

TITLE: Trigger Housing Screw Front XP100

Process Header

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Document ID: Trig Hous Scr Front XP100	Remington Arms Company
Part Name: Trigger Housing Screw Front 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 285852 - Replaces Old Paper Process - Chg. Description Op.#5	GLC 293289

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
15469	1	Trigger Housing Screw, Front - XP100
16504	1	Blank

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Process Routing

pt	Oper	Operation Description	Part Numbers
8551	5	Degrease, Wash, Carbo-Nitride Harden (Micro-Carb), Oil Quench, Degrease, Wash	15469
8551	10	Lindberg Draw, Air Cool	15469
9257	12	Inspect for Hardness	15469
8579	15	Black Oxide, Oil with Steelgard	15469
		(To Trigger Housing Assembly)	15469
		To MRP Crib #29	

Operation Step Detail

Operation: 5

Step

Operation / Step Description

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

Operation: 5

Tool Number

Tooling Description

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

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TITLE: Trigger Housing Screw Front XP100

Operation Procedure Notes Operation: 5

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: .75 Carbon Pot. @ 1600 Degrees F

MAXIMUM LOAD: 5000 Pcs. - 2 Baskets 2500 Pcs. per Basket

TIME: 1.5 Hrs. @ 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: 10

Step Operation / Step Description

Lindberg Draw, Air Cool

Operation Tool Detail Operation: 10

Tool Number Tooling Description

Std Lindberg Furnace

Std Basket - 12"x20"x2" Deep

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TITLE: Trigger Housing Screw Front XP100

Operation Procedure Notes Operation: 10

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: 350 - 400 Degrees F

MAXIMUM LOAD: 5000 Pcs. - 2 Baskets 2500 Pcs. per Basket

TIME: 1 Hr. @ Temp.

QUENCH: Air Cool

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail Operation: 12

Step Operation / Step Description

Inspect for Hardness

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Operation Procedure Notes Operation: 12

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: File Hardness

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail Operation: 15

Step Operation / Step Description

Black Oxide, Oil with Steelgard

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Operation Procedure Notes Operation: 15

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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