

TITLE: Trigger Link Pin XP100

## Process Header

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|                                   |                                      |
|-----------------------------------|--------------------------------------|
| Document ID: Trig Link Pin XP100  | Remington Arms Company               |
| Part Name: Trigger Link Pin 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 283475 - Replaces Old Paper Process - Chg. Description Op.#4 | GLC 293288 |
|-------------|-----------------------------------------------------------------------------------------|------------|

## Process Approval List

Approved By: Badge #: Date: Designation:

|          |  |  |  |
|----------|--|--|--|
| Jacksora |  |  |  |
|----------|--|--|--|

## Process General Notes

Notes:

## Process Material

Part Number Qnty Description

|       |   |                  |
|-------|---|------------------|
| 15459 | 1 | Trigger Link Pin |
| 16505 | 1 | Blank            |

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**Process Routing**

| Dept | Oper | Operation Description                                      | Part Numbers |
|------|------|------------------------------------------------------------|--------------|
| 8551 | 4    | Degrease, Carbo-Nitride (Micro-Carb), Oil Quench, Degrease | 15459        |
| 8551 | 8    | Lindberg Draw                                              | 15459        |
| 9257 | 10   | Inspect for Hardness                                       | 15459        |
| 8551 | 12   | Torch Draw - Small End                                     | 15459        |
|      |      | To MRP Crib #29                                            | 15459        |

**Operation Step Detail**

Operation: 4

| Step | Operation / Step Description                               |
|------|------------------------------------------------------------|
|      | Degrease, Carbo-Nitride (Micro-Carb), Oil Quench, Degrease |

**Operation Tool Detail**

Operation: 4

| Tool Number | Tooling Description                  |
|-------------|--------------------------------------|
| Std         | Micro-Carb Furnace                   |
| Std         | Basket - 12"x20"x2" Deep (Fine Mesh) |

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Operation Procedure Notes

Operation: 4

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: .75 Carbon Pot. @ 1650 Degrees F

MAXIMUM LOAD: 10000 Pcs. - 2 Baskets 5000 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 from Oil

Operation Step Detail

Operation: 8

Step

Operation / Step Description

Lindberg Draw

Operation Tool Detail

Operation: 8

Tool Number

Tooling Description

Std Electric Lindberg Furnace

Std Basket - 12"x20"x2" Deep (Fine Mesh)

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Operation Procedure Notes

Operation: 8

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE: 350 +/- 10 Degrees F

MAXIMUM LOAD: 10000 Pcs. - 2 Baskets 5000 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: 10

Step

Operation / Step Description

Inspect for Hardness

Operation Tool Detail

Operation: 10

Tool Number

Tooling Description

Std

Rockwell Hardness Tester

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Operation Procedure Notes

Operation: 10

## Description

## PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL &amp; SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS:

INSPECT FOR: File Hard

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS: Free of Oil

Operation Step Detail

Operation: 12

Step

Operation / Step Description

Torch Draw - Small End

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Operation Procedure Notes

Operation: 12

Description

## PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL &amp; SPECIFICATION: .08/.20 Carbon Steel

TEMPERATURE:

MAXIMUM LOAD:

TIME:

QUENCH:

REMARKS: Torch Draw Small End - 1/8" Up

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

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