

TITLE: Safety Button XP100

Process Header

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

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
08-Oct-1992	Retype Entire Process from 279150 - Replaces Old Paper Process	GLC 293110

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
91495	1	Safety Button - XP100
1501		Raw Material - .0135 Lbs. - Zytel 105-BK-10A
1503		Raw Material - .0135 Lbs. - Zytel 101-NC-10

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Process Routing

Opt Oper	Operation Description	Part Numbers
8162 5	Blend Nylon Powder	91495
8162 10	Dry Nylon Powder	91495
8162 15	Injection Mold	91495
8579 20	Tumble to Remove Sharp Corners	91495
	To MRP Crib #29	91495

Operation Step Detail

Operation: 5

Step	Operation / Step Description
	Blend Nylon Powder

Operation Tool Detail

Operation: 5

Tool Number	Tooling Description
Std	Mini-Jector Molding Press - Type Zytel BK-10 Blend
Std	Tumbler
Std	Steel Barrel
1501	Zytel 105-BK-10A - 1 Can (25 Lb.)
1503	Zytel 101-NC-10 - 1 Can (25 Lb.)

Operation Procedure Notes

Operation: 5

Description

NOTE: Blend for Twenty Minutes.

Operation Step Detail

Operation: 10

Step	Operation / Step Description
	Dry Nylon Powder

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Operation Procedure Notes Operation: 10

Description

NOTE: Oven Dry 4 Hours @ 230 Degrees F
 - When Drying Material Reduce Temperature to 170 Degrees F After Initial
 4 Hour Cycle

Operation Step Detail Operation: 15

Step Operation / Step Description

Injection Mold

Operation Tool Detail Operation: 15

Tool Number Tooling Description

65 HA 100	Mini-Jector Molding Press - Type Zytel BK-10 Blend 4 Cavity Mold JGT Number 6982 Serial No. 89928 Insert : Serial No: 89928-B
Std	Mold Temperature Controller
Std	Container for Parts

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Operation Procedure Notes Operation: 15

Description

NOTES: 1. Use Mold Base Serial No. 89928 and Insert Serial No. 89928-B for Safety Button - The Insert Button is on the Back of the Insert

2. The XP100 Safety Buttons Will Have an X Molded On the Bottom of them in order to Distinguish Them from the 788

MOLD

CYCLE

JGT Serial No.: 6982
 Type: Tunnel Gated
 No. of Cavities: 4
 Knockout Setting: Max.
 Temp. Stationary Side: 130 Degrees F
 Temp. Moving Side: 130 Degrees F

Inject: 8 Seconds
 Cure: 30 Seconds
 Prepack: 0 Seconds
 Clamp Open Time: 2 Seconds

CLAMP

INJECTION PRESSURE - 1200 Lbs.

Adjust Clamp Toggle for Maximum
 Clamping Pressure

FEED ADJUSTMENT - Adjust for
 Minimum Inventory

TEMPERATURES

SHOT WEIGHT - 5 Grams

Plastifying Cylinder 575
 Nozzle Variac Setting 70

Semi - Automatic
 Full Automatic YES
 Air Blast YES

REMARKS: Adjust Operating Conditions Until Cold Weld Marks are Gone and Parts
 Fall from Mold

Operation Step Detail Operation: 20

Step Operation / Step Description

Tumble to Remove Sharp Corners

Operation Tool Detail Operation: 20

Tool Number Tooling Description

Std 5 Lb. Tumbling Barrel

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Operation Procedure Notes Operation: 20

Description

Number of Pcs.: 1000

Media: J-Stars

Compound: 501x4 Oz.

Water: 1 Quart

Time: 3 Hours

Rinse

To Unload Tip Barrel - Rotate with Water Running In to Float Parts Out of Barrel

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