TITLE: Trigger Force Screw 700

Process Header

Process Header

Document ID: Tr Force Scr 700	Remington Arms Company
Part Name: Trigger Force Screw 700	
Product Line: C/F Rifle	Effective Date: 11-Aug-1992-09:00:00
Engineering Group: Rifle	Origination Date: 31-Jul-1992

Process History

Status	Date/Time	Status Set	Responsible User
Submitted	5-AUG-1992	08:58:31.83	G.L.Cioch
Comment:""			
Fully Approved	10-AUG-1992	08:39:18.65	R.A.Jackson
Comment:			
Normal Release	11-AUG-1992	09:06:55.79	"CART"
Comment:			

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
31-Jul-1992	New Process	GLC 292908
05-Aug-1992	Correct Reason for Chg. #292908 Due to 1 Process Becoming 3 Separate Processes from New Process to: Retype Entire Process - Replaces Old Paper Process Delete Op. #12 and Combine with Op. #10 as Operator Inspection - Update from Cyanide to Microcarb Harden Chg. Crib #28 to 29	GLC 292923

Process Approval List

Approved By:	Badge #:	Date:	Designation:
R.A.Jackson	+ 00000	10-AUG-1992	Technical Supervisor

Process General Notes

Notes:

Document Number: Tr Force Scr 700   Rev:

R2520315

TITLE: Trigger Force Screw 700

Process Material

Part Number	Qnty	Description
17053		Trigger Force Screw - 700,7,XP-100,40XB
91920	1	Blank

Process Routing

Dept	Oper	Operation Description	Part Numbers
9260		Purchase Inspection	91920
8551	10	Degrease, Micro-Carb Harden,Oil Quench, Degrease	17053
8551	14	Nitre Black, Water Quench, Wash and Oil	17053
9257	16	Inspect for Color, and Oil	17053
		To Trigger Assembly - MRP Crib #29	17053

Operation Step Detail   Operation:

Step	Operation / Step Description
	Purchase Inspection

Operation Step Detail   Operation: 10

Step	Operation / Step Description
	Degrease, Micro-Carb Harden,Oil Quench,Degrease

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R2520316

TITLE: Trigger Force Screw 700

Operation Procedure Notes   Operation: 10

Description

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          PROCESS RECORD - HEAT TREAT SPECIFICATION
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MATERIAL & SPECIFICATION: .08/.20 Carbon

        STANDARD PRACTICE:

              TEMPERATURE: 1650 +/- 10 Degrees F at .75 Carbon Potential

             MAXIMUM LOAD: 15000 Pcs. Max. - 2 Baskets 7500 Pcs. per Basket

                     TIME: 1-1/2 Hrs. @ Temp.

                   QUENCH: Oil

                  REMARKS: Degrease

--------------------------------------------------------------

              INSPECT FOR: File Hard

     HEAT TREAT INSPECTION:

      STANDARD PRACTICE NO:

           HARDNESS LIMITS:

       APPEARANCE OF PARTS: Steel Gray Color - Free of Oil
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Operation Step Detail   Operation: 14

Step   Operation / Step Description

Nitre Black, Water Quench, Wash and Oil

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TITLE: Trigger Force Screw 700

Operation Procedure Notes   Operation: 14

Description

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┌─────────────────────────────────────────────────────────────────┐
│            PROCESS RECORD – HEAT TREAT SPECIFICATION              │
│    ──────────────────────────────────────────────────────────    │
│                                                                   │
│  MATERIAL & SPECIFICATION: .08/.20 Carbon                         │
│           TEMPERATURE: 925-950 Degrees F                          │
│           MAXIMUM LOAD: 1/2" in Bottom of Basket - (Approx. 15000 Pcs.) │
│                  TIME: 15 Min. Total                              │
│                QUENCH: Water                                      │
│               REMARKS:                                            │
│    ──────────────────────────────────────────────────────────    │
│                                                                   │
│            INSPECT FOR:                                           │
│   HEAT TREAT INSPECTION:                                          │
│    STANDARD PRACTICE NO:                                          │
│        HARDNESS LIMITS:                                           │
│     APPEARANCE OF PARTS: Shiny Black Color, Clean, Free of Salt, Well Oiled │
│                          for Storage                             │
└─────────────────────────────────────────────────────────────────┘
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Operation Step Detail   Operation: 16

Step   Operation / Step Description

Inspect for Color, and Oil

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R2520318

TITLE: Trigger Force Screw 700

Operation Procedure Notes   Operation: 16

Description

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PROCESS RECORD - HEAT TREAT SPECIFICATION
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MATERIAL & SPECIFICATION: .08/.20 Carbon
             TEMPERATURE:

           MAXIMUM LOAD:

                   TIME:

                 QUENCH:

                REMARKS:

----------------------------------------------------------------

            INSPECT FOR: Color and Oil

  HEAT TREAT INSPECTION:

   STANDARD PRACTICE NO:

        HARDNESS LIMITS:

   APPEARANCE OF PARTS: Shiny Black,Color,Clean,Free of Salt,Well Oiled for
                        Storage
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Operation Step Detail   Operation:

Step   Operation / Step Description

To Trigger Assembly - MRP Crib #28

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