TITLE: Trigger Guard XP100

Process Header

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Document ID: Trig Guard XP100	Remington Arms Company
Part Name: Trigger Guard XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 26-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:	
26-Oct-1992	Retype Entire Process from 281914 - Replaces Old Paper Process	GLC	293215

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksoRA			

Process General Notes

Notes:

Process Material

Part Number	Qnty	Description
15468	1	Trigger Guard - XP100
1501		.0169 Nylon Zytel 101 NC-10
1503		.0169 Nylon Zytel 105 BK-10A

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Process Routing

Dept	Oper	Operation Description	Part Numbers
8162	4	Blend Nylon Powder	15468
8162	8	Dry Nylon Powder	15468
8162	12	Injection Mold	15468
8162	16	Degate and Inspect	15468
		To MRP Crib #16	15468

Operation Step Detail Operation: 4

Step	Operation / Step Description
	Blend Nylon Powder

Operation Tool Detail Operation: 4

Tool Number	Tooling Description
Std	Newbury H-12-200T - Type Nylon Zytel
101 NC-10	Nylon Zytel - 1 Can 25#
105 BK-10A	Nylon Zytel - 1 Can 25#
Std	Aluminum Stearate - 7 Grams
Std	Steel Barrel
Std	Balance
#280	Chem. & Met. Std. Practice

Operation Procedure Notes Operation: 4

Description
NOTE: Blend for 20 Minutes

Operation Step Detail Operation: 8

Step	Operation / Step Description
	Dry Nylon Powder

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Operation Tool Detail Operation: 8

Tool Number	Tooling Description
Std	Newbury H-12-200T - Type Nylon Zytel
Std	Blend: Nylon Zytel 101 NC-10 Nylon Zytel 105 BK-10A Aluminum Stearate
Std	Lydon -Drying Oven
Std	Trays - 34" x 17" x 1-1/2" Deep

Operation Procedure Notes Operation: 8

Description
Oven Dry 4 Hours @ 230 Degrees F Note: When Holding Material for More Than 4 Hours; Reduce Temperature to 1750 Degrees F After Initial 4 Hour Cycle

Operation Step Detail Operation: 12

Step	Operation / Step Description
	Injection Mold

Operation Tool Detail Operation: 12

Tool Number	Tooling Description
Std	Newbury H-12 - 200T - Injection Molding Machine
89898	4 Cavity J.G. Tilp Injection Mold (Serial Number)
Std	Container for Parts
Std	Container for Sprue and Runner
Std	IMS Mold Temperature Controllers

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Operation Procedure Notes Operation: 12

Description
Material: 50% Zytel 101 NC 10 & 50% Zytel 105 BK 10A
Temperature Controller: Tank to be kept Full with Solution of Water and Sodium Nitrite 1/2 Lb./Gal. of Water
Sprue and Runner Container: To be Clean and Dry - and to be Sealed when Full to Prevent Contamination
Cylinder Temp. in Degrees F: Zone #1 - 515 Zone #2 - 510 Zone #3 - 495 Nozzle - 510
Timer Settings in Seconds: Cycle Time - 33.0 High Pressure Inject - 6.0 Low Pressure Inject - 5.0 L.P.C. Time - 3.75 Clamp Open - 2.5 Knock Out Timed - 0.0 Pre Pack - 0.0 Total Cycle - 39.25
Pressure Settings (PSI): High Inject - 1700 Low Inject - 1300
Inject Speeds: Speed #1 - Full Speed #2 - Full
Shot Settings (In.): LS - 13 - 5.25 LS - 4 - 14.75
Mold Temp. Degrees F: Movable Side - 150 Stationary Side - 160
Shot Wt. (Gr.): Total 59.3 Parts 51.4
Remarks: K.O. Pin Size K.O. Setting - Black Run Full Auto. Feed Bar 7-1/8 from Back Max. Day Light 5-3/4"

Operation Step Detail Operation: 16

Step	Operation / Step Description
	Degate and Inspect

TITLE: Trigger Guard XP100

Operation Tool Detail Operation: 16

Tool Number	Tooling Description
Std	Newbury H-12 - 200T - Type Nylon Zytel

Operation Procedure Notes Operation: 16

Description

Procedure:

1. Break Parts from Gate

2. Inspect for: a. Fill
   b. Sinks
   c. Cold Welds at Bottom of Bow
   d. Poor Fill

3. Regrind Container