

Process Header

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Document ID: Stock Assy XP100	Remington Arms Company
Part Name: Stock Assy	
Product Line: Pistol	Effective Date: 30-Jan-1990-12:00:00
Engineering Group: Shotgun Group	Origination Date: 10-Jan-1990

Process History

Status	Date/Time	Status Set	Responsible User
Submitted	12-FEB-1990	07:13:54.70	Shirley Willoughby
Comment:			
Fully Approved	12-FEB-1990	09:40:43.62	R.J.Orf
Comment:			
Normal Release	12-FEB-1990	10:19:47.00	Shirley Willoughby
Comment:			

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
10-Jan-1990	Retyped entire process from 287056 - Replaces old paper process. Added Black Stock Assy	RDP 289788

Process Approval List

Approved By:	Badge #:	Date:	Designation:
R.J.Orf	19079	12-FEB-1990	Supervisor-Eng

Process General Notes

Notes:

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Process Material

Part Number	Qty	Description
91765		Stock Assy XP100 - Brown
15463	1	Fore End Tip
15464	1	Fore End Tip Spacer
15493	2	Fore End Diamond
15448	1	Forward Receiver Screw Escutcheon
15465	1	Grip Diamond
15451	1	Rear Receiver Screw Escutcheon
15466	1	Stock Half, Left
15467	1	Stock Half, Right
15468	1	Trigger Guard
94749		Stock Assy XP100 - Black
15463	1	Fore End Tip
15464	1	Fore End Tip Spacer
15493	2	Fore End Diamond
15448	1	Forward Receiver Screw Escutcheon
15465	1	Grip Diamond
15451	1	Rear Receiver Screw Escutcheon
94747	1	Stock Half, Left
94748	1	Stock Half, Right
15468	1	Trigger Guard

Process Routing

Dept	Oper	Operation Description	Part Numbers	
8162	70	Weld Stock Halves with Forward and rear Receiver Screw Escutcheon and Trigger Guard in place.	91765	94749
8162	75	Striate bottom contour.	91765	94749
8162	80	Remove Striated burrs, and Flashing from Barrel Groove, Safety Slot, Fore End Tip and all other excess flashing.	91765	94749
8162	85	Assemble Accessories.	91765	94749
8162	90	Glass bead blast.		94749
8162	95	Water boil.		94749
8162	100	Dry.		94749
8162	105	Inspect, clean and repair if necessary.	91765	94749
		To Final Assembly Crib #29		

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Operation Step Detail

Operation: 70

Step

Operation / Step Description

Weld Stock Halves with Forward and rear Receiver Screw Escutcheon and Trigger Guard in place.

- 1 Apply two coats of Phenol to Stock Halves, wait a minimum of 2 minutes between coats. Phenol should only be applied to the areas that require welding. Apply third light coat to butt of grip and at Forward Receiver Screw Escutcheon area. DO NOT APPLY PHENOL TO TRIGGER GUARD AREA.
- 2 Install Forward Receiver Screw Escutcheon, part # 15448, Rear Receiver Screw Escutcheon, part # 15451, and Trigger Guard, part # 15468.
- 3 Position Stock Halves together and place in Assembly fixture to dry.

NOTE: Stock Assembly must dry for 35 min. in fixture and cure for 24 hrs. before next operation.

Operation Material Detail

Operation: 70

Part Number

Qty

Description

Phenol - 1 Liter bottles of Phenol Liquid
CAS Reg. # 108 - 95 - 2
Fisher Scientific Catalog No. A931I-1

Fisher Scientific Co.
15 Jet View Drive
Rochester N.Y.

Operation Tool Detail

Operation: 70

Tool Number

Tooling Description

E-85884 Pneumatic Clamping Fixture
Paasche Air Brush Model VL
Wood Holding fixture to spray Stocks
Spray Booth

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Operation Step Detail

Operation: 75

Step

Operation / Step Description

Striate bottom contour

- 1 Place Stock Assembly in Striating fixture.
- 2 Feed stocks from right to left to reduce the fuzz on cut edges.
- 3 Angling the Stock inward to the operator's left causes cutter pressure to be maintained and makes it easier to feed.

NOTE: Depth of cut is maintained by the difference in cutter and cutter bearing diameter.

Operation Tool Detail

Operation: 75

Tool Number

Tooling Description

E-70760	Striating Machine
E-85948	Striating Fixture
B-84879-W	Cutter

Operation Step Detail

Operation: 80

Step

Operation / Step Description

Remove Striated burrs, and Flashing from Barrel Groove, Safety Slot, Fore End Tip and all other excess flashing.

- 1 Remove striation burrs from Fore End, Trigger Guard, Front and Rear Receiver screw holes, Grip Diamond Recess and Butt.
- 2 Remove flashing from Barrel Groove, Safety slot, Fore End Tip, and all other excess flashing.

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Operation Tool Detail

Operation: 80

Tool Number

Tooling Description

File

E-xacto knife

Operation Step Detail

Operation: 85

Step

Operation / Step Description

Assemble Accessories

- 1 Position Fore End Tip Spacer, part # 15464.
- 2 Position Fore End Tip, part # 15463.
- 3 Position (2) Diamond Inlays - Fore End, part # 15493.
- 4 Position Grip Diamond, part # 15465.

NOTE: Stock Assembly must dry for 30 min. in fixture and cure for 24 hrs. before next operation.

Operation Material Detail

Operation: 85

Part Number

Qty

Description

Phenol - 1 Liter bottles of Phenol Liquid
CAS Reg. # 108 - 95 - 2
Fisher Scientific Catalog No. A931I-1

Fisher Scientific Co.
15 Jet View Drive
Rochester N.Y.

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Operation Tool Detail

Operation: 85

Tool Number

Tooling Description

E-85901

Assembly Fixture

Positioning Tool for Fore End Tip Spacer

Phenol Applicator

Operation Step Detail

Operation: 90

Step

Operation / Step Description

Glass Bead Blast

1 Glass bead blast entire Stock Assembly.

2 Blow glass beads off Stock Assembly.

NOTE: Bead Blast is to give Stock a Matt Finish.

Operation Tool Detail

Operation: 90

Tool Number

Tooling Description

Glass Bead Blaster in MIM Tool Room.

Operation Step Detail

Operation: 95

Step

Operation / Step Description

Water boil

1 Place 10 Stocks in boiling water. Make sure Stocks are completely submerged. Boil for 10 min.

2 Remove

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Operation Tool Detail

Operation: 95

Tool Number

Tooling Description

Fiberglass Tank with steam coils to heat water. Temperature of tank is controlled by operator and manual on/off valve.

Operation Step Detail

Operation: 100

Step

Operation / Step Description

Dry

- 1 Place stocks in boxes to dry before inspection.
- 2 Blow of excess glass beads, especially around Escutcheons.

Operation Step Detail

Operation: 105

Step

Operation / Step Description

Inspect, clean and repair if necessary.

- 1 Test Fore End Tip weld strength
- 2 Inspect for mars, scratches, etc.
- 3 Repair shinny spots with steel wool.
Repair dirty spacers with steel wool.
Repair any other defects as necessary within reason.

Operation Tool Detail

Operation: 105

Tool Number

Tooling Description

Steel Wool
Bench

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