

TITLE: Rear Receiver Screw XP100

Process Header

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Document ID: Rear Rec Scr XP100	Remington Arms Company
Part Name: Rear Receiver Screw XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 30-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
30-Oct-1992	Retype Entire Process from 283475 - Replaces Old Paper Process - Revise Heat Treat Process Changes Op.#5 Description - Add 97759	GLC 293278

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15450	1	Rear Receiver Screw - XP100
16503	1	Blank
97759	1	Rear Receiver Screw - XP100
97762	1	Blank

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Process Routing

Op	Oper	Operation Description	Part Numbers
8551	5	Degrease, Carbo-Nitride (MicroCarb) Harden Oil Quench, Degrease	15450, 97759
8551	10	Nitre Black, Water Quench, Wash, Dry and Oil	15450, 97759
9257	15	Inspect for Oil and Color	15450, 97759
		To MRP Crib #29	15450, 97759

Operation Step Detail Operation: 5

Step	Operation / Step Description
	Degrease, Carbo-Nitride (MicroCarb) Harden Oil Quench, Degrease

Operation Tool Detail Operation: 5

Tool Number	Tooling Description
Std	Micro-Carb Furnace
Std	Basket - 12"x20"x2" Deep

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Operation Procedure Notes Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: .75 Carbon Potetial - 1600 Degrees F

MAXIMUM LOAD: 3000 Pcs - 2 Baskets 1500 Pcs per Basket

TIME: 1.5 Hrs. @ Temp.

QUENCH: Oil

REMARKS: Degreased

INSPECT FOR: File Hard to Insure Proper Quench

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail Operation: 10

Step Operation / Step Description

Nitre Black, Water Quench, Wash, Dry and Oil

Operation Tool Detail Operation: 10

Tool Number Tooling Description

Std Nitre Black Bath

Std Basket - 12"x20"x3" Deep with Handle

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TITLE: Rear Receiver Screw XP100

Operation Procedure Notes Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: 925 - 950 Degrees F

MAXIMUM LOAD: 3000 Pcs per Basket

TIME: 15 - 20 Min. @ Temp.

QUENCH: Water

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free from Salts Well Oiled

Operation Step Detail Operation: 15

Step Operation / Step Description

Inspect for Oil and Color

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TITLE: Rear Receiver Screw XP100

Operation Procedure Notes Operation: 15

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free from Salts, Well Oiled

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