

Remington Arms Company, Inc.
Manufacturing Process Document

Document ID:
Product Line:

XMP EA Trig Hous Spacer Rear 700
C/F Rifle

Effective Date:
Origination Date:

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.

Wash
Grind To Thickness
Drill Secondary Spring Hole
SWECO

8-Dec-06
12:41pm-93

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Printed on:
<autodate>

(Enter Oper #)

(Enter the Operation Name in this field)

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PROCESS CONTROL INSPECTION RECORD						Revision Data:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						8-Dec-06	
Part No:	Part Name: XVP EA Trig Housing Spacer Rear 700					C/M Title:	
Operation No: (Enter Oper #)	Operation: (Enter the Operation Name in this field)						
Prod. Qty:	Prod. Order #:					Operator	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift		
VISUAL	VISUAL	100%	INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		
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			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

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<autodate>

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100

Wash

Operation Step Detail	Operation: 100
Step	Operation / Step Description
	WASH.
1	Place 200 parts into a basket
2	Place basket into washer
3	Use a 5 minute cycle time
4	After 2.5 minutes of the wash, raise basket and shake vigorously to loosen grit from the parts
5	Place basket back into washer for remaining 2.5 minutes of cycle
6	Remove basket from washer
7	Blow parts off using an air hose to remove the cleaning solution and remaining grit

Operation Tool Detail	Operation: 100
Tool Number	Tooling Description
Model AJA LIF	Magnus Washer
Surf Kleen	Washing Solvent (pH = 11-12)
Std.	Parts Basket

PROCESS CONTROL INSPECTION RECORD		THIS RECORD MUST STAY WITH THE PRODUCTION ORDER		Revision	8-Dec-06
		AT ALL TIMES		Date	
Part No:		Part Name:	XMP EA Trig Hous Spacer Rear 700	C/F Rifle	
Operation No. 100		Operation:	Wash		

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	Processed by:
	Date: <autodate>
	Work Center:

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<autodate>
Prod Qty

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110 Grind To Thickness

Operation Step Detail Operation: 110
Step Operation / Step Description

- GRIND TO THICKNESS
- 1 Locate the grinding wheels so that they touch one of the parts applying minimal pressure on it.
 - 2 Set the grinding wheels to 0 at this location.
 - 3 Carrier speed knob should be set to 3 - 3.5
 - 4 Turn on the carrier only and see if the wheels move or not.

Wheels should NOT be moving by carrier pressure

If the wheels or wheel is moving, turn off the carrier and repeat steps 1 -4
 - 5 If the wheels are not moving, back out each wheel to at least .050 to remove any backlash
 - 6 Turn on power to each wheel
 - 7 Turn on coolant
 - 8 Move in each wheel until the digital readout reads 0.
 - 9 Fill the magazine feeder tray with the flat side of the part against the flat side of the magazine
 - 10 A. Run one part through the grinding wheels and gage with micrometers
 B. If the part is .175 +/- .001, run 5 more parts and gage
 C. If the part is not in gage, adjust grinding wheels accordingly and repeat steps A - C
 - 11 Once the parts are in gage, run the parts keeping the magazine as full as possible
 - 12 Gage three parts per feeder loading or at least QP51 frequency
 - 13 If any parts are greater than 0.176 inches, screen parts and

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adjust wheels

- 14 If any parts are less than 0.174 inches, screen all parts and adjust wheels
- Scrap ALL parts less than 0.174 inches
- 15 Re-Dress wheels as necessary

Operation Tool Detail	Operation: 110
Tool Number	Tooling Description
Std	Gardner Double Disc Grinder
Std	Multi Point Diamond Gardner - 2
23"x2"x19"x12"	Grinding Wheel - STORES #307863 Jowitt & Rodgers Co. Grade W801/HB5L20PF Gardner Grade 60A3C-HG12-531D3
Ho Cut 797E	Coolant @ 1-2% Concentration & De-Foamer for 797E
D-35360	Carrier
Std	1 inch Micrometers (.174-.176)

Operation Procedure Notes	Operation: 110
Description	
Note: Part Received From Hi-Dense Div. - .178/182 Thickness	
Note: Parts That Do Not Clean-up Screen for .174 Dim. - Check Both Ends	
*****NEED SKETCH*****	
Note: The Right Side Only is Ground - Right Side as seen from Shooter's point of View - Right Side has Chamfered Holes	

