

PART:	Bain Spring (Purchase ready for Assembly)
INSPECTION PROCEDURE - QCS Form	
Detailed Description	
Inspection Planning	
Pieces Required For Assembly:	2
Issued For:	N/721 - All Callings - 17024 N/722 - All Callings - 17025
Vendor	
Material	1. Scale Wire, Packing, etc., as required need for each shipment of parts.
Heat Treatment	1. Stress Relieve
Set	: Decept reset.
Final Color	: Parts to be cleaned, pickled, and dried with light rust proofing oil applied at ship.
Packaging	: Purchase Order Number and quantity of pieces to be shown on each container; the gross weight if total must not exceed 20 lbs.
Acceptance Testings:	
Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Acceptance is determined if the quality on each of the following stages is satisfactory when using the "Incoming Outgoing Quality Limit" listed.	
Inspections **	Q.A.C.
Spec. No.	TIME
Cuts	"Elastometer" 75%
For 17022	Fine Length 75%
B-51001-S Pin	Ball Height 75%
B-51000-U Ring	L.H. of Spring 75%
B-50127-R Bushing	R.H. of Spring 75%
	Load at 50% Deflection 75%
For 17025	
B-51001-S Pin	
B-51000-U Ring	
B-50127-U Bushing	
Visual	Kind P.L. 75%
	End Squared and Ground 75%
	Leads, etc. 75%
** See Process Record - Inspection for Procedures	
Notes: As a matter of information only this part has been heat treated satisfactorily at Remington as follows: Stress Relief; Dupont Salt #1; 500 ± 40°F; 20 minutes; Water quench.	
CHECKED BY: E.S. Andrews	APPROVAL & DATE: R.M. Brown 4/19/64
REMINGTON ARMS COMPANY, INC. NEW BRITAIN, CT.	