent Spring

Make sure each end of Spring is securely located in the holes in the Blocker and Safety

7. Visual inspection of Bolt Stop Release

The bolt stop release should be free to move the entire range of the slotted holes.

8. Visual inspection Blocker Hold Down Stud and Trigger Pivot Pin

The head of each pin should be flush against the outer surface of the Blocker

9. Apply sealing layer of DUCO cement to the head of the Trigger Engagement Screw and Blocker Screw.

10. Apply 1 or 2 drops of REM OIL to the contact point of the Safety Slot and the Blocker Post.

11) Mark trigger assembly with inspector's identification stamp.

Locate trigger assembly on stamping fixture.

NOTE: MAKE SURE STAMP POSITION ON HOUSING DOES NOT DEFORM HOUSING (i.e. PLACE STAMP OVER A SPACER BLOCK)

Stamp inspector's identification on the left hand side above the top rivet and below the safety,

Stamp should also be as close to the rear of the assembly as reasonable.

\*Holding block for stamp B-53512

\*Use 1/16" size character

| PROCESS CONTROL INSPECTION RECORD   |  | THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |
|-------------------------------------|--|--------------------------------------------------------------|
| Part No:                            |  |                                                              |
| Operation No. 40                    |  |                                                              |
| Prod. Qty:                          |  |                                                              |
| Gage Description and Characteristic |  |                                                              |
| VISUAL                              |  |                                                              |
| #REF!                               |  |                                                              |
|                                     |  |                                                              |
|                                     |  |                                                              |

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|                                                          |                |                          |           |
|----------------------------------------------------------|----------------|--------------------------|-----------|
|                                                          |                | Revision Date: 14-Mar-08 |           |
| Part Name: XMP TRIG ASSY 700 7                           |                | C/F                      |           |
| Operation: Function Check Complete Trigger Assembly 100% |                |                          |           |
| Prod. Order #:                                           |                | Operator                 |           |
| Gage Number                                              | Gage Frequency | 1st Shift                | 2nd Shift |
| VISUAL                                                   | 100%           | INSPECT<br>REJECT        |           |
| #REF!                                                    | 100%           | INSPECT<br>REJECT        |           |
|                                                          |                | INSPECT<br>REJECT        |           |
| Pieces Run:                                              |                |                          |           |

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|                                                 |                  |
|-------------------------------------------------|------------------|
|                                                 | Processed by:    |
|                                                 | Date: <autodate> |
|                                                 | Work Center:     |
| Setup inspected by & Date:                      |                  |
| Remarks, Causes, Action Taken, Etc.             |                  |
|                                                 |                  |
|                                                 |                  |
|                                                 |                  |
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60R

Repair Rejected Trigger Assemblies

| Step | Operation / Step Description                                                                                               |
|------|----------------------------------------------------------------------------------------------------------------------------|
|      | Repair Rejected Trigger Assemblies                                                                                         |
|      | NOTE: Each repair Trigger Assembly is to go to Assembler who originally built it.                                          |
|      | 1. Make corrections as required.<br>Disassemble and scrap all questionable parts.                                          |
|      | NOTE: DO NOT REUSE THE RETAINERS AFTER REMOVING THEM                                                                       |
|      | 2. Return Trigger Assembly to process at point where it will again receive all applicable adjustments and function checks. |

|                                     |  |                                                              |  |
|-------------------------------------|--|--------------------------------------------------------------|--|
| PROCESS CONTROL INSPECTION RECORD   |  | THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |
| Part No:                            |  | Part Name:                                                   |  |
| Operation No: 60R                   |  | Operation:                                                   |  |
| Prod. Qty:                          |  | Prod. Order #:                                               |  |
| Gage Description and Characteristic |  | Gage Number                                                  |  |
| VISUAL                              |  | VISUAL                                                       |  |
|                                     |  |                                                              |  |
|                                     |  | Pieces Run:                                                  |  |