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Drill Secondary Spring Hole

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120

Operation Process Detail

Operation: 120

Step Description

Operation Tool Detail

Operation: 120

Tool Number Tooling Description

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date:	
Part No:		Part Name		XMP EA Trig Hous Spacer Rear 700	
Operation No: 120		Operation:		Drill Secondary Spring Hole	
Prod. Qty:		Prod. Order #:		Operator	
Gage Description and Characteristic		Gage Number		1st Shift	
VISUAL		VISUAL		2nd Shift	
		Gage Frequency		INSPECT REJECT	
		100%		INSPECT REJECT	
		Pieces Run:			

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8-Dec-06		Processed by:	
		Date	<autodate>
		Work Center:	
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3rd Shift	Remarks, Causes, Action Taken, Etc.		
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Sweco

130

Operation Process Detail

- 1 Rur. Parts with Compound And Media
- 2 Seperate Parts and Chips
- 3 Dip in 295 Wintech
- 4 1 To 2 Minutes in oven

Operation Tool Detail

Tool Number

Tooling Description

Machine-Sweco

Media:

Compound: 2260-D Soap

Load Size: 500 - 1000 Parts

Time: 1 Hr.

PROCESS CONTROL INSPECTION RECORD		THIS RECORD MUST
STAY WITH THE PRODUCTION ORDER AT ALL TIMES		
Part No:	Part Name	XMP EA Trig -ious Spacer Rear 700
Operation No: 130	Operation:	Sweco
Prod. Qty:	Prod. Order #:	
Gage Description and Characteristic	Gage Number	Gage Frequency
VISUAL	VISUAL	100%
	Pieces Run:	

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Operation: 112

Step Description

Operation: 112

5/8" Green Almco Cones

Store # 301283

[illegible]

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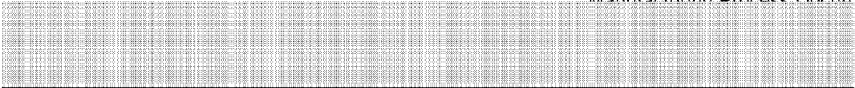
Printed on:
<autodate>



Dept	Oper	Operation Description	Part Numbers
9132	1	ISSUE FROM CRIB	301444
8574	100	WASH	301444
8574	110	GRIND TO THICKNESS	301444
8773	120	Drill Secondary Spring Hole	301444
0551	130	SWBCO	301444
To MRF Crib #24			

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
301444							Trigger Housing Spacer Rear - XMP EA
		301443	5	100	1.000		Trigger Housing Spacer Rear Blank - XMP LA

Dept Num Procedure by Steps Safety Key Points

Type "Ctrl+H" <i>from the desired destination</i> to insert this form. Execute <i>before</i> the next form below.									
PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR								Revision Date:	
								Part No:	
				Part Name:		XMP EA Trg Hous Spacer Rear 700		C/F R/lie	
Operation No: Part No:				Operation:		Part Name:			
Furnace and Load Number				Draw Temp		Furnace Date		Hardness Specification	
								HRc INSPECT REJECT	
HRc						H15n		H15n	
Tester No						Tester No		Tester No	
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	

8-Dec-06			Processed by:	
			Date: <autodate>	
			Work Center:	
Setup inspected by & Date:				
3rd Shift	Remarks, Causes, Action Taken, Etc.			
	Remington Arms Company, Inc. -- Ilion, New York			

8-Dec-06			Inspected by:		
	Prod. Qty:		Production Order #:		
Work Center:			Inspec. Date: <autodate>		
Hardness Specification		Hardness Specification		Break Test	
H15n	INSPECT	REJECT	H45n	INSPECT	REJECT
	H45n		Break Test Results (lbs)		
	Tester No				
	37				
	38				
	39				
	40				
	41				
	42				
	43				
	44				
	45				
	46				
	47				
	48				
			Sample Plan		
			Lot	Sample	Allowable
			Size	Size	Outside

47	72	93
48	73	94
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:

49			All	0
50		1-5	6	0
51		6-50	7	0
52		51-100	7	0
53		101-200	16	1
54		201-800	17	1
55		801-3000	27	2
56		3001-20000		
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