

PART: Ejector Spring (Purposes ready for Assembly)	PART NO. 1000
MANUAL PROCEDURE - 6-10-54	
Detailed Description	
Remington Planning	
Figures Required Per Assembly	
Uses of Part	B, B, T, L - All Ballistics B, T, L - All Ballistics
Vendor	
Material	1. Hard Wire
Heat Treatment	1. Stress Relieve
Set	1. Vendor need not set. Set must be set by holding 100 lbs. pressure for 10 min.
Final Color	1. Parts to be bright. Color of part, after inspection, must be like new or better.
Packaging	1. Examine each part and package. 2. Place in each container. 3. The green paint on the part must not exceed 200 lbs.
Acceptance Testing *	
Inspection will be based on statistical sampling according to Dodge and Dodge Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following figures is sufficient to meet within the tolerance. Outgoing Quality Limit* listed. Set sample only for 24 hrs. using Rod, Dry, BELFORD, and Valley Dry, before inspecting. Remainder of lot need not be set because set is automatically removed in use.	
Inspection**	
Spec. No.	Type
Coats	"Elasticometer"
B-51001-V	-Pin)
B-51000-V	-Ring)
B-50127-V	-Pushing)
Visual	1. Free Length 75 2. Solid Height 75 3. I.D. of Spring 75 4. O.D. of Spring 75 5. Load at 50% Deflection 75 6. Wind S.S. 75 7. Ends Squared and Ground 75 8. Seams, etc. 75
*See Process Record - Inspection for procedure.	
Note: As a matter of information only this part has been heat treated ballistically at Remington as follows: Stress Relief; DuPont Salt Pl; 580 ~ 400°F; 10 minutes; water quench.	
COMPILED BY: B.C. Andrews	APPROVAL & DATE: <i>R. V. Kinzer 1/1/55</i>
REMINGTON ARMS COMPANY, INC. 1000	