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|                                                 |                          |           |           |                                     |
|-------------------------------------------------|--------------------------|-----------|-----------|-------------------------------------|
|                                                 | Revision Date: 14-Mar-08 |           |           | Processed by:                       |
| XMP TR G ASSY 700 7                             | C/F                      |           |           | Date: <autodate>                    |
| Repair Rejected Trigger Assemblies              |                          |           |           | Work Center:                        |
|                                                 | Operator                 |           |           | Setup Inspected by & Date:          |
| Gage Frequency                                  | 1st Shift                | 2nd Shift | 3rd Shift | Remarks, Causes, Action Taken, Etc: |
| 100%                                            | INSPECT                  |           |           |                                     |
|                                                 | REJECT                   |           |           |                                     |
|                                                 | INSPECT                  |           |           |                                     |
|                                                 | REJECT                   |           |           |                                     |
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| Dept     | Oper | Operation Description                                            | Part Numbers                                           |
|----------|------|------------------------------------------------------------------|--------------------------------------------------------|
| 9132     | 1    | Issue from Crib                                                  | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773     | 5    | Demagnetize Springs                                              | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773     | 8    | Ultrasonic Clean & Rinse                                         | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773     | 10   | Assemble Trigger Assembly - Stage 1                              | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773     | 20   | Assemble Trigger Assembly - Stage 2                              | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773     | 30   | Adjust Trigger Assembly or Comparator 100%                       | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773     | 40   | Function Check Complete Trigger Assembly 100%<br>To MRP Crib #29 | 305570 305571 305572<br>305573 305574 305575<br>305576 |
| 8773 60R |      | Repair Rejected Trigger Assemblies<br>To MRP Crib #29            | 305570 305571 305572<br>305573 305574 305575<br>305576 |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM | Description                         |
|--------|----|--------|-----|------|-------|----|-------------------------------------|
|        |    |        |     |      |       |    | 305570 TRIGGER ASSY 700 RH BLACK    |
|        |    |        |     |      |       |    | 305571 TRIGGER ASSY 700SS RH SILVER |
|        |    |        |     |      |       |    | 305572 TRIGGER ASSY 700 LH BLACK    |
|        |    |        |     |      |       |    | 305573 TRIGGER ASSY 700SS LH SILVER |
|        |    |        |     |      |       |    | 305574 TRIGGER ASSY 7 BLACK         |
|        |    |        |     |      |       |    | 305575 TRIGGER ASSY 7SS SILVER      |
|        |    |        |     |      |       |    | 305576 TRIGGER ASSY 700ML SILVER    |
| 305570 |    |        |     |      |       |    | TRIGGER ASSY 700 RH BLACK           |
|        |    | 300660 | 10  | 20   | 1.000 |    | BLOCKER                             |
|        |    | 300664 | 20  | 30   | 1.000 |    | BLOCKER ADJUSTMENT SCREW            |
|        |    | 300666 | 30  | 20   | 1.000 |    | BLOCKER HOLD DOWN STUD              |
|        |    | 300668 | 40  | 20   | 1.000 |    | BCIT STOP RELEASE                   |
|        |    | 301517 | 45  | 20   | 1.000 |    | RETAINING RING                      |
|        |    | 305580 | 50  | 20   | 1.000 |    | SAFETY ASSY PLATED                  |
|        |    | 300679 | 60  | 10   | 1.000 |    | SAFETY DETENT SPRING                |
|        |    | 300682 | 70  | 20   | 1.000 |    | SAFETY PIVOT PIN                    |
|        |    | 300683 | 80  | 20   | 1.000 |    | SAFETY RETAINING CLIP               |
|        |    | 401623 | 90  | 20   | 1.000 |    | SEAR SAFETY CAM A2                  |
|        |    | 300686 | 100 | 10   | 1.000 |    | GEAR SPRING                         |
|        |    | 300688 | 110 | 20   | 1.000 |    | TRIGGER                             |
|        |    | 300696 | 120 | 20   | 1.000 |    | TRIGGER ENGAGEMENT SCREW            |
|        |    | 306380 | 130 | 20   | 1.000 |    | TRIGGER HOUSING ASSY PLATED         |
|        |    | 301516 | 140 | 20   | 1.000 |    | TRIGGER PIVOT PIN - GROOVED         |
|        |    | 300914 | 150 | 20   | 1.000 |    | TRIGGER FULL ADJUSTMENT SCREW       |
|        |    | 300694 | 160 | 10   | 1.000 |    | TRIGGER PULL SPRING                 |
|        |    | 24484  | 170 | 20   | 0.500 |    | BCIT STOP PIN                       |
| 305571 |    |        |     |      |       |    | TRIGGER ASSY 700SS RH SILVER        |
|        |    | 300660 | 10  | 20   | 1.000 |    | BLOCKER                             |
|        |    | 300664 | 20  | 30   | 1.000 |    | BLOCKER ADJUSTMENT SCREW            |
|        |    | 300666 | 30  | 20   | 1.000 |    | BLOCKER HOLD DOWN STUD              |
|        |    | 300668 | 40  | 20   | 1.000 |    | BCIT STOP RELEASE                   |
|        |    | 301517 | 45  | 20   | 1.000 |    | RETAINING RING                      |
|        |    | 305581 | 50  | 20   | 1.000 |    | SAFETY ASSY PLATED                  |
|        |    | 300679 | 60  | 10   | 1.000 |    | SAFETY DETENT SPRING                |
|        |    | 300682 | 70  | 20   | 1.000 |    | SAFETY PIVOT PIN                    |
|        |    | 300683 | 80  | 20   | 1.000 |    | SAFETY RETAINING CLIP               |
|        |    | 401623 | 90  | 20   | 1.000 |    | SEAR SAFETY CAM A2                  |
|        |    | 300686 | 100 | 10   | 1.000 |    | SEAR SPRING                         |

