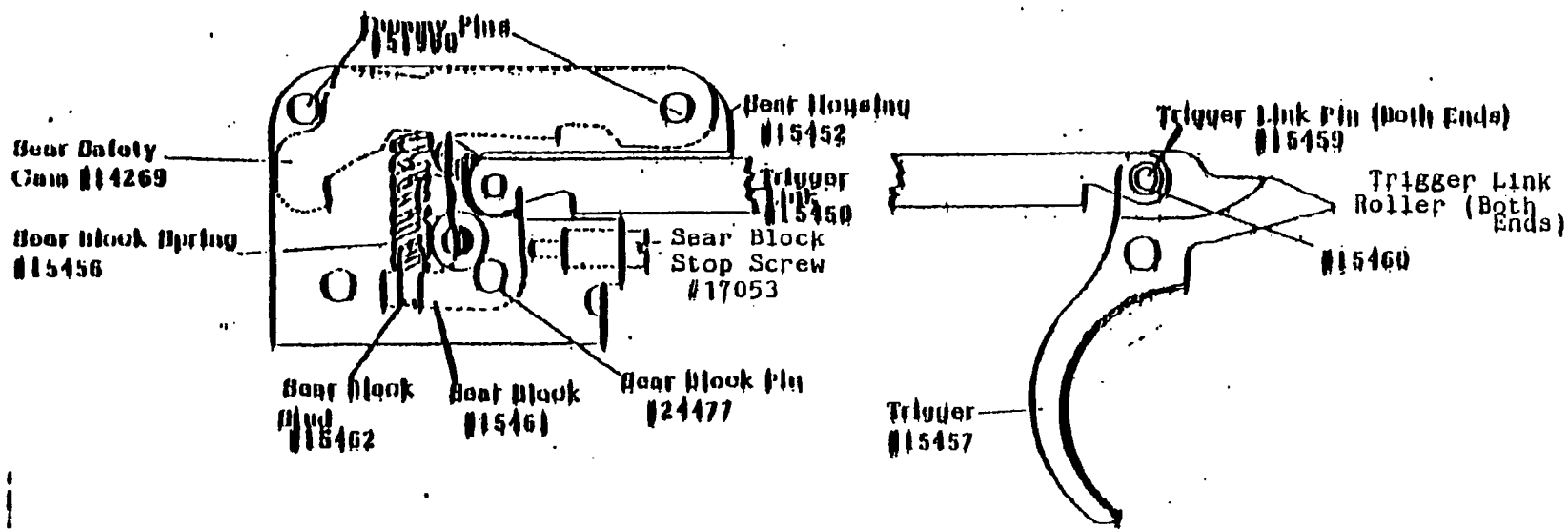


DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MHP-JAA-279130

DESCRIPTIVE INFORMATION

SEAR HOUSING ASSEMBLY



PART NAME	Sear Housing Assembly	COOLANT	SET UP	MODEL No.	XP-100	OPER. No.	55
TYPE			MACH. HRS.	DEPT. No.	15	PAGE	1 OF 12
			MACHINE				

PROCESS JNDS

DATES AND REASONS FOR REVISIONS 9/28/80-NEW-MRP-JAA-279130

TOOL, MACHINES AND EQUIPMENT		QA OR CAL	APPROVAL AND DATES	
SPEED	FEED			
		Fixture	D-85455	1. Pick Sear Block Assembly 2. Polish Sear Safety Cam contact surface. • Use new crocus cloth • Keep rear edge sharp 3. Pick Roller • Roller must be burr-free, 4. Insert Roller into Sear Block Assembly link pin hole.
		Crocus Cloth	Std.	
OPERATION DESCRIPTION		PART NO.		
Assemble Sear Housing Assembly		26970		
PART NAME Sear Housing Assembly		COOLANT	FILE UP	MODEL No. XP-100
TYPE		MACHINE	DEPT No. 15	OPER. No. 55
			PAGE 2	OF 12

AU 0001

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0109113 R2510101

DATE AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

Trigger Link
#15450



PART NAME Sear Housing Assembly SET UP MODEL No. XP-100 OPER. No. 55
TYPE MACH. NRS. DEPT. No. 15 PAGE 3 OF 12
MACHINE

PROCT RECORD

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MHP-JAA-21,130

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL

● 保护双基

FIELD

5. Pick Trigger Link
 - Black Color
 - Ears must be straight (Both Ends)
 - Holes must be counter-sunk (Both Ends),
6. Assemble Trigger Link (Housing End) over Sear Block
7. Insert Trigger Link Pin (with head to the left) and swage end,
 - Swage must be on right side,
 - Swage must be flush or below surface,
 - Sear Block must freely rotate about pivot pin.

PART NAME Sear Housing Assembly COOLANT

SET UP

MODEL No. XP-100

OPER. NO. 55

TYPE

- MACH. HRS.

