

TITLE: Trigger Housing XP100

Process Header

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Document ID: Trig Hous XP100	Remington Arms Company
Part Name: Trigger Housing XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 31-Oct-1992

Process Revision Reasons

Date: Reason For Revision: Eng Log #:

31-Oct-1992	Retype Entire Process from 283474 - Replaces Old Paper Process - Chg. Description Op.#19	GLC 293291
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Process Approval List

Approved By: Badge #: Date: Designation:

JacksonRA

Process General Notes

Notes:

Process Material

Part Number Qty Description

15473	1	Trigger Housing - XP100
16871	1	Blank

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Process Routing

pt	Oper	Operation Description	Part Numbers
8567	5	Grind Face of Tabs	14573
8575	10	Drill and Tap (2) Trigger Housing Screw Holes, Drill and Tap (1) Trigger Adjusting Screw Hole, Drill and Ream Trigger Pin Hole	14573
8502	15	Deburr	14573
8551	19	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease	14573
8551	21	Nitre Black	14573
9257	25	Inspect for Color and Oil	14573
		(To Trigger Housing Assembly)	14573
		To MRP Crib #29	

Operation Step Detail

Operation: 5

Step

Operation / Step Description

Grind Face of Tabs

Operation Tool Detail

Operation: 5

Tool Number

Tooling Description

Std Van Norman Grinder

D-86360 Grinding Fixture

Operation Procedure Notes

Operation: 5

Description

NOTE: Set Grinding Depth to Position where Both Tabs are Ground Flat

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Operation Step Detail

Operation: 10

Step

Operation / Step Description

Drill and Tap (2) Trigger Housing Screw Holes, Drill and Tap (1) Trigger
Adjusting Screw Hole, Drill and Ream Trigger Pin Hole

Operation Tool Detail

Operation: 10

Tool Number

Tooling Description

Std	4 Spindle Drill Press with (2) Tapping Heads
Std	#31 (.120 Dia.) Drill (Taper Length)
A-85357	Comb. Drill and C'Sink
A-85358	Comb. Drill and C'Sink
Std	Reamer - RS-4 - (.125 Dia.)
Std	#5-40NC-2 Tap GH - 1-2 Flutes - Plug Chamfer
Std	#10-32 UNF-2 Tap
D-85100	Drill Jig
Gages:	
B-80207-A	Thread Gage #5-40NC-2
B-80207-L	Thread Gage #10-32 NF-2
B-80268-L	Plug Gage .1252/.1242
C-85130	Pinning Gage

Operation Procedure Notes

Operation: 10

Description

NOTE: Drill both Holes (#31 Drill) from One Side and Line Ream Both Holes
from Opposite Side

Operation Step Detail

Operation: 15

Step

Operation / Step Description

Deburr

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Operation Tool Detail

Operation: 15

Tool Number

Tooling Description

Std	File
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Operation Step Detail

Operation: 19

Step

Operation / Step Description

	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease
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Operation Tool Detail

Operation: 19

Tool Number

Tooling Description

Std	Micro-Carb Furnace
Std	Basket - 12"x20"x2" Deep

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Operation Procedure Notes Operation: 19

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1010

TEMPERATURE: .75 Carbon Pot. @ 1600 Degrees F.

MAXIMUM LOAD: 250 Pcs. - 2 Baskets 125 Pcs. per Basket
(Spread Out)

TIME: 1.5 Hours @ Temp.

QUENCH: Oil

REMARKS: Wash

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: 21

Step Operation / Step Description

Nitre Black

Operation Tool Detail Operation: 21

Tool Number Tooling Description

Std Nitre Pot Furnace

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

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Operation Procedure Notes Operation: 21

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1010

TEMPERATURE: 900 - 950 Degrees F

MAXIMUM LOAD: 125 Pcs. per Basket

TIME: 10 - 15 Minutes

QUENCH: Water

REMARKS:

INSPECT FOR: Color

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Uniform Black Color, Free of Salts, Well Oiled

Operation Step Detail Operation: 25

Step Operation / Step Description

Inspect for Color and Oil

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Operation Procedure Notes Operation: 25

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: C-1010

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: Color and Oil

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Uniform Black Color, Free of Salts, Well Oiled

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