**BARBER - RE 0002740**

RE00002712

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|        |        |     |    |       |                               |
|--------|--------|-----|----|-------|-------------------------------|
|        | 300688 | 110 | 20 | 1.000 | TRIGGER                       |
|        | 300696 | 120 | 20 | 1.000 | TRIGGER ENGAGEMENT SCREW      |
|        | 306380 | 130 | 20 | 1.000 | TRIGGER HOUSING ASSY PLATED   |
|        | 301516 | 140 | 20 | 1.000 | TRIGGER PIVOT PIN - GROOVED   |
|        | 300914 | 150 | 20 | 1.000 | TRIGGER PULL ADJUSTMENT SCREW |
|        | 300694 | 160 | 10 | 1.000 | TRIGGER PULL SPRING           |
|        | 24484  | 170 | 20 | 0.500 | BOLT STOP PIN                 |
| 305572 |        |     |    |       | TRIGGER ASSY 700 LH BLACK     |
|        | 300662 | 10  | 20 | 1.000 | BLOCKER                       |
|        | 300664 | 20  | 30 | 1.000 | BLOCKER ADJUSTMENT SCREW      |
|        | 300666 | 30  | 20 | 1.000 | BLOCKER HOLD DOWN STUD        |
|        | 300670 | 40  | 20 | 1.000 | BOLT STOP RELEASE             |
|        | 301517 | 45  | 20 | 1.000 | RETAINING RING                |
|        | 305582 | 50  | 20 | 1.000 | SAFETY ASSY PLATED            |
|        | 300680 | 60  | 10 | 1.000 | SAFETY DETENT SPRING          |
|        | 300682 | 70  | 20 | 1.000 | SAFETY PIVOT PIN              |
|        | 300683 | 80  | 20 | 1.000 | SAFETY RETAINING CLIP         |
|        | 401623 | 90  | 20 | 1.000 | SEAR SAFETY CAM A2            |
|        | 300686 | 100 | 10 | 1.000 | SEAR SPRING                   |
|        | 300688 | 110 | 20 | 1.000 | TRIGGER                       |
|        | 300696 | 120 | 20 | 1.000 | TRIGGER ENGAGEMENT SCREW      |
|        | 306381 | 130 | 20 | 1.000 | TRIGGER HOUSING ASSY PLATED   |
|        | 301516 | 140 | 20 | 1.000 | TRIGGER PIVOT PIN - GROOVED   |
|        | 300914 | 150 | 20 | 1.000 | TRIGGER PULL ADJUSTMENT SCREW |
|        | 300694 | 160 | 10 | 1.000 | TRIGGER PULL SPRING           |
|        | 24484  | 170 | 20 | 0.500 | BOLT STOP PIN                 |
| 305573 |        |     |    |       | TRIGGER ASSY 700SS LH SILVER  |
|        | 300662 | 10  | 20 | 1.000 | BLOCKER                       |
|        | 300664 | 20  | 30 | 1.000 | BLOCKER ADJUSTMENT SCREW      |
|        | 300666 | 30  | 20 | 1.000 | BLOCKER HOLD DOWN STUD        |
|        | 300670 | 40  | 20 | 1.000 | BOLT STOP RELEASE             |
|        | 301517 | 45  | 20 | 1.000 | RETAINING RING                |
|        | 305583 | 50  | 20 | 1.000 | SAFETY ASSY PLATED            |
|        | 300680 | 60  | 10 | 1.000 | SAFETY DETENT SPRING          |
|        | 300682 | 70  | 20 | 1.000 | SAFETY PIVOT PIN              |
|        | 300683 | 80  | 20 | 1.000 | SAFETY RETAINING CLIP         |
|        | 401623 | 90  | 20 | 1.000 | SEAR SAFETY CAM A2            |
|        | 300686 | 100 | 10 | 1.000 | SEAR SPRING                   |
|        | 300688 | 110 | 20 | 1.000 | TRIGGER                       |
|        | 300696 | 120 | 20 | 1.000 | TRIGGER ENGAGEMENT SCREW      |
|        | 306381 | 130 | 20 | 1.000 | TRIGGER HOUSING ASSY PLATED   |
|        | 301516 | 140 | 20 | 1.000 | TRIGGER PIVOT PIN - GROOVED   |
|        | 300914 | 150 | 20 | 1.000 | TRIGGER PULL ADJUSTMENT SCREW |
|        | 300694 | 160 | 10 | 1.000 | TRIGGER PULL SPRING           |
|        | 24484  | 170 | 20 | 0.500 | BOLT STOP PIN                 |

