

TITLE: Trigger Link XP100

Process Header

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Document ID: Trig Link XP100	Remington Arms Company
Part Name: Trigger Link 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 279148 - Replaces Old Paper Process	GLC 293211

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksORA			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15458	1	Trigger Link - XP100
16325	1	Blank

Process Routing

Dept	Oper	Operation Description	Part Numbers
8579	5	C'Sink (4) Places	15458
8579	10	Black Oxide Color	15458
		To Sear Housing Assembly	15458

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Operation Step Detail

Operation: 5

Step

Operation / Step Description

C'Sink (4) Places

Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

C-85135

Holding Block

A-85370

C'Sink

A-86123

Flush Pin Gage - Depth - .031/.021

Operation Step Detail

Operation: 10

Step

Operation / Step Description

Black Oxide Color

Operation Procedure Notes

Operation: 10

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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