

## Process Header

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Document ID: Bolt Stop XP100	Remington Arms Company
Part Name: Bolt Stop XP100	
Product Line: C/F Rifle	Effective Date: 08-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 07-Oct-1992

## Process Revision Reasons

Date: Reason For Revision: Eng Log #:

07-Oct-1992	Retype ENTire Process from 284125 - Replaces Old Paper Process - Removed 221 FB	GLC 293099
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## Process Approval List

Approved By: Badge #: Date: Designation:

JacksonRA

## Process General Notes

Notes:

## Process Material

Part Number Qty Description

91761	1	Bolt Stop - XP100
C-16812	1	Blank

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**Process Routing**

Dept	Oper	Operation Description	Part Numbers
8551	4	Neutral Salt Harden, Oil Quench, Wash and Dry	91761
8551	8	Nitre Black, Water Quench, Wash and Dry, Oil for Storage	91761
9257	12	Inspect for Rockwell Hardness	91761
		To MRP Crib #29	91761

**Operation Step Detail**

**Operation: 4**

**Step**

**Operation / Step Description**

	Neutral Salt Harden, Oil Quench, Wash and Dry
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**Operation Tool Detail**

**Operation: 4**

**Tool Number**

**Tooling Description**

Std	Ajax Electric Neutral Salt Bath
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Operation Procedure Notes      Operation: 4

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE: 1550 Degrees F

MAXIMUM LOAD:

TIME: 15 Min. @ Temp.

QUENCH: Oil

REMARKS: Wash and Dry

INSPECT FOR: Product Check for File Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Clean, Dry, Free from Salt

Operation Step Detail      Operation: 8

Step      Operation / Step Description

Nitre Black, Water Quench, Wash and Dry, Oil for Storage

Operation Tool Detail      Operation: 8

Tool Number      Tooling Description

Std      Rem. Gas Nitre Pot Furnace

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Operation Procedure Notes      Operation: 8

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE: 900 Degrees F

MAXIMUM LOAD: 1000 Pcs. - Approximately 1/3 Basket

TIME: 20 Min. Total

QUENCH: Water

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Black Color, Clean, Free from Salt, Well Oiled for Storage

Operation Step Detail

Operation: 12

Step

Operation / Step Description

Inspect for Rockwell Hardness

Operation Tool Detail

Operation: 12

Tool Number

Tooling Description

Std

Rockwell Hardness Tester

165

Spot Anvil

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Operation Procedure Notes      Operation: 12

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1095 or C-1070

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness, Color, and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO: 164 - Spot Anvil #165

HARDNESS LIMITS: RC 37-42

APPEARANCE OF PARTS: Black Color, Clean, Free from Salt, Well Oiled for Storage

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