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|        |         |     |    |       |                               |
|--------|---------|-----|----|-------|-------------------------------|
| 305574 | 300660  | 10  | 20 | 1.000 | TRIGGER ASSY 7 BLACK          |
|        | BLOCKER |     |    |       |                               |
|        | 300664  | 20  | 30 | 1.000 | BLOCKER ADJUSTMENT SCREW      |
|        | 300666  | 30  | 20 | 1.000 | BLOCKER HOLD DOWN STUD        |
|        | 300672  | 40  | 20 | 1.000 | BOLT STOP RELEASE             |
|        | 301517  | 45  | 20 | 1.000 | RETAINING RING                |
|        | 305584  | 50  | 20 | 1.000 | SAFETY ASSY PLATED            |
|        | 300679  | 60  | 10 | 1.000 | SAFETY DETENT SPRING          |
|        | 300682  | 70  | 20 | 1.000 | SAFETY PIVOT PIN              |
|        | 300683  | 80  | 20 | 1.000 | SAFETY RETAINING CLIP         |
|        | 401623  | 90  | 20 | 1.000 | SEAR SAFETY CAM A2            |
|        | 300686  | 100 | 10 | 1.000 | SEAR SPRING                   |
|        | 300688  | 110 | 20 | 1.000 | TRIGGER                       |
|        | 300696  | 120 | 20 | 1.000 | TRIGGER ENGAGEMENT SCREW      |
|        | 306380  | 130 | 20 | 1.000 | TRIGGER HOUSING ASSY PLATED   |
|        | 301516  | 140 | 20 | 1.000 | TRIGGER PIVOT PIN - GROOVED   |
|        | 300914  | 150 | 20 | 1.000 | TRIGGER PULL ADJUSTMENT SCREW |
|        | 300694  | 160 | 10 | 1.000 | TRIGGER PULL SPRING           |
|        | 24484   | 170 | 20 | 0.500 | BOLT STOP PIN                 |
| 305575 |         |     |    |       | TRIGGER ASSY 7SS SILVER       |
|        | 300660  | 10  | 20 | 1.000 | BLOCKER                       |
|        | 300664  | 20  | 30 | 1.000 | BLOCKER ADJUSTMENT SCREW      |
|        | 300666  | 30  | 20 | 1.000 | BLOCKER HOLD DOWN STUD        |
|        | 300672  | 40  | 20 | 1.000 | BOLT STOP RELEASE             |
|        | 301517  | 45  | 20 | 1.000 | RETAINING RING                |
|        | 305585  | 50  | 20 | 1.000 | SAFETY ASSY PLATED            |
|        | 300679  | 60  | 10 | 1.000 | SAFETY DETENT SPRING          |
|        | 300682  | 70  | 20 | 1.000 | SAFETY PIVOT PIN              |
|        | 300683  | 80  | 20 | 1.000 | SAFETY RETAINING CLIP         |
|        | 401623  | 90  | 20 | 1.000 | SEAR SAFETY CAM A2            |
|        | 300686  | 100 | 10 | 1.000 | SEAR SPRING                   |
|        | 300688  | 110 | 20 | 1.000 | TRIGGER                       |
|        | 300696  | 120 | 20 | 1.000 | TRIGGER ENGAGEMENT SCREW      |
|        | 306380  | 130 | 20 | 1.000 | TRIGGER HOUSING ASSY PLATED   |
|        | 301516  | 140 | 20 | 1.000 | TRIGGER PIVOT PIN - GROOVED   |
|        | 300914  | 150 | 20 | 1.000 | TRIGGER PULL ADJUSTMENT SCREW |
|        | 300694  | 160 | 10 | 1.000 | TRIGGER PULL SPRING           |
|        | 24484   | 170 | 20 | 0.500 | BOLT STOP PIN                 |
| 305576 |         |     |    |       | TRIGGER ASSY 700ML SILVER     |
|        | 300660  | 10  | 20 | 1.000 | BLOCKER                       |
|        | 300664  | 20  | 30 | 1.000 | BLOCKER ADJUSTMENT SCREW      |
|        | 300666  | 30  | 20 | 1.000 | BLOCKER HOLD DOWN STUD        |
|        | 301517  | 45  | 20 | 1.000 | RETAINING RING                |
|        | 305581  | 50  | 20 | 1.000 | SAFETY ASSY PLATED            |

