

TITLE: Trigger Balance Pin XP100

Process Header

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Document ID: Trig Balance Pin XP100	Remington Arms Company
Part Name: Trigger Balance Pin 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 283490 - Replaces Old Paper Process	GLC 293210

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15471	1	Trigger Balance Pin - XP100
13859	1	Blank

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Process Routing

Step	Oper	Operation Description	Part Numbers
8551	5	Degrease, Neutral Salt Harden, Wash & Dry	15471
8551	10	Lindberg Temper	15471
9257	15	Inspect for Hardness	15471
8579	20	Black Oxide Color	15471
		To MRP Crib #29	15471

Operation Step Detail

Operation: 5

Step

Operation / Step Description

	Degrease, Neutral Salt Harden, Wash & Dry
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Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

Std	Ajax Electric Salt Furnace
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Operation Procedure Notes Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: High Carbon Steel

TEMPERATURE: 1500 - 1550 Degrees F

MAXIMUM LOAD: 1" Deep in Bottom of Basket

TIME: 15 Minutes

QUENCH: Oil

REMARKS: Parts Must Be Dry Before Entering Salt

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Salt Residue, Clean & Dry

Operation Step Detail Operation: 10

Step Operation / Step Description

Lindberg Temper

Operation Tool Detail Operation: 10

Tool Number Tooling Description

Std Lindberg Electric Furnace

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Operation Procedure Notes Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: High Carbon Steel

TEMPERATURE: 350 - 400 Degrees F

MAXIMUM LOAD:

TIME: 1 Hour

QUENCH: Air Cool

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail Operation: 15

Step Operation / Step Description

Inspect for Hardness

Operation Tool Detail Operation: 15

Tool Number Tooling Description

Std Rockwell Hardness Tester

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Operation Procedure Notes Operation: 15

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: High Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Rockwell Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS: R15N 90/92

APPEARANCE OF PARTS:

Operation Step Detail Operation: 20

Step Operation / Step Description

Black Oxide Color

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Operation Procedure Notes Operation: 20

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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