

TITLE: Sear Housing XP100

Process Header

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Document ID: Sear Hous XP100	Remington Arms Company
Part Name: Sear Housing XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 24-Oct-1992

Process Revision Reasons

Date: Reason For Revision: Eng Log #:

24-Oct-1992	Retype Entire Process from 281657 - Replaces Old Paper Process	GLC 293207
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Process Approval List

Approved By: Badge #: Date: Designation:

JacksORA

Process General Notes

Notes:

Process Material

Part Number Qty Description

15452	1	Sear Housing - XP100
15744	1	Blank

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Process Routing

Dept	Oper	Operation Description	Part Numbers
8579	3	Clean Sear Housing	15452
8579	5	Weld Tab and Deburr	15452
8575	7	Ream 4 Holes & C'Sink Safety Detent Hole	15452
8502	9	Deburr Inside and Outside	15452
8575	10	Tap Sear Block Stop Screw Hole	15452
8579	16	Black Oxide	15452
		To MRP Crib #29	15452

Operation Step Detail

Operation: 3

Step

Operation / Step Description

	Clean Sear Housing
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Operation Procedure Notes

Operation: 3

Description

Procedure:

Chem. & Met. Standard Practice No. 206

1. Alkaline Clean
2. Hot Water Rinse
3. Pickle Dip
4. Cold Water Rinse
5. Alkaline Clean (To Prevent Rusting)

Operation Step Detail

Operation: 5

Step

Operation / Step Description

	Weld Tab and Deburr
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Operation Tool Detail

Operation: 5

Tool Number	Tooling Description
Std	TW Welder - Type E-B3=8-10
Std	Fixture - Taylor Winfield "T" Clamping Fixture U-12446
26#	Pressure
P-7	Tap
50	Squeeze - Cycles
40	Hold - Cycles
30	Off - Cycles
2 + 10	Weld - Cycles
65%	Weld Heat %
No	Temper
Std	Upper Electrode - Mallory 3 Part No. 3415 Offset Nose Electrode - (NOT A STORES ITEM)
STD	Lower Electrode - RWMA No. C-228

Operation Procedure Notes

Operation: 5

Description

NOTE: Due to Voltage Changes - The Percentage of Weld Heat Must Be Varied to Obtain Satisfactory Welds

Operation Step Detail

Operation: 7

Step

Operation / Step Description

Ream 4 Holes & C'Sink Safety Detent Hole
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Operation Tool Detail

Operation: 7

Tool Number	Tooling Description
C-85373	Holding Jig
A-85452-W	Step Reamer - (.1244)
A-85452-V	Step Reamer - (.1257)
A-85452-T	Step Reamer - (.1261)
A-54497	Piloted C'Sink Aircraft Stop
	Gages:
B-80154-K	Plug Gage - .126/.125 Dia.
B-80154-D	Plug Gage - .1264/.1254 Dia.
B-80219-R	Plug Gage - .1247/.1237 Dia.
C-50264	C'Sink Gage
A-82354	Master

Operation Procedure Notes

Operation: 7

Description

Note: For Gage C-50264 Use Master A-82354
- Tol. - Set Dial to "0" to ".0043"
USE SIDE OF MASTER MARKED FOR M/600 & 40X

Operation Step Detail

Operation: 9

Step	Operation / Step Description
	Deburr Inside and Outside

Operation Step Detail

Operation: 10

Step	Operation / Step Description
	Tap Sear Block Stop Screw Hole

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Operation Tool Detail

Operation: 10

Tool Number	Tooling Description
C-85317	Holding Fixture
B-90187-Q	H.S.S. Tap #6-40 NF-2
B-80223-W	Thread Plug

Operation Step Detail

Operation: 16

Step

Operation / Step Description

Black Oxide

Operation Procedure Notes

Operation: 16

Description

SMALL PARTS BLACK OXIDE COLOR

BLACK OXIDE RACK/FIXTURE:

LOAD SIZE:

STEP	PROCESS SEQUENCE	TEMPERATURE	CONCENTRATION	IMERSION TIME
1	Alkaline Clean	212 F	7-9%	3-5 Minutes
2	Cold Water Rinse	Ambient	-----	1 Minute
3	Muriatic Acid	Ambient	15-17%	10-15 Seconds
4	Cold Water Rinse	Ambient	-----	1 Minute
5	Black Oxide #1	290 F	6.5-6.8 lbs/gal	30 Minutes
6	Cold Water Rinse	Ambient	-----	1 Minute
7	Black Oxide #2	300 F	7.0-7.3 lbs/gal	30 Minutes
8	Hot Water Rinse	212 F	-----	1 Minute
9	Braze Color	185 F	1.0-1.3 lbs/gal	30 Minutes
10	Hot Water Rinse	212 F	-----	1 Minute
11	Steelgard	Ambient	15-20%	30 Seconds

NOTE FOR POWDER METAL AND M.I.M. PARTS

- * Increase immersion time on step #3 to 30-45 seconds.
- * Increase immersion time on step #8 to 30 minutes.

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