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|        |     |    |       |                               |
|--------|-----|----|-------|-------------------------------|
| 300679 | 60  | 10 | 1.000 | SAFETY DETENT SPRING          |
| 300682 | 70  | 20 | 1.000 | SAFETY PIVOT PIN              |
| 300683 | 80  | 20 | 1.000 | SAFETY RETAINING CLIP         |
| 401623 | 90  | 20 | 1.000 | SEAR SAFETY CAM A2            |
| 300686 | 100 | 10 | 1.000 | SEAR SPRING                   |
| 300688 | 110 | 20 | 1.000 | TRIGGER                       |
| 300696 | 120 | 20 | 1.000 | TRIGGER ENGAGEMENT SCREW      |
| 306380 | 130 | 20 | 1.000 | TRIGGER HOUSING ASSY PLATED   |
| 301516 | 140 | 20 | 1.000 | TRIGGER PIVOT P.L.N - GROOVED |
| 300914 | 150 | 20 | 1.000 | TRIGGER PULL ADJUSTMENT SCREW |
| 300694 | 160 | 10 | 1.000 | TRIGGER PULL SPRING           |
| 24484  | 170 | 20 | 0.500 | BOLT STOP PIN                 |

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| Date:     | Reason for Revision:                                                                                                                                                                                           | Eng: | Log #: |
|-----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|--------|
| 10-Feb-05 | NEW                                                                                                                                                                                                            | GLC  | 313771 |
| 15-Mar-05 | REWRITE OPERATION DETAIL INFO FOR OP#20, 30, 40, & 50                                                                                                                                                          | GLC  | 314153 |
| 17-Mar-05 | REVISE OPERATION STEPS OF OP#20 & 30                                                                                                                                                                           | GLC  | 314154 |
| 18-Mar-05 | REVISE OPERATION STEPS OF OP#20 & 30                                                                                                                                                                           | GLC  | 314158 |
| 08-Apr-05 | DEPT 8772 WAS 8579                                                                                                                                                                                             | GLC  | 314361 |
| 29-Aug-05 | DEPT#8773 WAS 8772                                                                                                                                                                                             | GLC  | 315338 |
| 20-Dec-05 | PT#305570 305571 305574 305575 & 305576 - TRIGGER HOUSING ASSY<br>PT#306380 WAS 305390<br>PT#305572 & 305573 - TRIGGER HOUSING ASSY PT#306381 WAS 305591                                                       | GLC  | 316386 |
| 27-Jun-06 | ADD DETAIL INFO TO OP#20                                                                                                                                                                                       | GLC  | 316331 |
| 16 Mar 06 | Added new loctite and ultra sonic cleaner pre loctite<br>262 for blocker screw is now 660<br>242 for engagement screw is now 660<br>242 for trigger pull screw is now 643                                      | JFD  | 311936 |
| 22-Mar-06 | Added fixture press in op 20 for pressing pins                                                                                                                                                                 | JFD  | 311937 |
| 27-Mar-06 | Removed loctite on trigger pull screw at op 20<br>Added wording to duco cement engagement and trigger pull<br>screw after final settings in op 20                                                              | JFD  |        |
| 13-Apr-06 | OP 20 Changed wording to move trigger pull final settings<br>to final assembly.<br>Moved trigger assembly settings from op 20 to proper<br>location in op 30<br>Removed old fire control steps and terminology | JFD  | 311939 |
| 24-Apr-06 | Increase blocker adjustment from .003" Max to .006" Max<br>and .003" Min                                                                                                                                       | JFD  | 311940 |

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|           |                                                                                                                                                                                                                                                                                                                                                                                                                                   |     |        |
|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|--------|
| 27-Apr-06 | Added molykote to op 30 and increased pull settings to 4.5#                                                                                                                                                                                                                                                                                                                                                                       | JFD | 311941 |
|           | Added .030" shim for blocker assembly to aid in op 20                                                                                                                                                                                                                                                                                                                                                                             |     |        |
|           | Removed duco cement to trigger pull screw in op 30                                                                                                                                                                                                                                                                                                                                                                                |     |        |
