

TITLE: Trigger Powder Metal XP100

Process Header

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Document ID: Trig PM XP100	Remington Arms Company
Part Name: Trigger Powder Metal 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 285852 - Replaces Old Paper Process	GLC 293208

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15457	1	Trigger Powder Metal - XP100
16872	1	Blank

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Process Routing

Step	Oper	Operation Description	Part Numbers
8502	35	Drill and Ream Two Holes	15457
8502	40	C'Sink to Deburr (2) Holes, Both Sides	15457
8502	47	Mill Front End	15457
8502	49	Belt Sand to Deburr	15457
8579	51	Supersheen	15457
8579	55	Black Oxide Color	15457
		To MRP Crib #29	15457

Operation Step Detail

Operation: 35

Step

Operation / Step Description

	Drill and Ream Two Holes
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Operation Tool Detail

Operation: 35

Tool Number

Tooling Description

Std	2 Spindle Drill Press
Std	Coolant - Dasco (20:1)
Std	Drill - #31 (.120 Dia.)
Std	Reamer - RS-4 (.1261 Dia.)
D-85144	Drill Jig
	Gages:
B-80154-D	Plug Gage - .1264/.1254
C-85172	Position Gage

Operation Step Detail

Operation: 40

Step

Operation / Step Description

	C'Sink to Deburr (2) Holes, Both Sides
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Operation Tool Detail

Operation: 40

Tool Number

Tooling Description

Std	1 Spindle Drill Press
Std	Weldon C'Sink Tool - DB 8 - 90 Degree HS
C-85035	Holding Block
C-85172	Position Gage

Operation Step Detail

Operation: 47

Step

Operation / Step Description

Mill Front End

Operation Tool Detail

Operation: 47

Tool Number

Tooling Description

Std	Whitney Hollow Mill with Air Feed
D-85145	Vise Jaws
Std	Vise 3"
-38671	Cutter
D-85146	Base Gage - .564/.558

Operation Step Detail

Operation: 49

Step

Operation / Step Description

Belt Sand to Deburr

Operation Tool Detail

Operation: 49

Tool Number

Tooling Description

Std	Belt Sander
Std	Belt - 120 Grit

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Operation Procedure Notes Operation: 49

Description

NOTE: Belt Sand Both Sides and Front End per Sample

Operation Step Detail Operation: 51

Step Operation / Step Description

Supersheen

Operation Tool Detail Operation: 51

Tool Number Tooling Description

Std	DB 2020
#3-1/2	Chip Size (2M Type)
18	RPM
500	Pcs per Compartment

Operation Procedure Notes Operation: 51

Description

Grind 3-1/2 Chip - 3 Oz. Immunol - Water Low - Time 2.5 Hours - Rinse 3 Times

NOTE: SEPARATE FROM CHIP AND OIL

Operation Step Detail Operation: 55

Step Operation / Step Description

Black Oxide Color

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Operation Procedure Notes Operation: 55

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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