

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0106006
R2506994

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/10/69 - Retyped from 5/13/63-Revised process - chg. read. & equip. CP- 267968
9/8/76 - Chg. dept. no. 61 to 15 - Joy - 275236
1/20/77 - Added item five - Joy - 275554

1-31-78 M. REMEMBER TO READ LAND A-B

DESCRIPTIVE INFORMATION

1 Assemble Extractor To Bolt Assembly with Extractor Rivet.
B Blend Extractor with Extractor shroud.

2. Assemble Ejector Spring and Ejector to Bolt with Ejector Pin.
a. Pin must be a drive fit.
b. Ejector must be free with tension.

3. Check for Extractor movement.
Max. Plug must depress Extractor to bottom on face of Bolt.

4. Number Bolt to match Receiver Serial number with Ideal etcher.
a. Use last four numbers only.

5. If necessary, file Extractor to insure good working fit under shroud of Bolt Head.

EXTRACTOR MUST BE SHAPED TO BOLT SHROUD BY ADJUSTING BOTH ENDS OF EXTRACTOR ON ALL CALIBERS. CLAW OF EXTRACTOR MUST BE CHECKED ON TENSION PLUG FOR GO & NO GO

EQUIPMENT-TOOLS & GAGES

Only correct components of good color
Not broken or deformed should be used.
Fixture D-84993
Punch C-71477W
Hydraulic Press - Pressure approx. 2200 lbs., .027 on deflection Ga. T8-1764

Shell Head Dia. Max. Plug (222 Mag.) B-848316

Ideal Etcher Std.
NOTE: - Numbers must be uniform and legible.

Vise Jaws C-61730

OPERATION DESCRIPTION	OCC. No.						
Assemble Extractor, to Bolt Assembly and rivet. Assemble Ejector Spring, and Ejector to Bolt with Ejector Pin. Number Bolt.	STD. HRS/G						
	STD. No.						
	EFF. DATE						
PART No.							
GA.							

PART NAME Final Assembly COOLANT SET UP TIME MODEL No XP-100 OPER. No 90

TYPE AACH. HRS DEPT. No 15 64 PAGE 1 OF 1

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 - b. Ejector must be free with tension.
3. Check for Extractor movement.
Max. Plug must depress Extractor to bottom on face of Bolt.
4. Number Bolt to match Receiver Serial number with Ideal etcher.
 - a. Use last four numbers only.
5. If necessary, file Extractor to insure good working fit under shroud of Bolt Head.

Fixture D-84993

Punch C-71477W

Hydraulic Press - Pressure approx.

2200 lbs., .027 on deflection Ga. TS-1764

Shell Head Dia. Max. Plug (222 Mag.) B-84831A

Ideal Etcher

Std.

NOTE: - Numbers must be uniform and legible.

Vise Jaws

C-51730

OPERATION DESCRIPTION		OCC. No.						
Assemble Extractor, to Bolt Assembly and rivet. Assemble Ejector Spring, and Ejector to Bolt with Ejector Pin. Number Bolt.		STD. HRS/C						
		UID. No.						
		EFF. DATE						
	PART No.							
	GA.							

PART NAME	Final Assembly	COOLANT		SET UP TIME		MODEL No.	XP-100	OPER. No.	90
TYPE				CH. HRS.		DEPT. No.	15 <i>h</i>	PAGE	1
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PART NAME Final Assembly COOLANT _____ SET UP _____ MODEL No. XP-100 OPER. No. 90
TYPE _____ CH. HRS. _____ DEPT. No. 15 64 PAGE 1 /F

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