| 18-May-06 | Clarified wording in op 30 to apply duco on trigger pull screw at final assembly                                                                                                                                                                                                                                                                                                                                                  | JFD | 311942 |
|           | op 30, Slave pins removed from process                                                                                                                                                                                                                                                                                                                                                                                            |     |        |
|           | Increase trigger pull weight from 4.5# to 5# to assist setting at final assembly in op30                                                                                                                                                                                                                                                                                                                                          |     |        |
| 30-Jun-06 | Op 20, Molycoat to be applied to trigger in step 4                                                                                                                                                                                                                                                                                                                                                                                | CSB | 315058 |
|           | Op 30, Trigger pull setting moved ahead of blocker adjustment, Op 40, Add note to allow for 4 hour Loctite cure before function checks.                                                                                                                                                                                                                                                                                           |     |        |
| 19-Jul-06 | Moved all assembly content contained in Op 30 to Op 20, and added section headers for each individual step.                                                                                                                                                                                                                                                                                                                       | CSB | 315859 |
|           | Op 30 - Noted zones on comparator screen for each adjustment step, added section 16, cycle and re-check and section 18, inspection.                                                                                                                                                                                                                                                                                               |     |        |
|           | Op 40 - Add visual inspection of Safety Retainer                                                                                                                                                                                                                                                                                                                                                                                  |     |        |
| 22-Aug-06 | Renumbered Op 10 - Demagnetize Springs as Op 5. Revised assembly sequence per Industrial Engineering study and split content into 2 stages designated as Op 10 and 20.                                                                                                                                                                                                                                                            | CSB | 315862 |
| 24-Aug-06 | Updated Routing Page to Match Previous Revision                                                                                                                                                                                                                                                                                                                                                                                   | CSB | 315683 |
| 29-Aug-06 | Comparator Screen D-7C0-CL-252 now at Rev 3                                                                                                                                                                                                                                                                                                                                                                                       | CSB | 317649 |
| 07-Oct-06 | PT#305570 305571 305572 305573 305574 305575 & 305576:<br>TRIGGER PIVOT PIN - GROOVED PT#301516 WAS TRIGGER PIVOT PIN - PT#300693<br>ADD RETAINING RING - PT#301517                                                                                                                                                                                                                                                               | GLC | 318036 |
| 10-Oct-06 | XMP WAS SP1 (X-MARK PRO NEW NAME FOR SAFETY PIVOT LOCK)                                                                                                                                                                                                                                                                                                                                                                           | GLC | 318039 |
| 01-Nov-06 | Operation 10, Remove molycoat, add staking of Trigger Pin and temporary use of bolt stop pin to secure safety.<br>Operation 20, Reverse sequence of Blocker and Engagement Screws.<br>Operation 30, Add adjuster's identification stamp and increase trigger pull screw weight from 5 to 7 lbs<br>Operation 40, Add molycoat and visual inspection steps 6, 7, 8, and 9.<br>Delete Operation 30, (ID stamp added to Operation 30) | CSB | 317653 |