DEPT. No. 15

- PAGE 4 OF 12

MACHINE

PROCT RECORD

DATE . . . REASONS FOR REVISIONS 9729780-NEW-MNP-JAA-279, 30

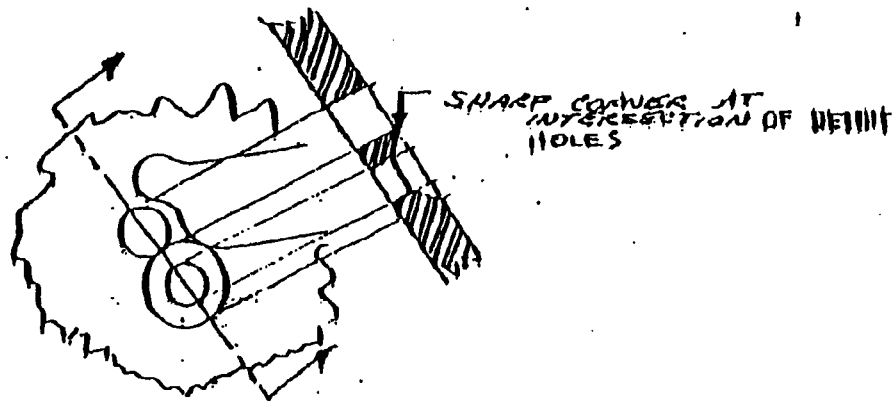
[illegible]

DATE AND REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION

12. Plot Bear Housing

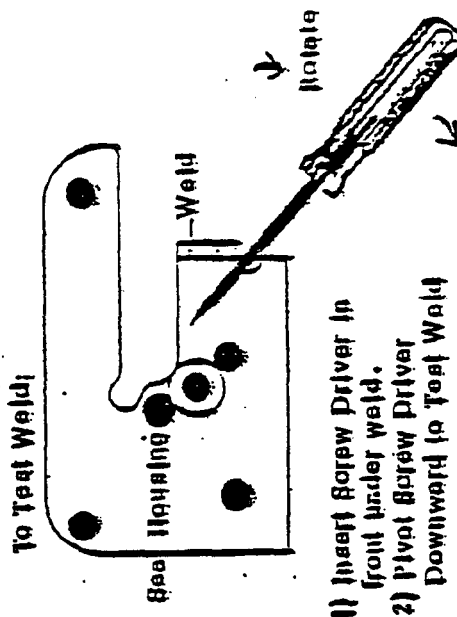
- Black Color
- Sharp Corner at Intersection of the two safety detent holes - No Flat
- Uniform opening at top for Bear Safety Cam



PART NAME Sear Housing Assembly COOLANT _____ SET UP _____ MODEL No. XP-100 OPER. No. 55
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 6 OF 12
 MACHINE

DATE AND REASON FOR REVISIONS 9/29/80-NEW-MRP-JAA-279130

DESCRIPTIVE INFORMATION



PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 55
TYPE MACH. HRS. 15 PAGE 7 OF 12
MACHINE

PROC. RECORD

DATES , 10 REASONS FOR REVISIONS 9/29/80-NEW-MRP-JAA-2, 9130

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT

GA. OR CAL.

WELLS

FIELD

13. Sear Housing Cont,
• Weld at front of housing must not interfere
with Sear Block Screw Hole,

14. Test Weld

- Pry Sear Housing with medium force on screw driver to test for good weld.

Weld must remain good,
(Note Illustration)

PART NAME Sear Housing Assembly COOLANT _____ SET UP _____ MODEL No. XP-100 OPEN No. 55
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 8 OF 12
MACHINE _____

REF ID: A6408

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 9/29/80-NEW-MMP-JAA-219130

[illegible]

APPROVAL AND DATES

15. Assemble Trigger Link Assembly into Sear Housing, and insert Sear Block Pin, Drive Pin Left to Right.

This is easiest done by pivoting Sear Block Assembly fully forward - hold vertically - and place Sear Housing over it.

- Pin must be flush on right side and tight in housing.
- Sear Block Assembly and Trigger Link must be free in housing.

Hold Sear Housing, Move Link forward and backward.

- Link and Sear Block Assembly must move freely.

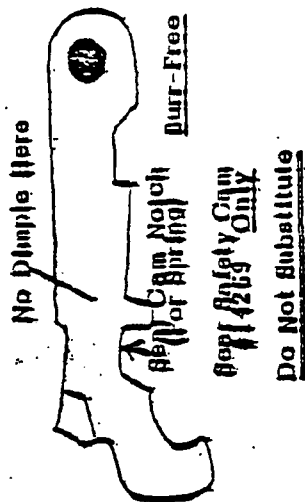
Press left end of Sear Block Pin firmly against bench block.

- Pin must not move. Stake Housing at right side if required.

PART NAME. Swag Housing Assembly COOLANT _____ SET UP _____ MODEL No. XP-100 OPER. No. 55
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 9 OF 12
MACHINE _____

DATE AND REASON FOR REVISIONS 9/29/80-NEW-MRP-JAN-27/9130

DESCRIPTIVE INFORMATION



PART NAME Sear Housing Assembly COOLANT SET UP TIME MODEL No XP-100 OPER. No 55
 TYPE MACHINE MACH. HRS. 15 PAGE 10 OF 12

PROJECT RECORD

DATE . . . **REASONS FOR REVISIONS** 9/20/80-NEW-MRP-JAA-279130

[illegible]

PROCF RECORD

DATE: 9/29/80 REASON: NEW-MRP-JAA-2, 130

APPROVAL AND DATES

[illegible]

20. Install Rear Dummy Pin over Sear Safety Cam.
21. Check for correct Sear Safety Cam freedom and Spring Force.
 - Sear Safety Cam must not bind in Housing.

Pull Link forward and hold, Then, Depress Sear Safety Cam at top rear and release,
 - Sear Safety Cam must fully depress and return to full upward position against dummy pin.
 - Sear Block must fully rotate under Sear Safety Cam.

Hold Sear Housing Pull Trigger Link and Release
 - Sear Block must return under Sear Housing with Spring Force,

PART NAME Sear Housing Assembly COOLANT TIME SET UP MODEL No. XP-100 OPER. No. 55
TYPE MACH. HRS. DEPT. No. 15 PAGE 12 OF 12
MACHINE