

|                                                                                                                                                                                                                                                                             |                                                                                                                            |                           |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------|---------------------------|
| PART: Sear Spring (Purchase ready for Assembly)<br>Trigger Spring                                                                                                                                                                                                           |                                                                                                                            | PART No. 17047            |
| MATERIAL PROCUREMENT #1007 Rev. 2                                                                                                                                                                                                                                           |                                                                                                                            |                           |
| Detailed Description                                                                                                                                                                                                                                                        |                                                                                                                            |                           |
| Remington Planning                                                                                                                                                                                                                                                          |                                                                                                                            |                           |
| Pieces Required Per Assembly: 2 (1 Sear Spring - 1 Trigger Spring)                                                                                                                                                                                                          |                                                                                                                            |                           |
| Uses of Parts : M/721- All Calibers; M/722- All Calibers                                                                                                                                                                                                                    |                                                                                                                            |                           |
| Vendor                                                                                                                                                                                                                                                                      |                                                                                                                            |                           |
| Material                                                                                                                                                                                                                                                                    | : Music Wire. packing - same material used for each shipment of parts.                                                     |                           |
| Heat Treatment                                                                                                                                                                                                                                                              | : Stress Relieve (See footnote)                                                                                            |                           |
| Set                                                                                                                                                                                                                                                                         | : Remove by holding fully compressed for 24 hrs;                                                                           |                           |
| Final Color                                                                                                                                                                                                                                                                 | : Parts to be bright, free of rust, oiled with light rust proofing oil (SAE-20 or equiv.)                                  |                           |
| Packaging                                                                                                                                                                                                                                                                   | : Purchase Order Number and quantity of pieces shown on each container, the gross weight of which must not exceed 200 lbs. |                           |
| Acceptance Testing:                                                                                                                                                                                                                                                         |                                                                                                                            |                           |
| Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the following gages is sufficient to keep within the "Average Outgoing Quality Limit" listed. |                                                                                                                            |                           |
| Inspection: **                                                                                                                                                                                                                                                              |                                                                                                                            |                           |
| Gage No.                                                                                                                                                                                                                                                                    | Type                                                                                                                       | Allowance                 |
| 1. Coats                                                                                                                                                                                                                                                                    | "Elasticometer" with                                                                                                       | Free Length 7%            |
| B-51001T - Pin                                                                                                                                                                                                                                                              | }                                                                                                                          | Solid Height 7%           |
| B-51000T - Ring                                                                                                                                                                                                                                                             |                                                                                                                            | I.D. of Spring 7%         |
| B-50127T - Bushing                                                                                                                                                                                                                                                          |                                                                                                                            | O.D. of Spring 7%         |
|                                                                                                                                                                                                                                                                             |                                                                                                                            | Load at 50% Deflection 7% |
| 2. Visual                                                                                                                                                                                                                                                                   | Wind R.H.                                                                                                                  | 7%                        |
|                                                                                                                                                                                                                                                                             | Ends Squared and Ground                                                                                                    | 7%                        |
|                                                                                                                                                                                                                                                                             | Seams, etc.                                                                                                                | 7%                        |
| 3. Set Sample by holding compressed for 24 hours Rod Dwg. B51564W, Collar B51565W.                                                                                                                                                                                          |                                                                                                                            |                           |
| 4. Repeat step 1.                                                                                                                                                                                                                                                           |                                                                                                                            |                           |
| Parts must meet drawing requirements at steps 1 and 4.                                                                                                                                                                                                                      |                                                                                                                            |                           |
| **See Process Record - Inspection for procedure.                                                                                                                                                                                                                            |                                                                                                                            |                           |
| Notes: As a matter of information only this part has been heat treated satisfactorily at Remington as follows:                                                                                                                                                              |                                                                                                                            |                           |
| Stress Relief; DuPont Salt #1; 380 - 400°F; 10 minutes; water quench.                                                                                                                                                                                                       |                                                                                                                            |                           |
| COMPILED BY:<br>C.B. Buonassisi                                                                                                                                                                                                                                             | APPROVAL & DATE: <i>R.H. Jones 4/19/46</i>                                                                                 |                           |
| REMINGTON ARMS COMPANY, INC. ILION, N. Y.                                                                                                                                                                                                                                   |                                                                                                                            |                           |