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|-----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|--------|
| 02-Nov-06 | Operation 40 Add check for blocker screw movement.                                                                                                                                                                               | CSB | 317654 |
| 15-Nov-06 | Operation 20 - Add note on Loctite application<br>Operation 30 - Change trigger pull weight to 5.5 lbs<br>Operation 40 - Add check for engagement screw movement<br>Operation 40, Step 9 Add DUCO cement to Blocker Screw        | CSB | 317655 |
| 06-Dec-06 | Operation 10 - Add use of 0.119" pin to step 4 - Add Blocker Hold Down Stud.                                                                                                                                                     | CSB | 317658 |
| 31-Jan-07 | Added Operation # 8 Ultrasonic Clean & Rinse                                                                                                                                                                                     | RJG | 318647 |
| 20-Mar-07 | Operation 10 -Add installation of trigger pivot pin retaining ring and bolt stop release. Also added note about not reusing retaining ring and trigger pivot pin after removal.                                                  | CSB | 317674 |
| 21-Mar-07 | Added QTY 0.100 of 24484 Bolt Stop Pin to Assemblies 305570, 305571, 305572, 305573, 305574, 305575, 305576 for inventory control.                                                                                               | CSB | 317675 |
| 26-Apr-07 | Operation 10 - Add LH press fixture.<br>Operation 30 - Add LH comparator screen.<br>Operation 30 - Add option of 2 hour, 120 degree cure cycle for LOCTITE 660. Add requirement for marking cure cycle information on each load. | CSB | 317683 |
| 15-Jun-07 | Adjust QTY 0.500 of 24484 Bolt Stop Pin to Assemblies 305570, 305571, 305572, 305573, 305574, 305575, 305576 for inventory control per request of Production                                                                     | CSB | 319589 |
| 18-Sep-07 | Add Step 10, REM OIL to Operation 40                                                                                                                                                                                             | CSB | 320016 |
| 04-Oct-07 | PT#305570 305571 305572 305573 305574 305575 305576<br>REPAIR SEAR SAFETY CAM - PT#401559 WAS SEAR SAFETY CAM<br>PT#305585                                                                                                       | GLC | 320505 |
| 21-Jan-08 | Op 30, step 20, add check of 5.5 lb trigger pull.<br>Op 40, Add step 11, inspector's stamp                                                                                                                                       | CSB | 320555 |
| 14-Mar-08 | Part #s 305570 305571 305572 305573 305574 305575 305576<br>Sear Safety Cam - Part #401623 Was Repair Sear Safety<br>Cam Part # 401559 in BOM                                                                                    | CSB | 320560 |

Dept Num Procedure by Steps Safety Key Points

| PROCESS CONTROL INSPECTION RECORD                             |  |  |  |  |            |    |                     |  |                        | Revision<br>Date: |    |
|---------------------------------------------------------------|--|--|--|--|------------|----|---------------------|--|------------------------|-------------------|----|
| THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR |  |  |  |  |            |    |                     |  |                        | Part No:          |    |
| Operation No. Part No:                                        |  |  |  |  | Part Name: |    | XMP TRIG ASSY 700 7 |  |                        |                   |    |
| Furnace and Load Number                                       |  |  |  |  | Operation: |    | Part Name           |  | C/F                    |                   |    |
|                                                               |  |  |  |  | Draw Temp  |    | Furnace Date        |  | Hardness Specification |                   |    |
| HRc                                                           |  |  |  |  |            |    | HRc                 |  | INSPECT<br>REJECT      |                   |    |
| Tester No                                                     |  |  |  |  | H15n       |    | H15n                |  | H15n                   |                   |    |
| 35                                                            |  |  |  |  |            | 60 |                     |  |                        |                   | 81 |
| 36                                                            |  |  |  |  |            | 61 |                     |  |                        |                   | 82 |
| 37                                                            |  |  |  |  |            | 62 |                     |  |                        |                   | 83 |
| 38                                                            |  |  |  |  |            | 63 |                     |  |                        |                   | 84 |
| 39                                                            |  |  |  |  |            | 64 |                     |  |                        |                   | 85 |
| 40                                                            |  |  |  |  |            | 65 |                     |  |                        |                   | 86 |
| 41                                                            |  |  |  |  |            | 66 |                     |  |                        |                   | 87 |
| 42                                                            |  |  |  |  |            | 67 |                     |  |                        |                   | 88 |
| 43                                                            |  |  |  |  |            | 68 |                     |  |                        |                   | 89 |
| 44                                                            |  |  |  |  |            | 69 |                     |  |                        |                   | 90 |
| 45                                                            |  |  |  |  |            | 70 |                     |  |                        |                   | 91 |
| 46                                                            |  |  |  |  |            | 71 |                     |  |                        |                   | 92 |
| 47                                                            |  |  |  |  |            | 72 |                     |  |                        |                   | 93 |
| 48                                                            |  |  |  |  |            | 73 |                     |  |                        |                   | 94 |

|                            |                                                 |                  |  |
|----------------------------|-------------------------------------------------|------------------|--|
| 14-Mar-08                  |                                                 | Processed by:    |  |
|                            |                                                 | Date: <autodate> |  |
|                            |                                                 | Work Center:     |  |
| Setup Inspected by & Date: |                                                 |                  |  |
| 3rd Shift                  | Remarks, Causes, Action Taken, Etc.             |                  |  |
|                            |                                                 |                  |  |
|                            |                                                 |                  |  |
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|------------------------|------------|--------------------------|-------------|-------------------|--|
| 14-Mar-08              |            | Inspected by:            |             |                   |  |
|                        | Prod. Qty: | Production Order #:      |             |                   |  |
|                        |            |                          |             |                   |  |
| Work Center:           |            | Inspec. Date: <autodate> |             |                   |  |
| Hardness Specification |            | Hardness Specification   |             | Break Test        |  |
| H15n                   |            | H45n                     |             | INSPECT REJECT    |  |
|                        |            | INSPECT REJECT           |             | INSPECT REJECT    |  |
|                        | H45n       | Break Test Results (lbs) |             |                   |  |
|                        | Tester No  |                          |             |                   |  |
|                        | 37         |                          |             |                   |  |
|                        | 38         |                          |             |                   |  |
|                        | 39         |                          |             |                   |  |
|                        | 40         |                          |             |                   |  |
|                        | 41         |                          |             |                   |  |
|                        | 42         |                          |             |                   |  |
|                        | 43         |                          |             |                   |  |
|                        | 44         |                          |             |                   |  |
|                        | 45         |                          |             |                   |  |
|                        | 46         |                          |             |                   |  |
|                        | 47         |                          |             |                   |  |
|                        | 48         |                          |             |                   |  |
|                        | 49         |                          |             |                   |  |
|                        | 50         |                          |             |                   |  |
|                        |            | Sample Plan              |             |                   |  |
|                        |            | Lot Size                 | Sample Size | Allowable Outside |  |
|                        |            | 1-5                      | All         | 0                 |  |

|    |    |     |
|----|----|-----|
| 49 | 74 | 95  |
| 50 | 75 | 96  |
| 51 | 76 | 97  |
| 52 | 77 | 98  |
| 53 | 78 | 99  |
| 54 | 79 | 100 |
| 55 | 80 | 101 |
|    |    |     |

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:

|    |  |              |    |   |
|----|--|--------------|----|---|
| 51 |  | 6 - 50       | 6  | 0 |
| 52 |  | 51 - 100     | 7  | 0 |
| 53 |  | 101 - 200    | 7  | 0 |
| 54 |  | 201 - 800    | 16 | 1 |
| 55 |  | 801 - 3000   | 17 | 1 |
| 56 |  | 3001 - 20000 | 27 | 2 |
| 57 |  |              |    |   |

*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*